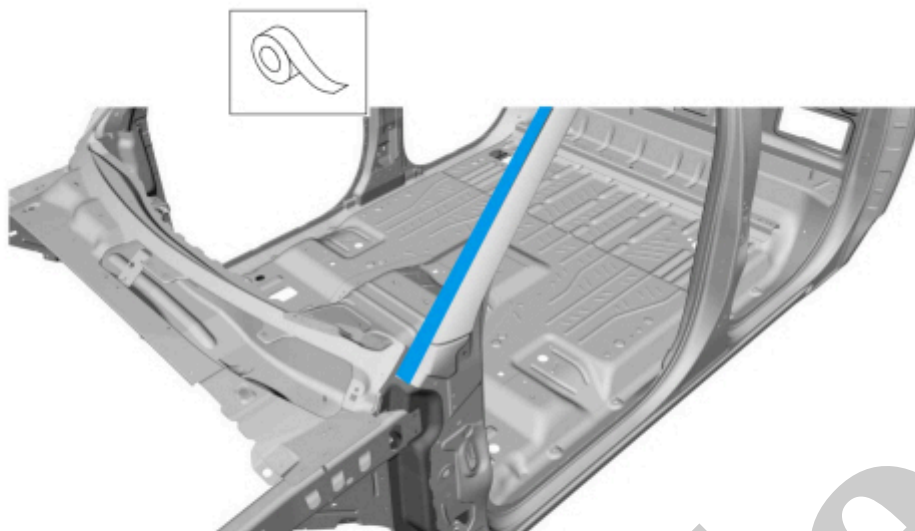


Your Ultimate Source for OEM Repair Manuals

FactoryManuals.net is a great resource for anyone who wants to save money on repairs by doing their own work. The manuals provide detailed instructions and diagrams that make it easy to understand how to fix a vehicle.

1987 FORD Fiesta 3 Doors OEM Service and Repair Workshop Manual

[Go to manual page](#)



E331523

[Click here to learn about symbols, color coding, and icons used in this manual.](#)

22. Install the windshield.

Refer to: [Fixed Glass](#)(501-11 Glass, Frames and Mechanisms, General Procedures).

23. Install the front door hinges to the body.

Torque : 20 lb.ft (27 Nm)



B-Pillar and Reinforcement - SuperCrew

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

B-Pillar and Reinforcement - 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).

6. Remove the SPR (self-piercing rivet) fasteners.

Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer

Use the General Equipment: Belt Sander



[Click here to learn about symbols, color coding, and icons used in this manual.](#)

7. Remove and discard the FDS (flow drill screw) fasteners.

Use the General Equipment: Polydrive Bit Socket



[Click here to learn about symbols, color coding, and icons used in this manual.](#)

