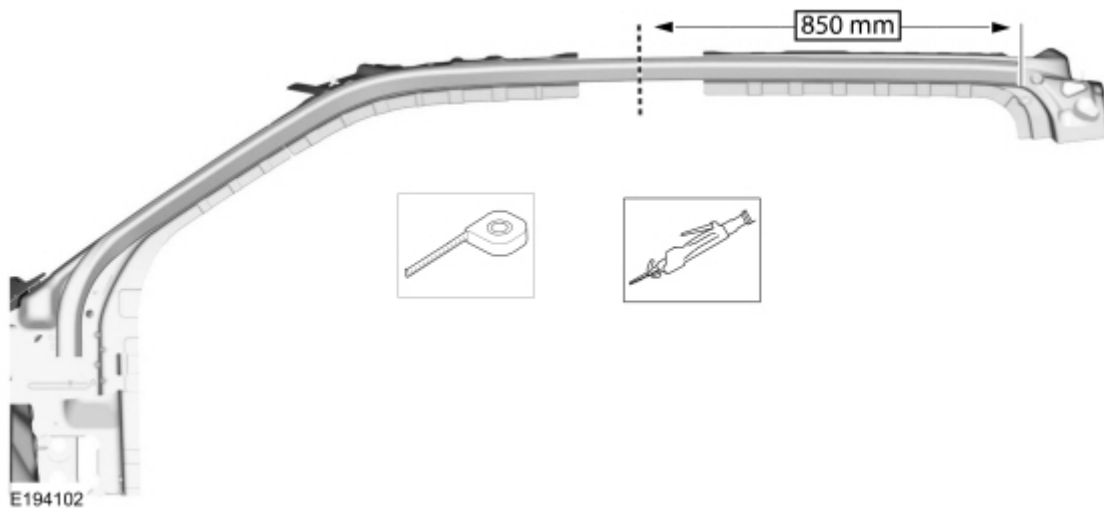


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2015 FORD Ranger Super Cab OEM Service and Repair Workshop Manual

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27. Remove the roof side rail section.



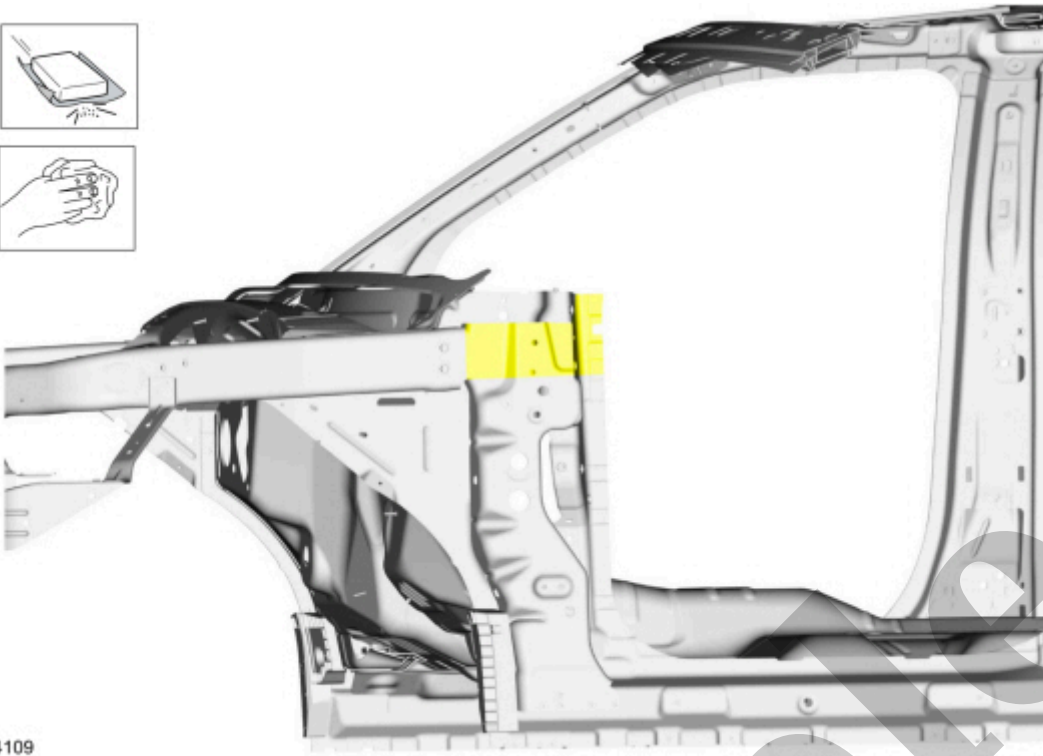
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Installation

