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2017 FORD Ranger Super Cab OEM Service and Repair Workshop Manual

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Roof Side Rail - SuperCrew

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

Roof Side Rail - SuperCrew

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.

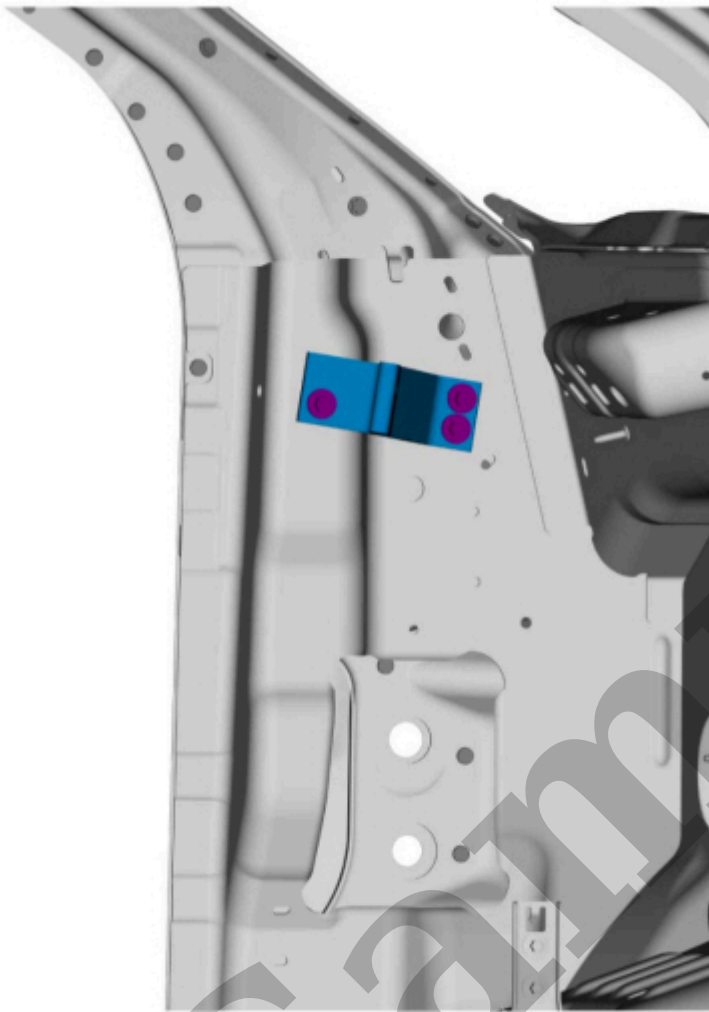
1. WARNING

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).

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

10. Remove the 3 bolts and the cross-car beam bracket.



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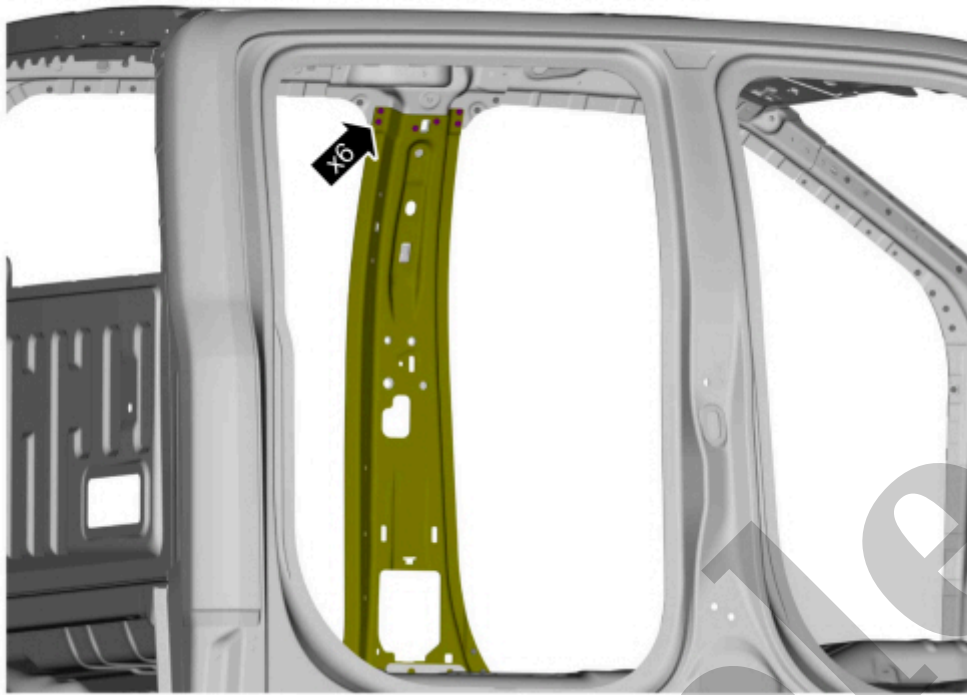
[Click here to learn about symbols, color coding, and icons used in this manual.](#)

