

# Your Ultimate Source for OEM Repair Manuals

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## 2014 FORD Ranger Super Cab OEM Service and Repair Workshop Manual

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12. **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.

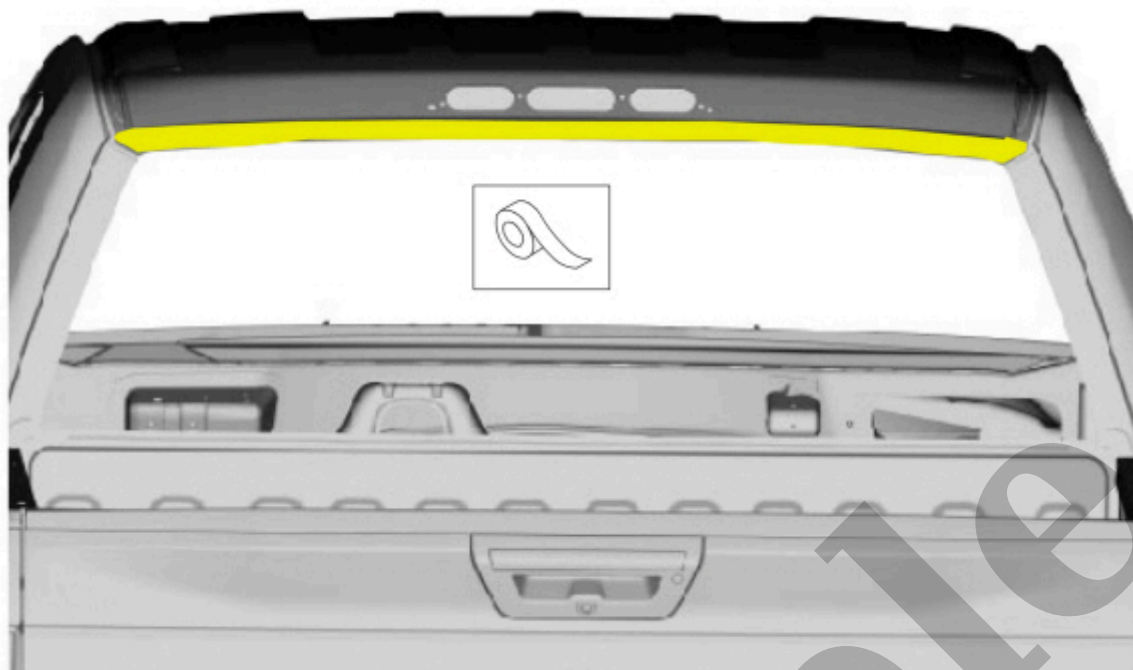
**NOTE**

Blind or solid rivets may be used in place of SPR (self-piercing rivet) in the original SPR (self-piercing rivet) location after enlarging hole to 6.5 mm.

Install the fasteners.

Item	SPR (self-piercing rivet) Number	SPR (self-piercing rivet) Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	W708714-S900	AT	DZ09-025/H	SA-0400/SA-0401	W707638-S900C	W790376-S900	-
2	W710246-S900	BN	DP10-200/H	SA-0400/SA-0401	W708777-S900C	W790376-S900	-
3	W708713-S900	AS	DZ09-025/H	SA-0400/SA-0401	W702512-S900C	W790376-S900	-

