

F-SERIES CREW CAB FLOOR PAN INSTALLATION - SERVICE KIT INSTRUCTIONS

KIT		
Part Number	Description	Quantity
FL34-1611140-AH	Crew Cab Panel Floor	1
SKFL34-1611140-AA	Instruction Sheet	1

NOT INCLUDED IN KIT (PROCURE LOCALLY)		
Part Number	Description	Quantity
W702512-S900C	Blind Rivets	210
W708777-S900C	Blind Rivets	58
W702554-S900C	Blind Rivets	18
W707638-S900C	Blind Rivets	As Needed
W716819-S450	Pierce Nut M8	5
Motorcraft TA-1, 3M 8115 or Fusor 108B	Metal Panel Bonding Adhesive	1

SERVICE GUIDELINES:

- Aluminum repairs should be performed in an area protected from steel working areas, and tools used in aluminum repair should be quarantined from steel repair tools.
- Replacement Self-Piercing Rivets (SPRs) are the preferred replacement during repair for original SPR locations, where feasible. Blind rivets are the next preferred replacement for original SPRs. In some cases, solid rivets may also be used as a replacement for SPRs. The figures will explicitly call out which rivets are possible.
- Replacement SPRs are to be installed adjacent to original SPR location.

NOTE: Do not install replacement SPR in original SPR hole.

- Blind rivets may be installed in original SPR holes, after they are reamed out to 6.5mm. Be sure to grind all surfaces of the flange smooth prior to blind rivet installation in original SPR locations.
- Flow Drill Screws (FDS) are to be replaced by blind rivets only. The original location of the FDS is used, but reamed out to 6.5mm.
- Rivets may be removed by drilling, grinding, or SPR gun set up as a rivet removal tool.
- Using heat (not exceeding 425 °F) to loosen a rivet bonded panel should only be done when all panels in the joint will be replaced or separated and new adhesive applied.
- Flange preparation for adhesive is to grind to clean metal with 80-120 grit, clean, and then apply the adhesive, spreading it out with an acid brush, covering any exposed aluminum.
- Clecos are an excellent way to hold the panels into position when fitting and drilling rivet holes.

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FIGURE 1 RIVET LOCATIONS

NOTE: The following are common between all cab styles.

- **Black squares represent the location of the rivets (W708777-S900C)**
 - Eight (8) rivets (four (4) per side) to the reinforcements (15113A46/7) and the #2 crossmember (15/1610598)
 - Twelve (12) rivets (six (6) per side) to sled runner (1510370/1) and torque box extension (1510024/5)
 - Two (2) rivets (one (1) per side) to #1 crossmember (1510684) and sled runner (1510370/1)
 - Ten (10) rivets (five (5) per side) to #1 crossmember (1510684) and torque box extension (1510024/5)
 - Four (4) rivets (two (2) per side) to torque box (1510414/5) and sled runner (1510370/1)
 - Sixteen (16) rivets (eight (8) per side) to dash (1501610) and torque box (1510414/5)
 - Six (6) rivets (three (3) per side) to floor tunnel and torque box (1510414/5)
- **Black dots represent the location of the rivets (W702554-S900C)**
 - Eighteen (18) rivets, (nine (9) per side) next to oval slot go to the torque box (1510414/5) and torque box extension (1510024/5).

