

CERTAIN 2018 MODEL YEAR F-150 RAPTOR SUPERCAB VEHICLES — ROOF CENTER BOW K-BRACE RIVET INSTALLATION

OVERVIEW

In the affected vehicles, the roof center bow K-brace may be missing rivets to the roof rail structure. Vehicles with missing K-brace roof rivets may have reduced structural integrity, potentially increasing the risk of injury in a rollover. Dealers are to drill and install two rivets on each side of the roof structure following the Service Procedure below.

SERVICE PROCEDURE

Recommended Tool List:

3/8" Drive Ratchet (Power Tool)
3/8" Drive Ratchet (Hand Tool)
3/8" Drive 10mm Deep Socket
1/4" Drive Ratchet (Power Tool)
1/4" Drive Ratchet (Hand Tool)
1/4" Drive 7mm Deep Socket
1/4" Drive T20 Torx® Bit
Drill
1/4" (6.5mm) Drill Bit
Drill Bit Stop Collar
Small Flathead Screwdriver
Pneumatic Rivet Gun
Adhesive Application Gun



1. Remove the headliner. Please follow the Workshop Manual (WSM) procedures in Section 501-05.
2. Lower, but do not fully remove the right hand (RH) and left hand (LH) side curtain airbags.
See Figure 1.

⚠ WARNING: The ignition must remain in the OFF position for a minimum of 1 minute before disconnecting the side curtain airbag electrical connectors. Leave the ignition in the OFF position until this service procedure is completed.

- a. Disconnect both side curtain airbag electrical connectors.
- b. Remove the four fasteners on each side, as shown in Figure 1.
- c. Lower the RH and LH side curtain airbags.
- d. Using a drop cloth or equivalent, cover the airbags to avoid metal shaving contamination.

NOTE: LH side curtain airbag shown, RH similar.