Installation

NOTICE

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

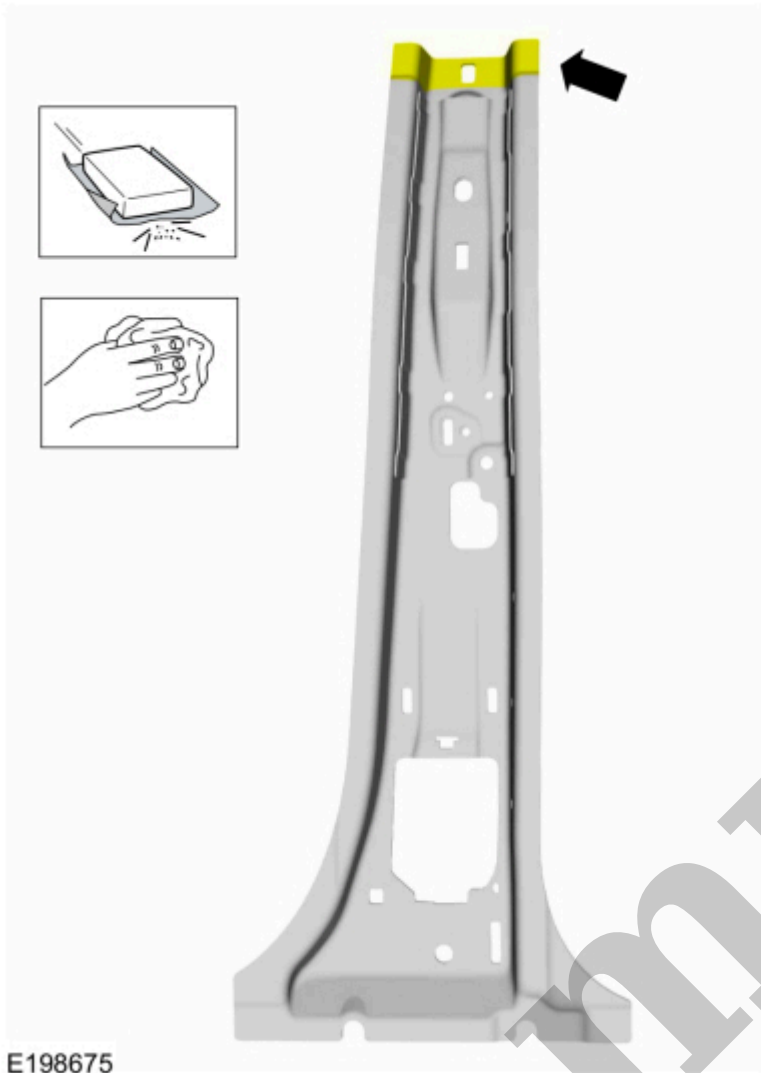
NOTE

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.



[Click here to learn about symbols, color coding, and icons used in this manual.](#)

3. Sand using 80 grit sand paper to remove e-coat and clean the B-pillar service panel lower mating surface.



[Click here to learn about symbols, color coding, and icons used in this manual.](#)

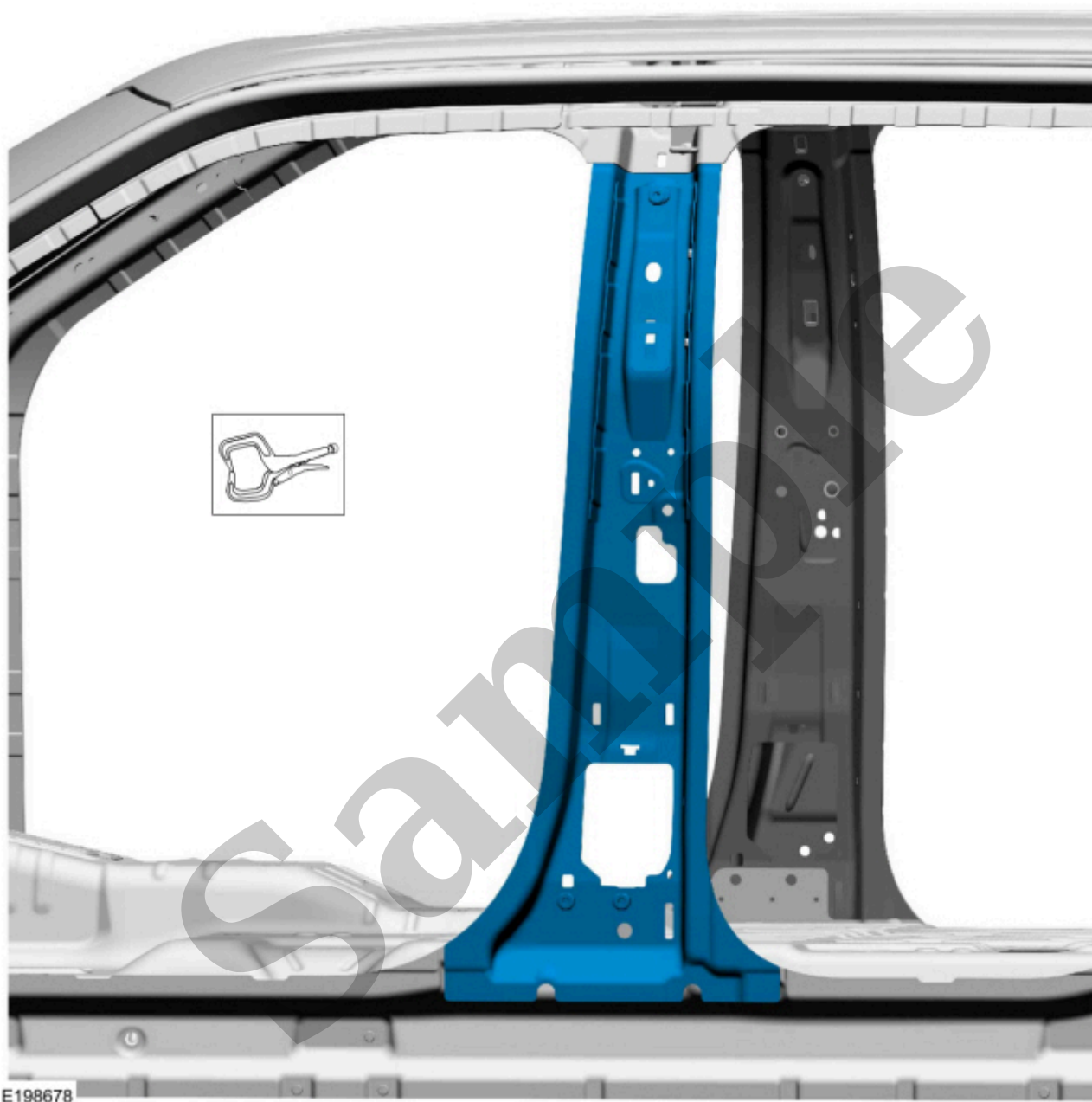
5. Apply adhesive.

