

501-30 Rear End Sheet Metal Repairs  
Removal and Installation

2021 F-150

Procedure revision date: 09/25/2020

## Floor Panel

### Special Tool(s) / General Equipment

6.5 mm Drill Bit
11 mm Drill Bit
Scraper for Straight Edges
Polydrive Bit Socket
Self-Piercing Rivet (SPR) Remover/Installer
Belt Sander
Blind Rivet Gun
Hot Air Gun
Locking Pliers

### Materials

Name	Specification
Metal Bonding Adhesive TA-1, TA-1-B, 3M™ 08115, LORD Fusor® 108B	-
Seam Sealer TA-2-B, 3M™ 08308, LORD Fusor® 803DTM	-

### 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.

-  **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).

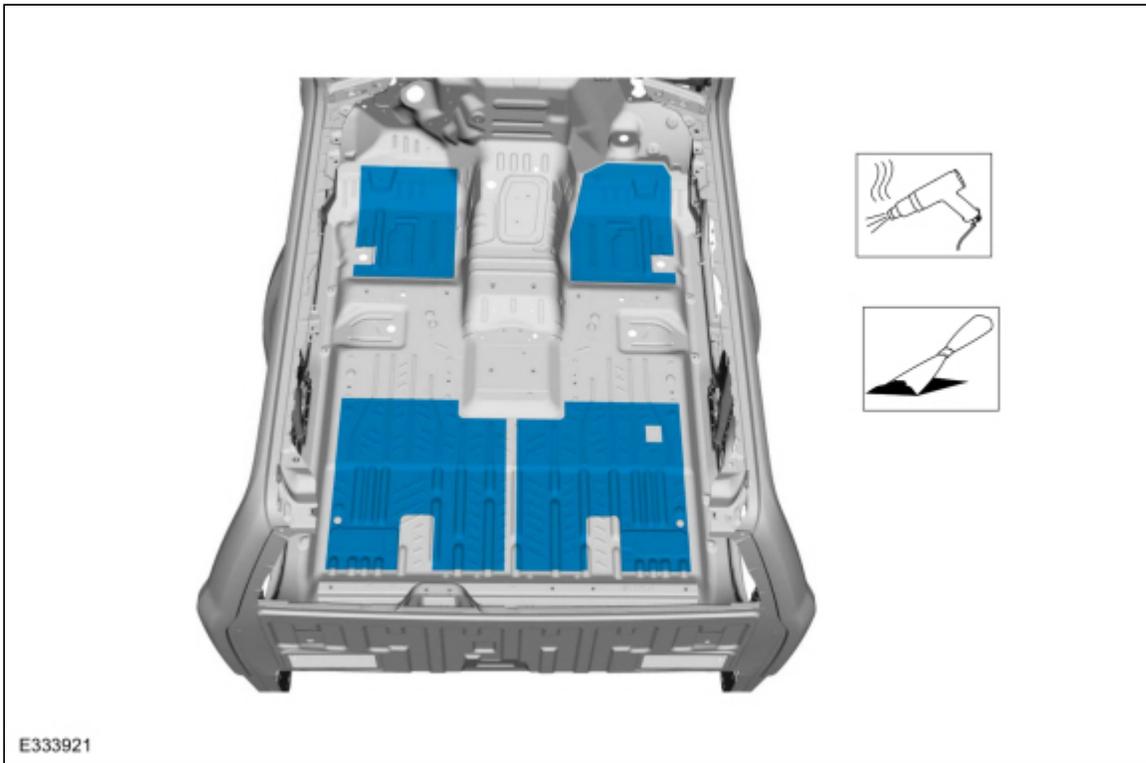
Refer to: [High Voltage System Health and Safety Precautions - Overview](#) (100-00 General Information, Description and Operation).

**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.

**NOTE:** SuperCrew cab shown, Regular cab and SuperCab similar.

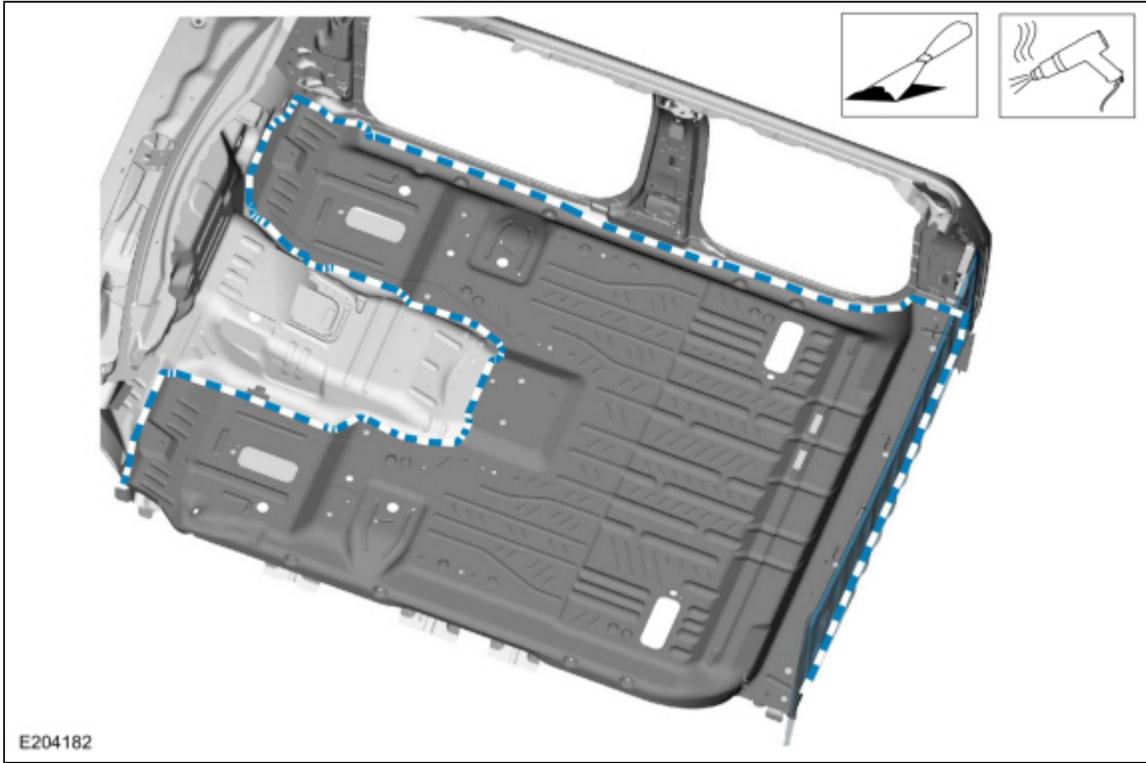
2. Depower the SRS.  
Refer to: [Supplemental Restraint System \(SRS\) Depowering](#) (501-20B Supplemental Restraint System, General Procedures).
3. Remove the seats.  
Refer to: [Front Center Seat](#) (501-10A Front Seats, Removal and Installation).  
Refer to: [Front Seat](#) (501-10A Front Seats, Removal and Installation).  
Refer to: [Front Seat Track](#) (501-10A Front Seats, Removal and Installation).  
Refer to: [Rear Seat LH - SuperCab](#) (501-10B Rear Seats, Removal and Installation).  
Refer to: [Rear Seat RH - SuperCab](#) (501-10B Rear Seats, Removal and Installation).  
Refer to: [Rear Seat LH - SuperCrew](#) (501-10B Rear Seats, Removal and Installation).  
Refer to: [Rear Seat RH - SuperCrew](#) (501-10B Rear Seats, Removal and Installation).
4. If equipped:  
Remove the console.  
Refer to: [Floor Console](#) (501-12 Instrument Panel and Console, Removal and Installation).
5. Remove the carpeting and position the wiring harnesses away from the working area.
6. Remove the rocker panel.  
Refer to: [Rocker Panel - Regular Cab](#) (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).  
Refer to: [Rocker Panel - SuperCab](#) (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).  
Refer to: [Rocker Panel - SuperCrew](#) (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).
7. Remove the NVH pads.  
Use the General Equipment: Scraper for Straight Edges  
Use the General Equipment: Hot Air Gun





- 8. Remove the seam sealer.  
Use the General Equipment: Scraper for Straight Edges  
Use the General Equipment: Hot Air Gun

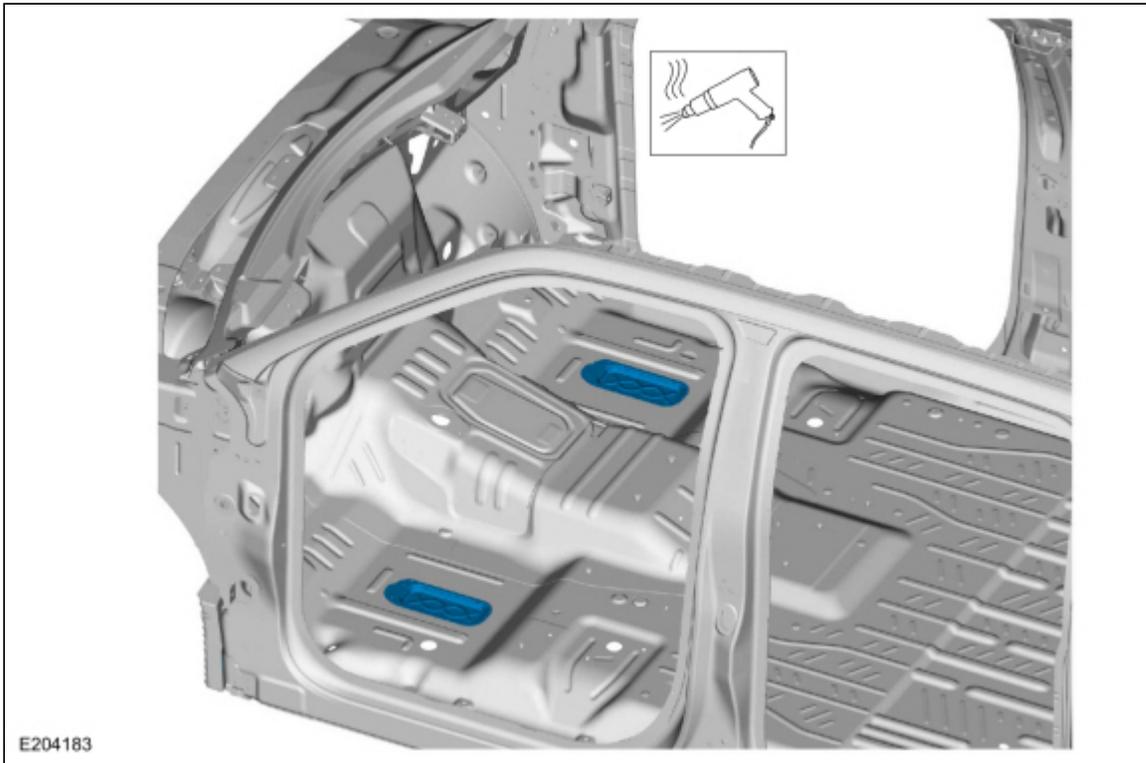




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- 9. Break the adhesive bond and remove the floor inspection covers.  
Use the General Equipment: Hot Air Gun





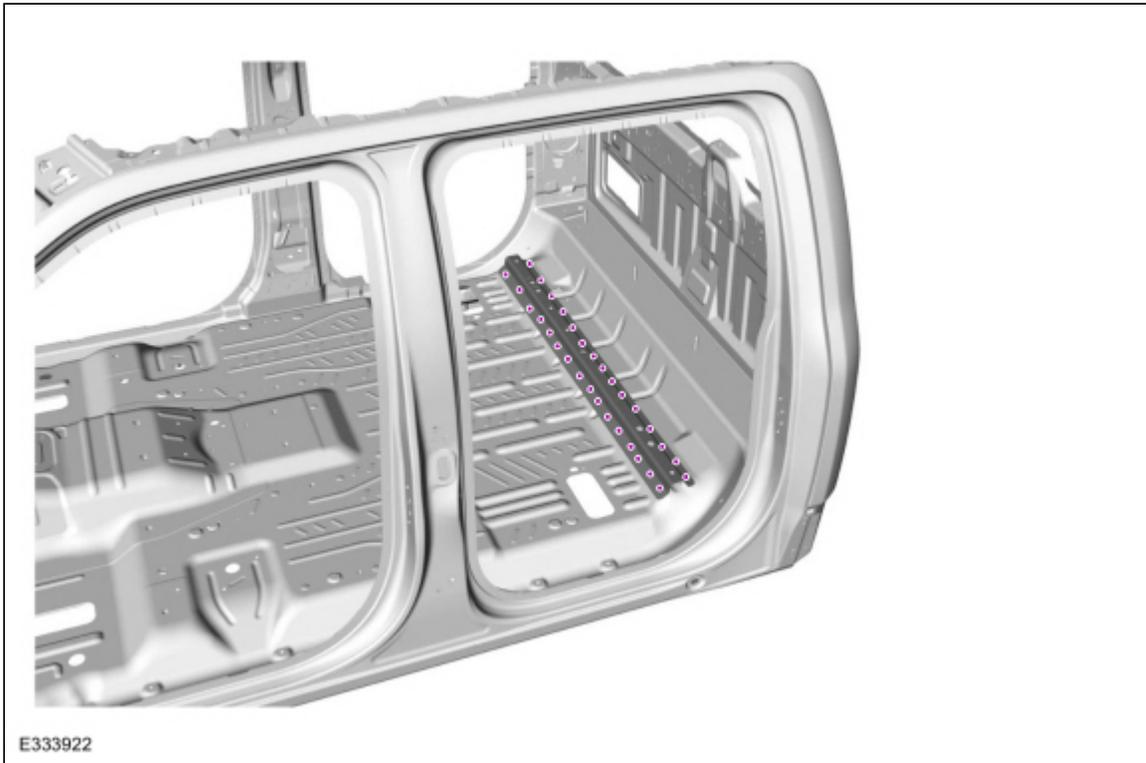
10. **SuperCab and SuperCrew:**

Remove the rear seat brace SPR fasteners.

