

## F-SERIES BOX SIDE OUTER ASSEMBLY - SERVICE KIT INSTRUCTIONS

KIT		
Part Number	Description	Quantity
FL34-9527840-A	Panel Assembly Body Side Outer 5.5' (RH) - No Holes	1
SKFL34-9527840-AB	Instruction Sheet	1
NOT INCLUDED IN KIT (PROCURE LOCALLY)		
Part Number	Description	Quantity
W707638-S900C	Blind Rivet	53
W702512-S900C	Blind Rivet	4
W708464-S450B	Bolt M6 x 15	2
Motorcraft TA-1, 3M 8115 or Fusor 108B	Metal Panel Bonding Adhesive	1

KIT		
Part Number	Description	Quantity
FL34-9527841-A	Panel Assembly Body Side Outer 5.5' (LH) - No Holes	1
SKFL34-9527840-AB	Instruction Sheet	1
NOT INCLUDED IN KIT (PROCURE LOCALLY)		
Part Number	Description	Quantity
W707638-S900C	Blind Rivet	53
W702512-S900C	Blind Rivet	4
W708464-S450B	Bolt M6 x 15	2
Motorcraft TA-1, 3M 8115 or Fusor 108B	Metal Panel Bonding Adhesive	1

KIT		
Part Number	Description	Quantity
FL34-9527840-B	Panel Assembly Body Side Outer 5.5' (RH) - Holes	1
SKFL34-9527840-AB	Instruction Sheet	1
NOT INCLUDED IN KIT (PROCURE LOCALLY)		
Part Number	Description	Quantity
W707638-S900C	Blind Rivet	53
W702512-S900C	Blind Rivet	4
W708464-S450B	Bolt M6 x 15	2
Motorcraft TA-1, 3M 8115 or Fusor 108B	Metal Panel Bonding Adhesive	1

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KIT		
Part Number	Description	Quantity
FL34-9527841-B	Panel Assembly Body Side Outer 5.5' (LH) - Holes	1
SKFL34-9527840-AB	Instruction Sheet	1
NOT INCLUDED IN KIT (PROCURE LOCALLY)		
Part Number	Description	Quantity
W707638-S900C	Blind Rivet	53
W702512-S900C	Blind Rivet	4
W708464-S450B	Bolt M6 x 15	2
Motorcraft TA-1, 3M 8115 or Fusor 108B	Metal Panel Bonding Adhesive	1

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Part Number	Description	Quantity
FL34-9627840-A	Panel Assembly Body Side Outer 6.5' (RH) - No Holes	1
SKFL34-9527840-AB	Instruction Sheet	1
NOT INCLUDED IN KIT (PROCURE LOCALLY)		
Part Number	Description	Quantity
W707638-S900C	Blind Rivet	57
W702512-S900C	Blind Rivet	4
W708464-S450B	Bolt M6 x 15	2
Motorcraft TA-1, 3M 8115 or Fusor 108B	Metal Panel Bonding Adhesive	1

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FL34-9627841-A	Panel Assembly Body Side Outer 6.5' (LH) - No Holes	1
SKFL34-9527840-AB	Instruction Sheet	1
NOT INCLUDED IN KIT (PROCURE LOCALLY)		
Part Number	Description	Quantity
W707638-S900C	Blind Rivet	57
W702512-S900C	Blind Rivet	4
W708464-S450B	Bolt M6 x 15	2
Motorcraft TA-1, 3M 8115 or Fusor 108B	Metal Panel Bonding Adhesive	1

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KIT		
Part Number	Description	Quantity
FL34-9627840-B	Panel Assembly Body Side Outer 6.5' (RH) - Holes	1
SKFL34-9527840-AB	Instruction Sheet	1
NOT INCLUDED IN KIT (PROCURE LOCALLY)		
Part Number	Description	Quantity
W707638-S900C	Blind Rivet	57
W702512-S900C	Blind Rivet	4
W708464-S450B	Bolt M6 x 15	2
Motorcraft TA-1, 3M 8115 or Fusor 108B	Metal Panel Bonding Adhesive	1

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Part Number	Description	Quantity
FL34-9627841-B	Panel Assembly Body Side Outer 6.5' (LH) - Holes	1
SKFL34-9527840-AB	Instruction Sheet	1
NOT INCLUDED IN KIT (PROCURE LOCALLY)		
Part Number	Description	Quantity
W707638-S900C	Blind Rivet	57
W702512-S900C	Blind Rivet	4
W708464-S450B	Bolt M6 x 15	2
Motorcraft TA-1, 3M 8115 or Fusor 108B	Metal Panel Bonding Adhesive	1