11. .

Remove and discard the FDS (flow drill screw) fasteners

Use the General Equipment: Polydrive Bit Socket

E192601



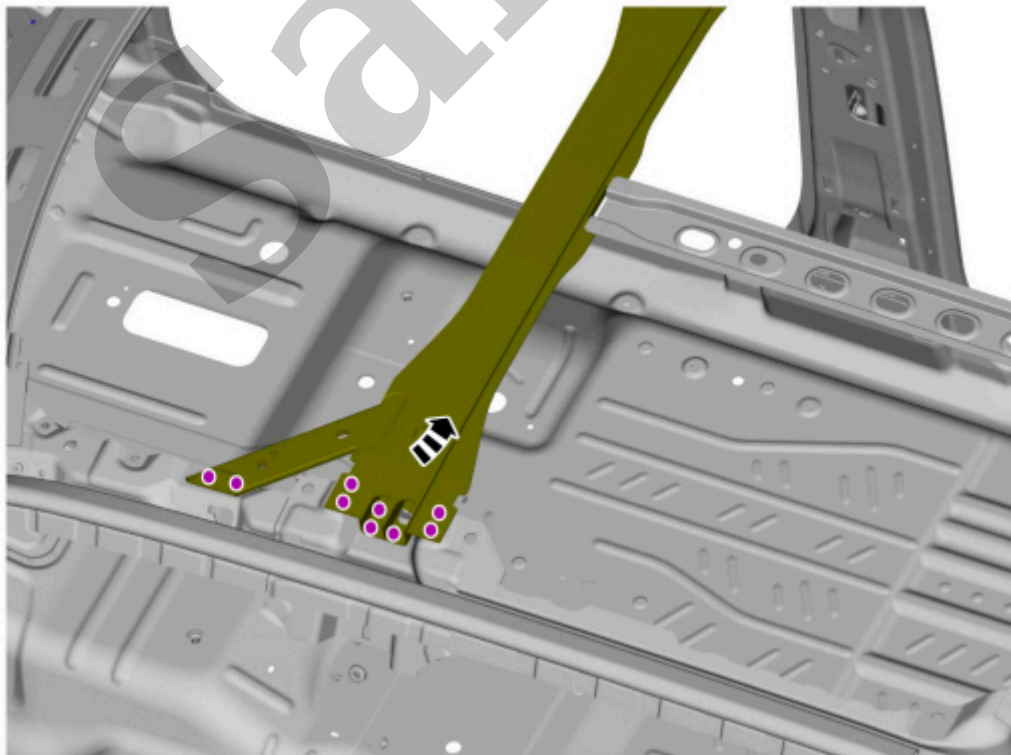
[Click here to learn about symbols, color coding, and icons used in this manual.](#)

15. Remove the SPR (self-piercing rivet) fasteners and position aside the roof panel reinforcement.

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

Use the General Equipment: Belt Sander

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18. Remove the SPR (self-piercing rivet) fasteners on the C-pillar inner panel.

