

F-SERIES BODY INSTALLATION FOR ALL CABS ROOF PANEL - SERVICE KIT INSTRUCTIONS

KIT		
Part Number	Description	Quantity
FL34-1550202-AC	Roof Panel Outer - Regular Cab	1
SKFL34-1550202-AB	Instruction Sheet	1

NOT INCLUDED IN KIT (PROCURE LOCALLY)		
Part Number	Description	Quantity
W702512-S900C	Blind Rivet	23
W702554-S900C	Blind Rivet	10
W708777-S900C	Blind Rivet	6
W707638-S900C	Blind Rivet	6
W790376-S900	Solid Rivet	22
W790377-S900	Solid Rivet	16
W708713-S900	Self Piercing Rivet (SPR) Rivet Code AS	20
W710246-S900	Self Piercing Rivet (SPR) Rivet Code BN	6
W717186-S900	Self Piercing Rivet (SPR) Rivet Code EN	10
W708714-S900	Self Piercing Rivet (SPR) Rivet Code AT	2
Motorcraft TA-1, 3M 8115 or Fusor 108B	Metal Panel Bonding Adhesive	1

KIT		
Part Number	Description	Quantity
FL34-1650202-AD	Roof Panel Outer - Crew Cab	1
SKFL34-1550202-AB	Instruction Sheet	1

NOT INCLUDED IN KIT (PROCURE LOCALLY)		
Part Number	Description	Quantity
W702512-S900C	Blind Rivet	23
W702554-S900C	Blind Rivet	10
W708777-S900C	Blind Rivet	6
W707638-S900C	Blind Rivet	6
W790376-S900	Solid Rivet	22
W790377-S900	Solid Rivet	16
W708713-S900	Self Piercing Rivet (SPR) Rivet Code AS	20
W710246-S900	Self Piercing Rivet (SPR) Rivet Code BN	6
W717186-S900	Self Piercing Rivet (SPR) Rivet Code EN	10
W708714-S900	Self Piercing Rivet (SPR) Rivet Code AT	2
Motorcraft TA-1, 3M 8115 or Fusor 108B	Metal Panel Bonding Adhesive	1

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KIT - FL34-1850202-AB		
Part Number	Description	Quantity
FL34-1850202-AB	Front Roof Panel Outer - Super Cab	1
SKFL34-1550202-AB	Instruction Sheet	1

NOT INCLUDED IN KIT (PROCURE LOCALLY)		
Part Number	Description	Quantity
W702512-S900C	Blind Rivet	23
W702554-S900C	Blind Rivet	10
W708777-S900C	Blind Rivet	6
W707638-S900C	Blind Rivet	6
W790376-S900	Solid Rivet	22
W790377-S900	Solid Rivet	16
W708713-S900	Self Piercing Rivet (SPR) Rivet Code AS	20
W710246-S900	Self Piercing Rivet (SPR) Rivet Code BN	6
W717186-S900	Self Piercing Rivet (SPR) Rivet Code EN	10
W708714-S900	Self Piercing Rivet (SPR) Rivet Code AT	2
Motorcraft TA-1, 3M 8115 or Fusor 108B	Metal Panel Bonding Adhesive	1

KIT		
Part Number	Description	Quantity
FL34-1650200-AF	Front Roof Panel Outer With Moonroof - Crew Cab	1
SKFL34-1550202-AB	Instruction Sheet	1

NOT INCLUDED IN KIT (PROCURE LOCALLY)		
Part Number	Description	Quantity
W702512-S900C	Blind Rivet	23
W702554-S900C	Blind Rivet	10
W708777-S900C	Blind Rivet	6
W707638-S900C	Blind Rivet	6
W790376-S900	Solid Rivet	22
W790377-S900	Solid Rivet	16
W708713-S900	Self Piercing Rivet (SPR) Rivet Code AS	20
W710246-S900	Self Piercing Rivet (SPR) Rivet Code BN	6
W717186-S900	Self Piercing Rivet (SPR) Rivet Code EN	10
W708714-S900	Self Piercing Rivet (SPR) Rivet Code AT	2
Motorcraft TA-1, 3M 8115 or Fusor 108B	Metal Panel Bonding Adhesive	1

