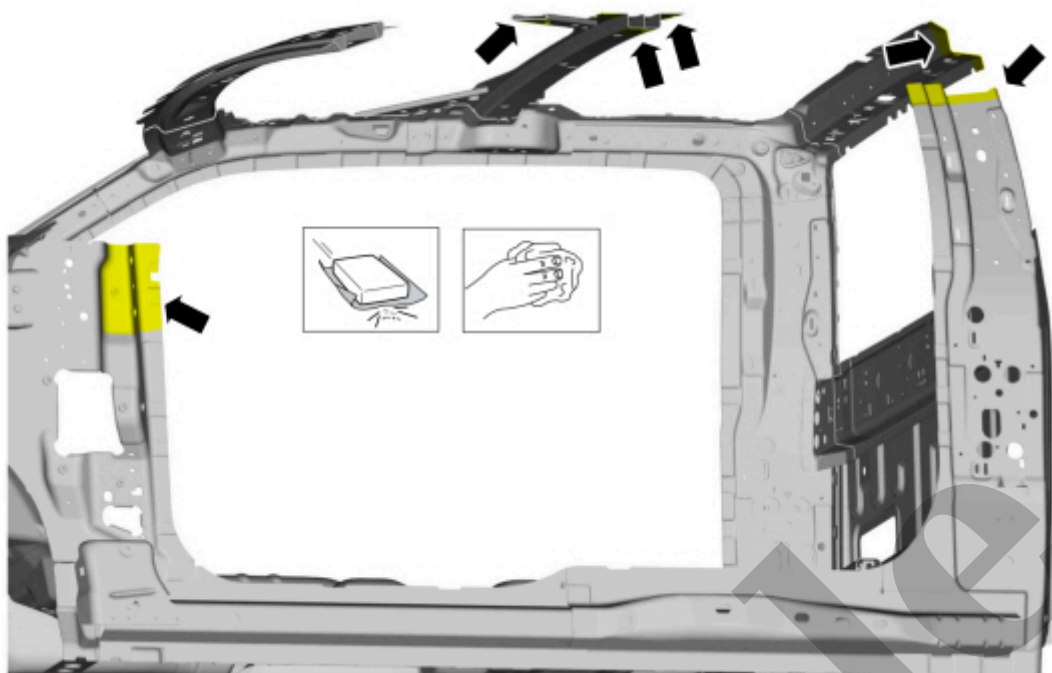


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## 2018 FORD Ranger Super Cab OEM Service and Repair Workshop Manual

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E193269

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2. Sand to remove e-coat using 80 grit sandpaper and clean.



E193270

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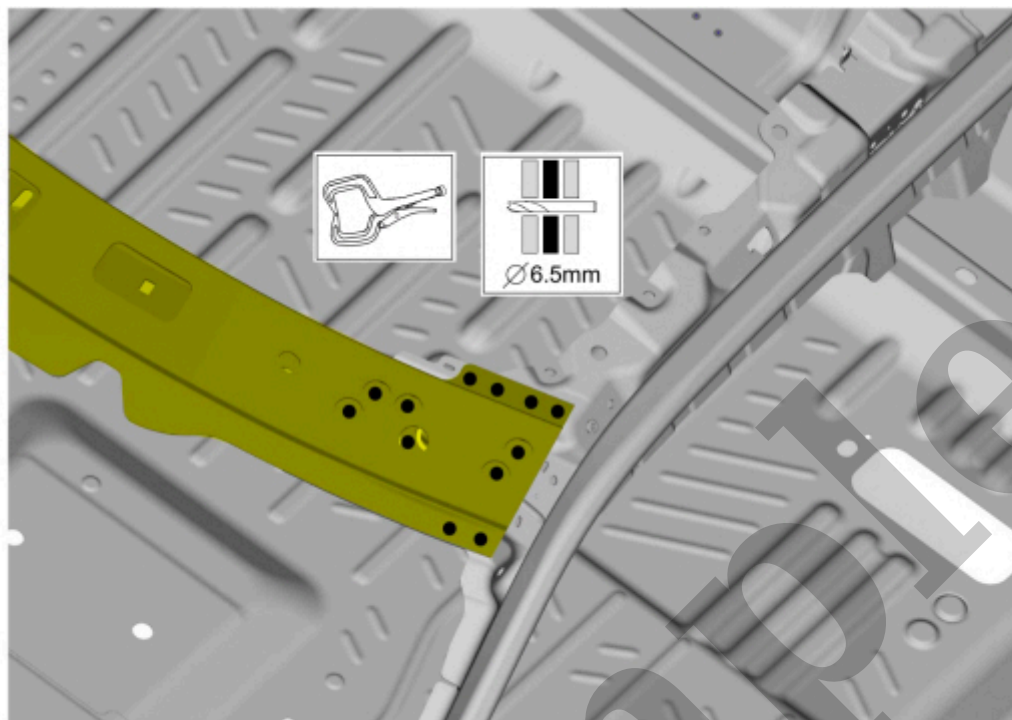
3. Apply adhesive.