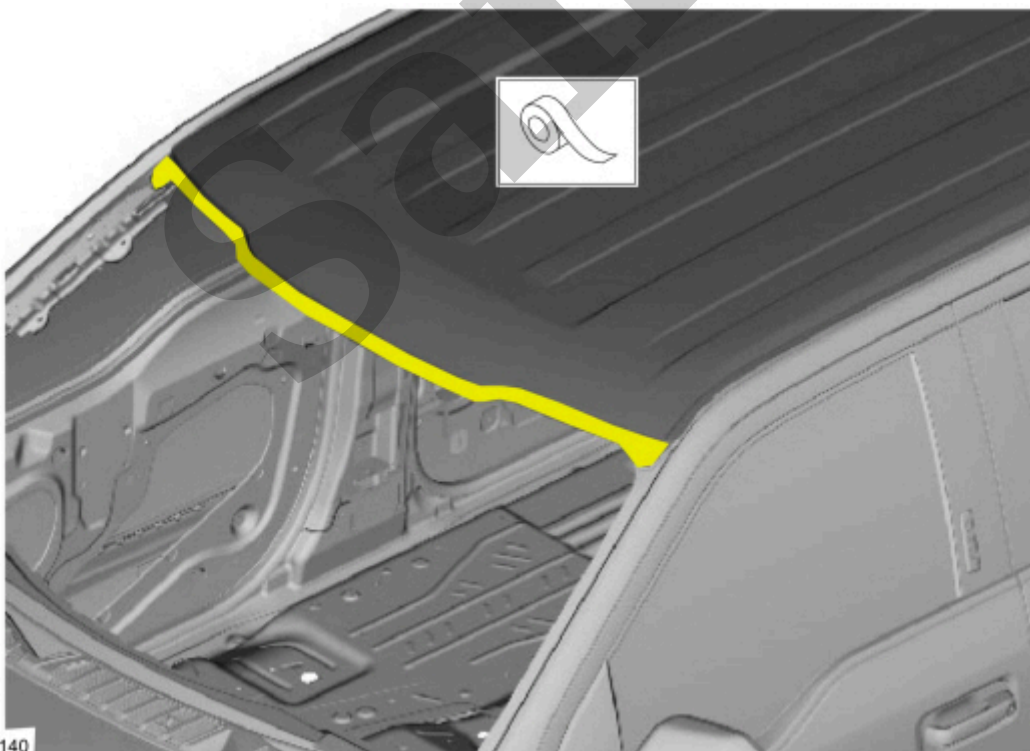
Refer to: [Joining Techniques](#)(501-25 Body Repairs - General Information, General Procedures).



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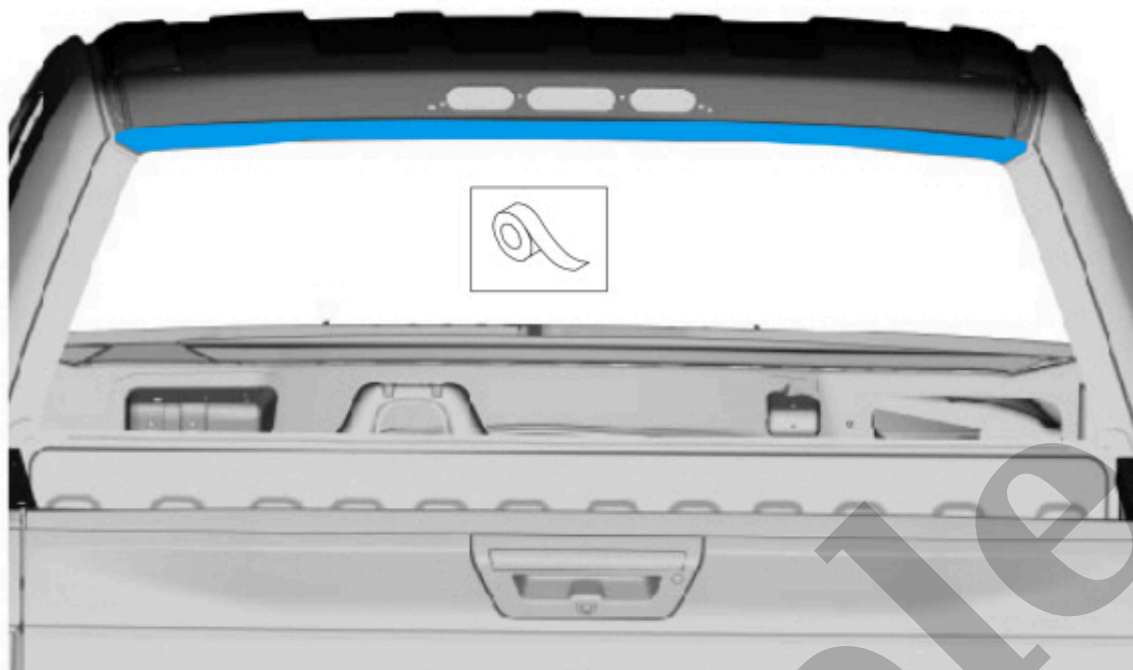
[Click here to learn about symbols, color coding, and icons used in this manual.](#)