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

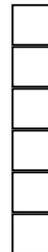
Use the General Equipment: Belt Sander

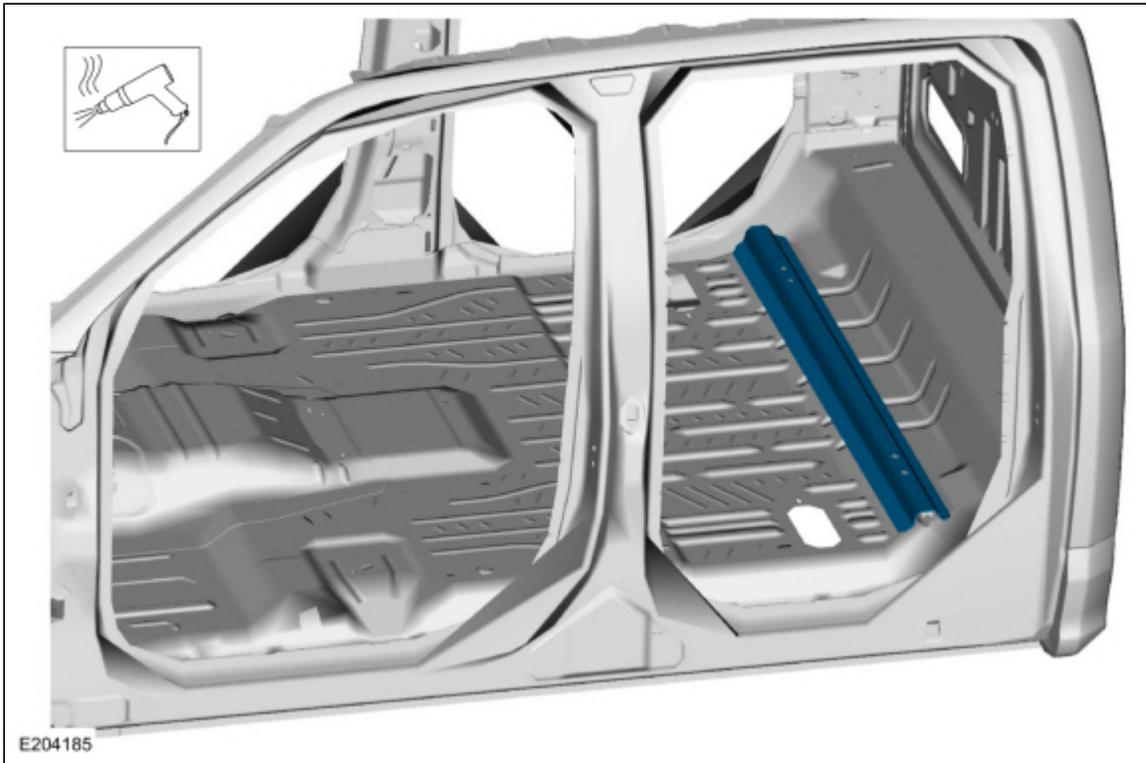




**11. SuperCab and SuperCrew:**

Break the adhesive bond and remove the rear seat brace.  
Use the General Equipment: Hot Air Gun



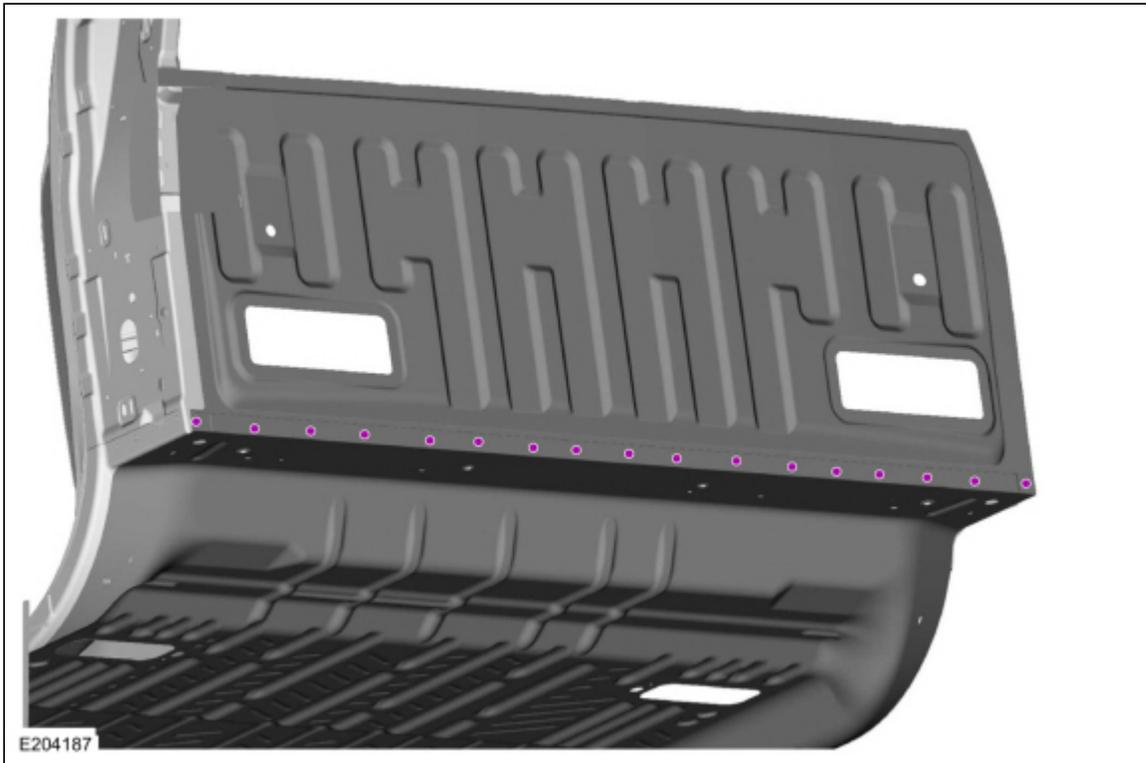


- 12. Remove the floor panel SPR fasteners.  
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer  
Use the General Equipment: Belt Sander



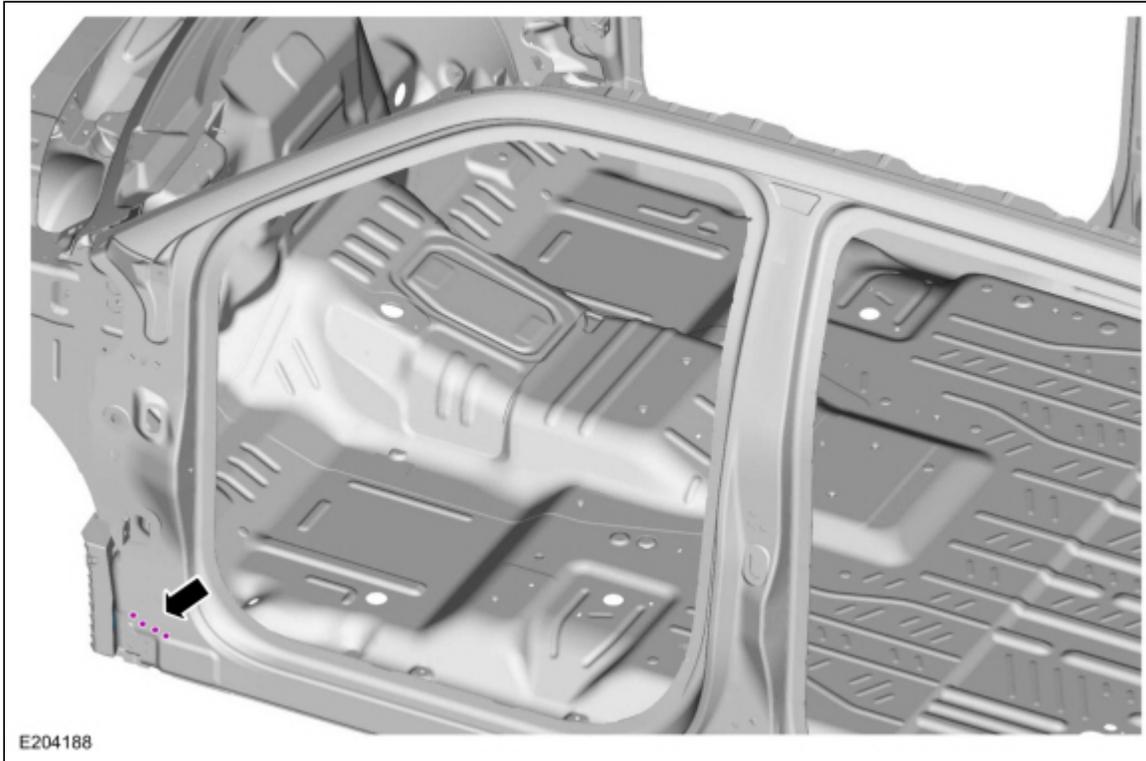


13. Remove the cab back to floor panel SPR fasteners.  
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer  
Use the General Equipment: Belt Sander



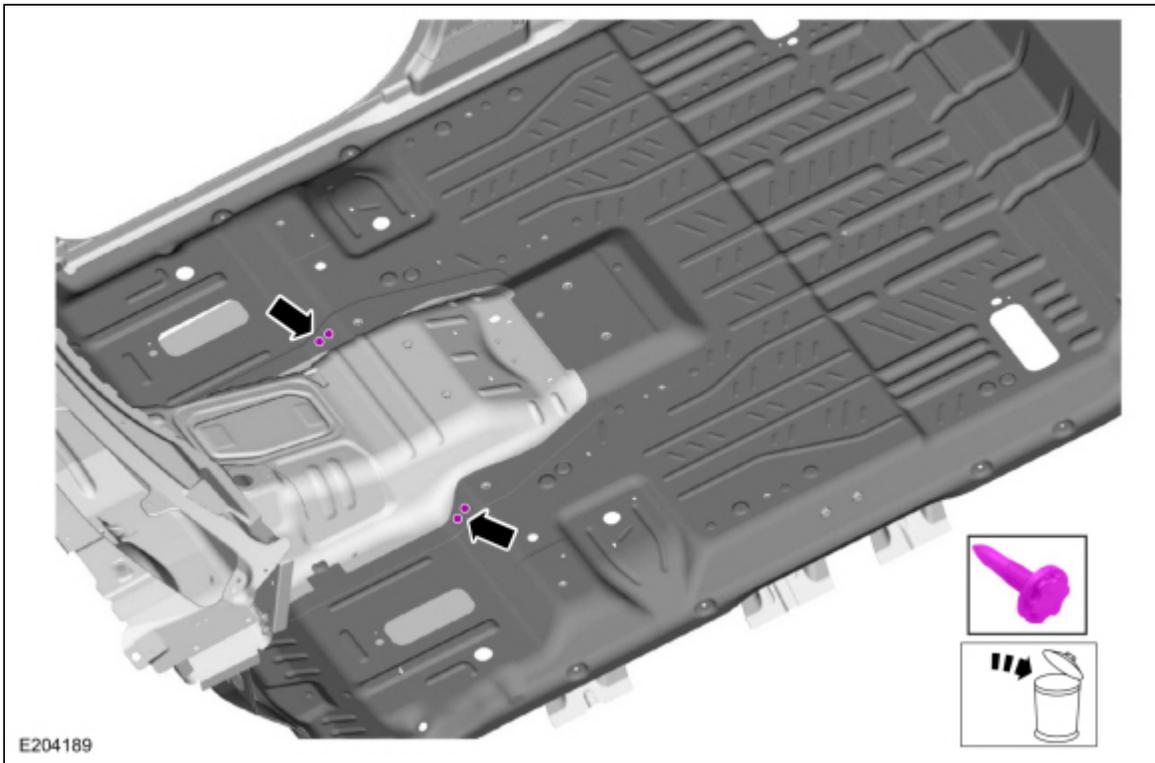
- 14. Remove the floor panel to A-pillar SPR fasteners (both sides).  
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer  
Use the General Equipment: Belt Sander