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

5. Position the windshield header panel, clamp in position and drill as indicated.

Use the General Equipment: Locking Pliers

Use the General Equipment: 6.5 mm Drill Bit



E192614

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**6. NOTE**

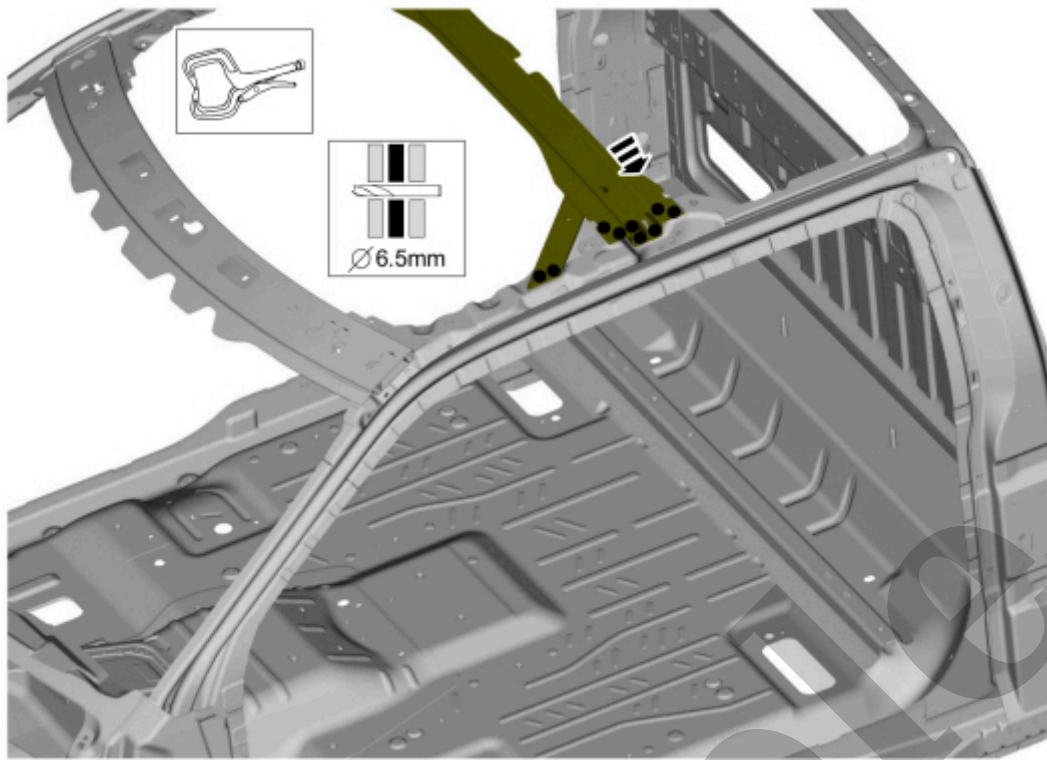
SPR (self-piercing rivet) fasteners may not be placed directly over original SPR (self-piercing rivet) location. They must be placed adjacent to original location matching original quantity.

**NOTE**

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

Install the fasteners.

