

F-SERIES ALL CABS FRONT DOOR OUTER PANEL INSTALLATION - SERVICE KIT INSTRUCTIONS

KIT		
Part Number	Description	Quantity
FL34-1620204-AE	Front Door Outer Panel - (RH)	1
SKFL34-1620204-AA	Instruction Sheet	1

KIT		
Part Number	Description	Quantity
FL34-1620205-AE	Front Door Outer Panel - (LH)	1
SKFL34-1620204-AA	Instruction Sheet	1

NOT INCLUDED IN KIT (PROCURE LOCALLY)		
Part Number	Description	Quantity
W790376-S900	Solid Rivet	10
W702512-S900C	Blind Rivet	10
Rotunda 501-078-1	Hem Opening Tools (RH)	1
Rotunda 501-078-2	Hem Opening Tools (LH)	1
501-080	Hem Closing Tool	1
Motorcraft TA-1, 3M 8115 or Fusor 108B	Metal Panel Bonding Adhesive	1

SERVICE GUIDELINES:

1. 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.
2. Replacement Self-Piercing Rivets (SPRs) are the preferred replacement during repair for original SPR locations, where feasible. Hemlocks are the next preferred replacement for original SPRs. (Refer to Figure 1).
3. Remove the door trim panel from the affected door and window glass. For additional information, refer to Section 501-11.
4. Remove the outside door handle and mirror assembly. For additional information, refer to Section 501-09.
5. Remove door trim including mouldings and weather strips.
6. Remove the door assembly and secure on a work stand.
7. Insert TOOL 501-078-1 (RH) or TOOL 501-078-2 (LH) in an air impact gun (620 kPa (90 psi) air pressure is required for consistent tool operation). Using the tool, open the hem flange around the perimeter of the panel.

NOTE: The use of a heat gun may be required to soften door panel adhesive.

8. Use a sharp knife to cut the adhesive between the door outer original panel, flutter beam, belt line reinforcement and intrusion beam.
9. Remove original door outer panel.

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10. Scuff sand only, DO NOT GRIND, the inner structure bonding surfaces. Do not sand to bare substrate, leave original e-coat as intact as possible.
11. Trial fit the service replacement panel to the door shell assembly.
12. Temporarily secure the outer panel to the door assembly and install on the vehicle to verify proper skin alignment.
13. Use reference marks to assist.
14. Scuff the replacement skin bonding areas, then clean with adhesive cleaner.
15. Apply metal bonding adhesive to the following areas: service replacement hem flange, flutter beam-to-outer panel, and outer belt reinforcement-to-outer panel. (Refer to figure 1).
16. Using a 501-080 Hem Closing Tool or the hammer and dolly method, close the perimeter door hem and smooth any residual adhesive in the joints.
17. (Refer to Figure 2) to install ten (10) (W717188-S900) SPR rivets code PW, or (W790376-S900) solid rivet.
18. Prime and Paint the door following Ford approved paint company materials/guidelines.
19. Install the door to the vehicle, align, and reassemble all components.
20. Apply anti-corrosion treatments as outlined in workshop manual section 501-35

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 1).

BLACK WAVY LINES AND DOTS REPRESENT THE LOCATION OF THE ADHESIVE MATERIAL

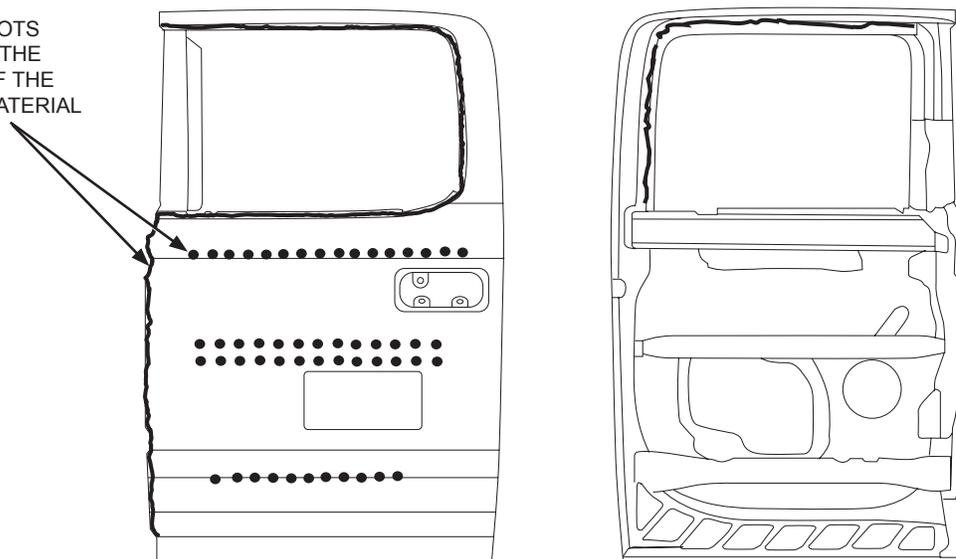


FIGURE 1

SKFL34-1620204-AA

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10-14

**F-SERIES ALL CABS FRONT DOOR OUTER PANEL
INSTALLATION - SERVICE KIT INSTRUCTIONS**

SQUARED NUMBERS ARE PRO SPOT MANDRELS

1	SA-0400/SA-0401
2	SA-0400/SA-0402

TEN (8)
W702512-S900C BLIND RIVETS
OR
W790376-S900 SOLID RIVETS

1

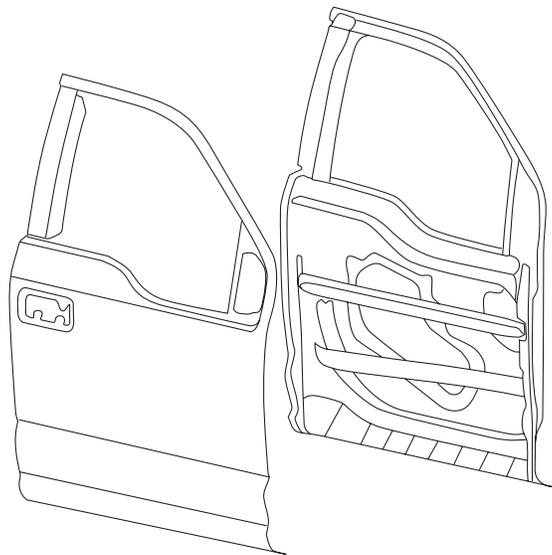
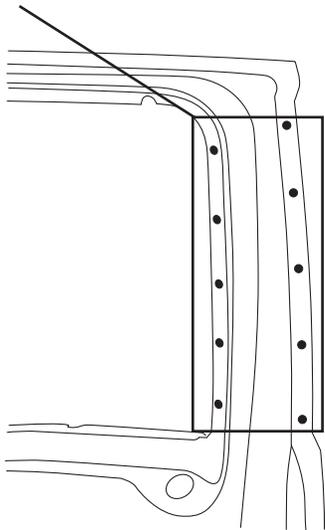


FIGURE 2