KIT		
Part Number	Description	Quantity
FL34-9827840-A	Panel Assembly Body Side Outer 8.0' (RH) - No Holes	1
SKFL34-9527840-AB	Instruction Sheet	1
NOT INCLUDED IN KIT (PROCURE LOCALLY)		
Part Number	Description	Quantity
W707638-S900C	Blind Rivet	62
W702512-S900C	Blind Rivet	4
W708464-S450B	Bolt M6 x 15	2
Motorcraft TA-1, 3M 8115 or Fusor 108B	Metal Panel Bonding Adhesive	1

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KIT		
Part Number	Description	Quantity
FL34-9827841-A	Panel Assembly Body Side Outer 8.0' (LH) - No Holes	1
SKFL34-9527840-AB	Instruction Sheet	1
NOT INCLUDED IN KIT (PROCURE LOCALLY)		
Part Number	Description	Quantity
W707638-S900C	Blind Rivet	62
W702512-S900C	Blind Rivet	4
W708464-S450B	Bolt M6 x 15	2
Motorcraft TA-1, 3M 8115 or Fusor 108B	Metal Panel Bonding Adhesive	1

KIT		
Part Number	Description	Quantity
FL34-9827840-B	Panel Assembly Body Side Outer 8.0' (RH) - Holes	1
SKFL34-9527840-AB	Instruction Sheet	1
NOT INCLUDED IN KIT (PROCURE LOCALLY)		
Part Number	Description	Quantity
W707638-S900C	Blind Rivet	62
W702512-S900C	Blind Rivet	4
W708464-S450B	Bolt M6 x 15	2
Motorcraft TA-1, 3M 8115 or Fusor 108B	Metal Panel Bonding Adhesive	1

KIT		
Part Number	Description	Quantity
FL34-9827841-B	Panel Assembly Body Side Outer 8.0' (LH) - Holes	1
SKFL34-9527840-AB	Instruction Sheet	1
NOT INCLUDED IN KIT (PROCURE LOCALLY)		
Part Number	Description	Quantity
W707638-S900C	Blind Rivet	62
W702512-S900C	Blind Rivet	4
W708464-S450B	Bolt M6 x 15	2
Motorcraft TA-1, 3M 8115 or Fusor 108B	Metal Panel Bonding Adhesive	1

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## **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.

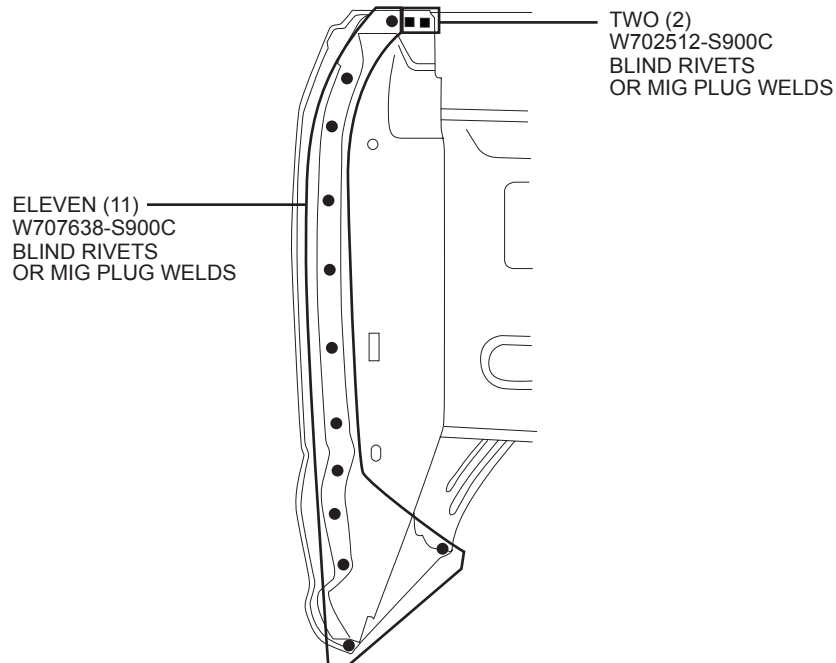
### **NOTE: Do not install replacement SPR in original SPR hole.**

- 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.
- MIG plug welds are to be performed using 5554 wire at 1.2mm, using pure argon as a shielding gas. In preparation for the plug welds, identify the specific weld locations and number, and drill a 6.5mm hole in the top panel for each location to weld.