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

[Click here to learn about symbols, color coding, and icons used in this manual.](#)

7. Install the B-pillar and clamp in position.

Use the General Equipment: Locking Pliers



[Click here to learn about symbols, color coding, and icons used in this manual.](#)

8. Drill for blind rivet fasteners.

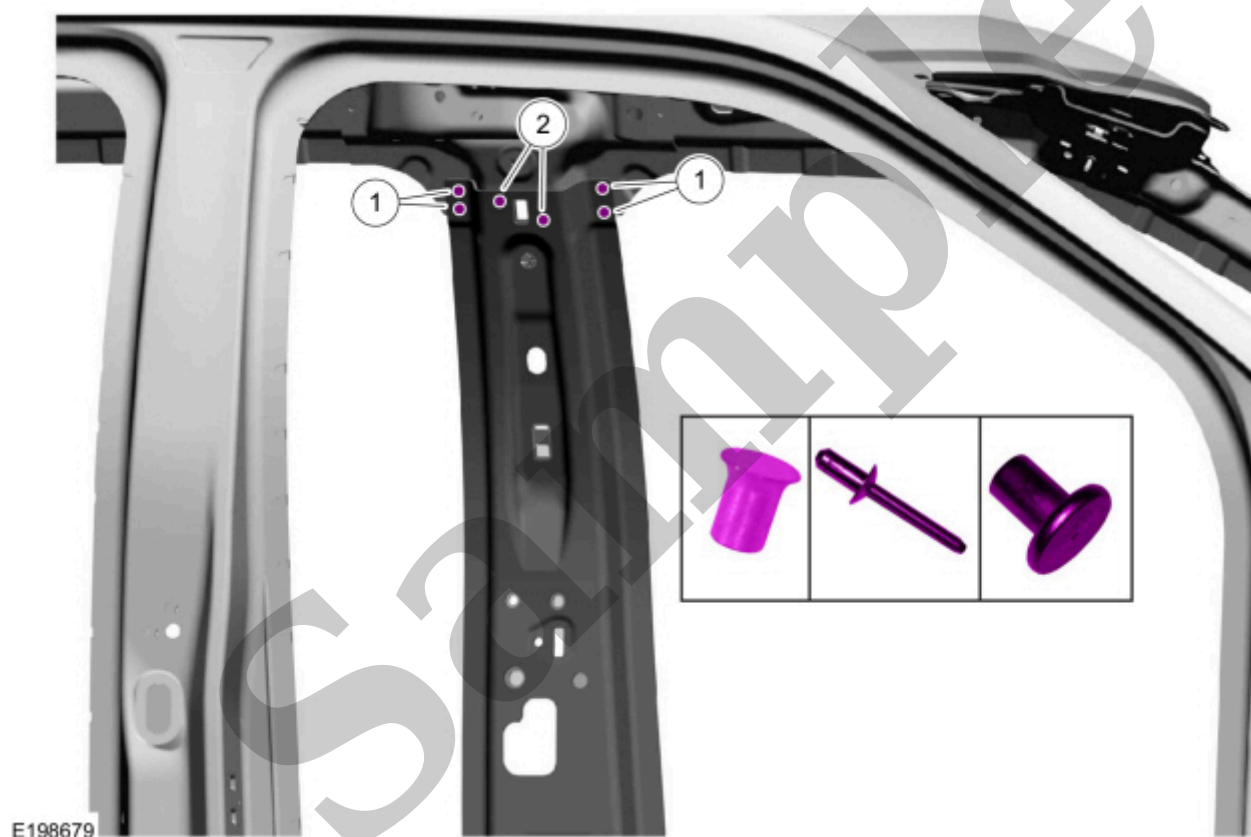
Use the General Equipment: 6.5 mm Drill Bit