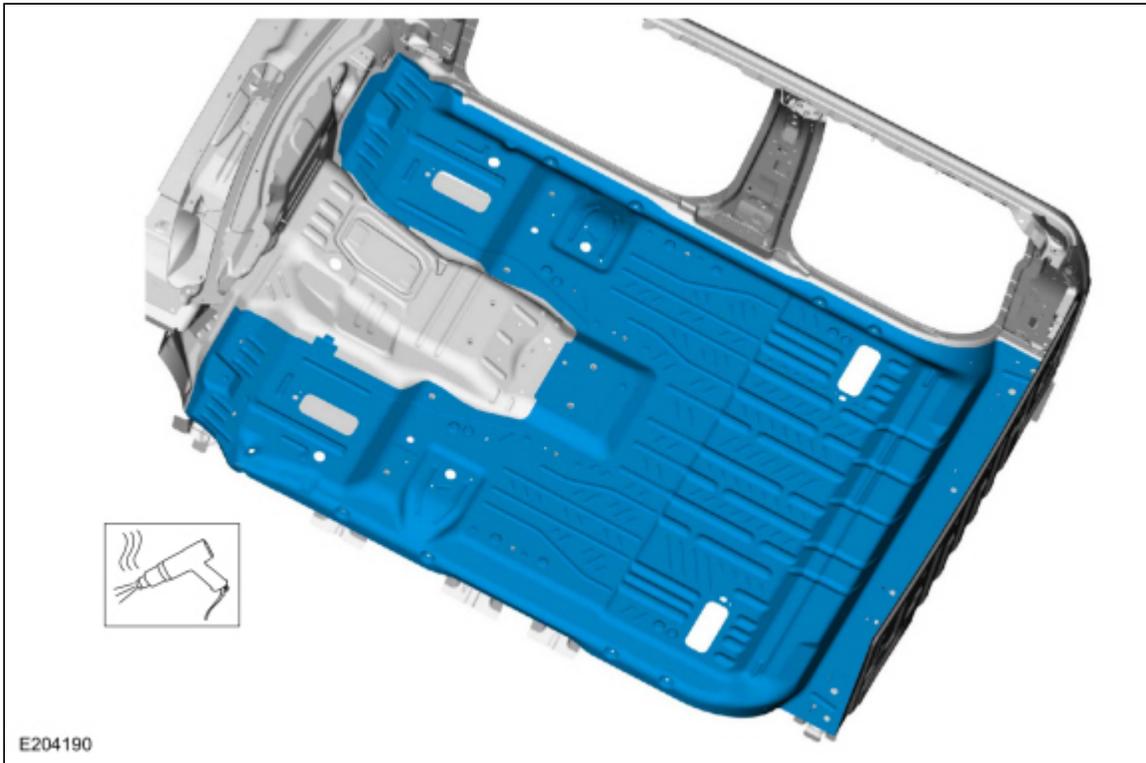
- 15. Remove and discard the FDS fasteners.  
Use the General Equipment: Polydrive Bit Socket





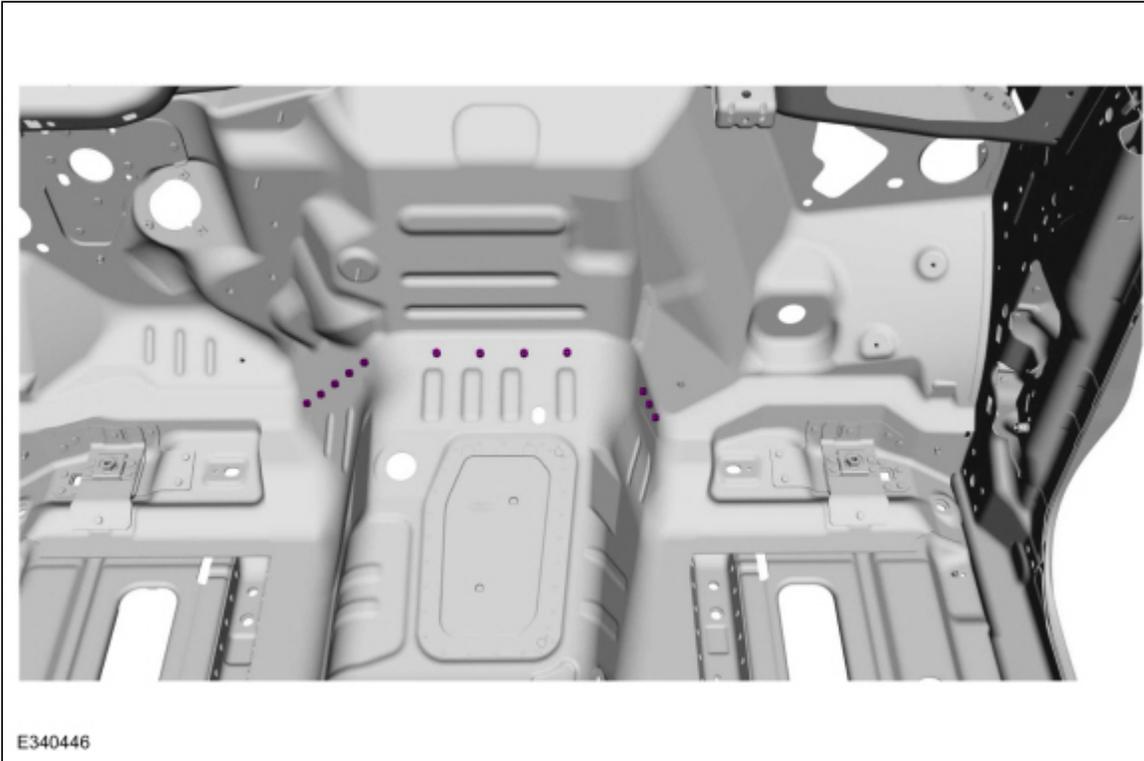
16. Break the adhesive bond and remove the floor panel assembly.  
Use the General Equipment: Hot Air Gun





17. Remove the floor pan tunnel fasteners.  
Use the General Equipment: Belt Sander

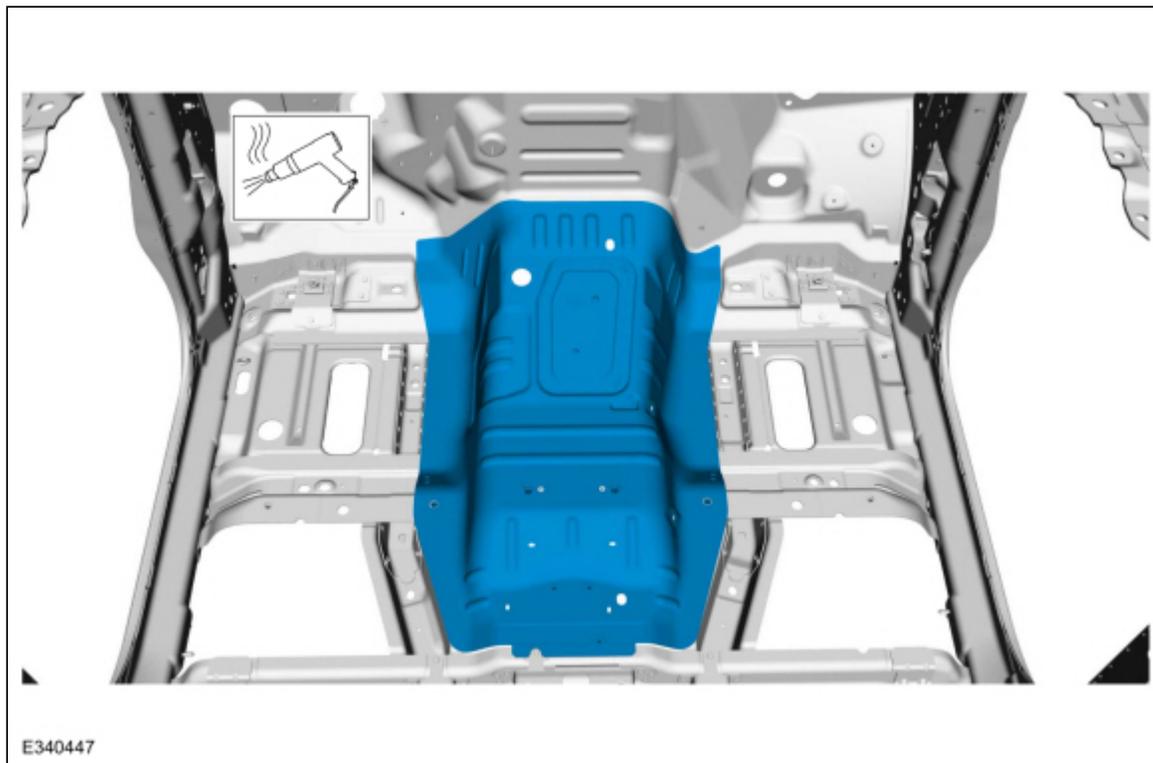




- 18. Break the adhesive bond and remove the floor pan tunnel.  
Use the General Equipment: Hot Air Gun





## Installation

**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.

**NOTE:** SuperCrew cab shown, Regular cab and SuperCab similar.

**NOTE:** SPR fasteners may not be placed directly over original SPR location. They must be placed adjacent to original location matching original quantity.

**NOTE:** Blind or solid rivet fasteners may be used in place of SPR fasteners after enlarging holes to 6.5 mm.

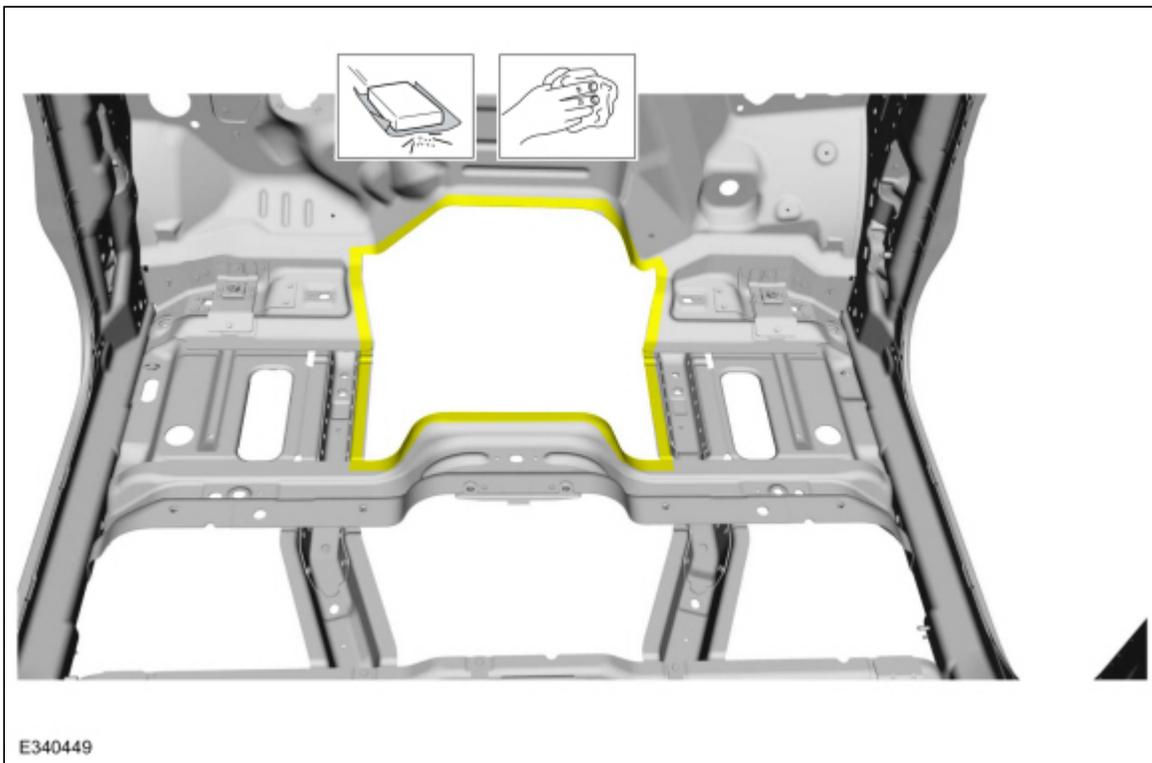
1. 80-120 grit:  
Sand and clean mating flanges on service panel.





