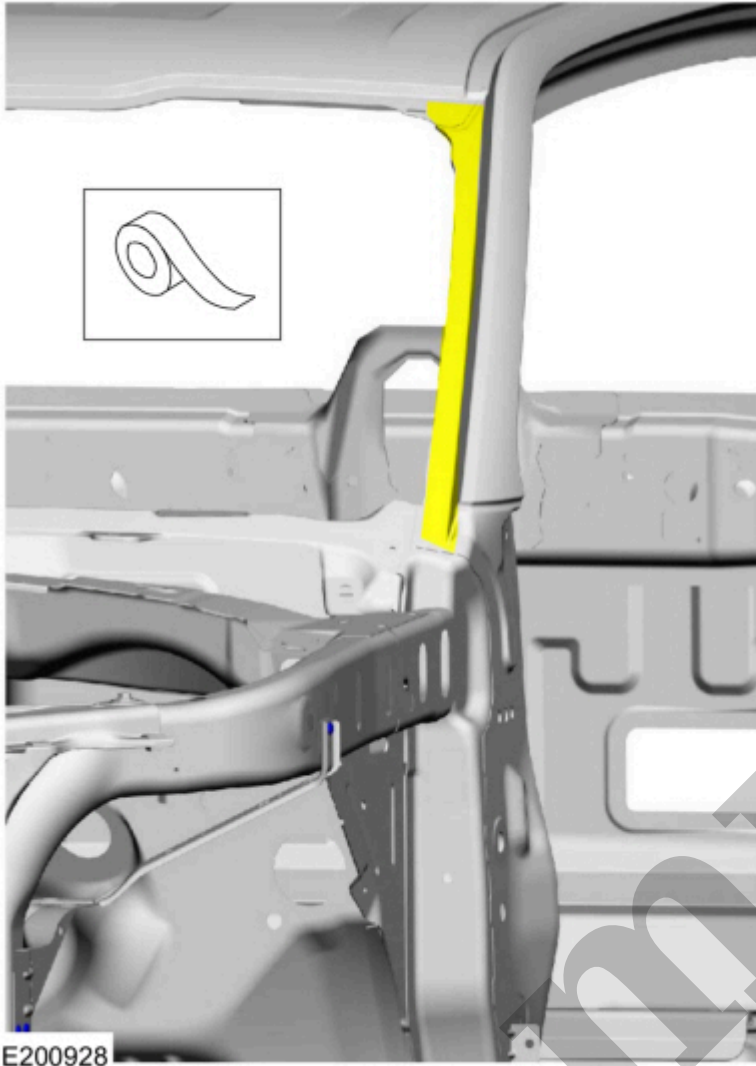


Your Ultimate Source for OEM Repair Manuals

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.

2006 FORD Fiesta 3 Doors OEM Service and Repair Workshop Manual

[Go to manual page](#)

