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2013 FORD Ranger Super Cab OEM Service and Repair Workshop Manual

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Roof Reinforcement - Regular Cab

501-28 Roof Sheet Metal Repairs	2022 F-150
Removal and Installation	Procedure revision date: 10/8/2020

Roof Reinforcement - Regular Cab

Removal

WARNING

Electric vehicles damaged by a crash may have compromised high voltage safety systems and present a potential high voltage electrical shock hazard. Exercise caution and wear appropriate Personal Protective Equipment (PPE) safety gear, including high voltage safety gloves and boots. Remove all metallic jewelry, including watches and rings. Isolate the HV system as directed by the Ford Emergency Response Guide for the vehicle. Failure to follow these instructions may result in serious personal injury or death.

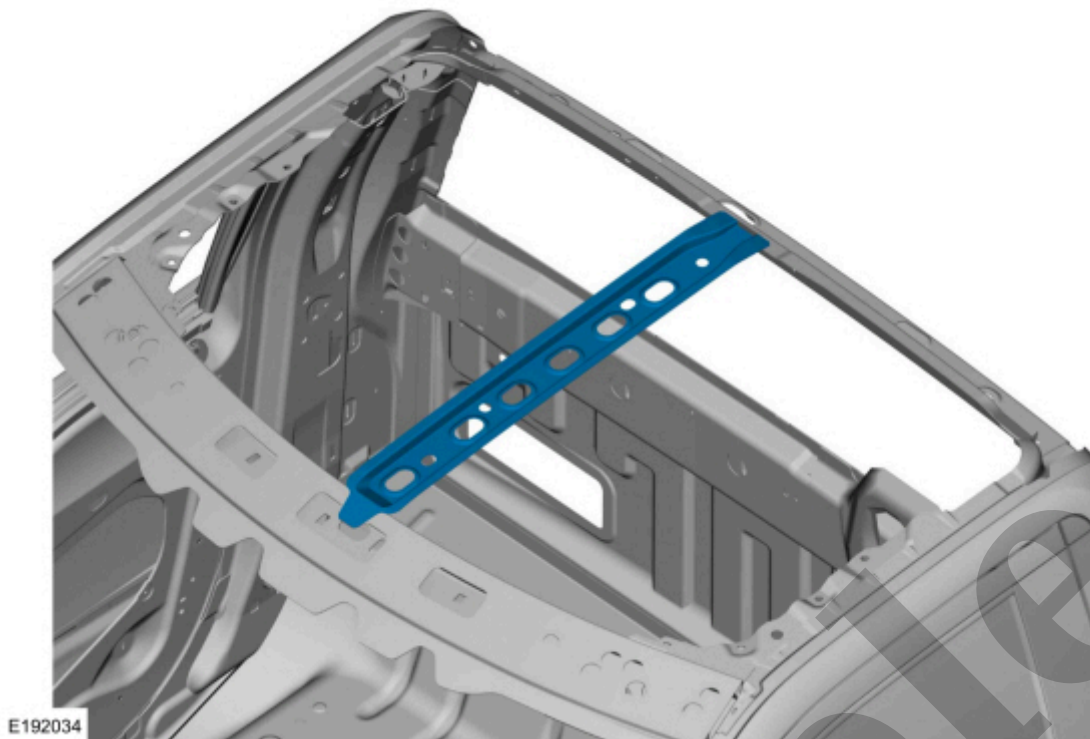
NOTICE

Battery electric vehicle (BEV), hybrid electric vehicle (HEV) and plug-in hybrid electric vehicle (PHEV) contain a high-voltage battery. Before cutting or welding near the high-voltage battery it must be removed to avoid damage.

1. WARNING

Before beginning any service procedure in this manual, refer to health and safety warnings in section 100-00 General Information. Failure to follow this instruction may result in serious personal injury.

Refer to: [Health and Safety Precautions](#)(100-00 General Information, Description and Operation).



[Click here to learn about symbols, color coding, and icons used in this manual.](#)

Installation

NOTE

SPR (self-piercing rivet) fasteners may not be placed directly over original SPR (self-piercing rivet) location. They must be placed adjacent to original location matching original quantity.

NOTE

Solid rivets or blind fasteners may be used in place of SPR (self-piercing rivet) fasteners after enlarging the existing hole to 6.5 mm.