- 2. 80-120 grit:  
Sand and clean the mating flanges.

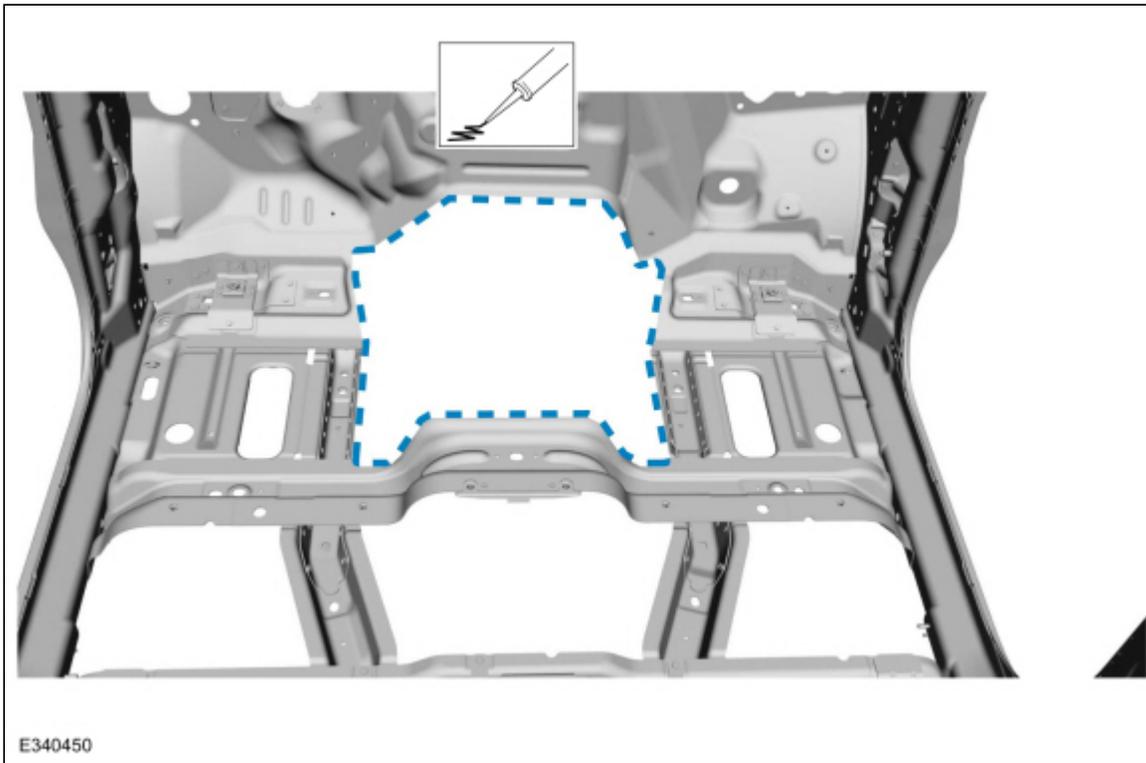




3. Apply adhesive.

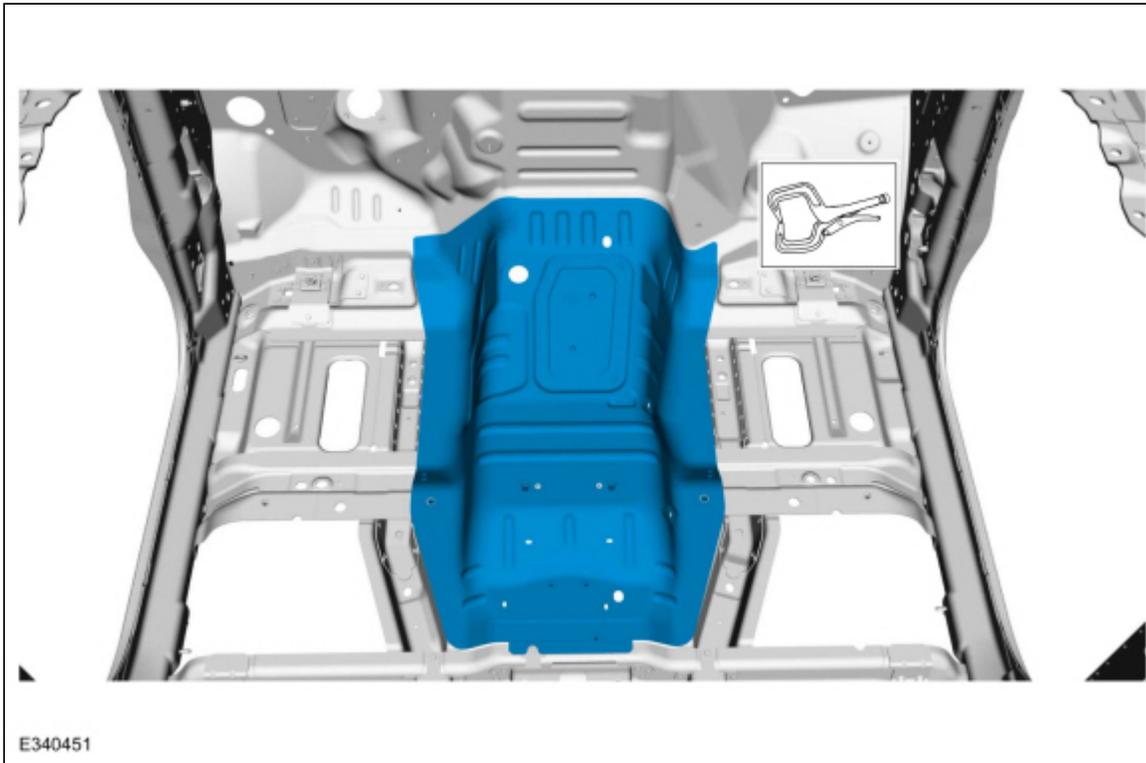
*Material:* Metal Bonding Adhesive / TA-1, TA-1-B, 3M™ 08115, LORD Fusor® 108B





4. Install, position and clamp the replacement panel.  
Use the General Equipment: Locking Pliers

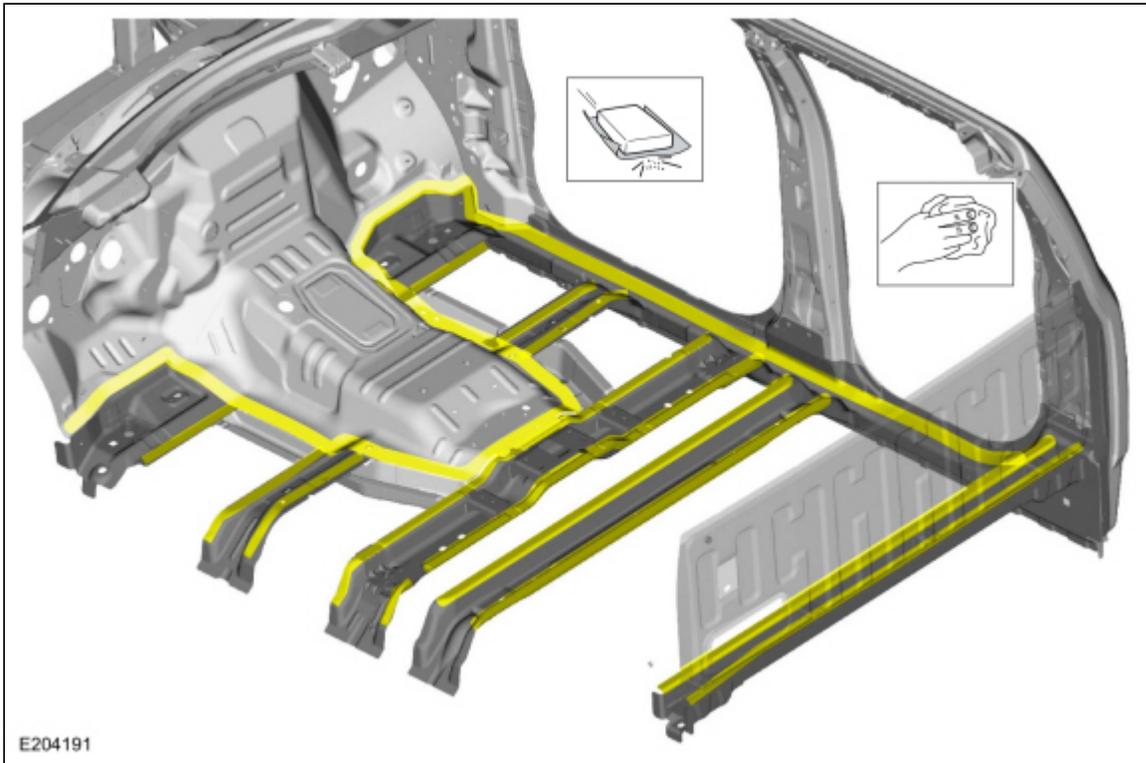




- 5. 80-120 grit sand paper.  
Sand to remove old adhesive and clean.

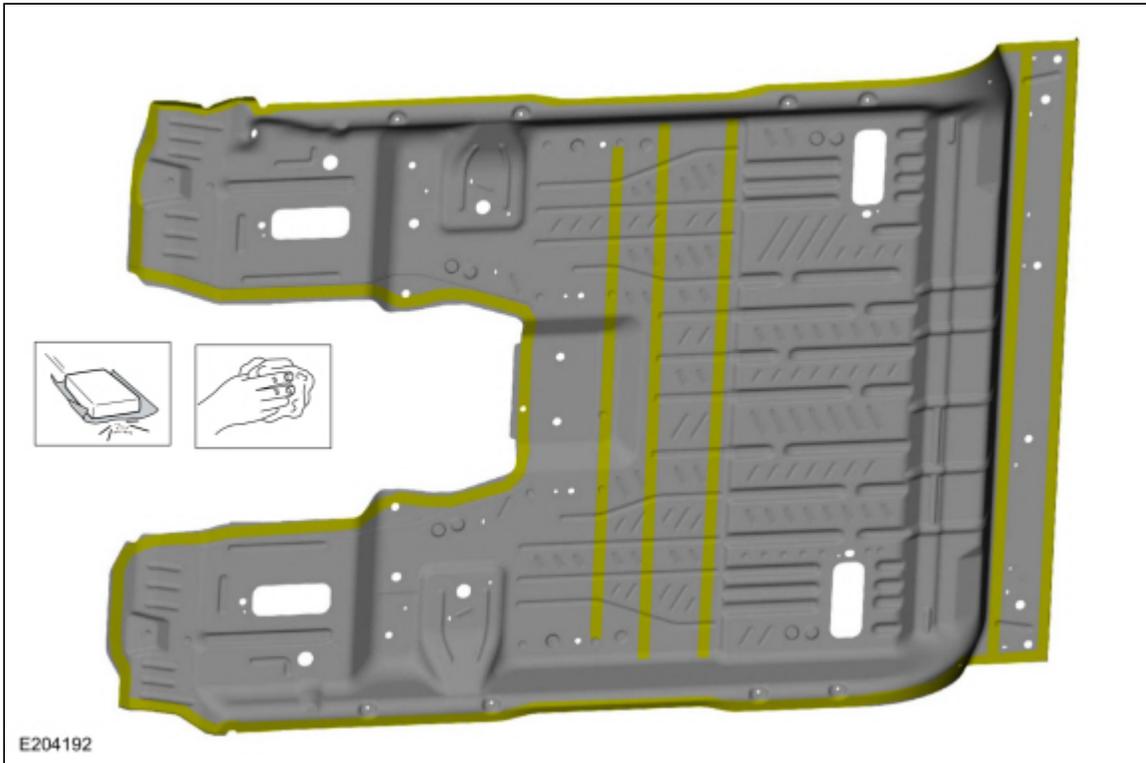




- 6. 80-120 grit sand paper.  
Sand to remove e-coat and clean.