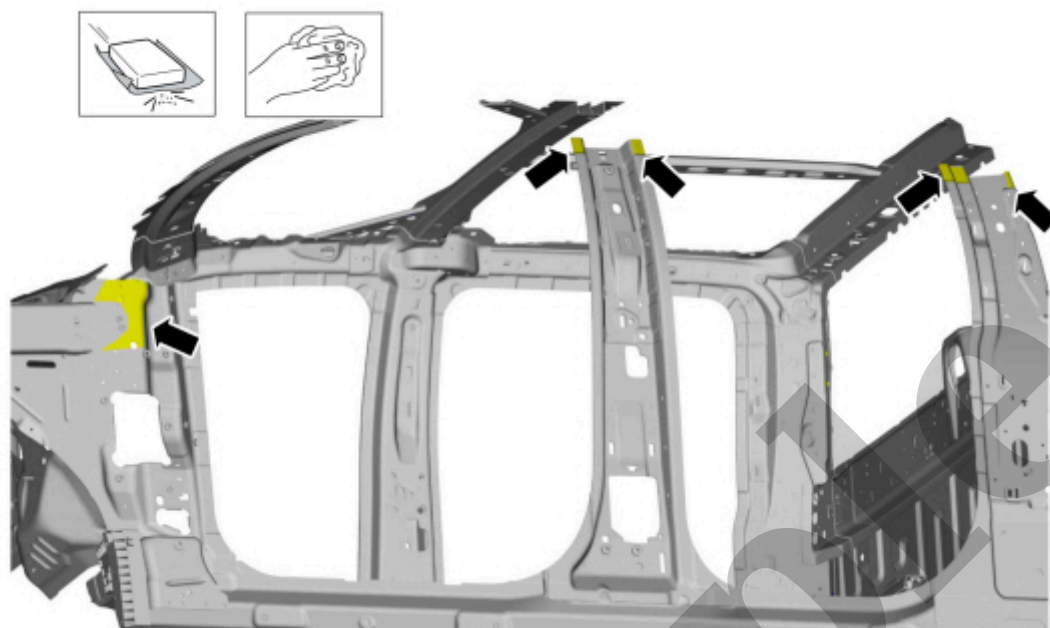
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer

Use the General Equipment: Belt Sander



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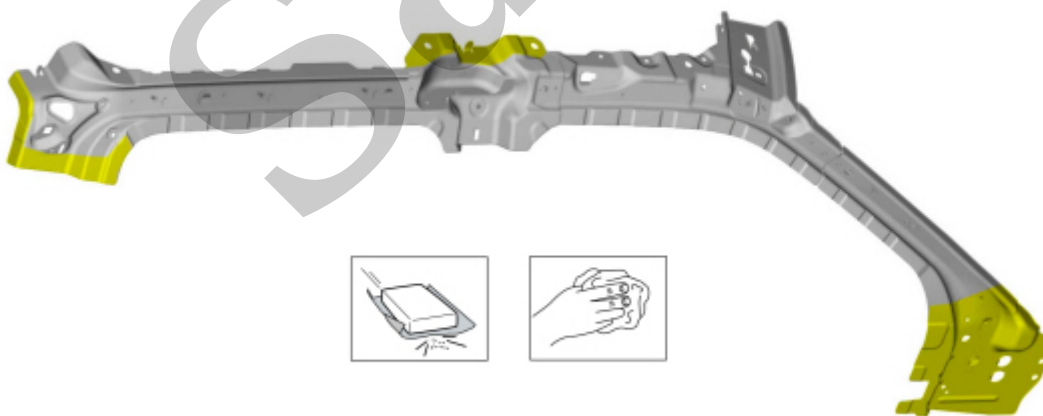
1. Sand to remove all remaining adhesive on the body side to roof mating surfaces using 80 grit sandpaper and clean.



