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1986 FORD Fiesta 3 Doors OEM Service and Repair Workshop Manual

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B-Pillar Outer Panel - SuperCrew

<i>501-29 Side Panel Sheet Metal Repairs</i>	<i>2022 F-150</i>
<i>Removal and Installation</i>	<i>Procedure revision date: 10/23/2020</i>

B-Pillar Outer Panel - SuperCrew

Removal

WARNING

Electric vehicles damaged by a crash may have compromised high voltage safety systems and present a potential high voltage electrical shock hazard. Exercise caution and wear appropriate Personal Protective Equipment (PPE) safety gear, including high voltage safety gloves and boots. Remove all metallic jewelry, including watches and rings. Isolate the HV system as directed by the Ford Emergency Response Guide for the vehicle. Failure to follow these instructions may result in serious personal injury or death.

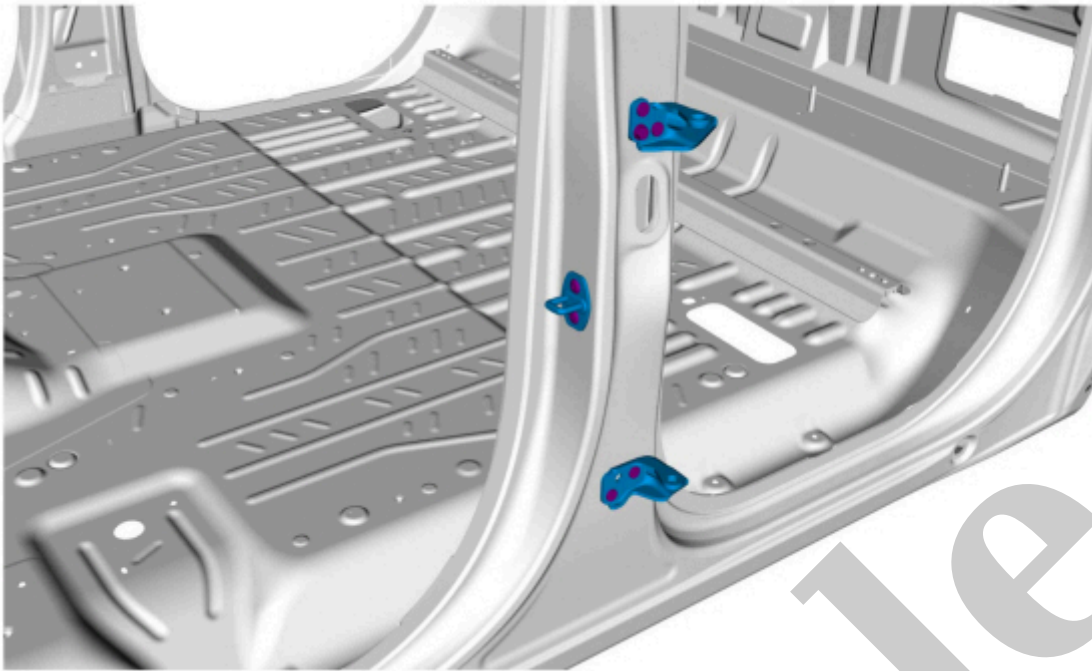
NOTICE

Battery electric vehicle (BEV), hybrid electric vehicle (HEV) and plug-in hybrid electric vehicle (PHEV) contain a high-voltage battery. Before cutting or welding near the high-voltage battery it must be removed to avoid damage.

1. **WARNING**

Before beginning any service procedure in this manual, refer to health and safety warnings in section 100-00 General Information. Failure to follow this instruction may result in serious personal injury.

Refer to: [Health and Safety Precautions](#)(100-00 General Information, Description and Operation).



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6. Remove the front and rear door tread plates and door opening weather strips.