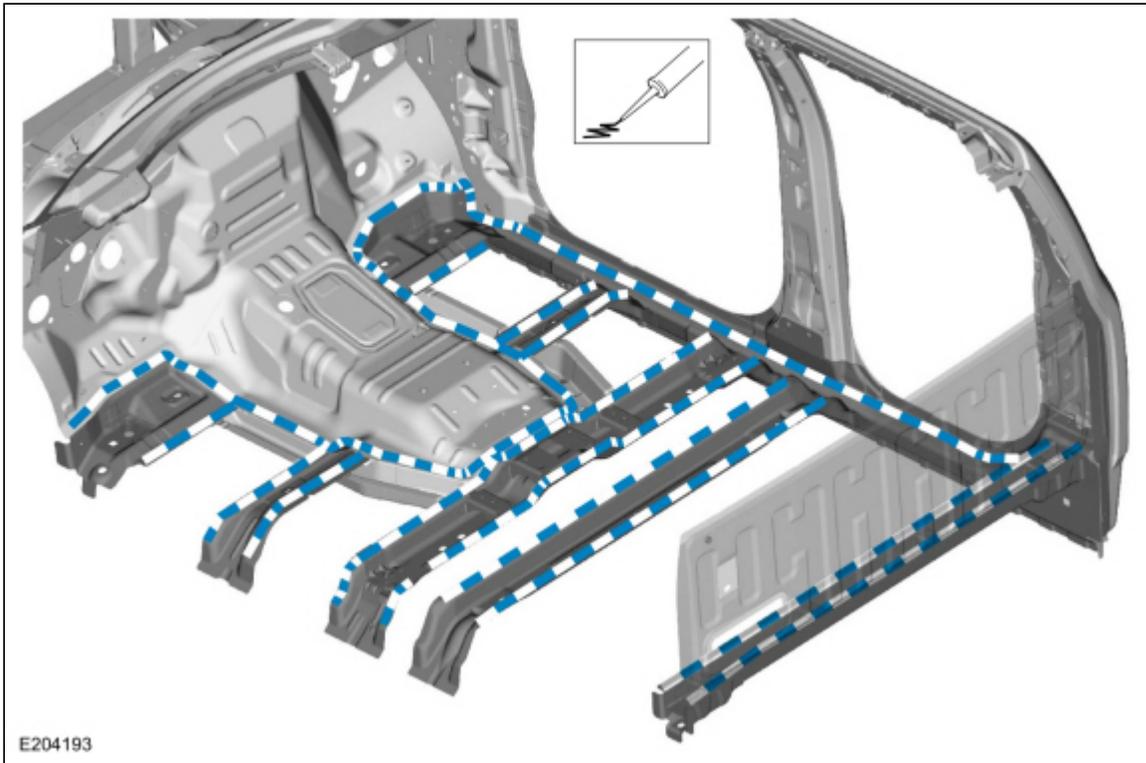




7. Apply adhesive.

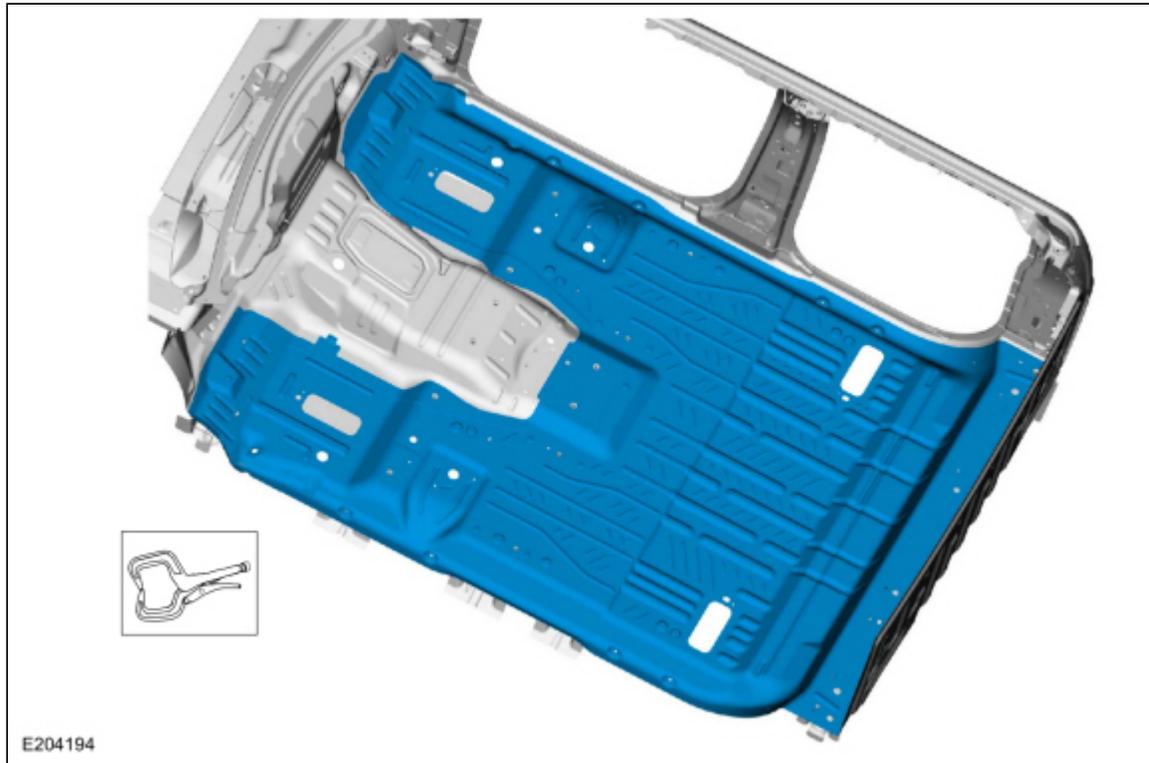
*Material:* Metal Bonding Adhesive / TA-1, TA-1-B, 3M™ 08115, LORD Fusor® 108B





- 8. Install and clamp in position.  
Use the General Equipment: Locking Pliers



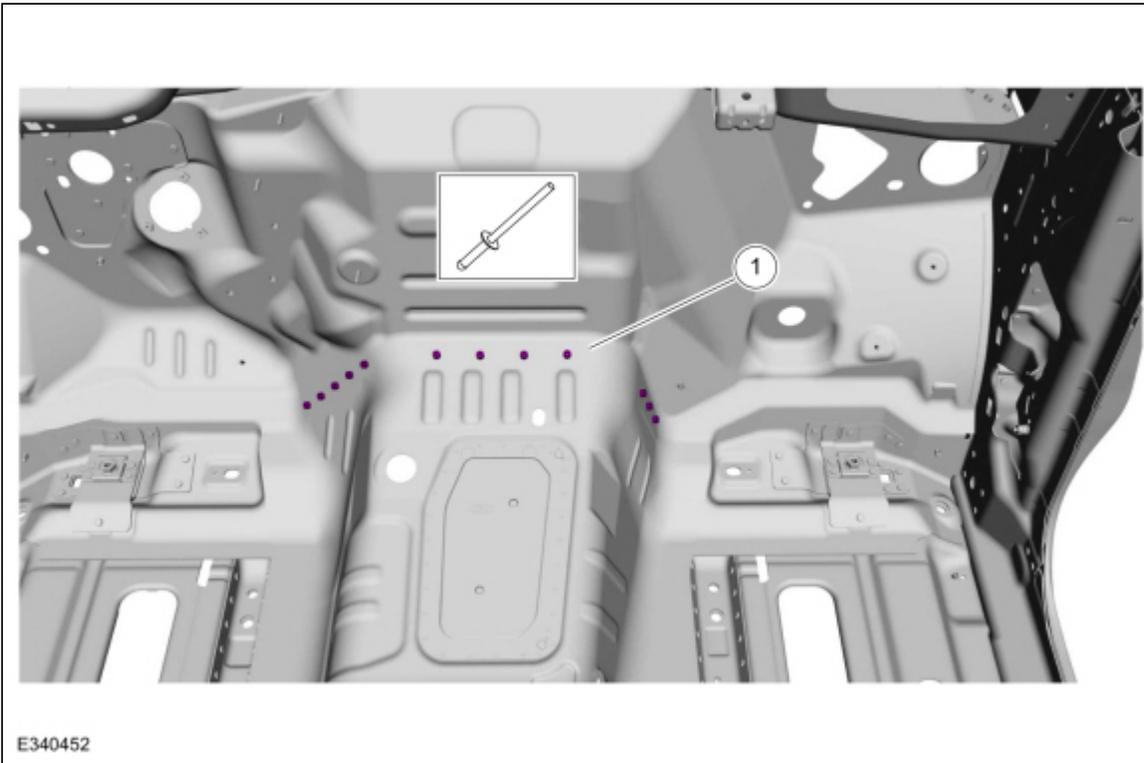


9. Install fasteners.

Item	SPR Number	SPR Code	Henrob®, Car-OLiner®, CMO®, Chief®, Spanesi®, Wielander and Schill® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W708777-S900C	-	-

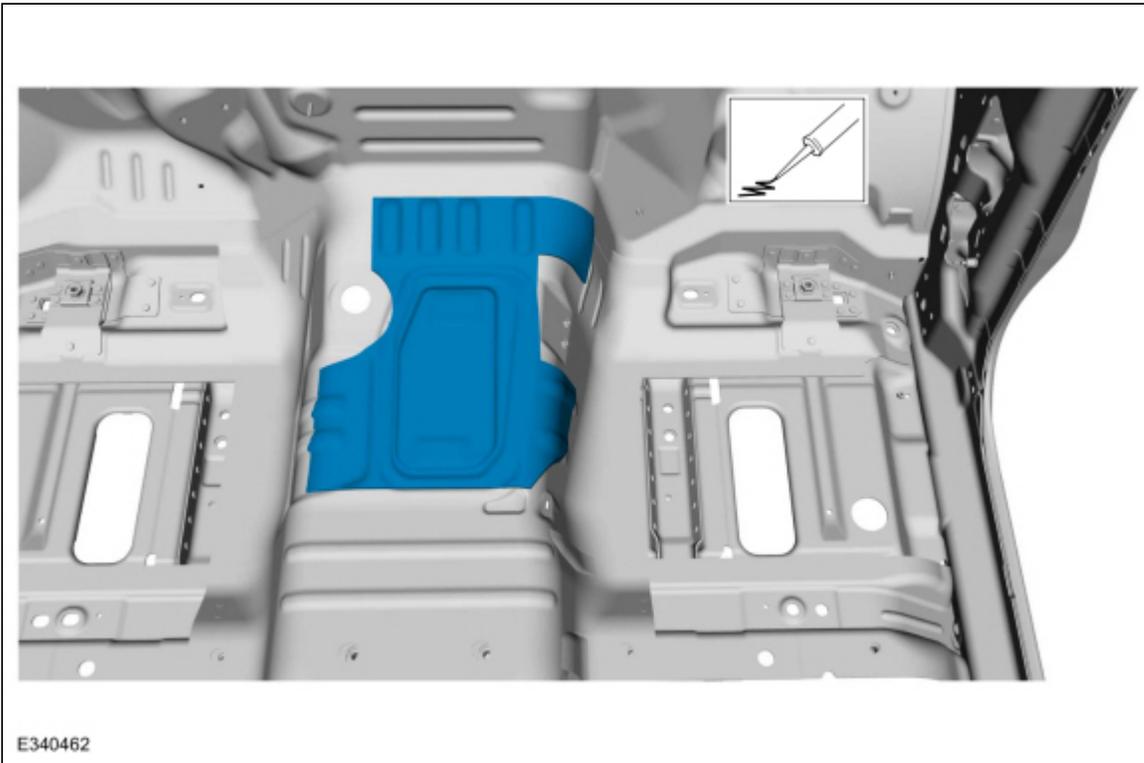
Use the General Equipment: Blind Rivet Gun