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

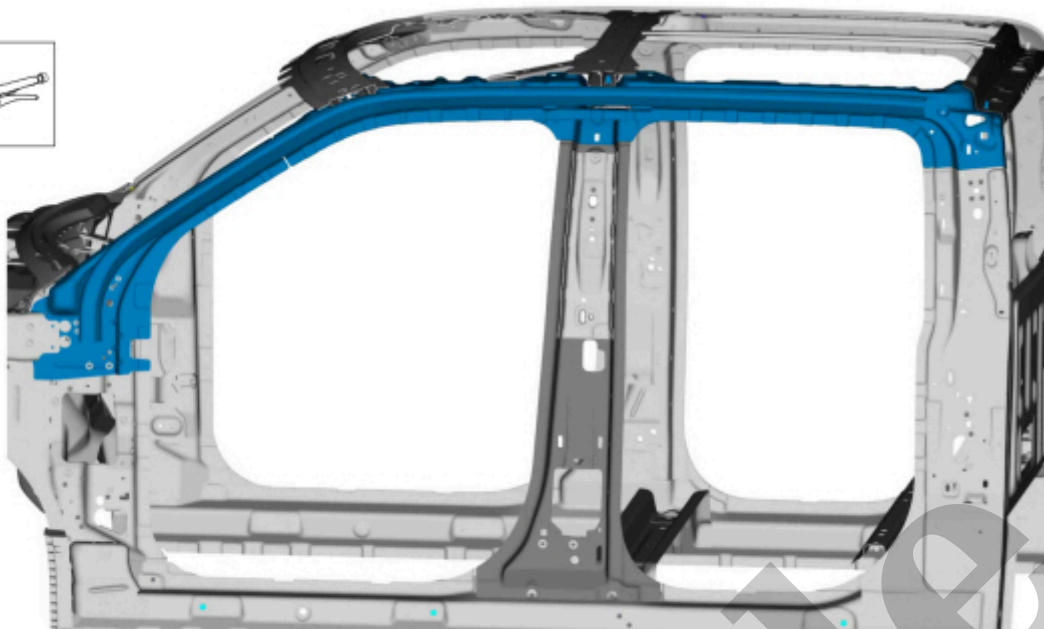
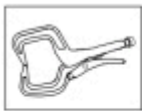
2. Sand to remove e-coat on the roof rail to body side roof mating surfaces using 80 grit sandpaper and clean.



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3. Apply adhesive.