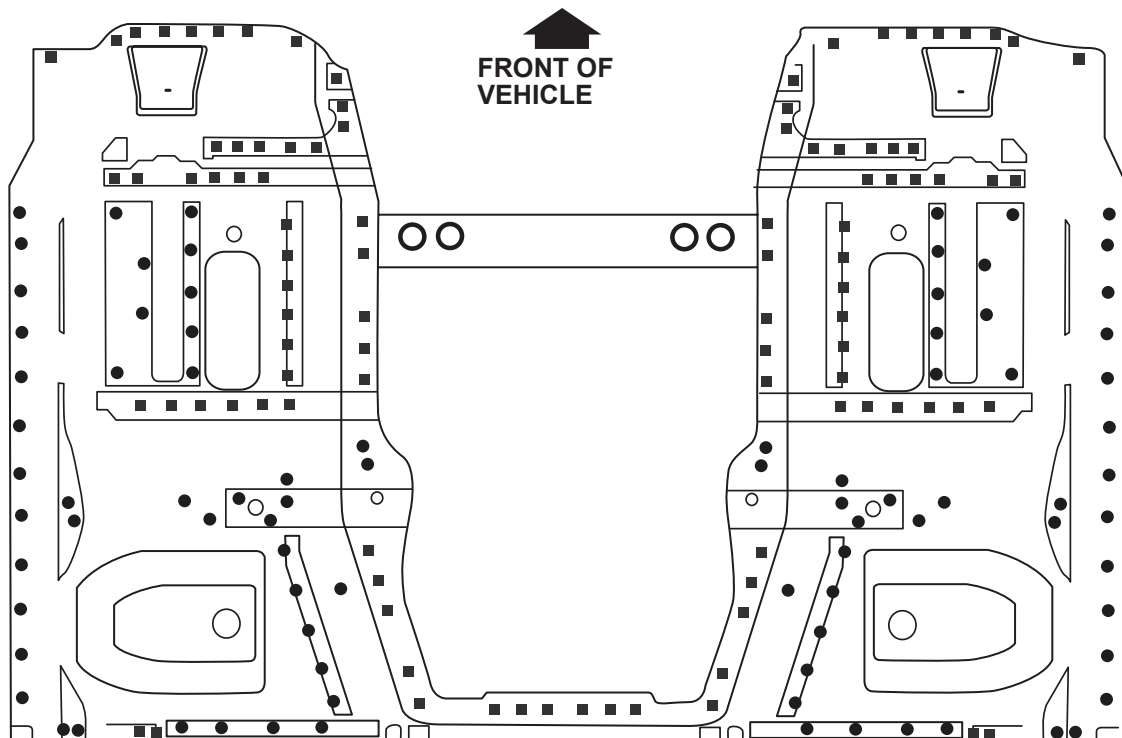


FIGURE 1

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FIGURE 2 RIVET LOCATIONS

- Black dots represent the location of the rivets (W702512-S900C) sixty-six (66) (thirty-three (33) per side) rivets to side sill.
 - Forty (40) rivets to the rear sill (16107A94)
 - Thirty (30) rivets to the #4 crossmember
 - Thirty Four (34) rivets to the #2 crossmember (1610598)
 - Twelve (12) (six (6) per side) to the #1 crossmember (1510692)
 - Ten (10) rivets (five (5) per side) to the sled runners (1510370/1)
 - Eighteen (18) rivets (nine (9) per side) to the torque box extension (1510024/5)
 - (Refer to Figure 3) for the floor pan tunnel on page 4 for the location and number of rivets.
- Black stars represent the five (5) pierce nuts (W716819-S450) used to secure the jack, sub-woofer and amp as needed.

NOTE: See the floor pan tunnel instruction sheet SKFL34-1511170-AA for the location and number of rivets required between them.

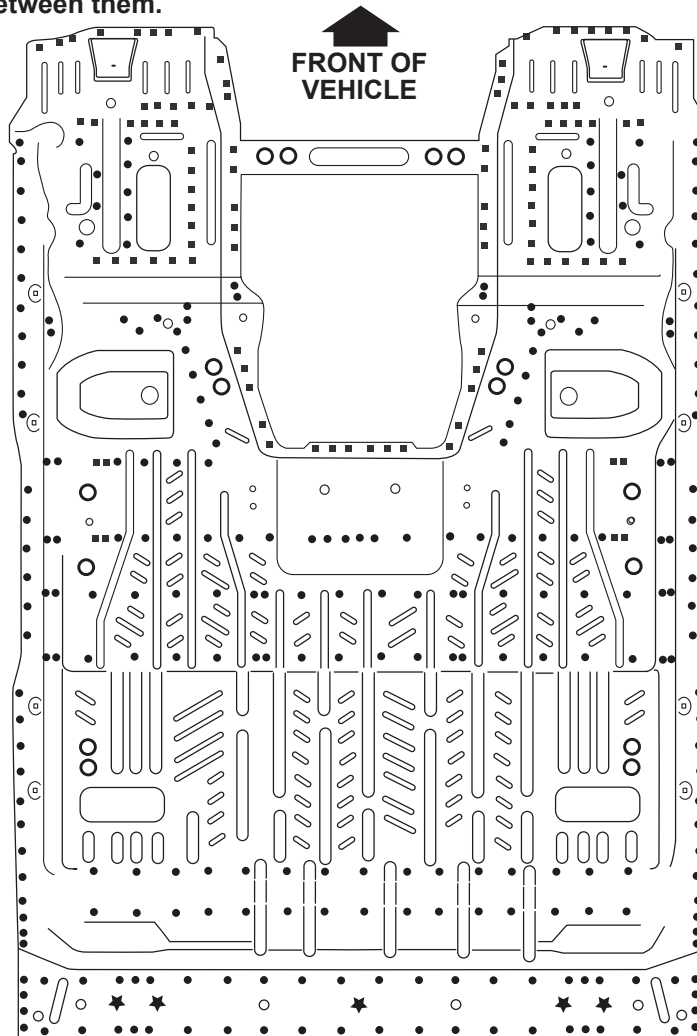


FIGURE 2

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- (Refer to Figure 5) for location for adhesive material.