Item	SPR (self-piercing rivet) Number	SPR (self-piercing rivet) Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
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**8. NOTE**

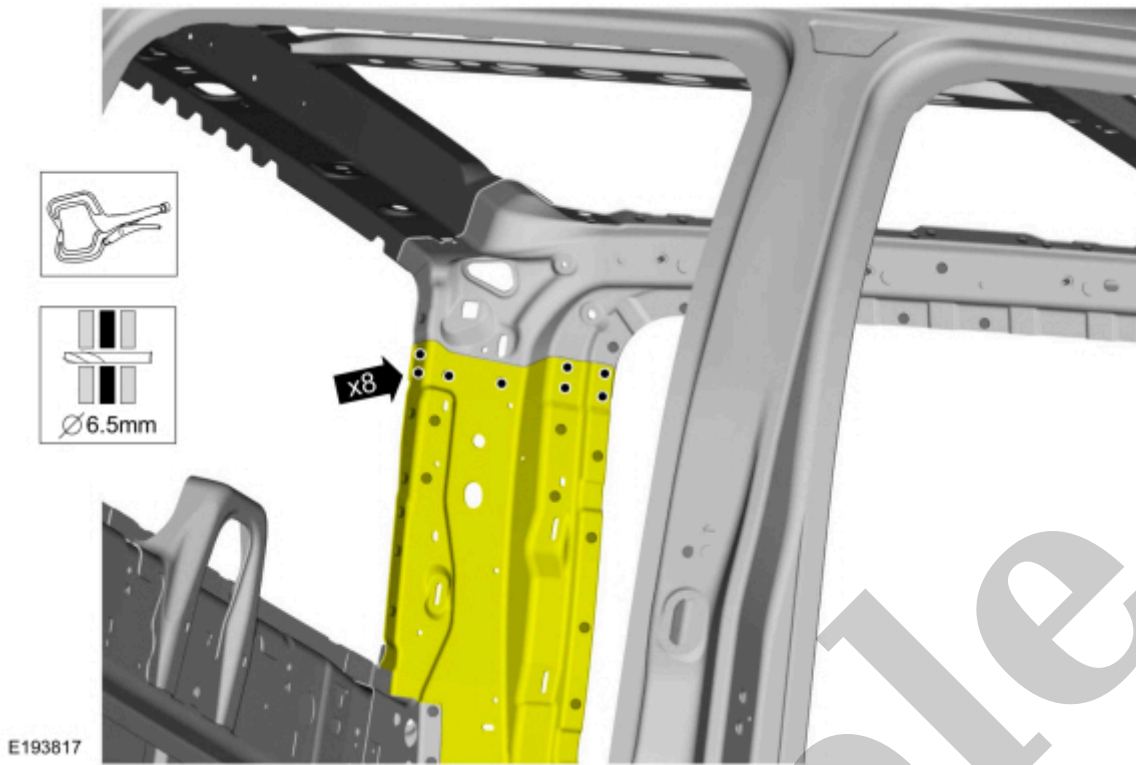
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Install the fasteners.

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	-	-	-	-	W708777-S900C	-	-



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**10. NOTE**

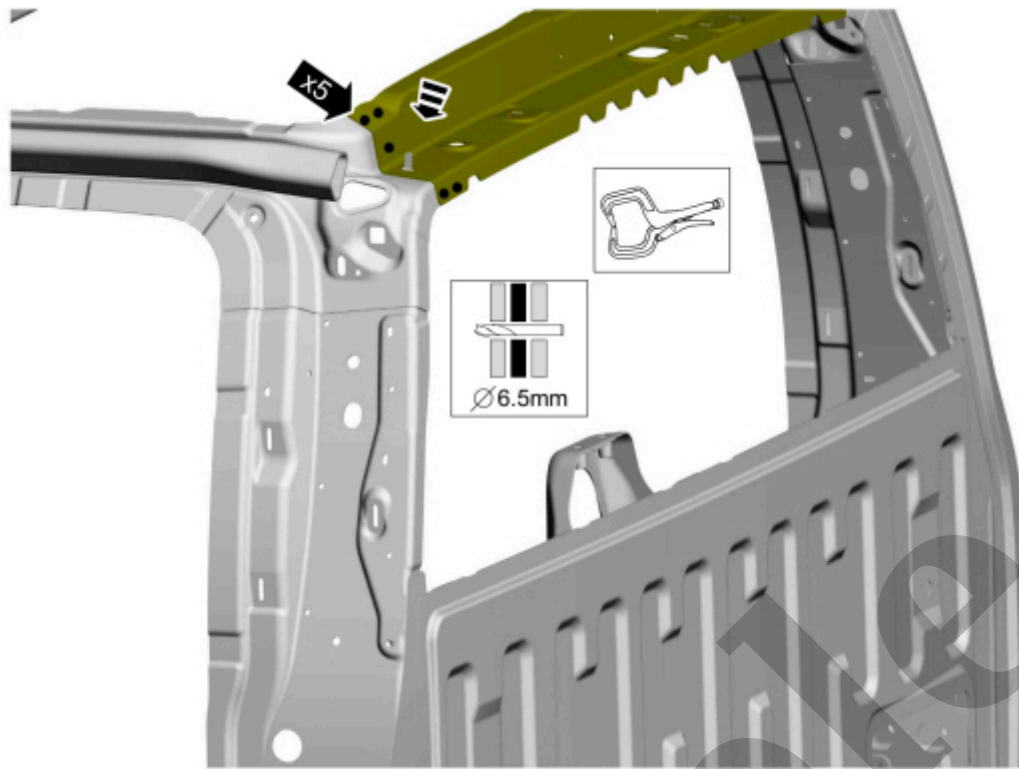
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Install the fasteners.