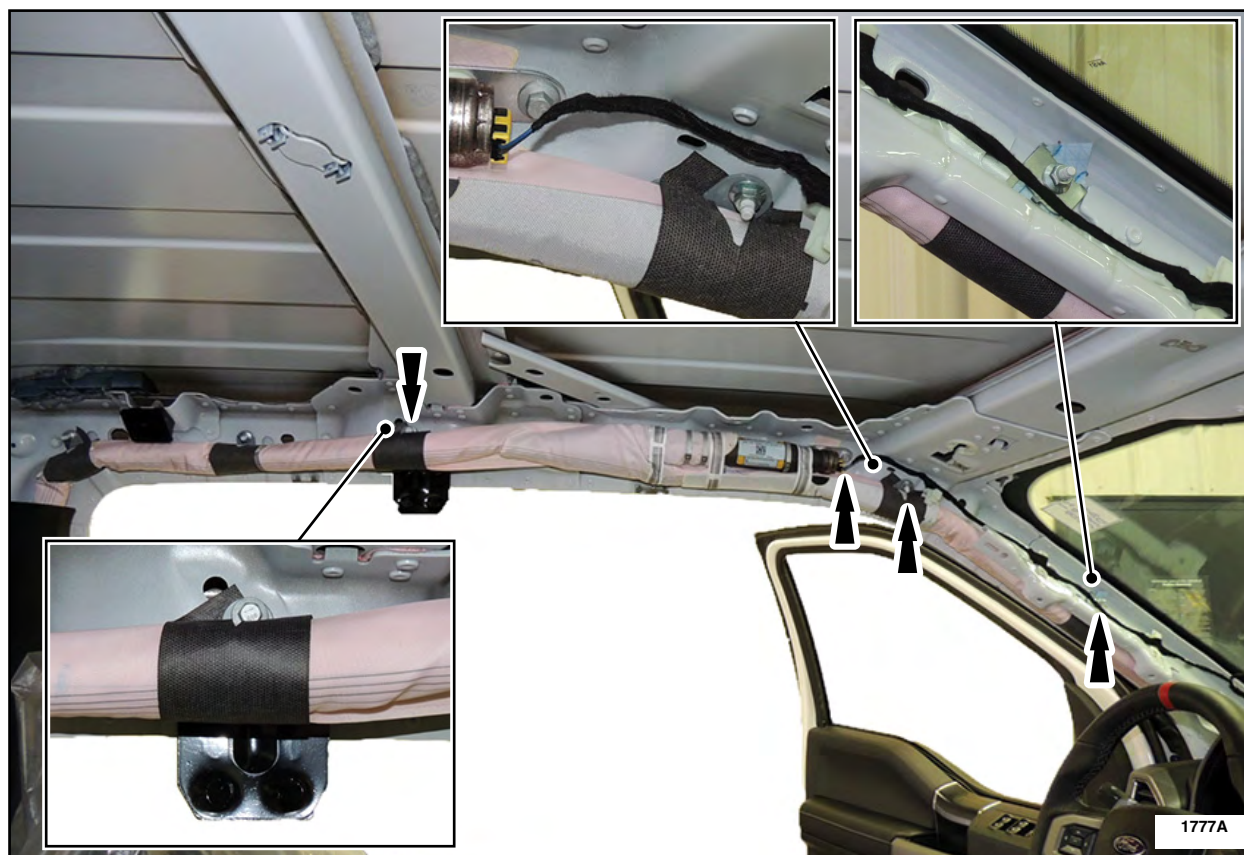


FIGURE 1



3. On both sides, mark the drilling locations on the roof rail at the center bow K-brace. See Figure 2.

NOTE: LH roof brace shown, RH similar.