15. Mask off the windshield glass channel.



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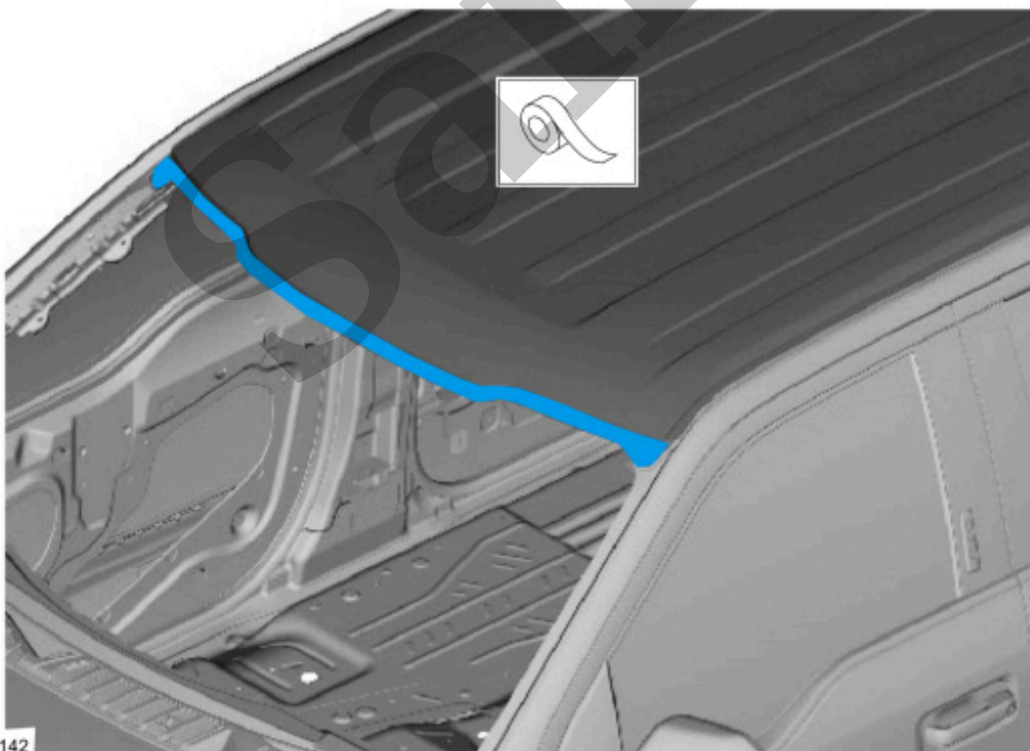
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19. Remove the masking in the windshield glass channel.



E191142

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# Roof Rear Frame

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

## Roof Rear Frame

### Removal

#### NOTE

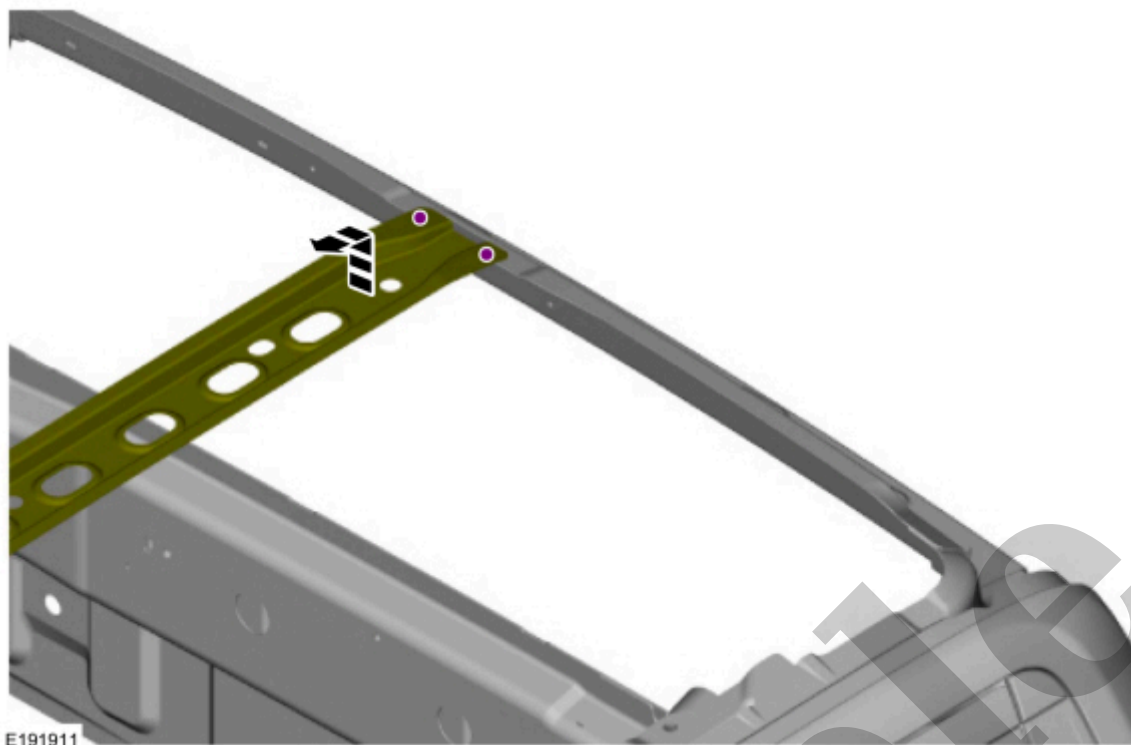
Aluminum body panels are highly receptive to heat transfer. With the extensive use of structural adhesives and non-structural sealers used in vehicle construction, the potential of heat transfer could impact adhesives and sealers in non-associated panels during the repair process. Many repairs areas that utilize structural adhesive may be separated after fastener removal by using a panel chisel along the joint/flange. Using heat not exceeding 425° F to loosen a bonded panel should only be done when all panels in the joint will be replaced and new adhesive applied.