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1	-	-	-	-	W708777-S900C	W702512-S900	-



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**12. NOTE**

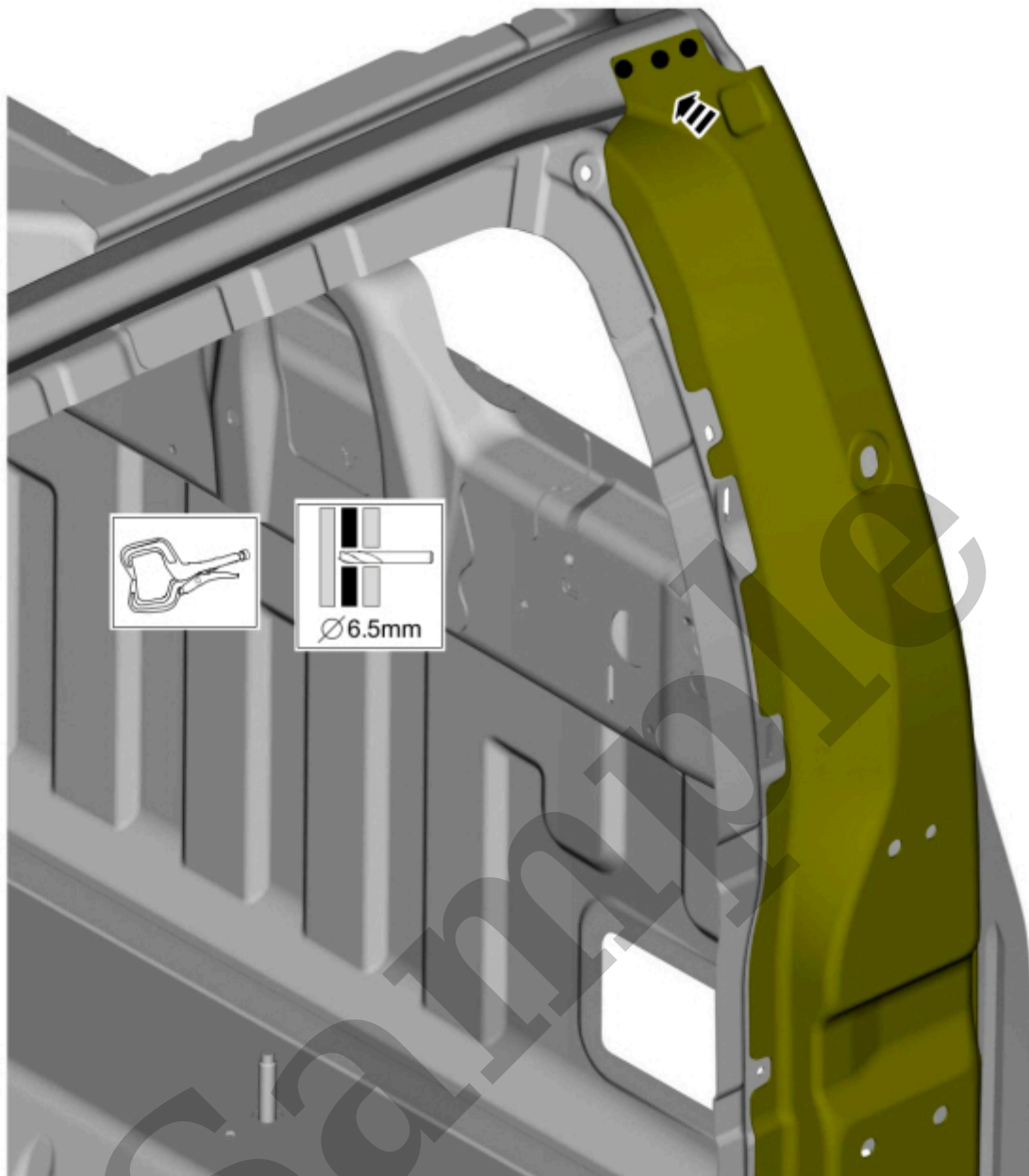
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Install the fasteners.