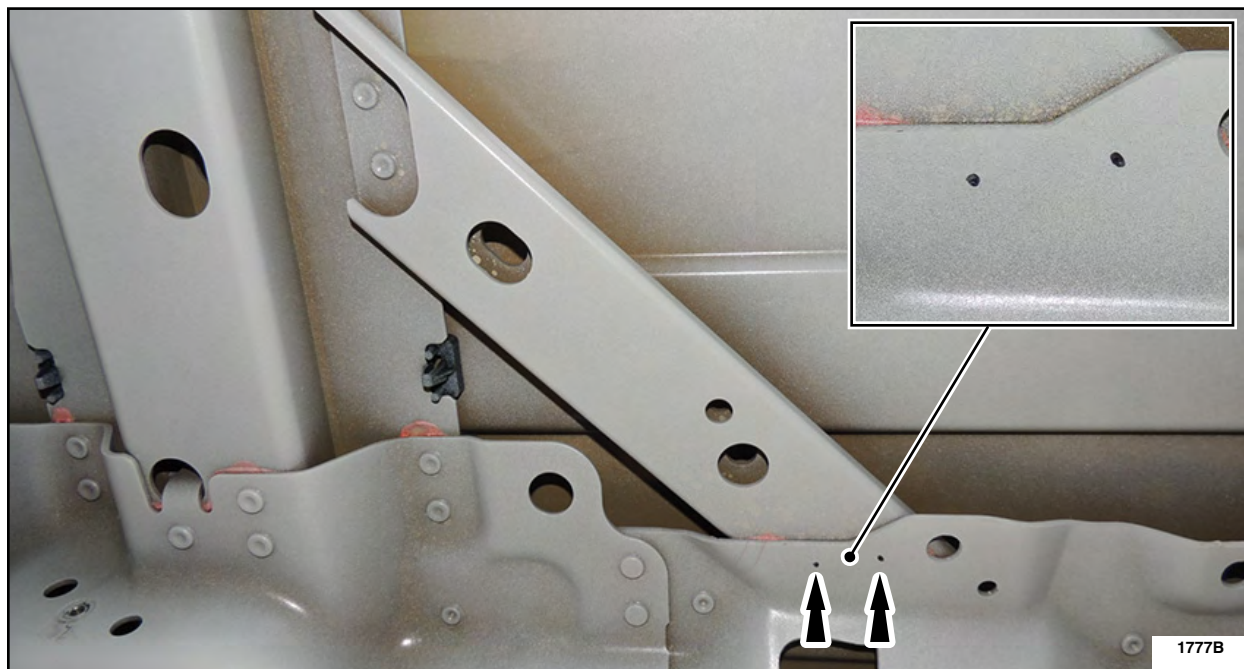


FIGURE 2

4. Using a 1/4" (6.5 mm) drill bit, install a drill stop set at a depth of 3/8" (9.5 mm). See Figure 3.

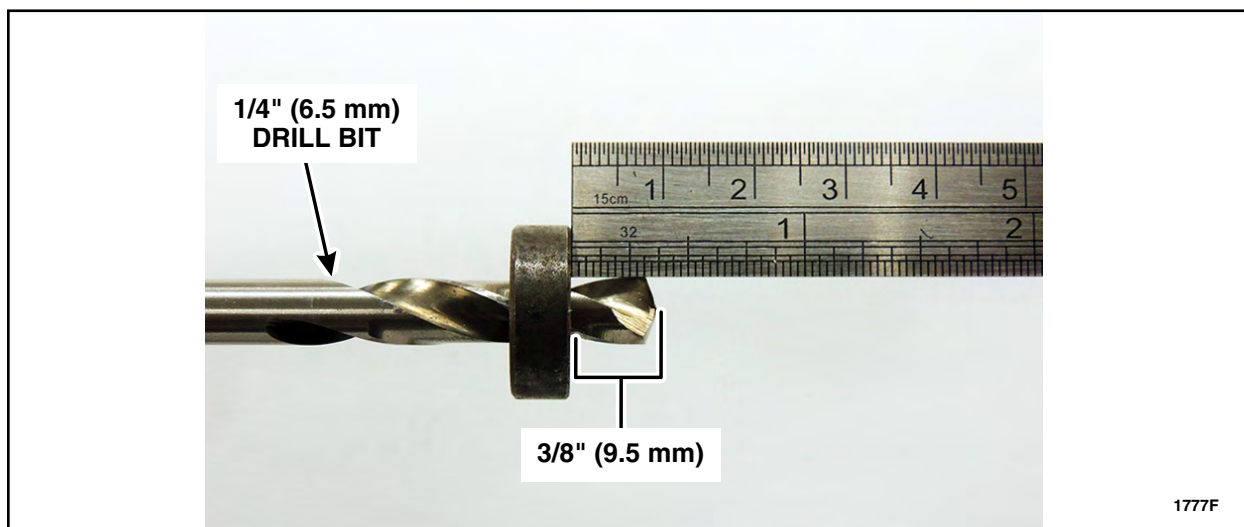


FIGURE 3

5. Temporarily position a suitable flat piece of metal above the RH and LH roof K-brace to prevent damage to the roof sheet metal. See Figure 4.

NOTE: Figure 4 shows a clean paint can lid being used above the roof K-brace to protect the roof sheet metal.



6. Drill the previously marked roof K-brace holes on the RH and LH side. See Figure 4.

- Using an assistant, hold a vacuum near the drilling location to capture the metal shavings.
- Remove the temporary flat piece of metal used to prevent damage to the roof sheet metal once drilling is complete.

NOTE: LH roof brace shown, RH similar.

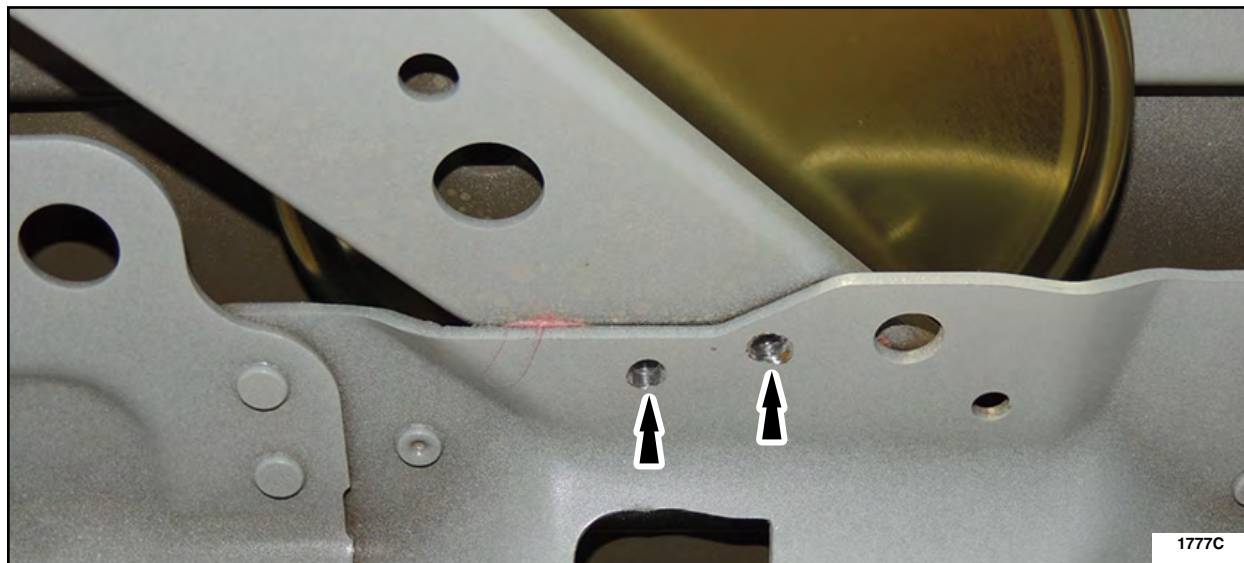


FIGURE 4

NOTE: Once the metal panel bonding adhesive is applied on both sides, the rivets should be installed within the specified work time of the adhesive that is being used.

7. Apply metal panel bonding adhesive where the RH and LH roof K-brace meets the roof rail. See Figure 5.

NOTE: LH roof brace shown, RH similar.