1. Install the roof reinforcement and clamp in position.

Use the General Equipment: Locking Pliers

3. NOTE

SPR (self-piercing rivet) fasteners may not be placed directly over original SPR (self-piercing rivet) location. They must be placed adjacent to original location matching original quantity.

NOTE

Solid rivets or blind fasteners may be used in place of SPR (self-piercing rivet) fasteners after enlarging the existing hole to 6.5 mm.

Install fasteners.

Item	SPR (self-piercing rivet) Number	SPR (self-piercing rivet) Code	Henrob®, Car-OLiner®, CMO®, Chief®, Spanesi®, Wielander and Schill® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid rivet	Rivnut®
1	-	-	-	-	W702512-S900C	-	-

Refer to: [Joining Techniques](#)(501-25 Body Repairs - General Information, General Procedures).

Use the General Equipment: Blind Rivet Gun



Roof Reinforcement - SuperCab

501-28 Roof Sheet Metal Repairs	2022 F-150
Removal and Installation	Procedure revision date: 10/8/2020

Roof Reinforcement - SuperCab

Removal

WARNING

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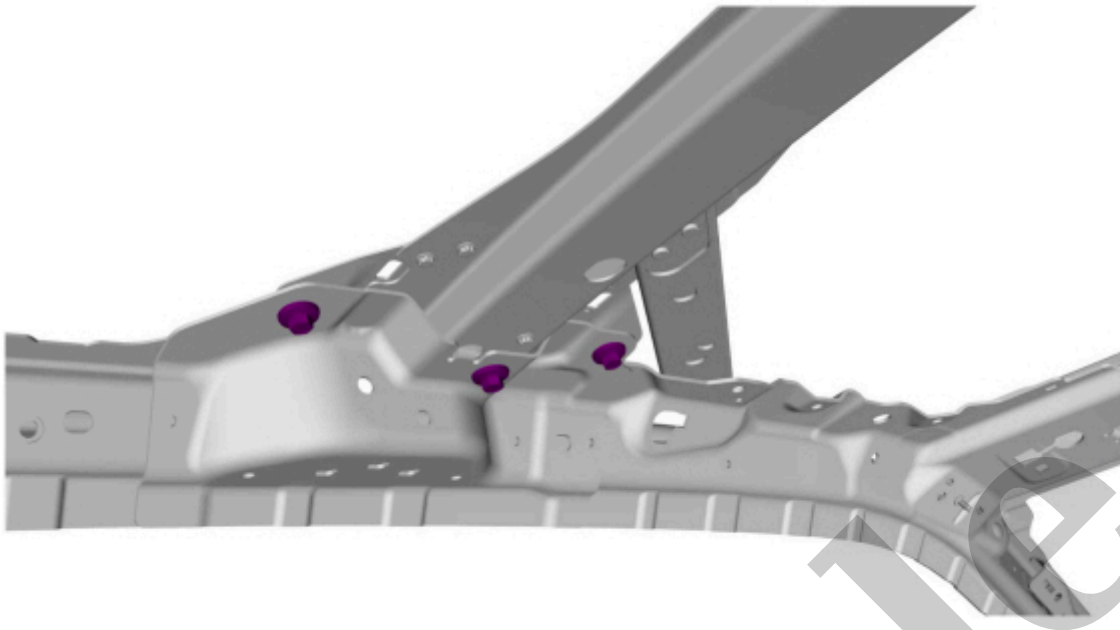
NOTICE

Battery electric vehicle (BEV), hybrid electric vehicle (HEV) and plug-in hybrid electric vehicle (PHEV) contain a high-voltage battery. Before cutting or welding near the high-voltage battery it must be removed to avoid damage.