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



E194109

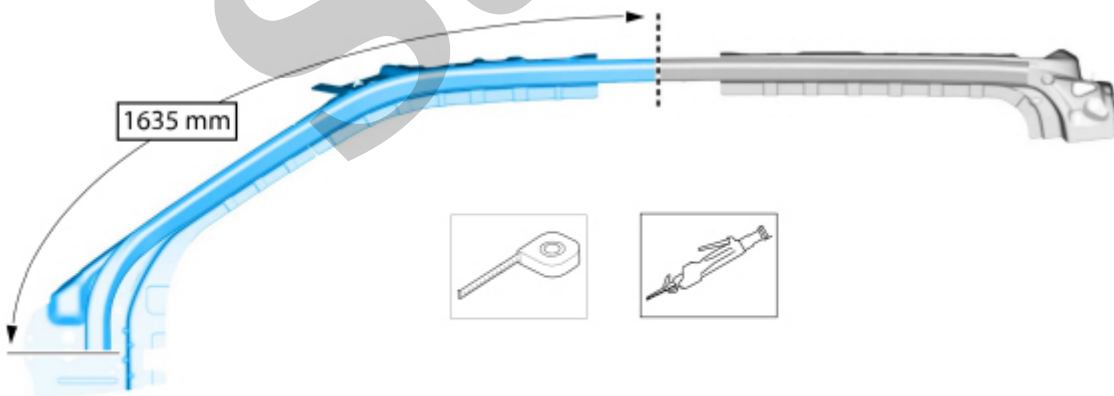
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3. NOTE

Measurement taken along the top of the side rail tube.

Carefully measure and cut the roof side rail tube service part as indicated.

Use the General Equipment: Air Body Saw



E194105

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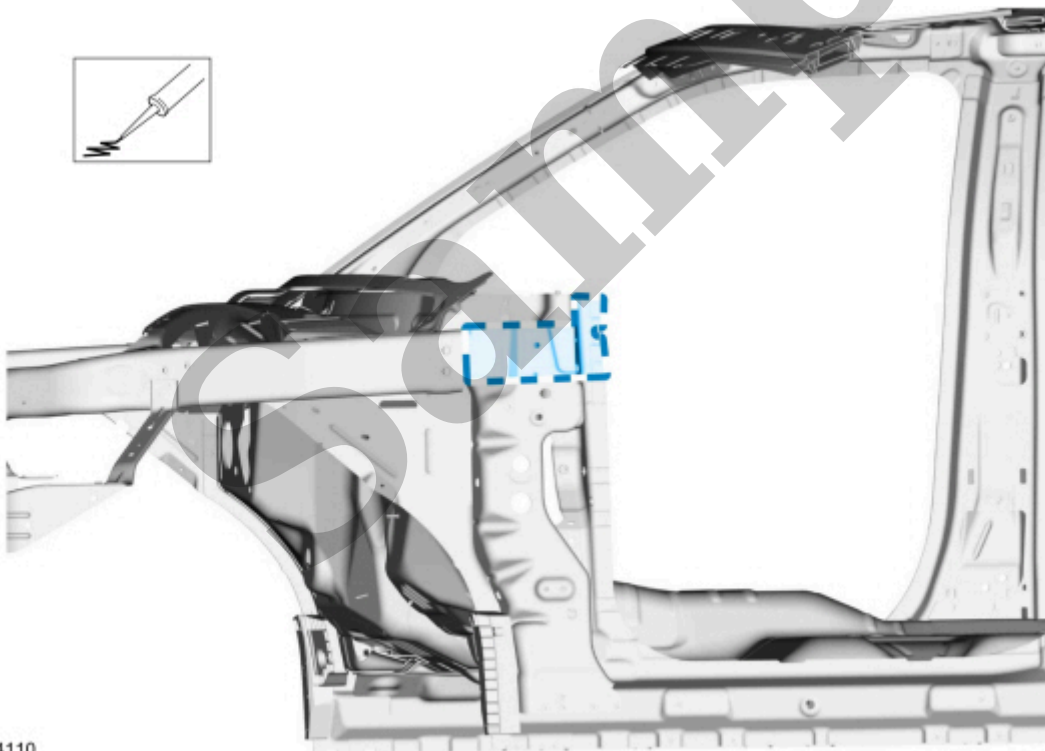