## **FIGURE 1 RIVET LOCATIONS**

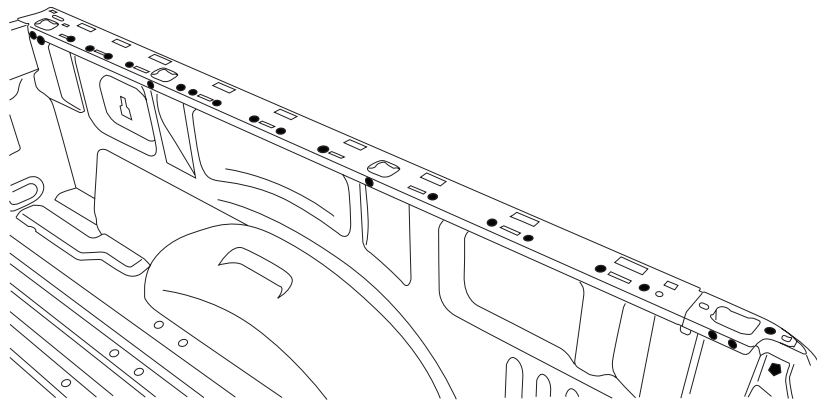
- Black dots represent the location of eleven (11) blind rivets (W707638-S900C) or MIG plug welds. (Refer to Figure 1).
- Black squares represent the location of two (2) rivets (W702512-S900C) or MIG plug welds. (Refer to Figure 1).



**FIGURE 1**

## **FIGURE 2 RIVET LOCATIONS**

- Black dots represent the location of blind rivets (W707638-S900C) or MIG plug welds. (Refer to Figure 2).
  - 5.5 foot box eighteen (17) blind rivets (W707638-S900C) or MIG plug welds.
  - 6.5 foot box twenty-two (21) blind rivets (W707638-S900C) or MIG plug welds.
  - 8.0 foot box twenty-six (26) blind rivets (W707638-S900C) or MIG plug welds.
- Black pentagon represent fastener (W708464-S450B). (Refer to Figure 2).



**FIGURE 2**  
**6.5' BOX SHOWN**

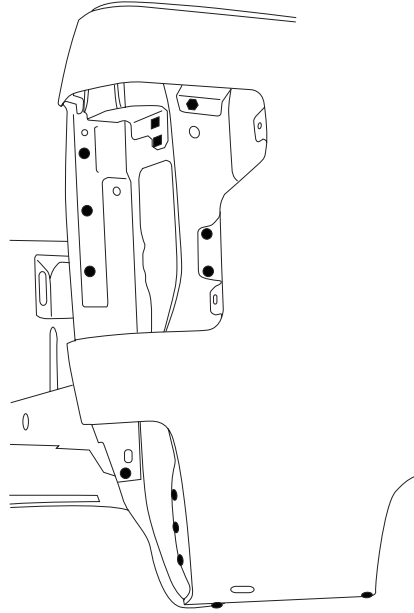
SKFL34-9527840-AB

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### **FIGURE 3 RIVET LOCATIONS**

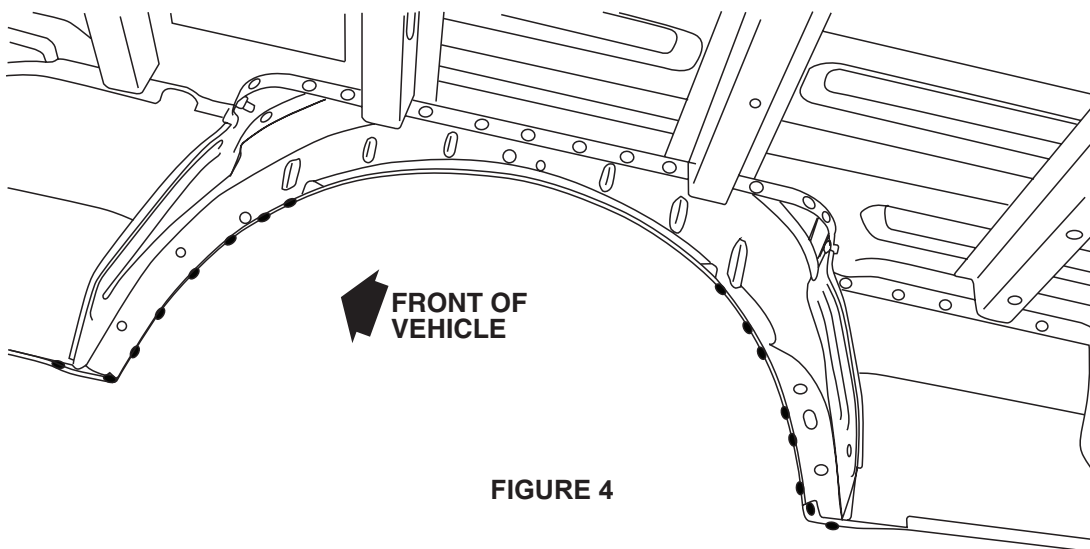
- Black dots represent the location of eleven (10) blind rivets (W707638-S900C) or MIG plug welds. (Refer to Figure 3).
- Black squares represent the location of two (2) rivets (W702512-S900C) or MIG plug welds. (Refer to Figure 3).
- Black pentagon represent the location of one (1) fastener (W708464-S450B). (Refer to Figure 3).