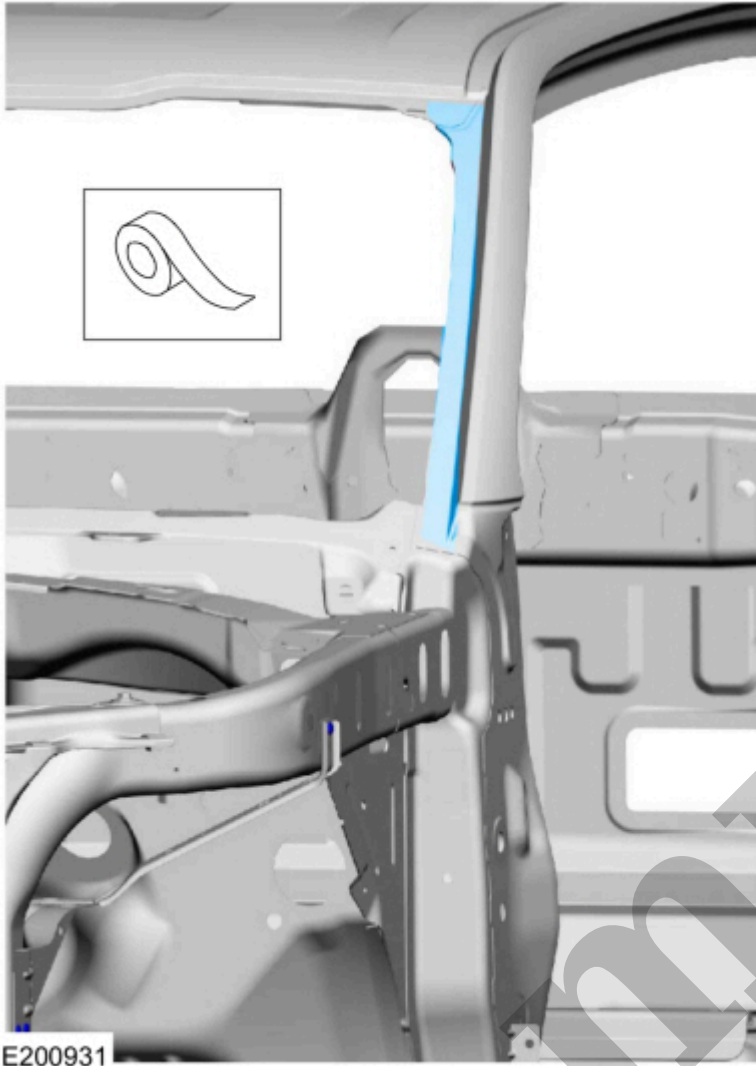


[Click here to learn about symbols, color coding, and icons used in this manual.](#)

52. **Seam Sealing:**

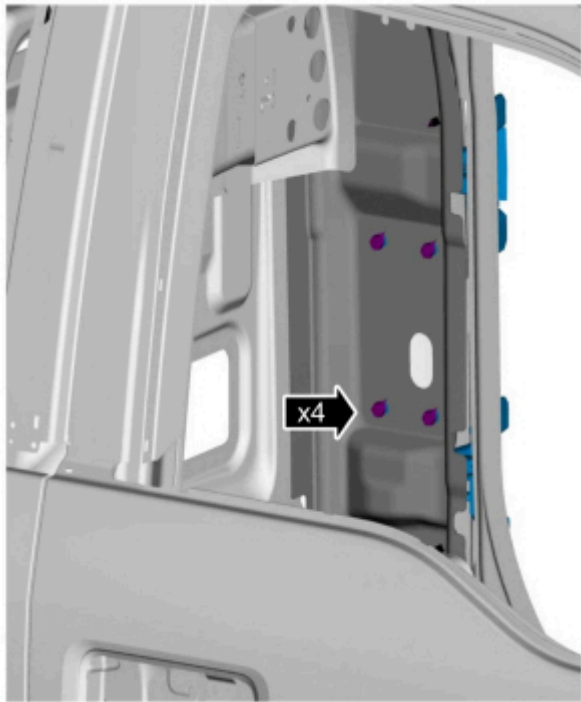
All seams must be sealed to production level.

Material : Seam Sealer / TA-2-B, 3M™ 08308, LORD Fusor® 803DTM

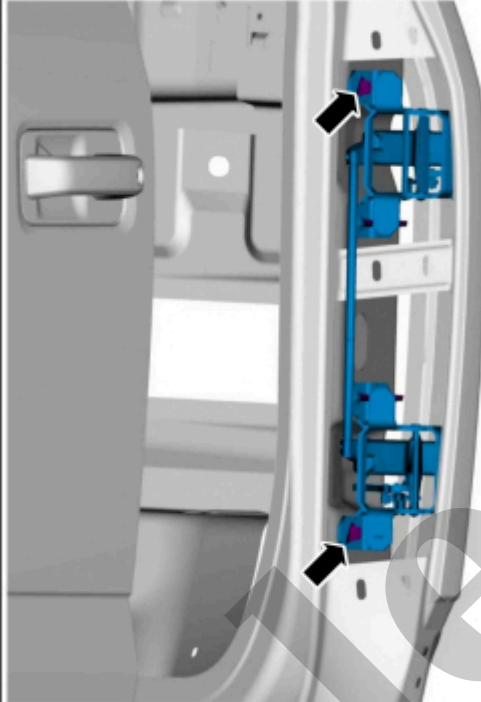


[Click here to learn about symbols, color coding, and icons used in this manual.](#)