### All vehicles

#### 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



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

#### **All vehicles**

4. On both sides.

Remove the SPR (self-piercing rivet) fasteners.

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

Use the General Equipment: Belt Sander



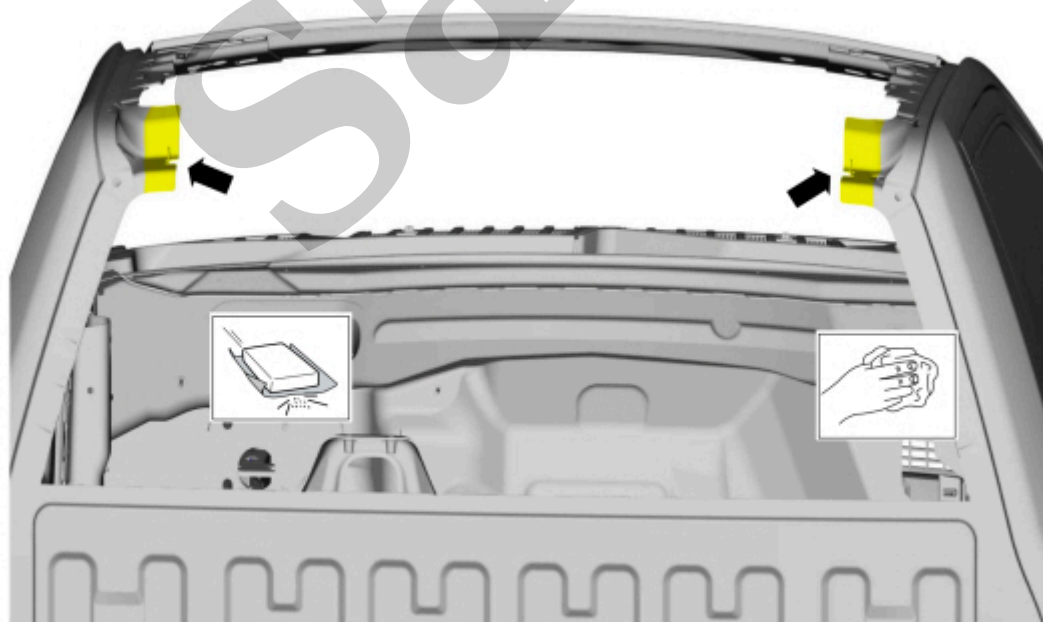
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## Installation

### All vehicles

1. Sand using 80 grit sandpaper to remove all adhesive and clean.



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4. Install the rear roof frame and clamp in position.

Use the General Equipment: Locking Pliers



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

5. On both sides,

Drill blind fastener holes as indicated

Use the General Equipment: 6.5 mm Drill Bit



rivet) location after enlarging hole to 6.5 mm.

On both sides.

Install fasteners

Item	SPR (self-piercing rivet) Number	SPR (self-piercing rivet) Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W707638-S900C	-	-

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

Use the General Equipment: Blind Rivet Gun

Blind fasteners may be used in place of SPR (self-piercing rivet) fasteners in the original SPR (self-piercing rivet) location after enlarging the hole to 6.5 mm.

#### NOTE

Without roof opening panel.

Reposition the center roof panel reinforcement clamp and 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: Locking Pliers

Use the General Equipment: Blind Rivet Gun