1. WARNING

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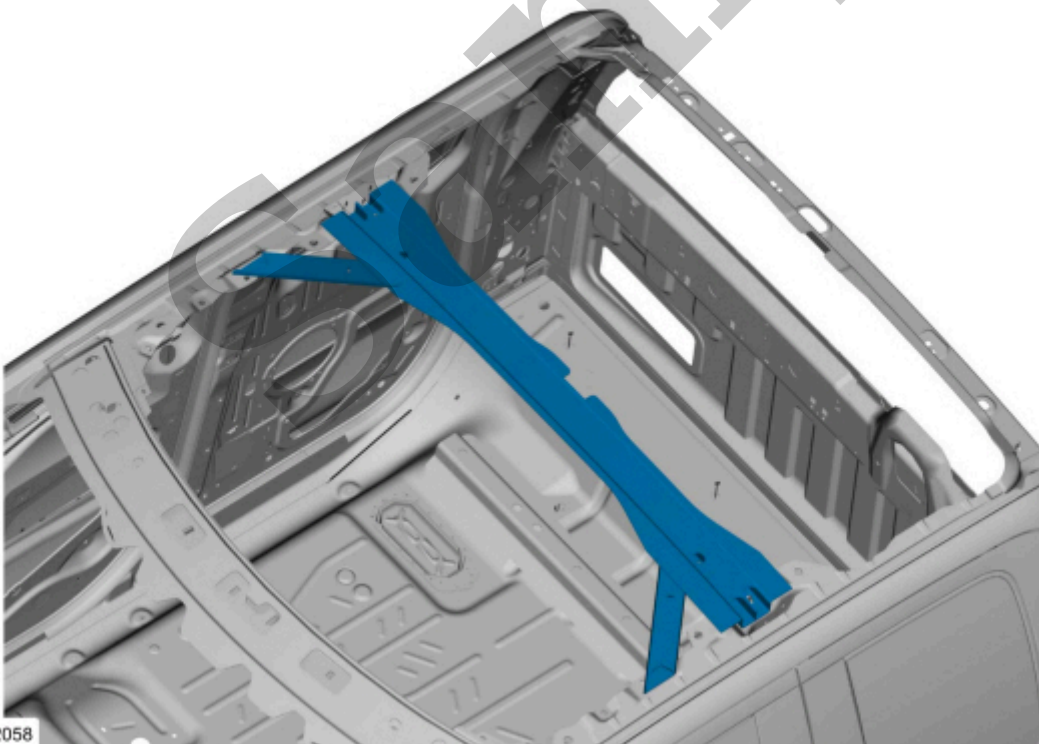
Refer to: [Health and Safety Precautions](#)(100-00 General Information, Description and Operation).



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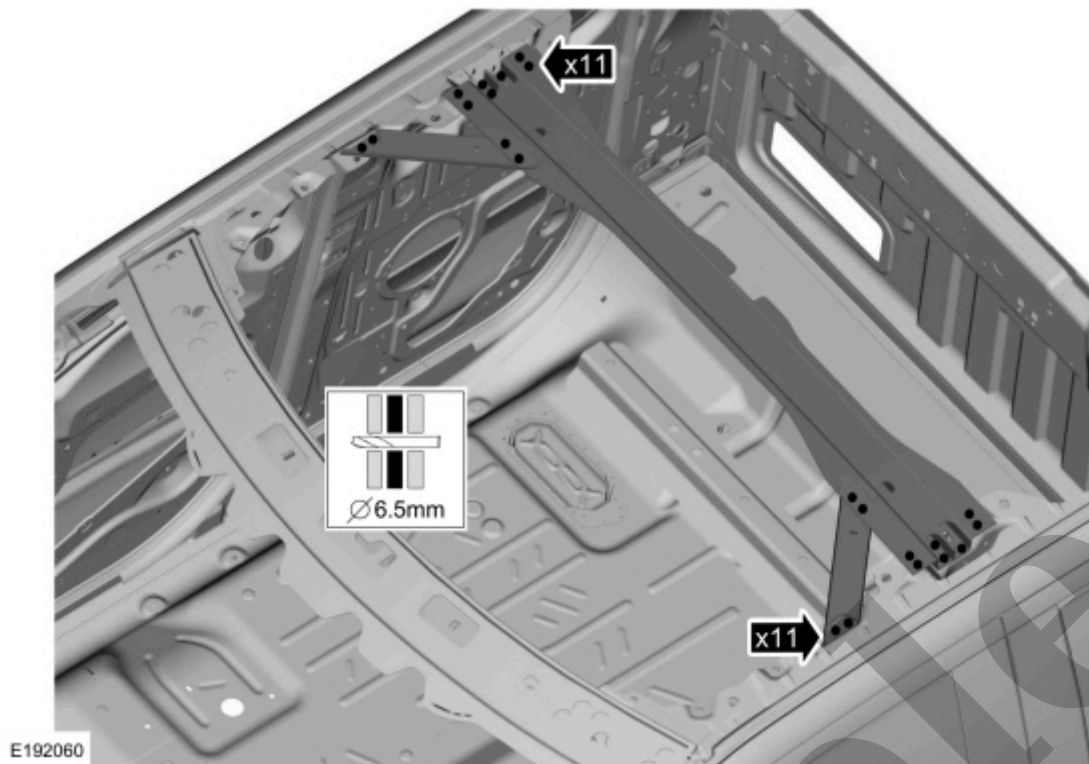
5. Remove the roof reinforcement.



