

F-SERIES BODY INSTALLATION FOR ALL CABS OUTER COWL TOP - SERVICE KIT INSTRUCTIONS

KIT		
Part Number	Description	Quantity
FL34-1502015-AL	Cowl Top Outer - All Cabs	1
SKFL34-1502015-AA	Instruction Sheet	1

NOT INCLUDED IN KIT (PROCURE LOCALLY)		
Part Number	Description	Quantity
W702512-S437	Blind Rivet	38
W708777-S437	Blind Rivet	4
W790376-S900	Solid rivet	32
W708713-S900	Self-Piercing Rivet (SPR) Code AS	32
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.

SKFL34-1502015-AA

SHEET 1 OF 2



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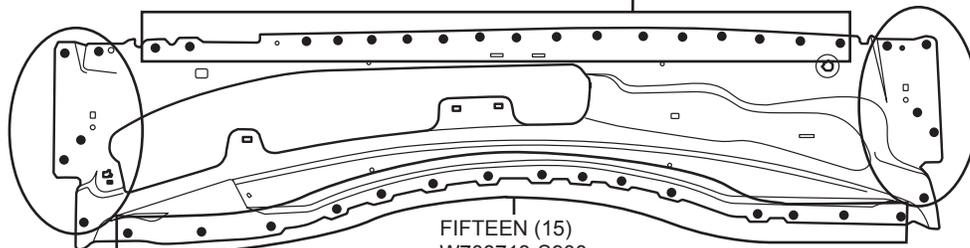
**F-SERIES BODY INSTALLATION FOR ALL CABS OUTER
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SQUARED NUMBERS ARE PRO SPOT MANDRELS

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

SEVENTEEN (17)
W708713-S900
AS DZ09-025/H
OR
W702512-S900C
BLIND RIVETS

1 **①**



FRONT OF VEHICLE

FIFTEEN (15)
W708713-S900
AS DZ09-025/H
OR
W702512-S900C
BLIND RIVETS

1 **①**

SEE VIEW A

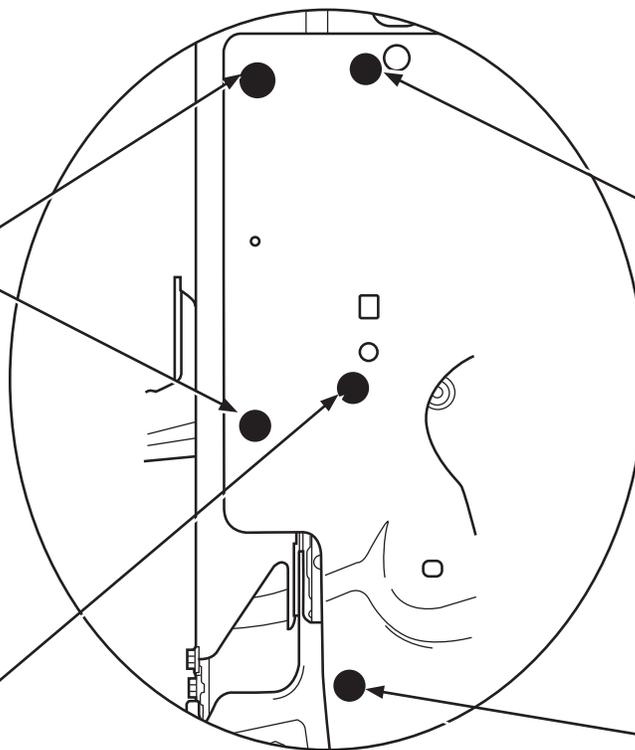
FIGURE 1

TWO (2) W702512-S900C
BLIND RIVETS - COWL TOP
OUTER TO FRONT END
APRON TUBE

ONE (1) W708777-S900C
BLIND RIVET COWL TOP
OUTER THRU COWL SIDE
TO COWL LOWER

ONE (1) W702512-S900C
BLIND RIVET - COWL TOP
OUTER TO COWL SIDE

ONE (1) W708777-S900C
BLIND RIVET - COWL TOP
OUTER TO HINGE PILLAR
TO COWL SIDE



VIEW A

LEFT HAND SIDE SHOWN, RIGHT HAND SIDE TYPICAL

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SHEET 2 OF 2



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