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	-	-	-	-	W707638-S900C	-	-



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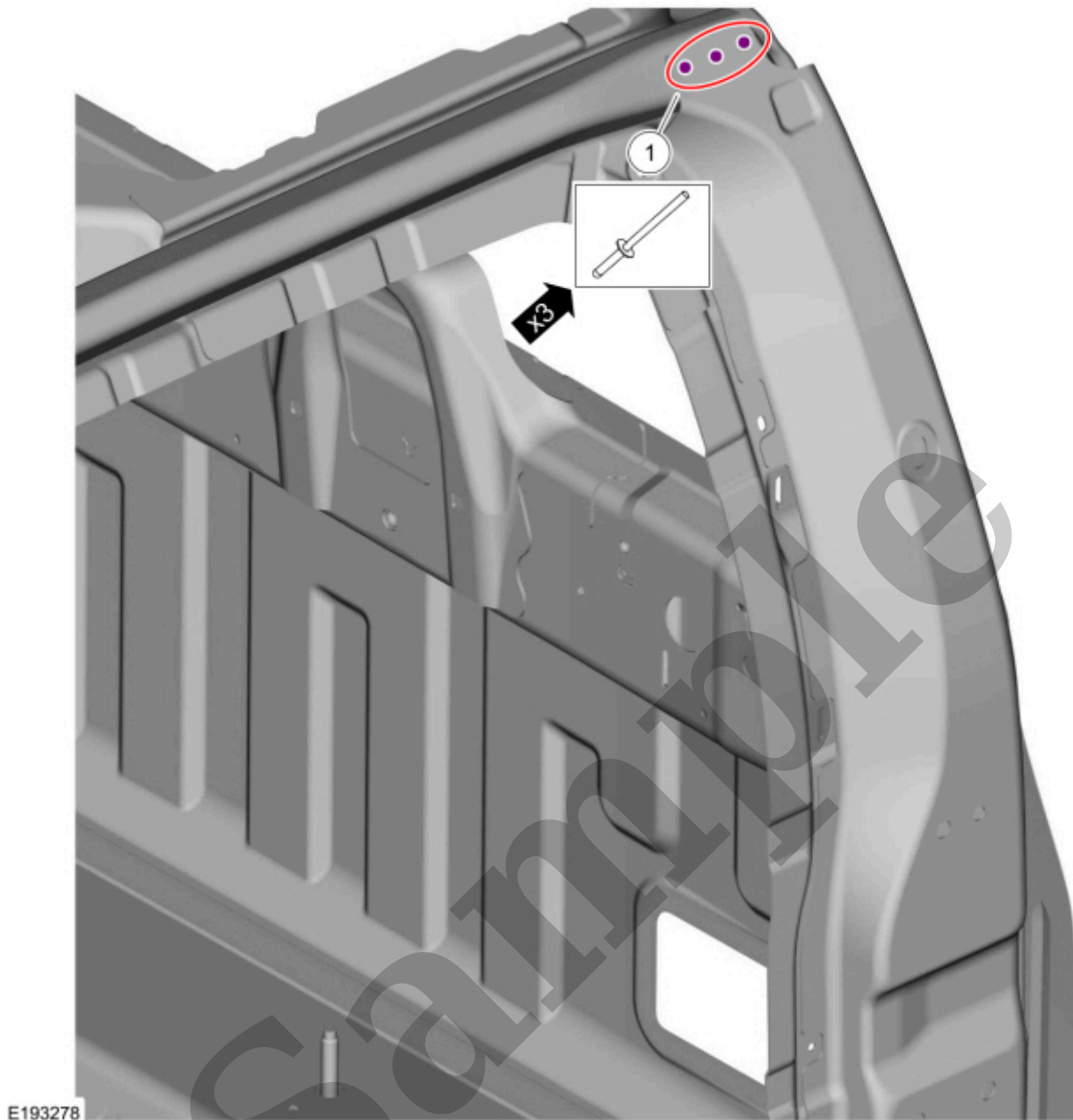
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14. **NOTE**