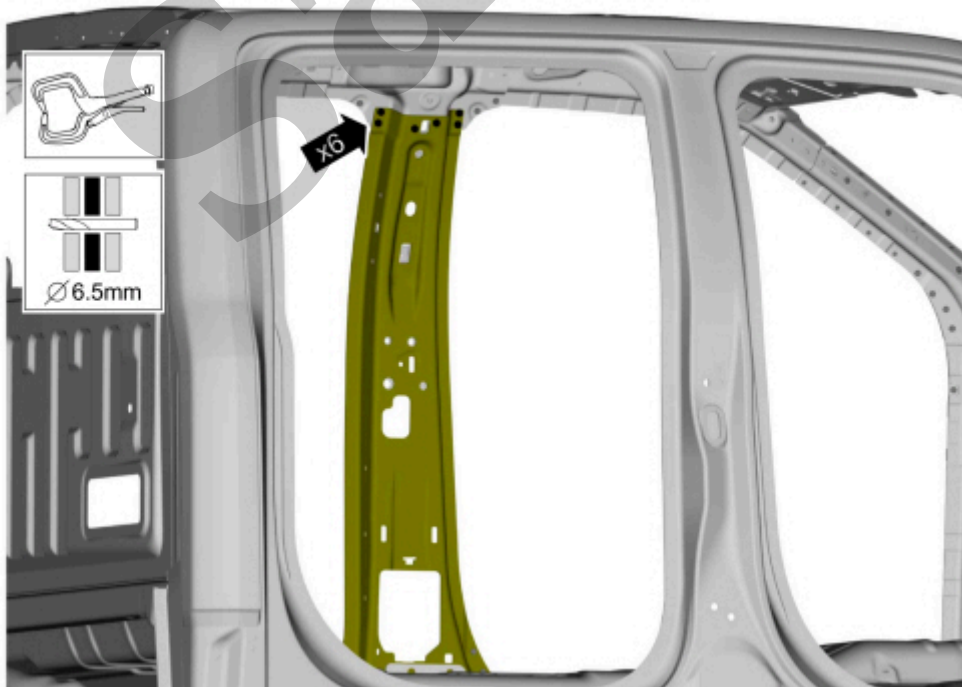
E192610

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

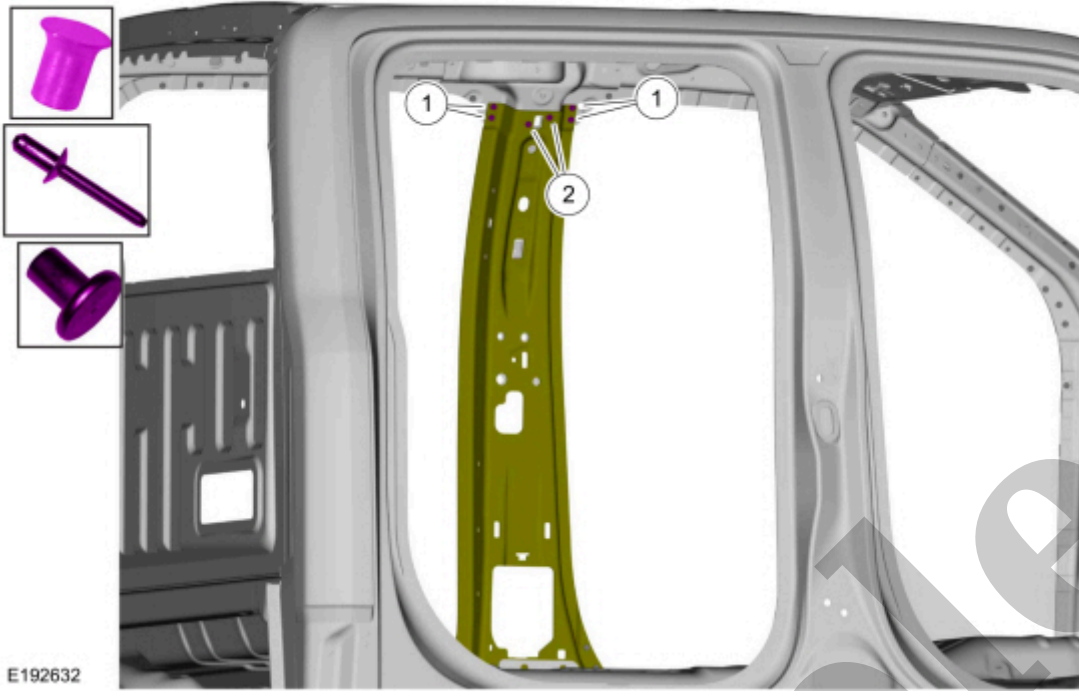
5. Reposition the B-pillar inner panel, clamp and drill for blind fasteners.