E194106

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7. Apply adhesive.

Material : Metal Bonding Adhesive / TA-1, TA-1-B, 3M™ 08115, LORD Fusor® 108B, Henkel Teroson EP 5055



E194110

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8. **NOTE**



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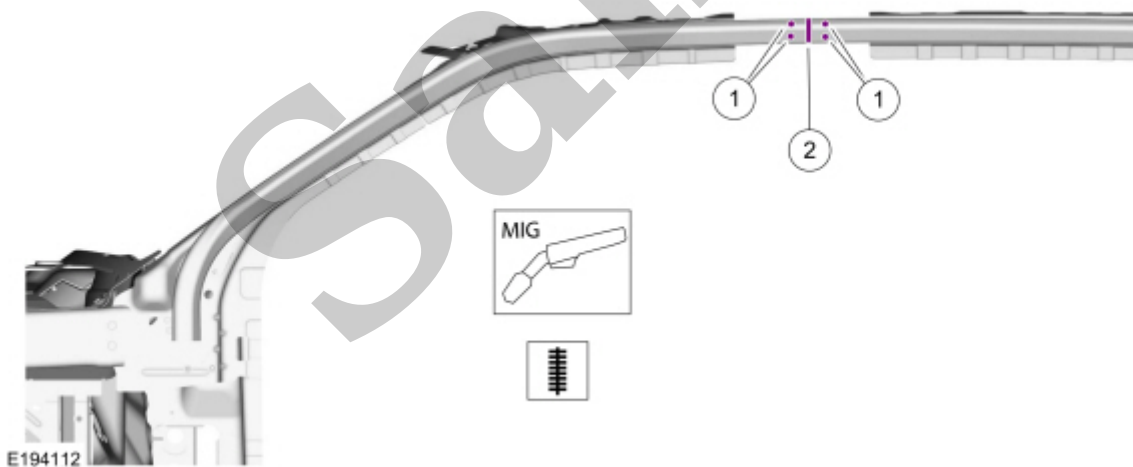
10. Weld as indicated.

- Install MIG (metal inert gas) plug welds.

Use the General Equipment: MIG/MAG Welding Equipment

- Entirely seam weld as indicated.