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 rivet fasteners may be used in place of SPR (self-piercing rivet) fasteners in



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15. Install the A-pillar reinforcement.

Refer to: [A-Pillar Outer Panel Section and Reinforcement](#)(501-29 Side Panel Sheet Metal Repairs, Removal and Installation).

16. Install the body side outer panel.

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).



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

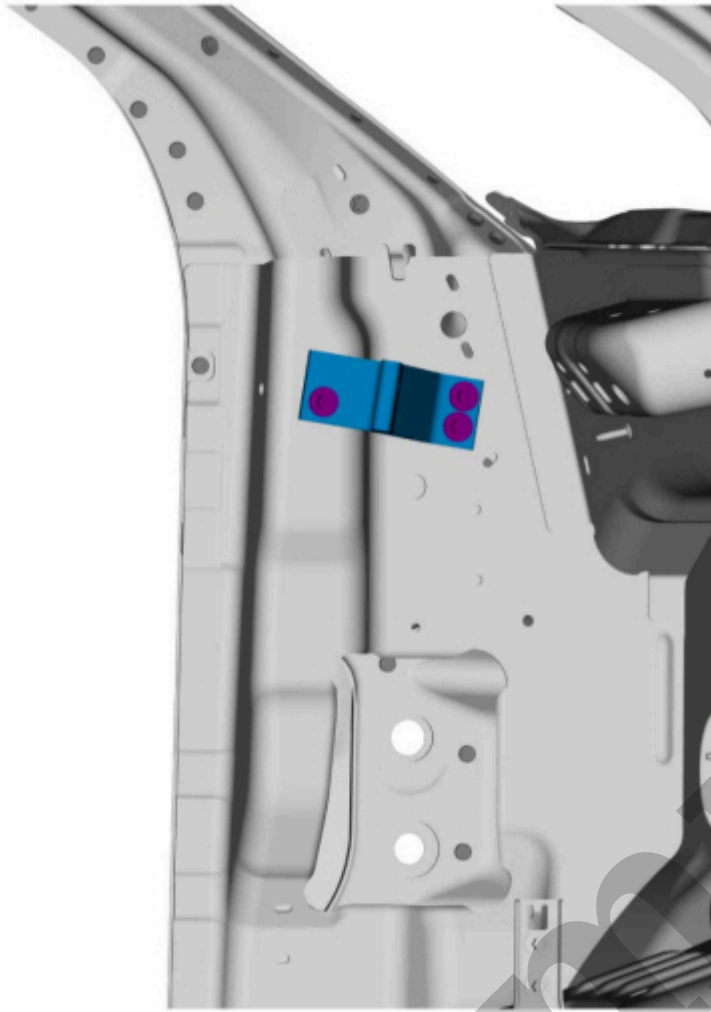
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1	-	-	-	-	W702512-S900C	-	-
2	-	-	-	-	W708777-S900C	-	-

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

Use the General Equipment: Blind Rivet Gun



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24. Install the instrument panel.

Refer to: [Instrument Panel](#)(501-12 Instrument Panel and Console, Removal and Installation).

25. Install the front and rear doors.

Refer to: [Front Door - SuperCab](#)(501-03 Body Closures, Removal and Installation).

Refer to: [Rear Door - SuperCab](#)(501-03 Body Closures, Removal and Installation).

26. Install the fender.

Refer to: [Fender](#)(501-02 Front End Body Panels, Removal and Installation).

Refer to: [Fender Splash Shield](#)(501-02 Front End Body Panels, Removal and Installation).

27. Align the doors.

Refer to: [Front Door Alignment - SuperCab](#)(501-03 Body Closures, General Procedures).