10. Install NVH pad.

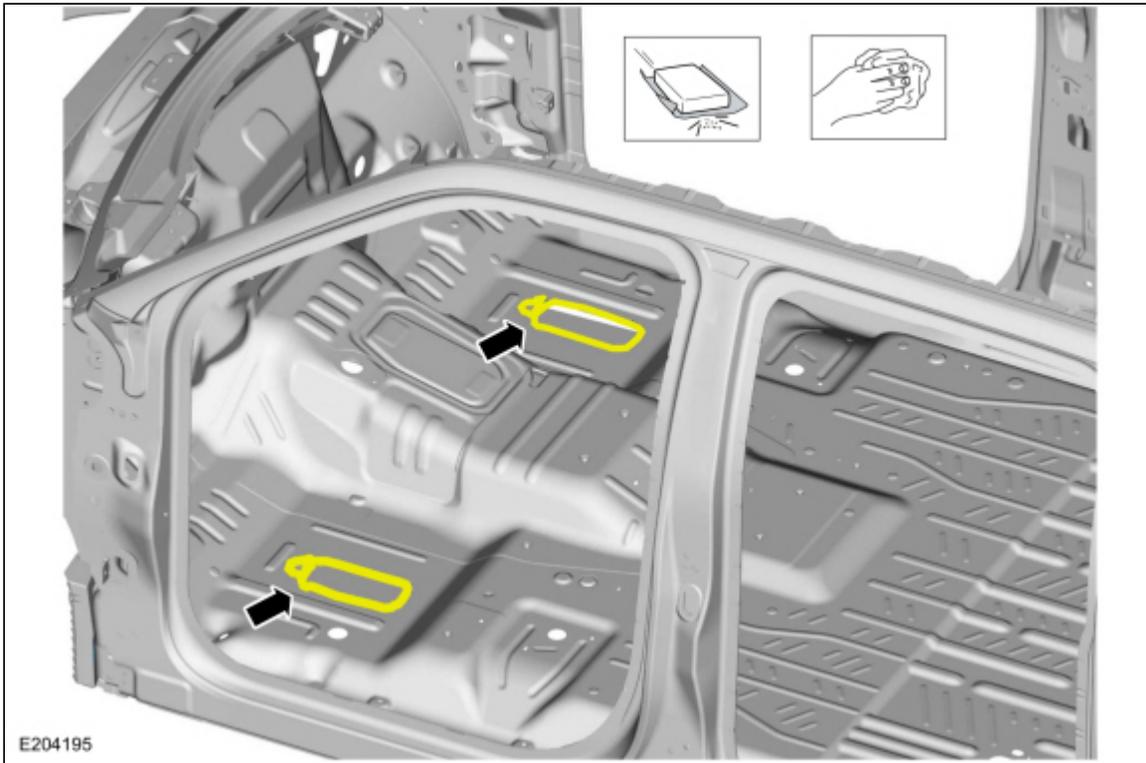




- 11. 80-120 grit sand paper.  
Sand to remove e-coat and clean.

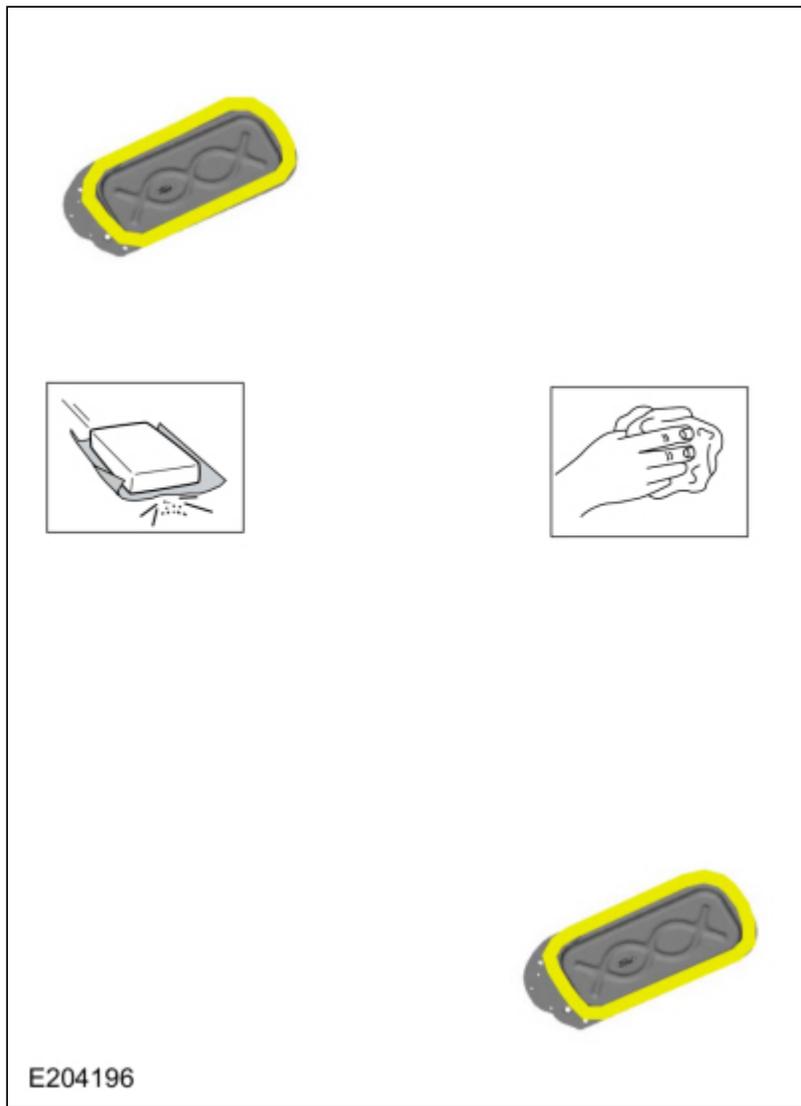




- 12. 80-120 grit sand paper.  
Sand to remove e-coat and clean.

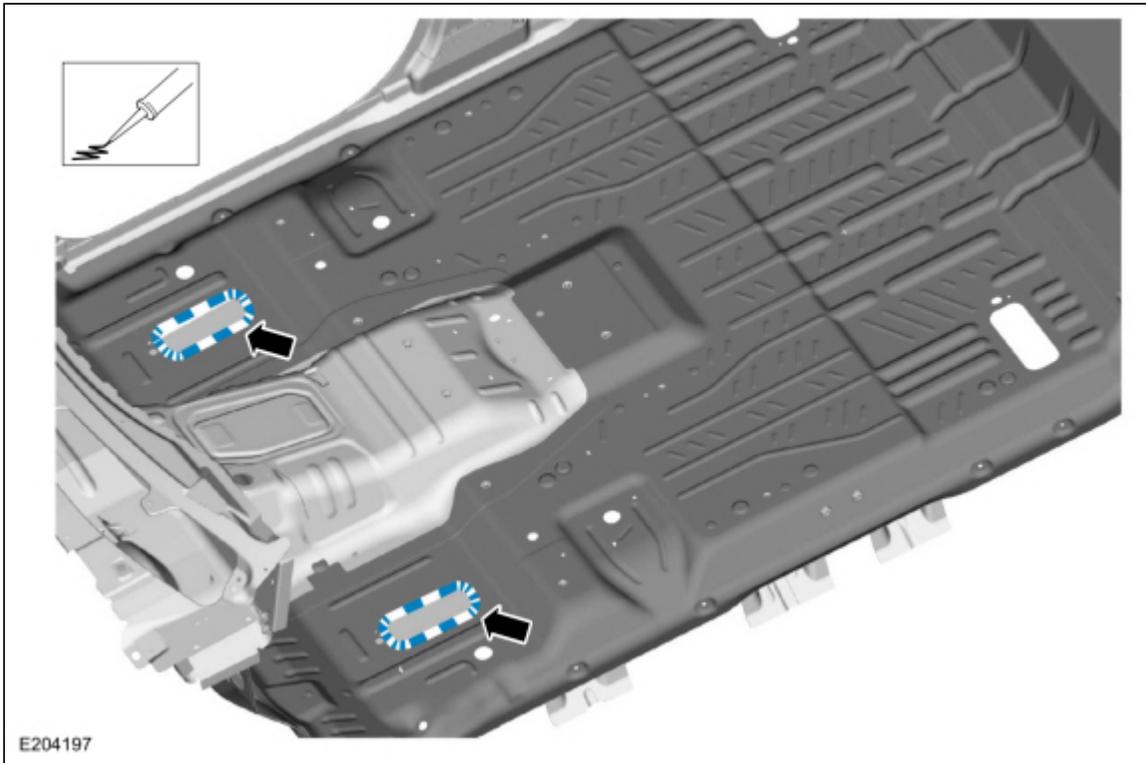




13. Apply adhesive.

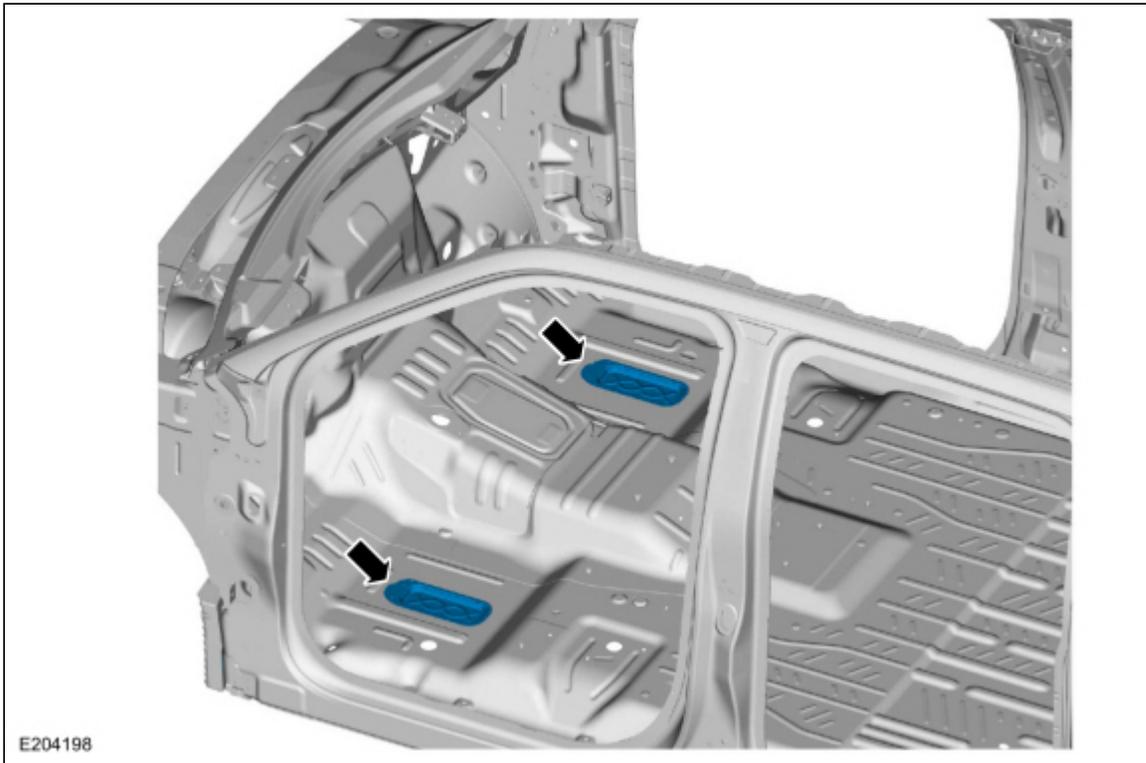
*Material:* Metal Bonding Adhesive / TA-1, TA-1-B, 3M™ 08115, LORD Fusor® 108B