Use the General Equipment: MIG/MAG Welding Equipment



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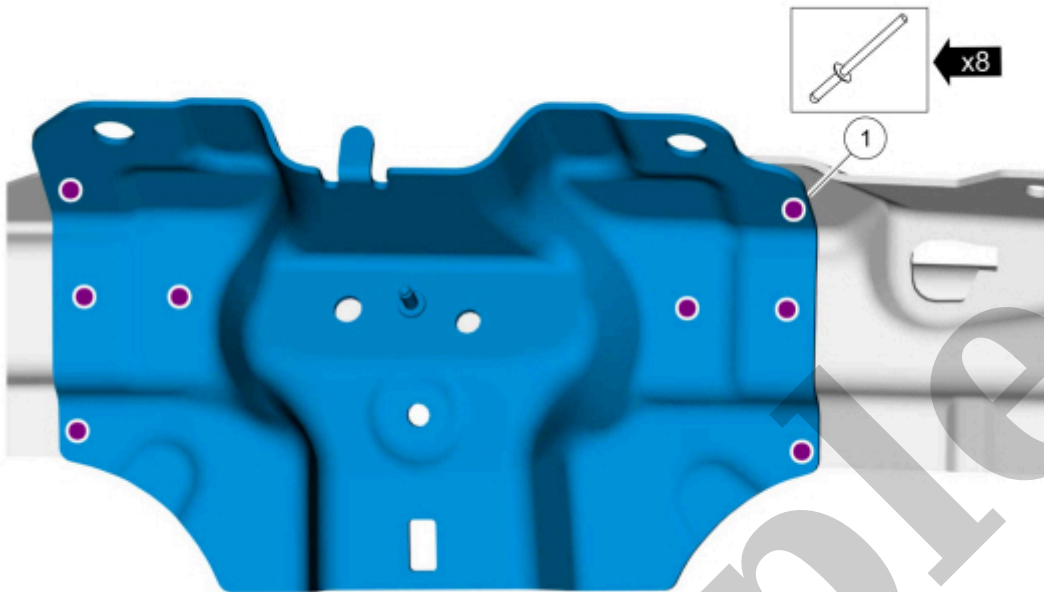
11. Metal finish as required using typical metal finishing techniques.

12. Install, clamp and drill side rail to B-pillar gusset as indicated.

Use the General Equipment: Locking Pliers

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

Use the General Equipment: Blind Rivet Gun



E194114

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14. Position the B-pillar inner panel, clamp and drill 6.5mm holes as indicated.

Use the General Equipment: Locking Pliers

Use the General Equipment: 6.5 mm Drill Bit

				0401			
2	-	-	-	-	W708777-S900C	-	-

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

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

Use the General Equipment: Blind Rivet Gun



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

16. Install the body side panel. Metal finish using typical metal finishing techniques.

Refer to: [Body Panel Sectioning](#)(501-26 Body Repairs - Vehicle Specific Information and Tolerance Checks, General Procedures).

