

F-SERIES COWL TOP INNER INSTALLATION - SERVICE KIT INSTRUCTIONS ALL CABS

KIT		
Part Number	Description	Quantity
FL34-1502018-AJ	Cowl Top Inner All Cabs	1
SKFL34-1502018-AA	Instruction Sheet	1

KIT		
Part Number	Description	Quantity
FL34-15020K64-AB	Wiper Blade Bracket (LH)	1
SKFL34-1502018-AA	Instruction Sheet	1

KIT		
Part Number	Description	Quantity
FL34-15020B72-AA	Wiper Blade Bracket (RH)	1
SKFL34-1502018-AA	Instruction Sheet	1

KIT		
Part Number	Description	Quantity
FL34-15044H29-AC	Brake Pedal Reinforcement	1
SKFL34-1502018-AA	Instruction Sheet	1

KIT		
Part Number	Description	Quantity
FL34-15045K03-AD	Instrument Panel Reinforcement	1
SKFL34-1502018-AA	Instruction Sheet	1

NOT INCLUDED IN KIT (PROCURE LOCALLY)		
Part Number	Description	Quantity
W702512-S900C	Blind Rivet	86
W708777-S900C	Blind Rivet	22
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

SKFL34-1502018-AA

SHEET 1 OF 4

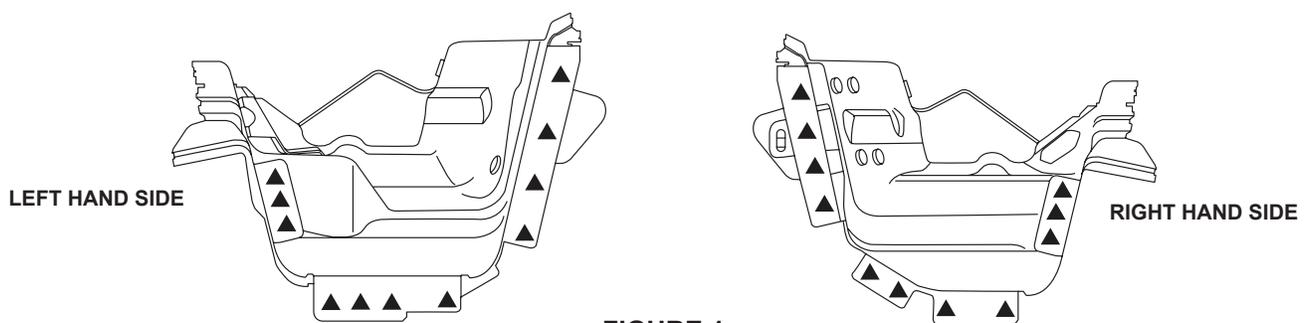


SERVICE GUIDELINES:

- 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.
-
- Black triangles represent the location of the blind rivets (W708777-S900C) eleven (11) per side between the cowl inner and the cowl sides. (Refer to Figure 1).



SKFL34-1502018-AA

SHEET 2 OF 4



CPR © 2014 FORD MOTOR COMPANY
DEARBORN, MICHIGAN 48121
10-14

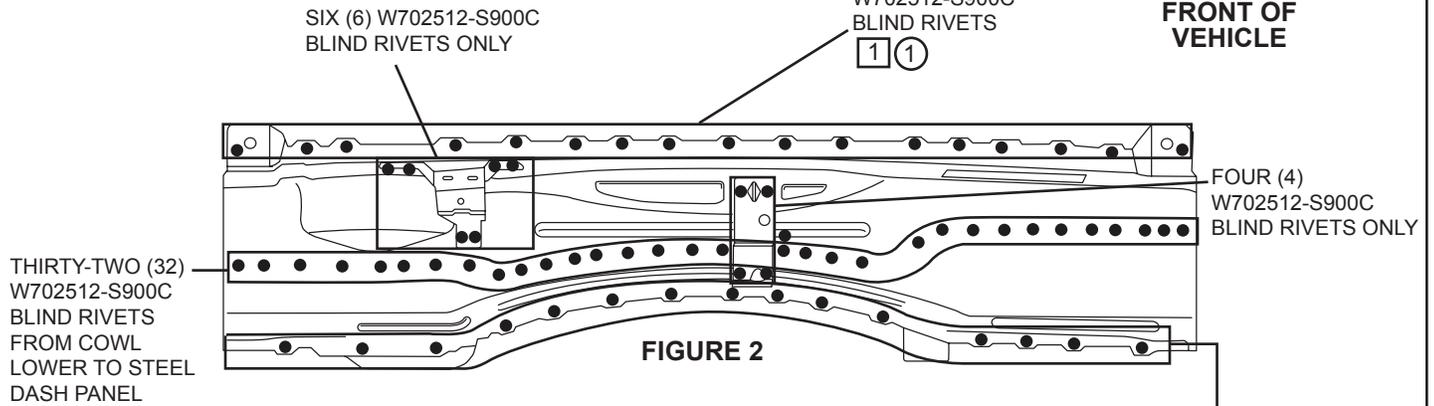
**F-SERIES COWL TOP INNER INSTALLATION -
SERVICE KIT INSTRUCTIONS ALL CABS**

**NOTE: Service SPR rivets may be used on the top also on forward flange and fifteen (15) on rear flange.
(Refer to Figure 2).**