NOTE: The location of SPR and adhesive shown below are based on the original production drawings and should only be used as a guideline. (Refer to Figure 5).

BLACK WAVY LINES
REPRESENT THE
LOCATION OF THE
ADHESIVE MATERIAL

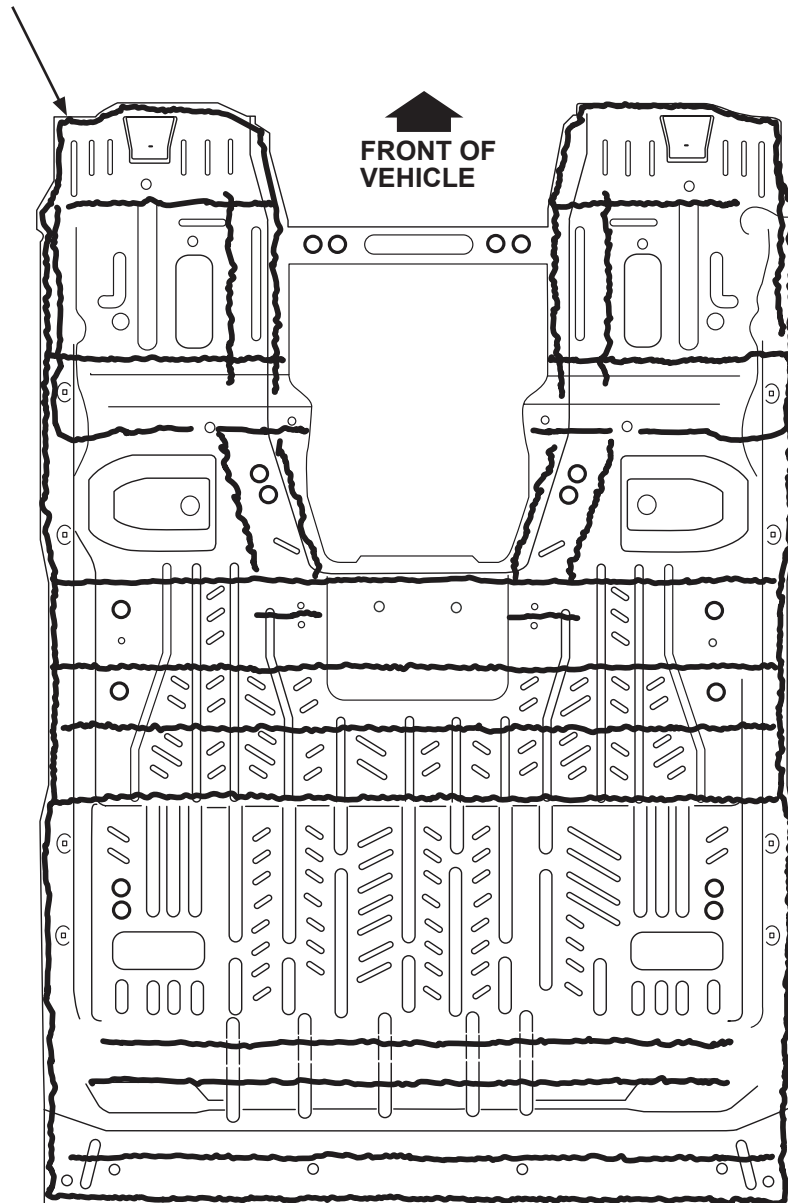


FIGURE 5

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SECTIONING OF THE FLOOR PAN

NOTE: Partial sectioning of the floor pan is allowed, based on technician judgement and extent of damage. For a robust and proper repair, the following criteria must be met:

- The damaged area is measured and pulled/restored back to original dimensional condition.
- The repair area must be at least 50mm away from the seat mounting track locations on the floor pan.
- The repair panel must be installed to crossmembers/sills/rockers using the specified rivet patterns and rivet type/sizes. (Refer to Figures 1 - 3).
- At least a 1" overlapping flange is maintained between the repair and original repair panels.
- The repair panel flange must be prepared and adhesive fully applied as per the general information guidelines.
- The repair flange rivets are Blind Rivets (W707638-S900C). The number of blind rivets used depends on the size of the repair panel. The rivets must be installed no further than 3" apart around entire repair panel.
- After installation of the repair panel is complete, follow all sealing, refinish, and corrosion protection steps required.