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

17. Position the roof reinforcement assembly, clamp and drill 6.5mm holes as indicated.

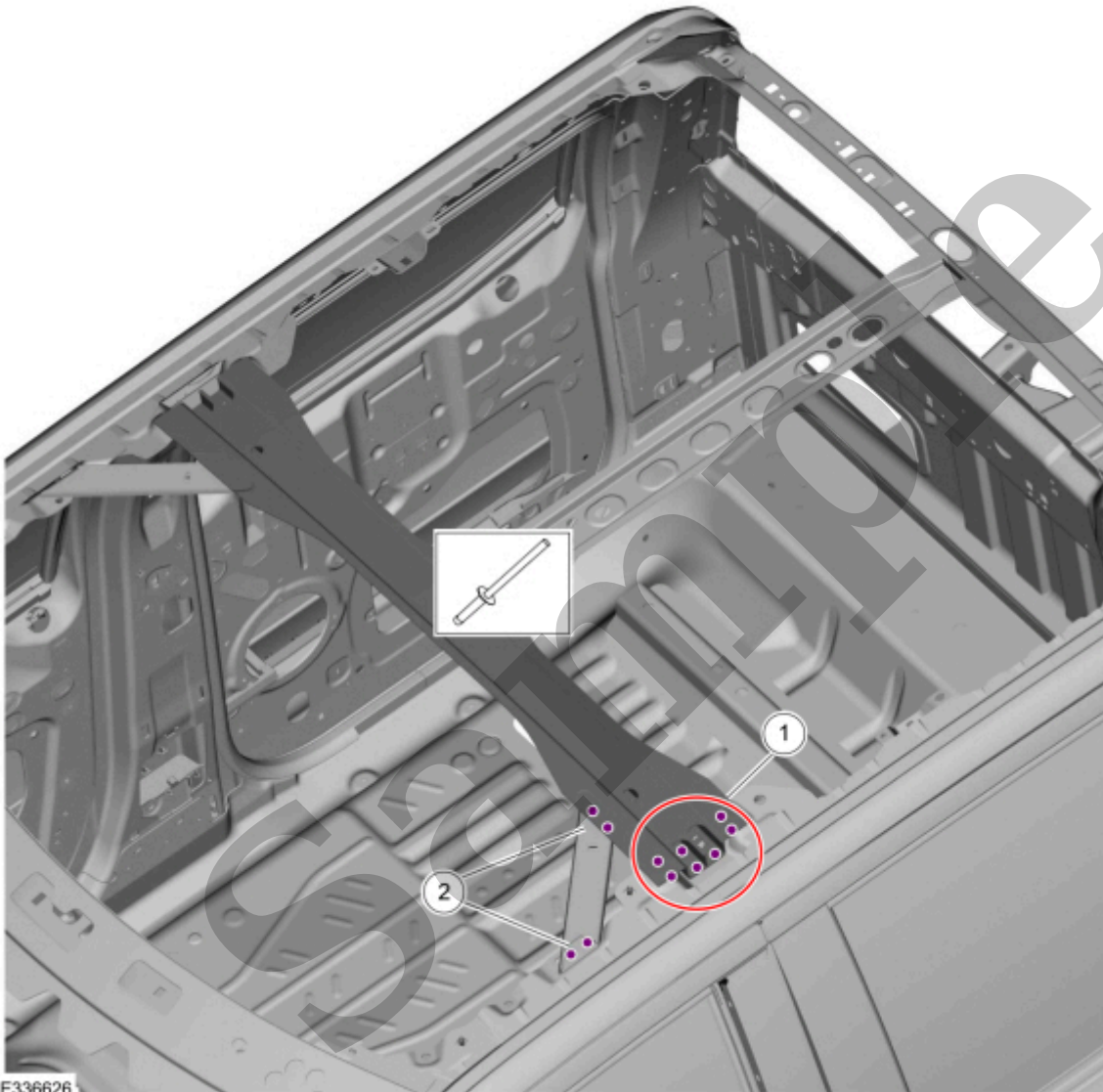
Use the General Equipment: Locking Pliers

Use the General Equipment: 6.5 mm Drill Bit

2	W717338-S900	EM	DP11- 225/H	-	-	-	-
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Refer to: [Joining Techniques](#)(501-25 Body Repairs - General Information, General Procedures).