14. Install the floor panel inspection covers.





- 15. Drill for fastener installation.  
Use the General Equipment: 6.5 mm Drill Bit  
Use the General Equipment: 11 mm Drill Bit



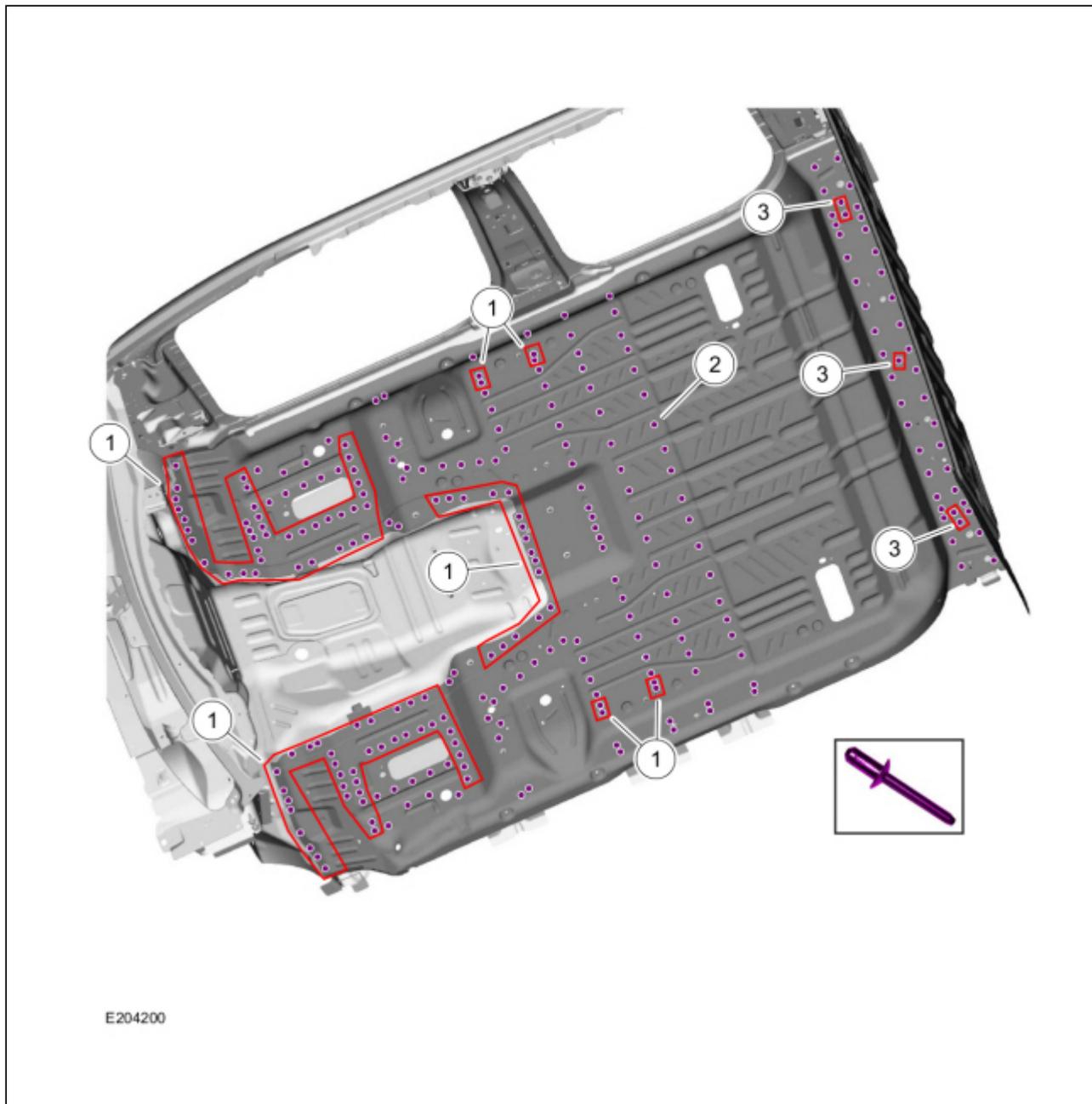


16. Install fasteners.

Item	SPR Number	SPR Code	Henrob®, Car-OLiner®, CMO®, Chief®, Spanesi®, Wielander and Schill® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W708777-S900C	-	-
2	-	-	-	-	W702512-S900C	-	-
3	-	-	-	-	-	-	W716819-S450 (M8)

Use the General Equipment: Blind Rivet Gun





17. Drill for fastener installation.  
Use the General Equipment: 6.5 mm Drill Bit



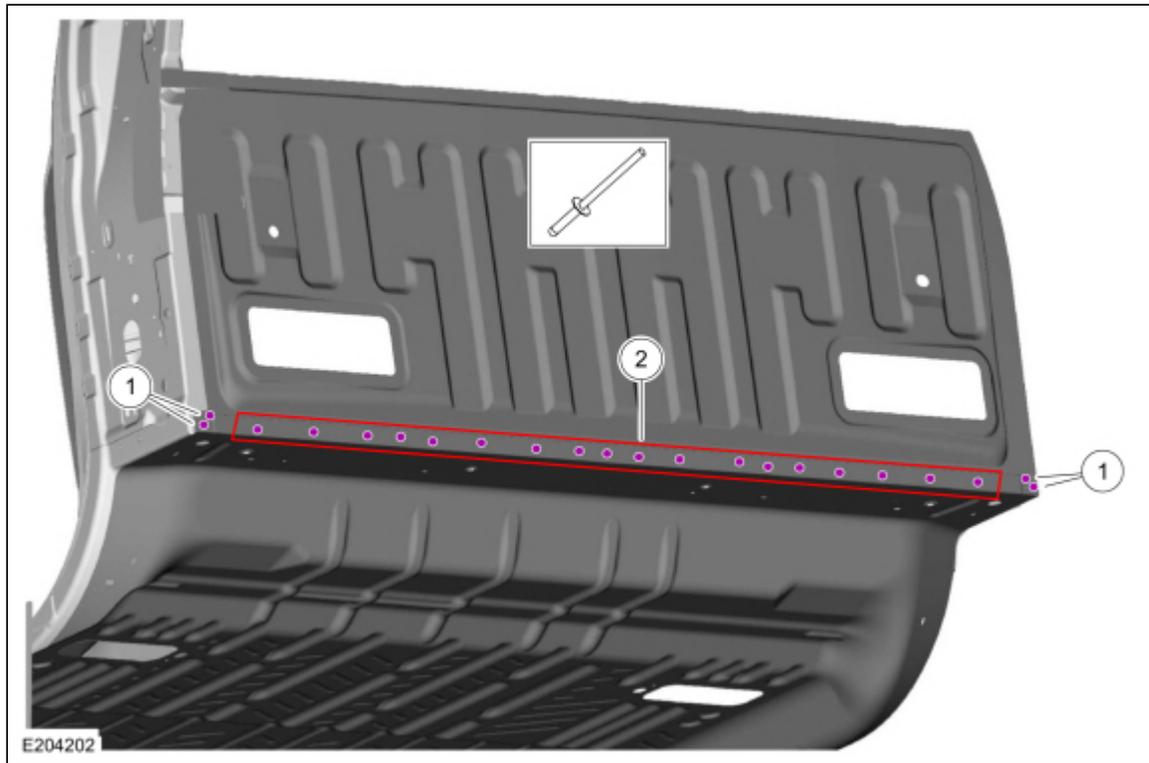


18. Install fasteners.

Item	SPR Number	SPR Code	Henrob®, Car-OLiner®, CMO®, Chief®, Spanesi®, Wielander and Schill® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W702512-S900C	-	-
2	-	-	-	-	W707638-S900C	-	-

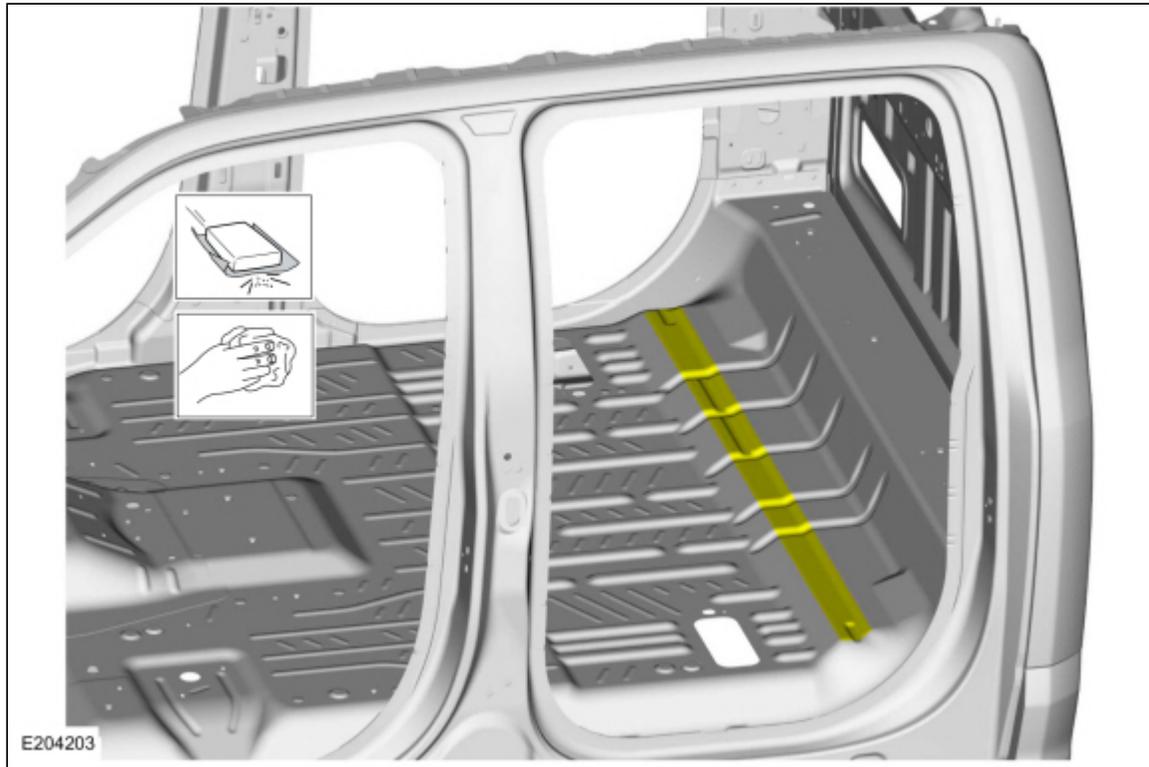
Use the General Equipment: Blind Rivet Gun





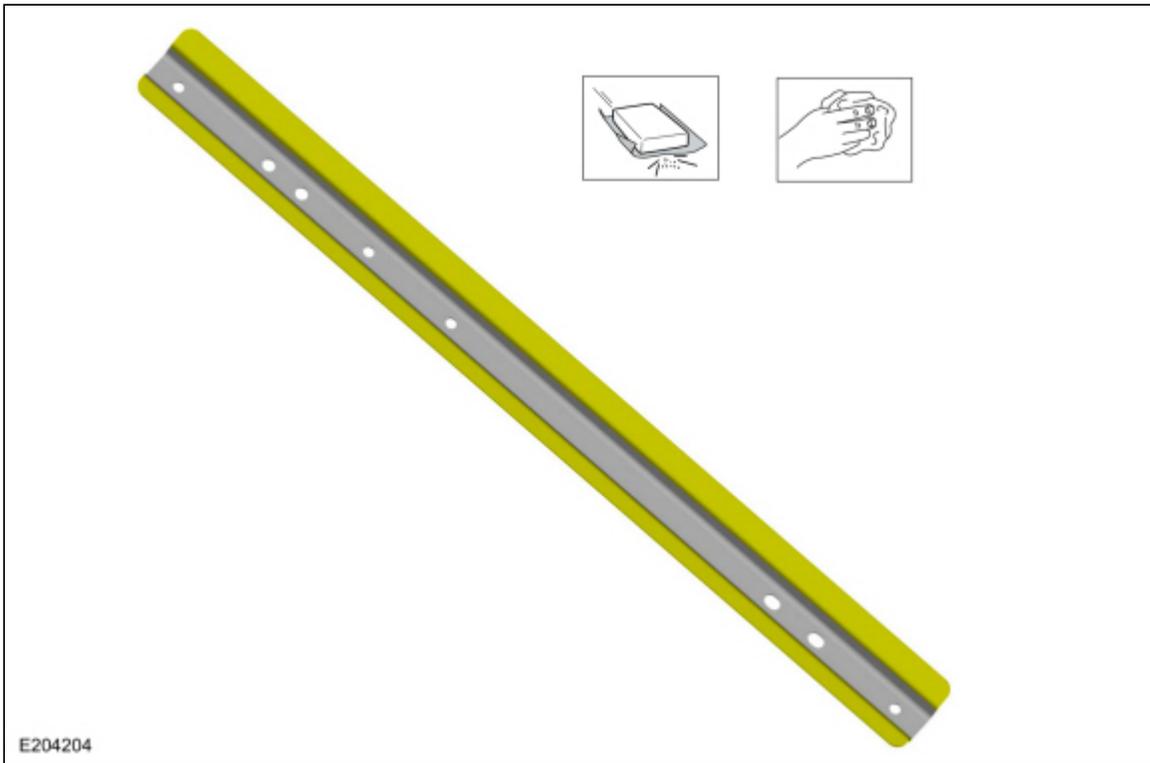
- 19. 80-120 grit sand paper (SuperCab and SuperCrew only)  
Sand to remove e-coat and clean).