7. Remove the side curtain air bag.

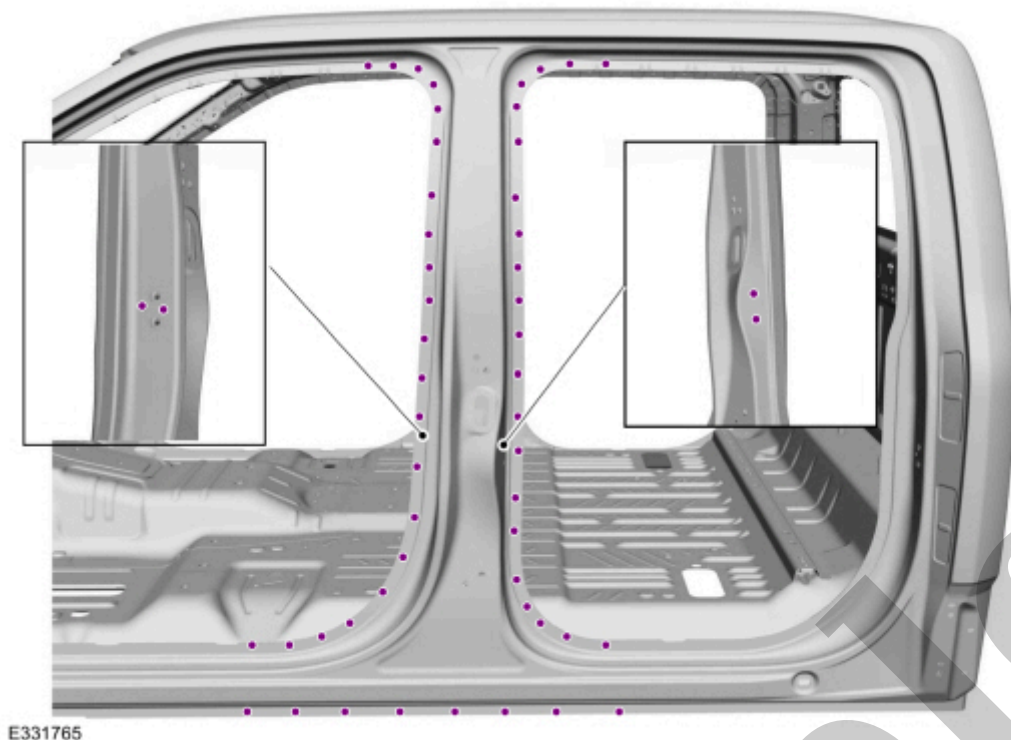
Refer to: [Side Curtain Airbag - SuperCrew](#) (501-20B Supplemental Restraint System, Removal and Installation).

8. Outer panel only

Carefully cut the outer panel only.

Use the General Equipment: Air Body Saw

Use the General Equipment: Spherical Cutter



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10. **NOTE**

Aluminum body panels are highly receptive to heat transfer. With the extensive use of structural adhesives and non-structural sealers used in vehicle construction, the potential of heat transfer could impact adhesives and sealers in non-associated panels during the repair process. Many repairs areas that utilize structural adhesive may be separated after fastener removal by using a panel chisel along the joint/flange. Using heat not exceeding 425° F to loosen a bonded panel should only be done when **all panels in the joint** will be replaced and new adhesive applied.

Break the adhesive bond and remove the B-pillar outer panel.

Use the General Equipment: Hot Air Gun



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2. Cut the service panel to fit repair.

Use the General Equipment: Air Body Saw

Use the General Equipment: Spherical Cutter

4. **NOTE**

The use of a backer plate when creating butt weld joints will produce a stronger and more uniform repair.

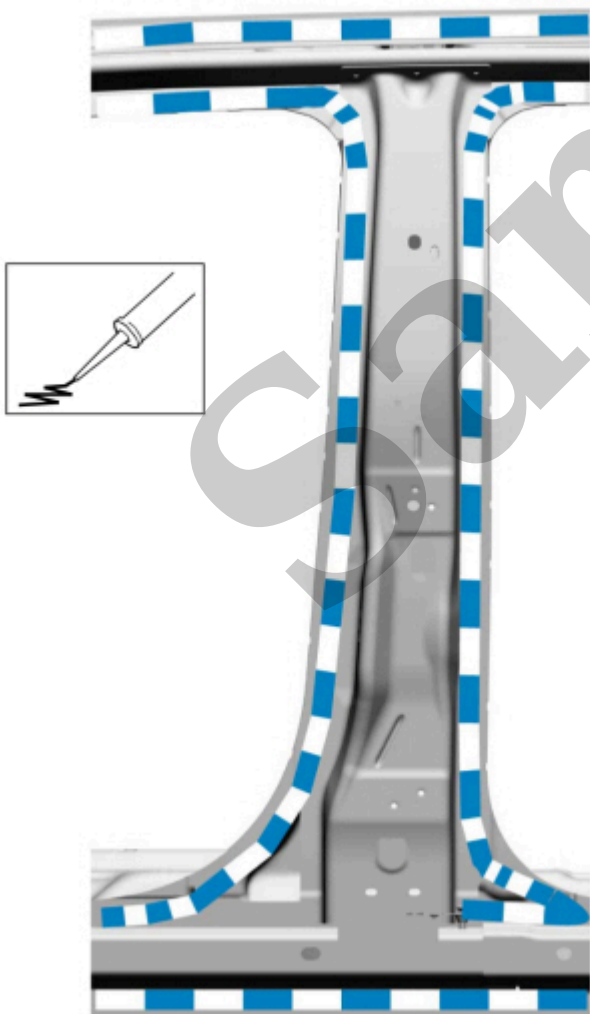
In butt-weld areas:

create a backer plate from an unused portion of the old body panel or service replacement panel and install on the vehicle at each sectioning joint.

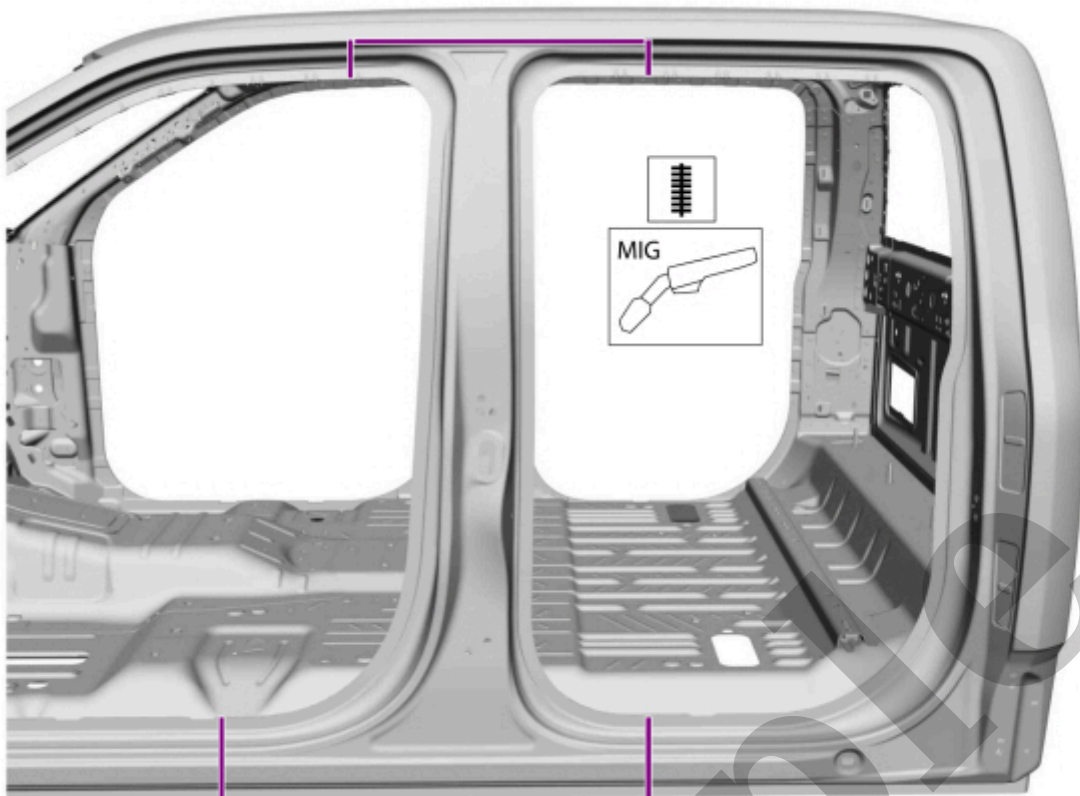
Refer to: [Joining Techniques](#)(501-25 Body Repairs - General Information, General Procedures).

5. Apply adhesive to the body side.

Material : Metal Bonding Adhesive / TA-1, TA-1-B, 3M™ 08115, LORD Fusor® 108B, Henkel Teroson EP 5055



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8. NOTE

Do not install SPR (self-piercing rivet) fasteners directly in old SPR (self-piercing rivet) fastener location. SPR (self-piercing rivet) fasteners must be installed adjacent to the original location matching original quantity.