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

Use the General Equipment: 6.5 mm Drill Bit



E192611

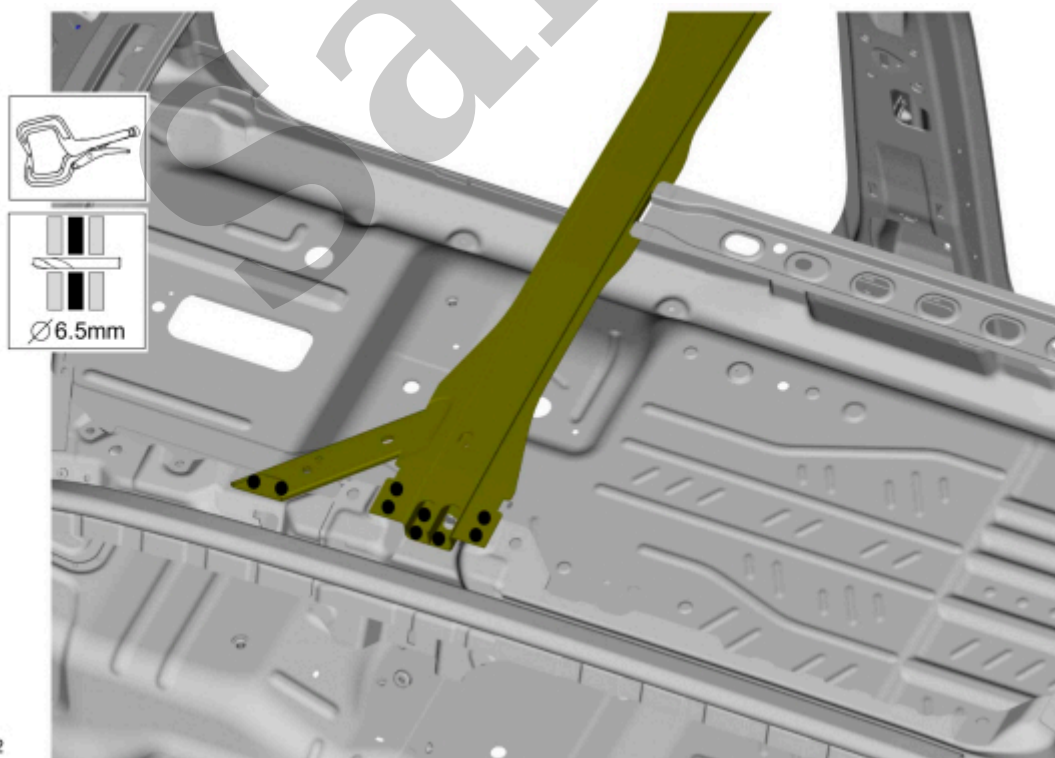


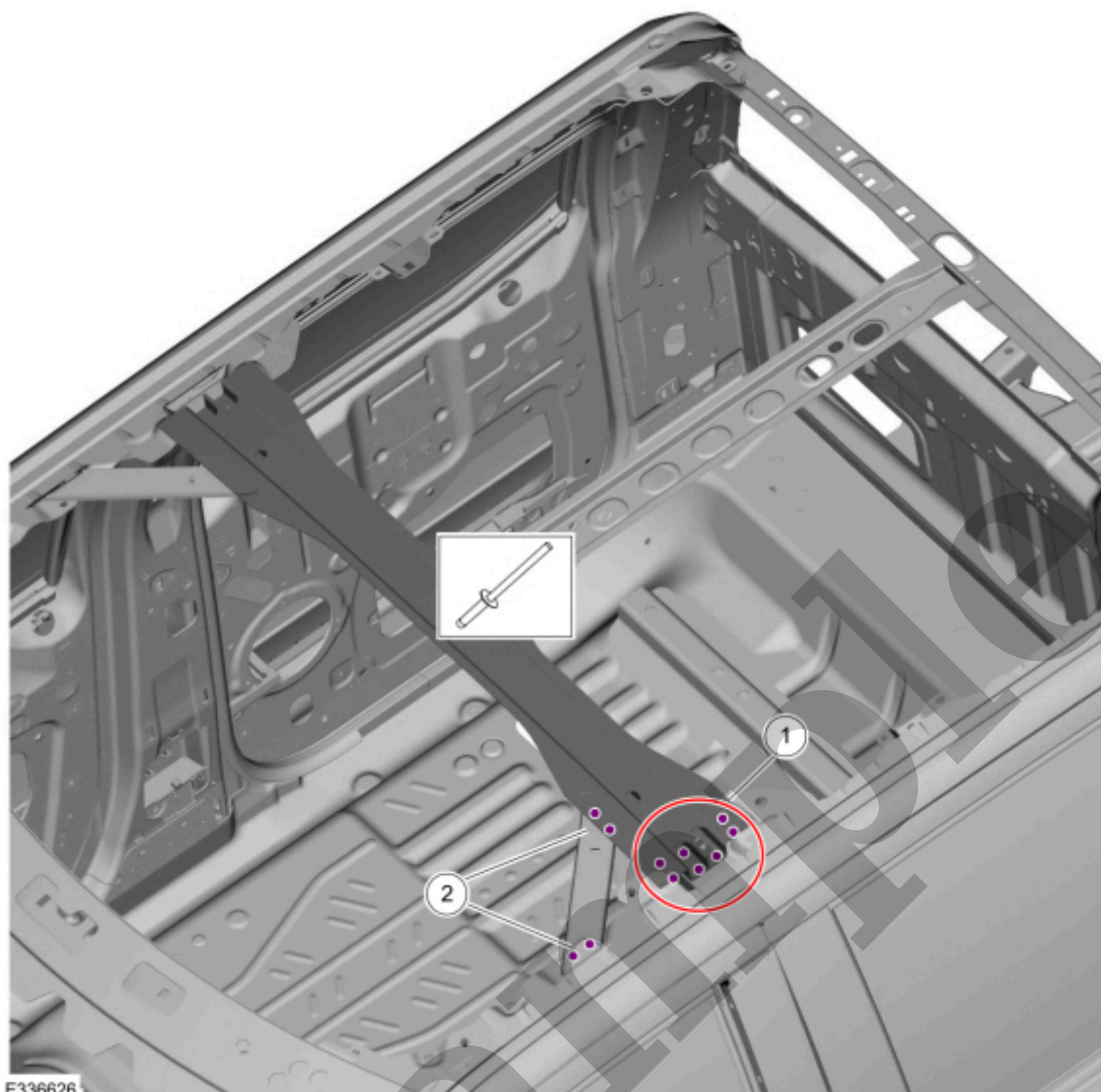
[Click here to learn about symbols, color coding, and icons used in this manual.](#)