20. 80-120 grit sand paper (SuperCab and SuperCrew only).  
Sand to remove e-coat and clean.

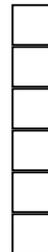


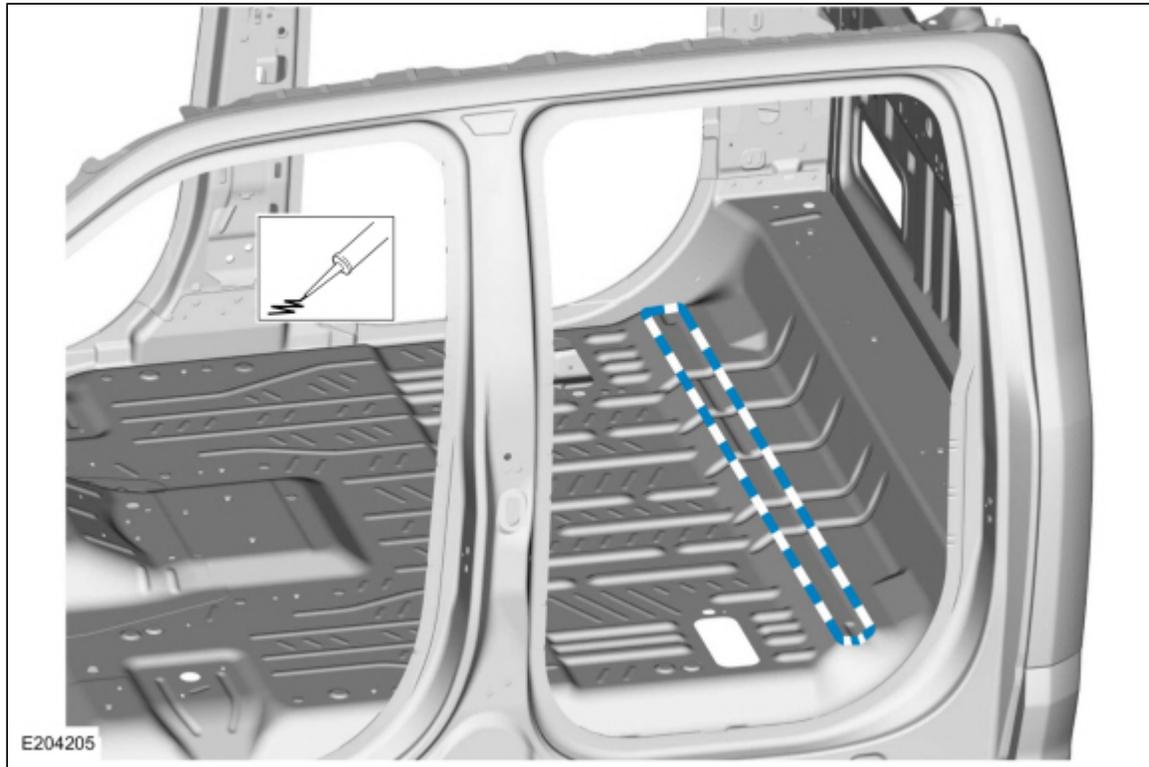


**21. SuperCab and SuperCrew only:**

Apply adhesive.

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





**22. SuperCab and SuperCrew only:**

Install the rear seat brace and clamp in position.

Use the General Equipment: Locking Pliers



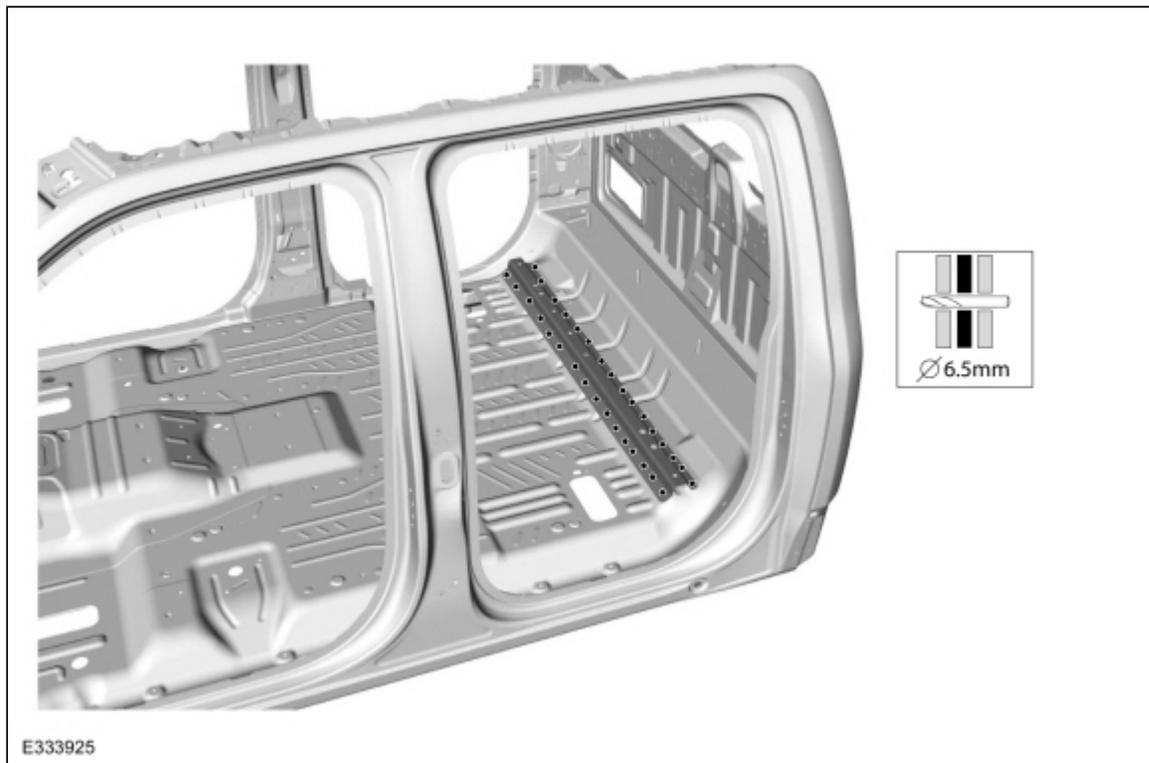


**23. SuperCab and SuperCrew only:**

Drill for fastener installation.

Use the General Equipment: 6.5 mm Drill Bit



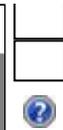


**24. SuperCab and SuperCrew only:**  
Install fasteners.

Item	SPR Number	SPR Code	Henrob®, Car-OLiner®, CMO®, Chief®, Spanesi®, Wielander and Schill® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	-	-	-	-	W707638-S900C	-	-

Use the General Equipment: Blind Rivet Gun





25. Install the rocker panel.

Refer to: [Rocker Panel - Regular Cab](#) (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).

Refer to: [Rocker Panel - SuperCab](#) (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).

Refer to: [Rocker Panel - SuperCrew](#) (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).

26. Seam Sealing:

All seams must be sealed to production level.

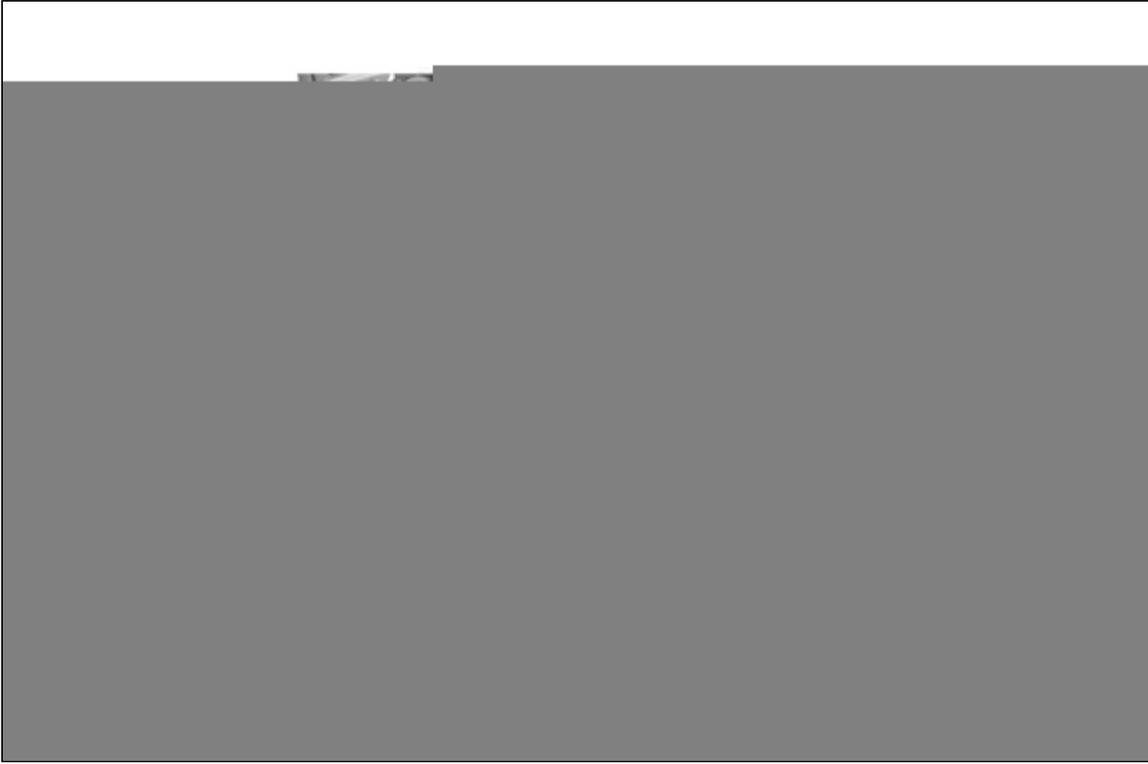
*Material:* Seam Sealer / TA-2-B, 3M™ 08308, LORD Fusor® 803DTM





27. Install NVH pads.





28. Reposition the wiring harnesses and install the carpeting.
29. If equipped:  
Install the console.  
Refer to: [Floor Console](#) (501-12 Instrument Panel and Console, Removal and Installation).
30. Install the seats.  
Refer to: [Front Center Seat](#) (501-10A Front Seats, Removal and Installation).  
Refer to: [Front Seat](#) (501-10A Front Seats, Removal and Installation).  
Refer to: [Front Seat Track](#) (501-10A Front Seats, Removal and Installation).  
Refer to: [Rear Seat LH - SuperCab](#) (501-10B Rear Seats, Removal and Installation).  
Refer to: [Rear Seat RH - SuperCab](#) (501-10B Rear Seats, Removal and Installation).  
Refer to: [Rear Seat LH - SuperCrew](#) (501-10B Rear Seats, Removal and Installation).  
Refer to: [Rear Seat RH - SuperCrew](#) (501-10B Rear Seats, Removal and Installation).
31. Repower the SRS.  
Refer to: [Supplemental Restraint System \(SRS\) Repowering](#) (501-20B Supplemental Restraint System, General Procedures).

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