NOTE

Solid rivets or blind rivet fasteners may be used in place of SPR (self-piercing rivet) fasteners after enlarging existing holes to 6.5 mm.

Install fasteners.

Item	SPR (self-piercing rivet) Number	SPR (self-piercing rivet) Code	Henrob® Car-O-Liner®, CMO®, Chief®, Spanesi® Wielande and Schill® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
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9. Metal finish using typical aluminum metal finishing techniques and a fiber-based body filler.

Refer to: [Special Repair Considerations for Aluminum Repairs](#)(501-25 Body Repairs - General Information, Description and Operation).

10. Refinish the repair using a Ford approved paint system.

11. Install the side curtain air bag.

Refer to: [Side Curtain Airbag - SuperCrew](#)(501-20B Supplemental Restraint System, Removal and Installation).

12. Install the front and rear door weather strips and scuff plates.

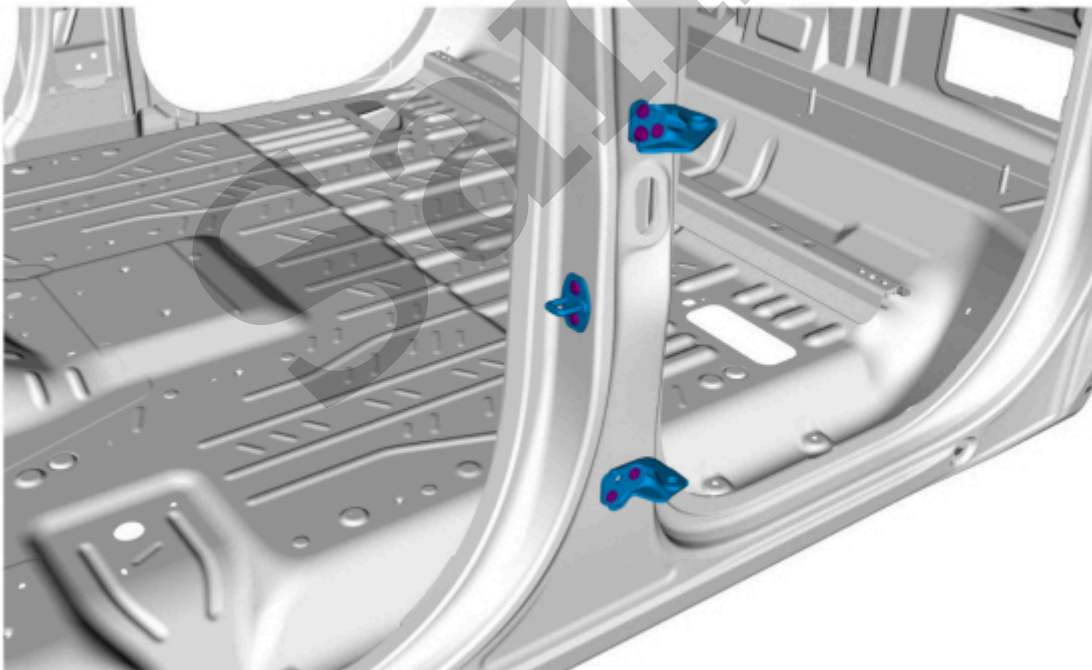
13. Install the front door striker and rear door hinges.

- Front door striker.

Torque : 18 lb.ft (25 Nm)

- Rear door hinges.

Torque : 22 lb.ft (30 Nm)



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14. Install and align the rear door.

C-Pillar Reinforcement

501-29 Side Panel Sheet Metal Repairs	2022 F-150
Removal and Installation	Procedure revision date: 10/23/2020

C-Pillar Reinforcement

Removal

NOTICE

Body side sectioning is prohibited within 50mm of door hinge, door striker and restraints anchoring points.

All vehicles

WARNING

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SuperCab and SuperCrew Cab

5. Remove the rear seat.

Refer to: [Rear Seat LH - SuperCab](#)(501-10B Rear Seats, Removal and Installation).

Refer to: [Rear Seat LH - SuperCrew](#)(501-10B Rear Seats, Removal and Installation).

Regular Cab

6. Remove the front seat.

Refer to: [Front Seat](#)(501-10A Front Seats, Removal and Installation).

SuperCab

7. Remove the rear door hinge.