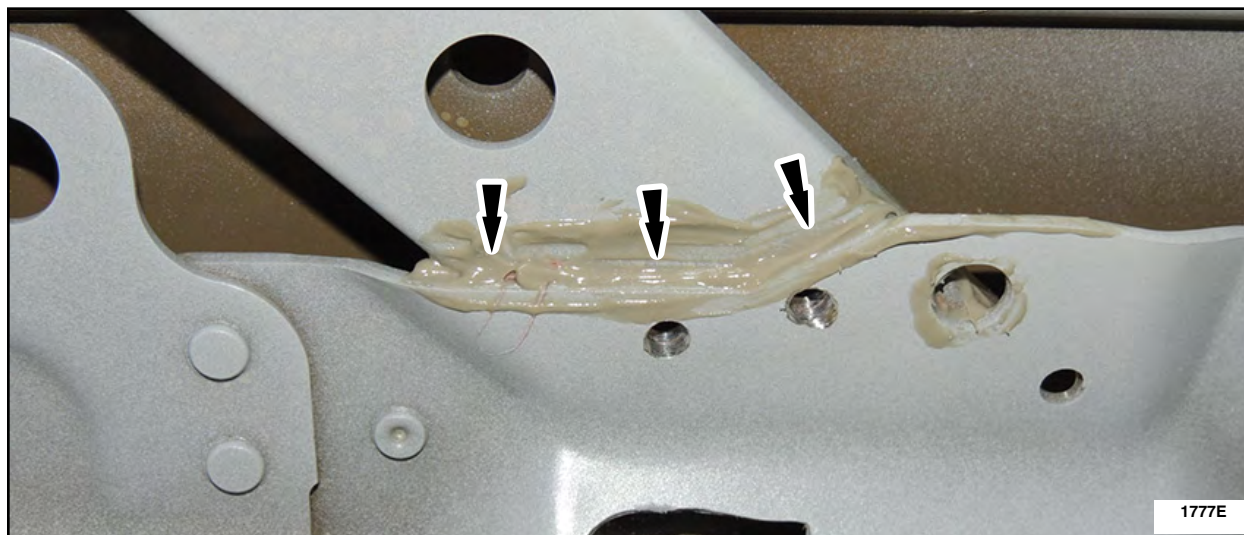


FIGURE 5



8. Using a pneumatic rivet gun, install two rivets into the RH and LH roof K-brace. See Figure 6.

NOTE: LH roof brace shown, RH similar.

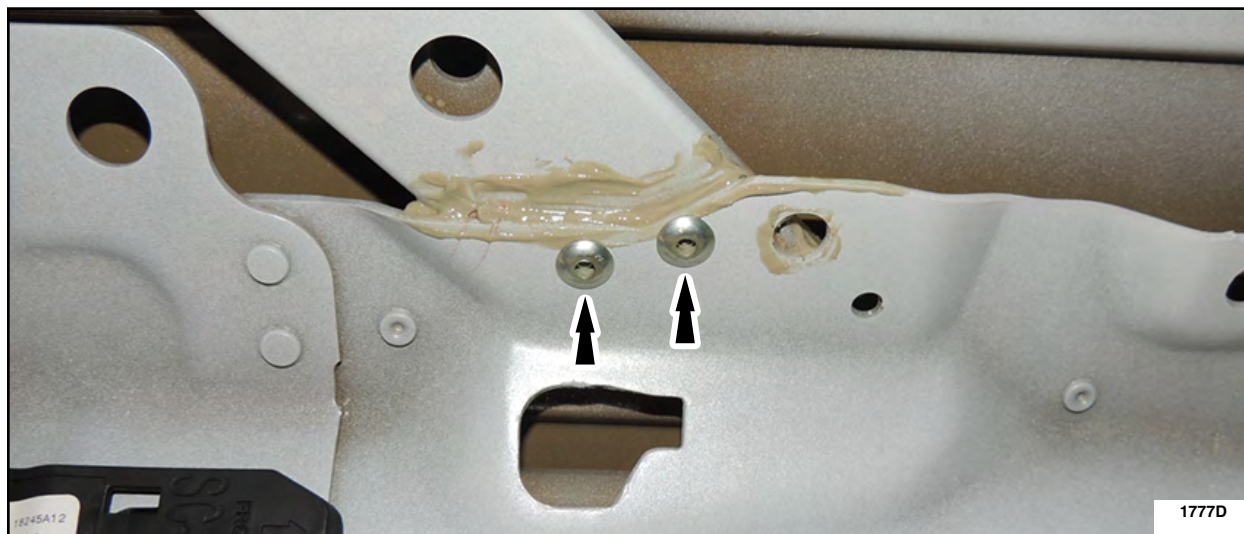


FIGURE 6

9. Reinstall the RH and LH side curtain airbag.

- a. Remove the protective cover from both side curtain airbags.
- b. Place the RH and LH side curtain airbag in its original position.
- c. Install the four RH and LH side curtain airbag fasteners shown in Figure 1.
 - Tighten fasteners to 93 lb.in (10.5 Nm).
- d. Connect both side curtain airbag electrical connectors.

10. Reinstall the headliner. Please follow the WSM procedures in Section 501-05.

11. Vacuum any metal shavings from the vehicle interior.