Use the General Equipment: Blind Rivet Gun



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

19. Position the windshield header panel, clamp and drill 6.5mm holes as indicated.

Use the General Equipment: Locking Pliers

Use the General Equipment: 6.5 mm Drill Bit

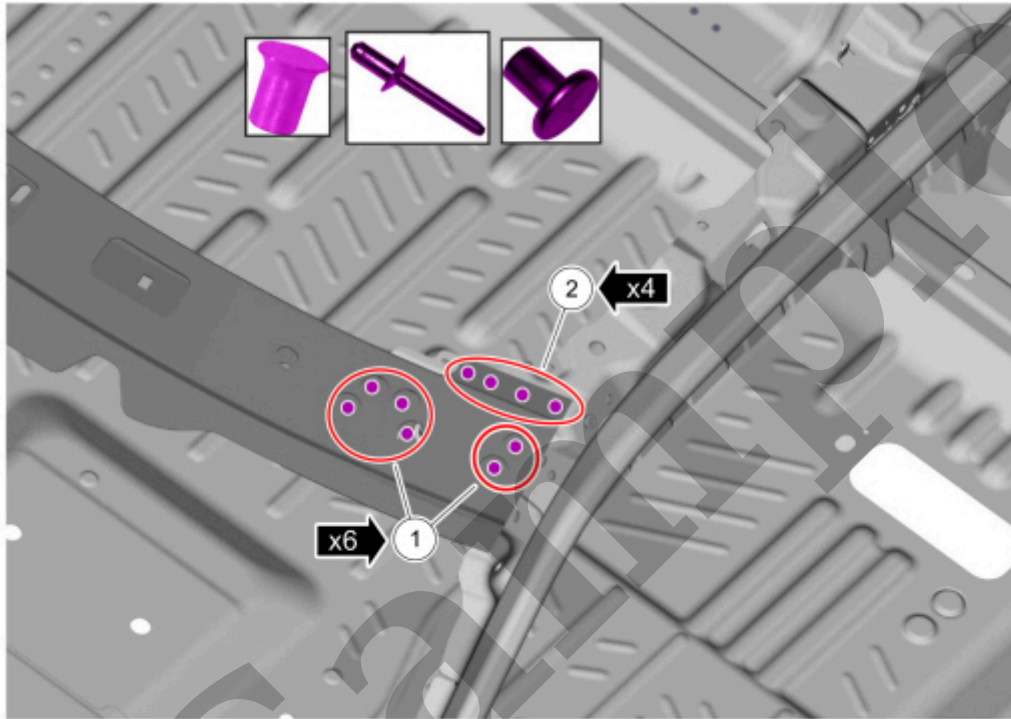
2	W710246-S900	BN	DP10-200/H	SA-0400/SA-0402	-	W790377-S900	-
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Refer to: [Joining Techniques](#)(501-25 Body Repairs - General Information, General Procedures).

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

Use the General Equipment: Blind Rivet Gun

Use the General Equipment: Blind Rivet Gun



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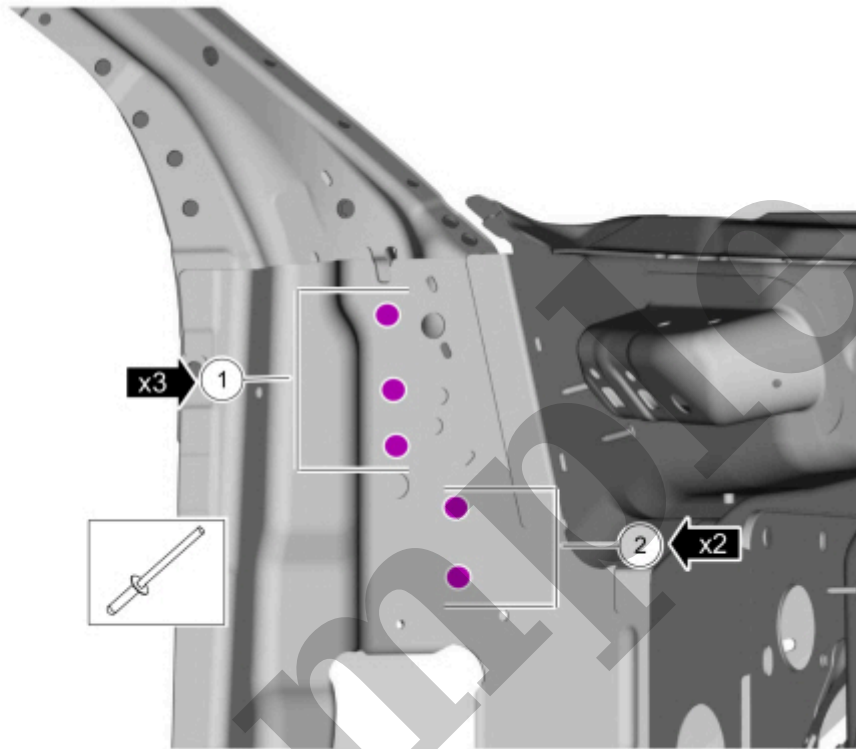
21. Drill the five 6.5mm holes as indicated.

Use the General Equipment: 6.5 mm Drill Bit

2	-	-	-	-	W708777- S900C	-	-
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Refer to: [Joining Techniques](#)(501-25 Body Repairs - General Information, General Procedures).

Use the General Equipment: Blind Rivet Gun



E192617

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23. Install the cross-car beam bracket and the bolts.

Torque : 18 lb.ft (25 Nm)