**FIGURE 3**

### **FIGURE 4 RIVET LOCATIONS**

- Black dots represent the location of sixteen (15) blind rivets (W707638-S900C) or MIG plug welds. (Refer to Figure 4).



**FIGURE 4**

SKFL34-9527840-AB

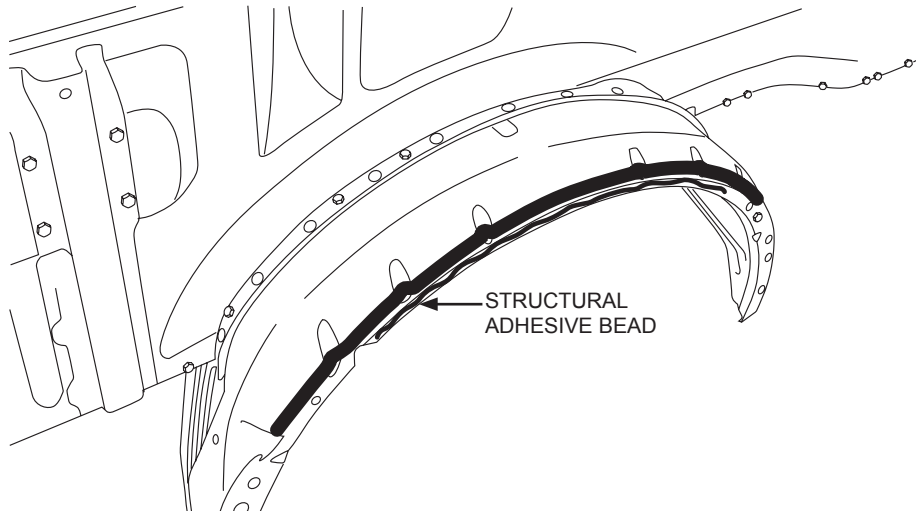
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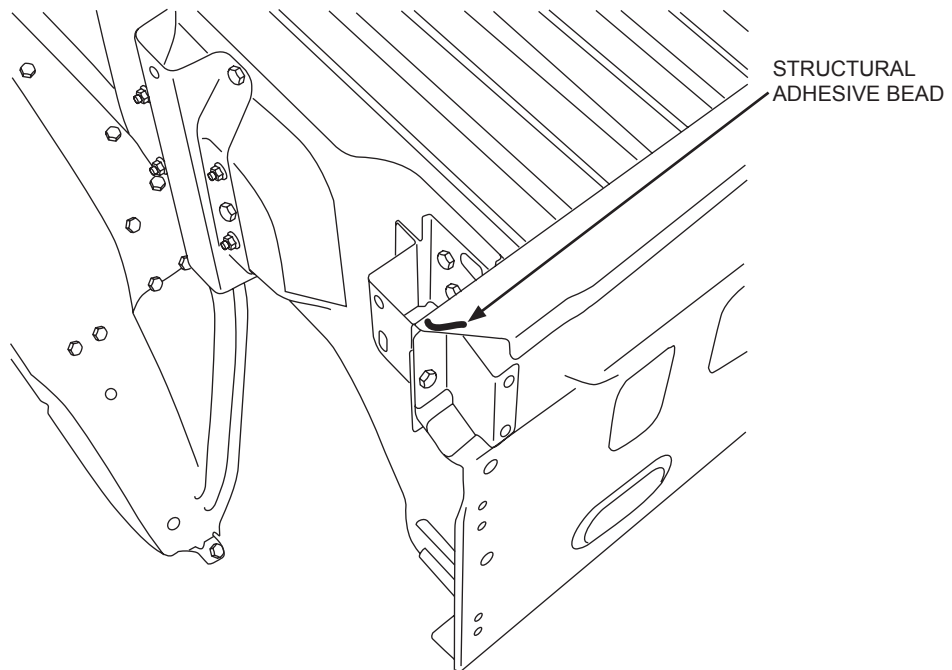
**F-SERIES BOX SIDE OUTER ASSEMBLY -  
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- (Refer to Figure 5) for structural adhesive bead size 6mm width 3mm height.



**FIGURE 5**

- (Refer to Figure 5) for structural adhesive bead size 4mm width 2mm height.



**FIGURE 6**