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KIT		
Part Number	Description	Quantity
FL34-1850200-AF	Front Roof Panel Outer With Moonroof - Super Cab	1
SKFL34-1550202-AB	Instruction Sheet	1

NOT INCLUDED IN KIT (PROCURE LOCALLY)		
Part Number	Description	Quantity
W702512-S900C	Blind Rivet	23
W702554-S900C	Blind Rivet	10
W708777-S900C	Blind Rivet	6
W707638-S900C	Blind Rivet	6
W790376-S900	Solid Rivet	22
W790377-S900	Solid Rivet	16
W708713-S900	Self Piercing Rivet (SPR) Rivet Code AS	20
W710246-S900	Self Piercing Rivet (SPR) Rivet Code BN	6
W717186-S900	Self Piercing Rivet (SPR) Rivet Code EN	10
W708714-S900	Self Piercing Rivet (SPR) Rivet Code AT	2
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

• (Refer to Figure 1) 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.

NOTE: Apply adhesive along roof rail edges and sides for all cabs.

SQUARED NUMBERS ARE PRO SPOT MANDRELS	
1	SA-0400/SA-0401
2	SA-0400/SA-0402
CIRCLED NUMBERS ARE SOLID RIVETS	
1	W790376-S900
2	W790377-S900

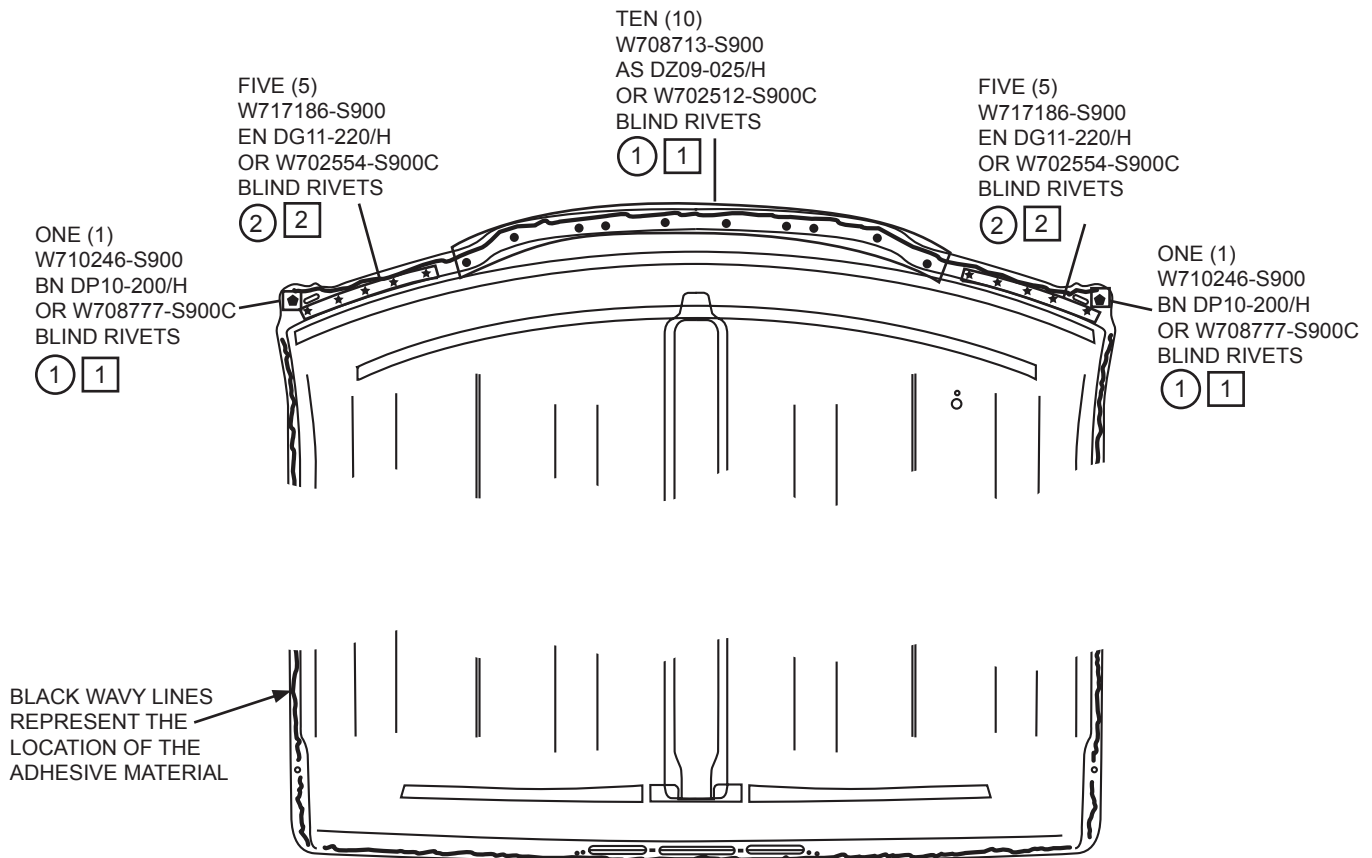


FIGURE 1



FIGURE 2 RIVET LOCATIONS

- (Refer to Figure 2) 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

SQUARED NUMBERS ARE PRO SPOT MANDRELS	
1	SA-0400/SA-0401
2	SA-0400/SA-0402
CIRCLED NUMBERS ARE SOLID RIVETS	
①	W790376-S900
②	W790377-S900

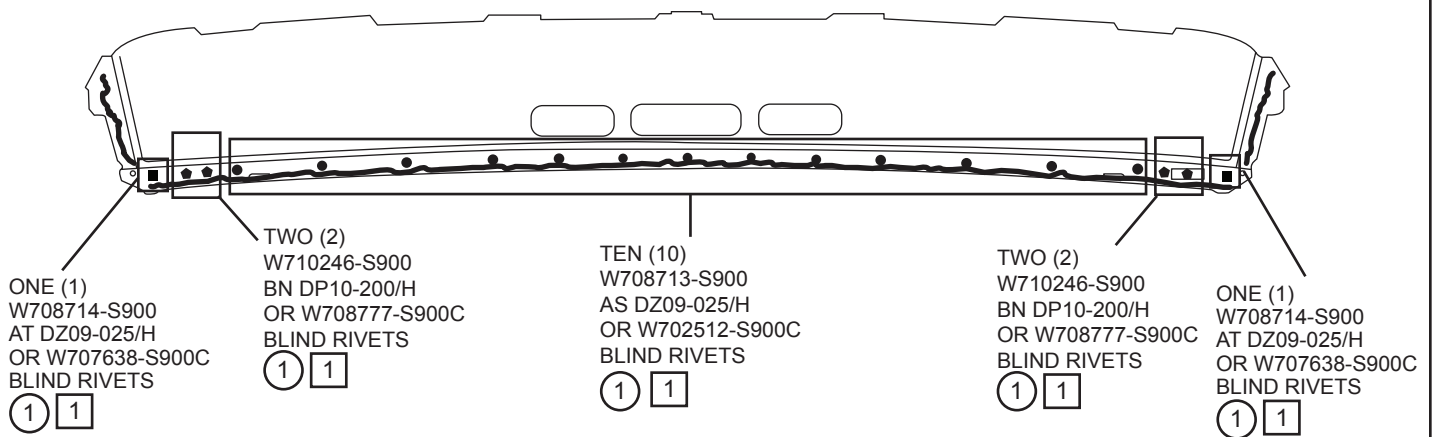


FIGURE 2