7. Position, clamp and drill the roof reinforcement assembly.

Use the General Equipment: Locking Pliers

Use the General Equipment: 6.5 mm Drill Bit





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

9. Position the windshield header panel, clamp and drill as indicated.

Use the General Equipment: Locking Pliers

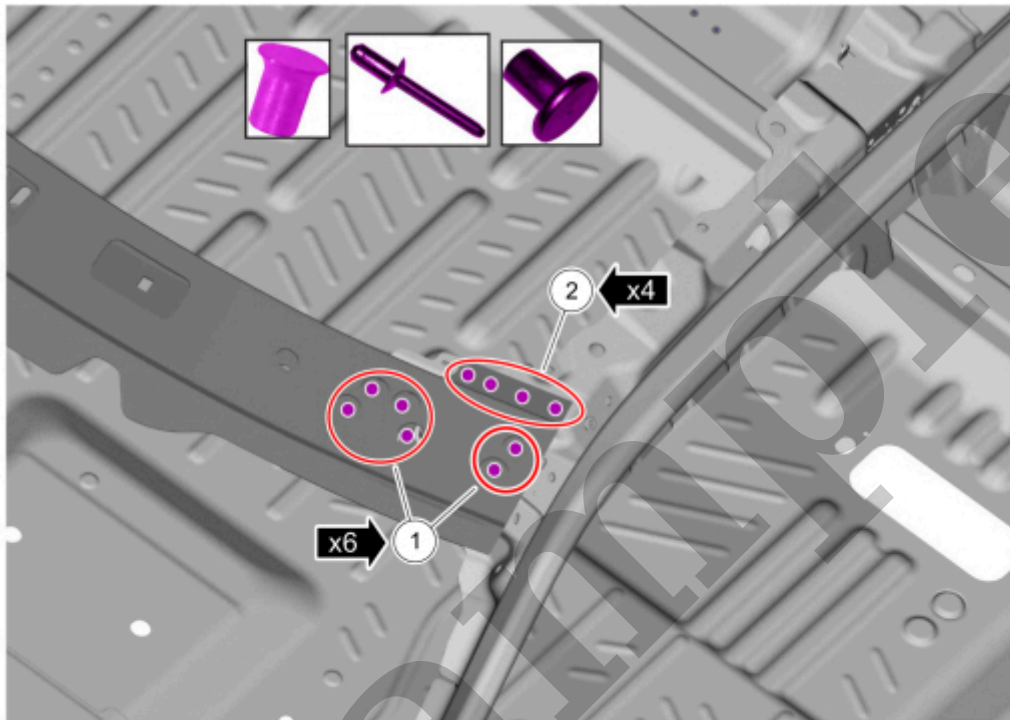
Use the General Equipment: 6.5 mm Drill Bit

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



E192615

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

11. Position, clamp and drill the C-pillar inner panel as indicated.

Use the General Equipment: Locking Pliers

Use the General Equipment: 6.5 mm Drill Bit