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 INSTALLED
USING MANDREL
DZ09-025/H
OR
W702512-S900C
BLIND RIVETS

↑
**FRONT OF
VEHICLE**



FIFTEEN (15)
W708713-S900
AS SPR RIVETS
OR W702512-S900C
BLIND RIVETS
FROM
COWL LOWER TO COWL
TOP OUTER

TWELVE (12) W702512-S900C
BLIND RIVETS ONLY

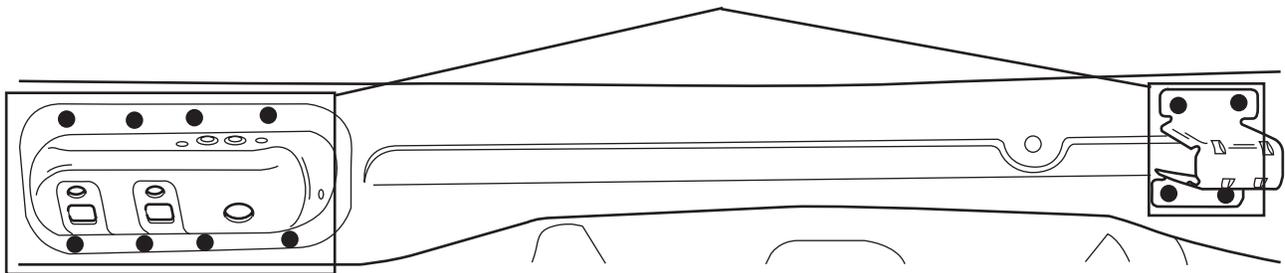


FIGURE 3

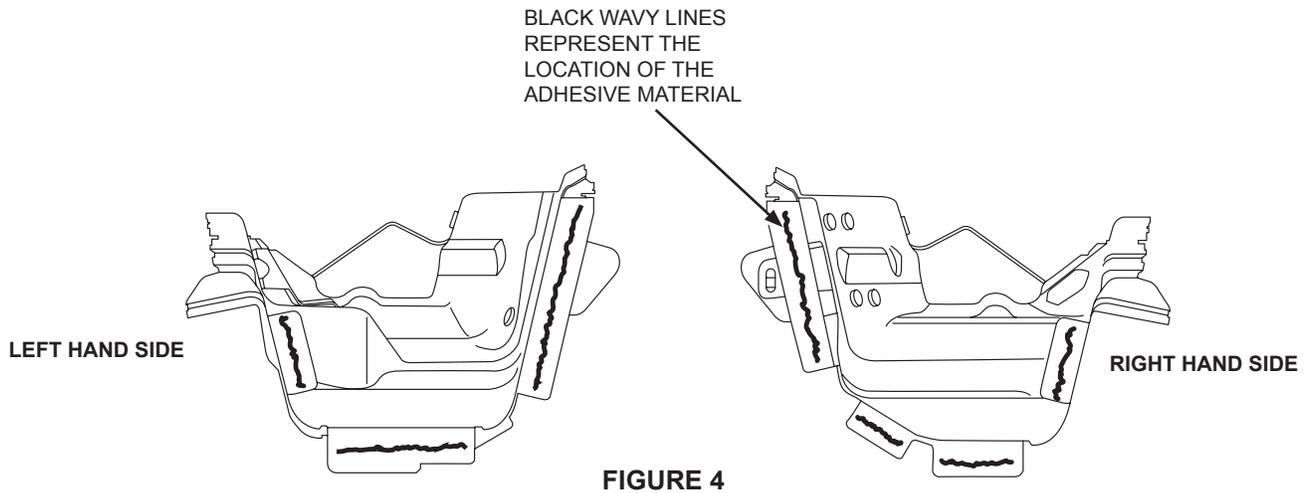
SKFL34-1502018-AA

SHEET 3 OF 4



- Black wavy lines represents the location of the adhesive material between the cowl inner and the cowl sides. (Refer to Figure 4).

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 4).

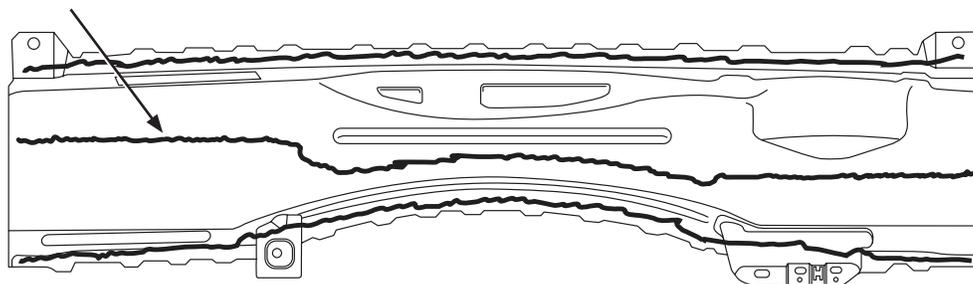


- Black wavy lines represents the location of the adhesive material between the cowl inner and the dash panel and between cowl inner and cowl top outer.

NOTE: It would be suggested that the adhesive be applied on the dash flange. (Refer to Figure 1).

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 5).

BLACK WAVY LINES REPRESENT THE LOCATION OF THE ADHESIVE MATERIAL



SKFL34-1502018-AA

SHEET 4 OF 4



CPR © 2014 FORD MOTOR COMPANY
DEARBORN, MICHIGAN 48121
10-14

**F-SERIES COWL TOP INNER INSTALLATION -
SERVICE KIT INSTRUCTIONS ALL CABS**