1	W717186-S900	EN	DG11-200/H	SA-0400/SA-0401	-	W790376-S900	-
2	-	-	-	-	W708777-S900C	-	-

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

Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer

Use the General Equipment: Blind Rivet Gun



[Click here to learn about symbols, color coding, and icons used in this manual.](#)

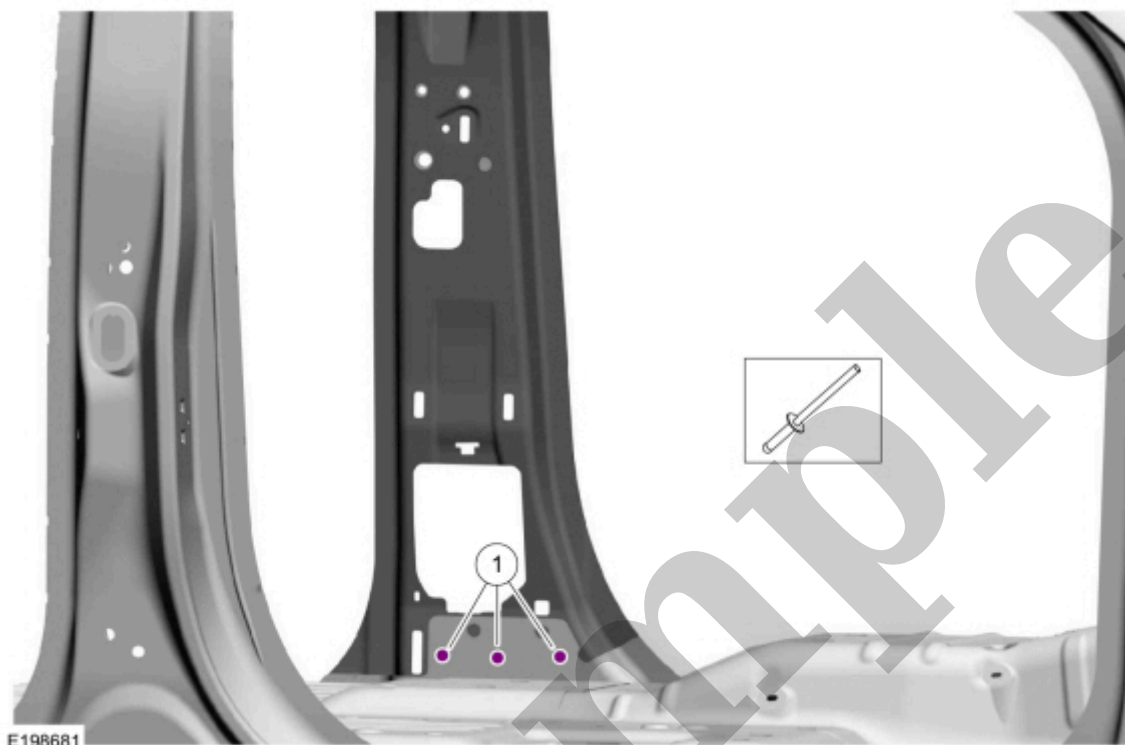
10. Drill 6.5 mm holes for blind rivet installation.

Use the General Equipment: 6.5 mm Drill Bit

1	-	-	-	-	W708777-S900C	-	-
---	---	---	---	---	---------------	---	---

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

Use the General Equipment: Blind Rivet Gun



[Click here to learn about symbols, color coding, and icons used in this manual.](#)

12. Refinish using a Ford approved paint system and typical refinishing techniques.

13. Install the rocker panel reinforcement.

Refer to: [Rocker Panel Inner Reinforcement - SuperCrew](#)(501-29 Side Panel Sheet Metal Repairs, Removal and Installation).

14. Install the side curtain air bag.

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

15. Install the front safety belt and safety belt height adjuster.

Refer to: [Front Seatbelt Retractor and Pretensioner - SuperCrew](#)(501-20A Seatbelt Systems, Removal and Installation).