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Installation



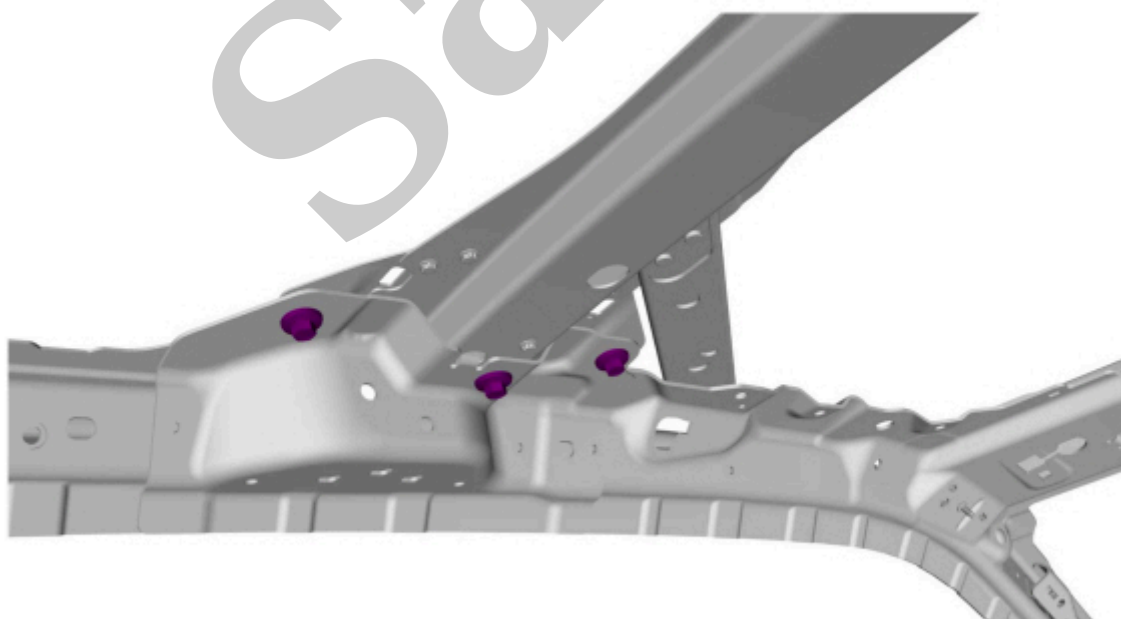
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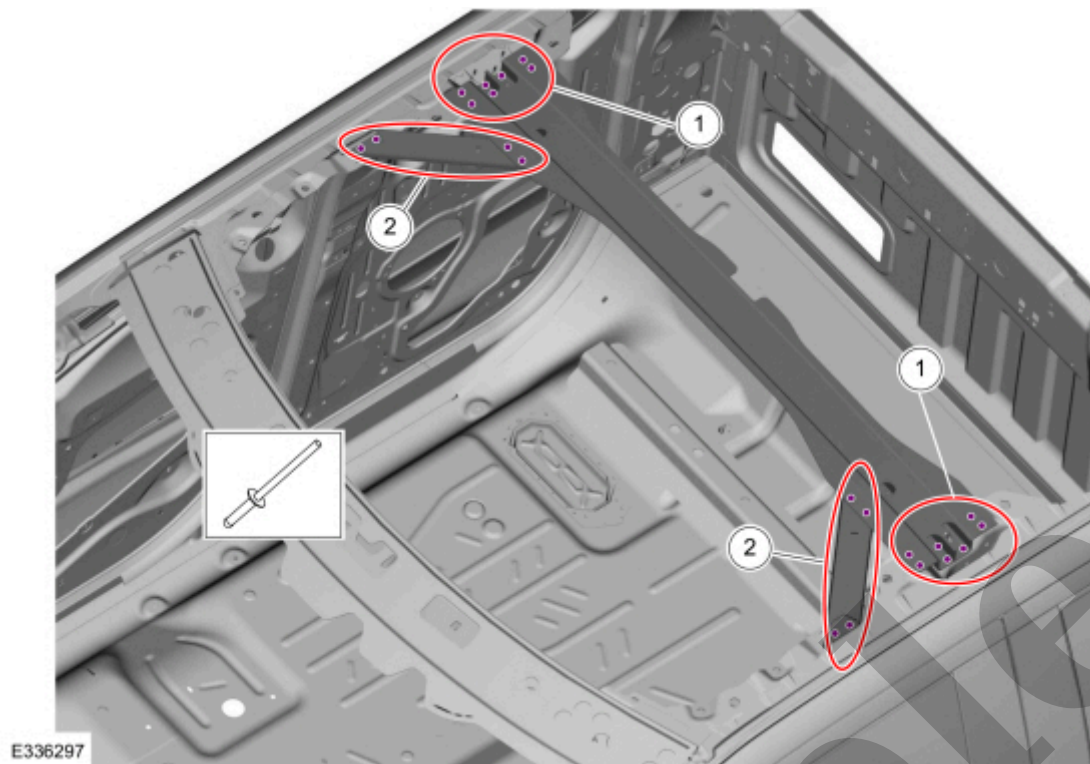
3. On Both Sides:

Install the fasteners.

Torque : 30 lb.ft (40 Nm)



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5. Install the roof panel.

Refer to: [Roof Panel - SuperCab](#)(501-28 Roof Sheet Metal Repairs, Removal and Installation).

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Refer to: [High Voltage System Health and Safety Precautions - Overview](#)(100-00 General Information, Description and Operation).

NOTE

Roof reinforcements are provided as 4 service parts (roof reinforcement, center reinforcement and K-braces), the following procedure assumes all components are to be replaced.

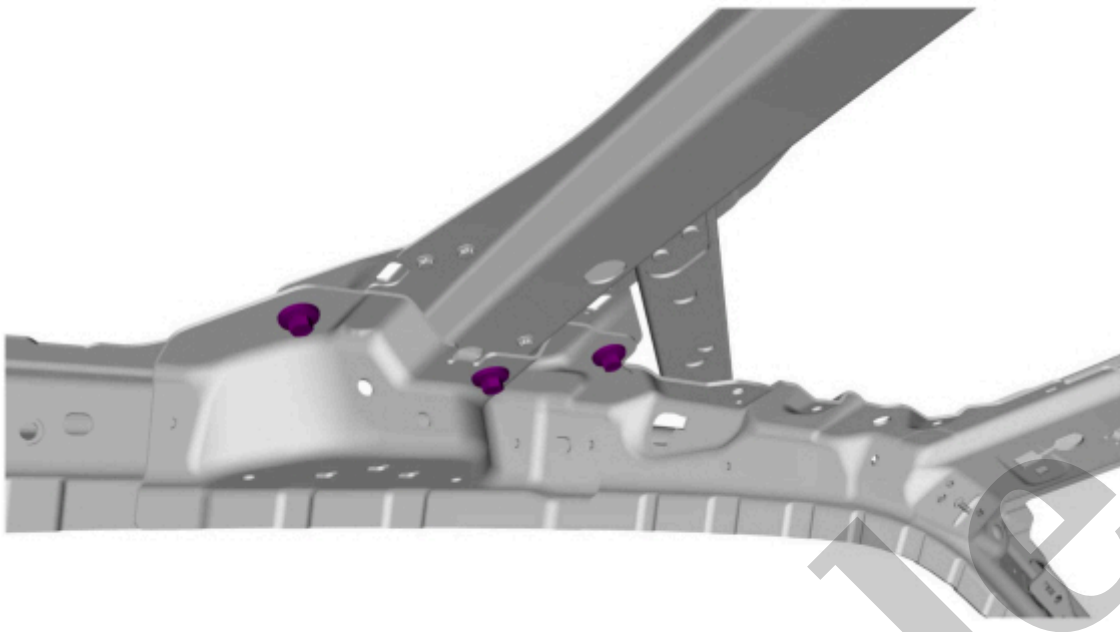
2. Remove the roof outer panel.

Refer to: [Roof Panel - SuperCrew](#)(501-28 Roof Sheet Metal Repairs, Removal and Installation).

3. Remove the SPR (self-piercing rivet) fasteners as indicated.

Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer

Use the General Equipment: Belt Sander



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5. Remove the roof reinforcement.