55. Unmask the rear window opening channel.



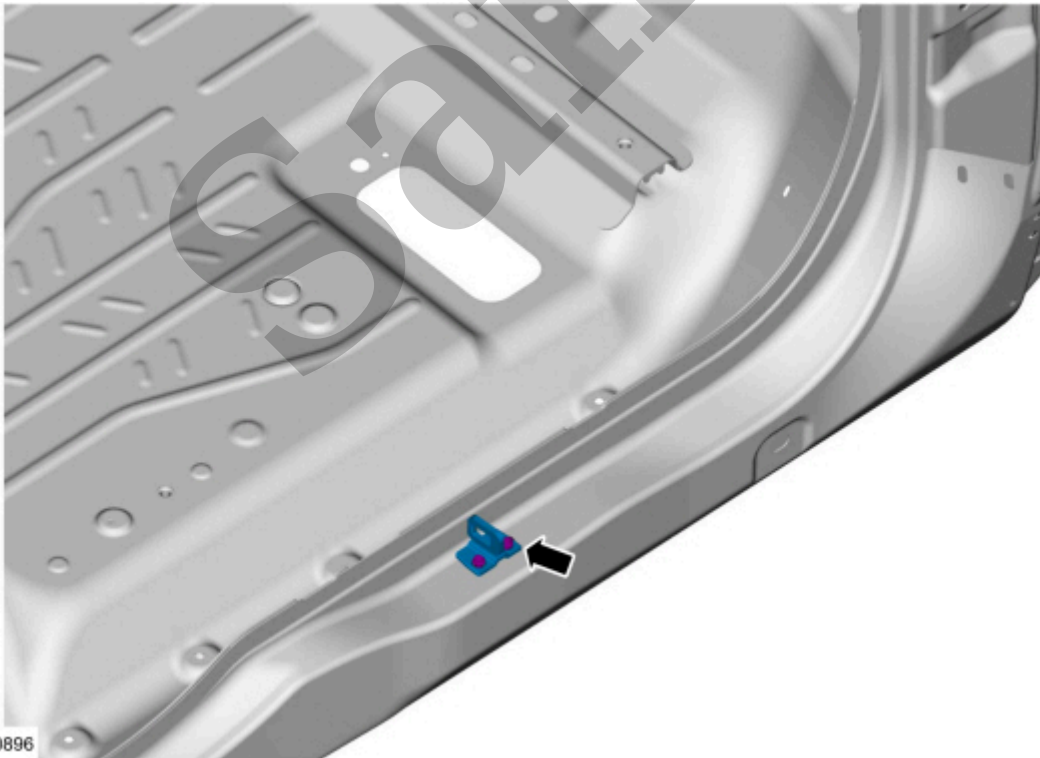
E199449



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

60. Install the rear door striker.

Torque : 18 lb.ft (25 Nm)



E200896

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



Rocker Panel Inner Reinforcement - 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>

Rocker Panel Inner 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).



E198299

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

7. Remove the front and rear door scuff plates and front and rear door opening weather strips.

8. Measure and cut

the outer layer only

of the vehicle body side.

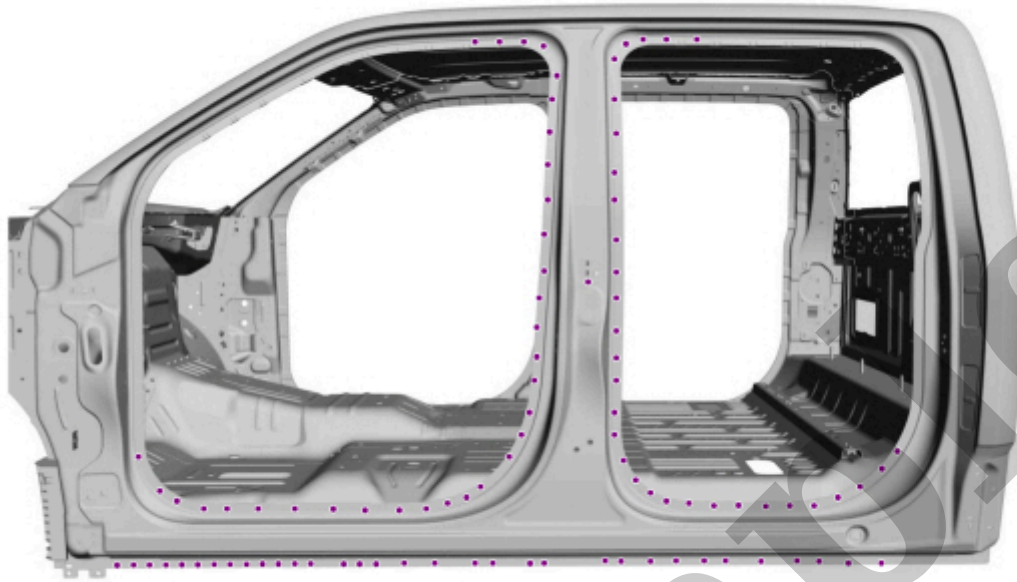
Use the General Equipment: Air Body Saw

Use the General Equipment: Spherical Cutter

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

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

Use the General Equipment: Belt Sander



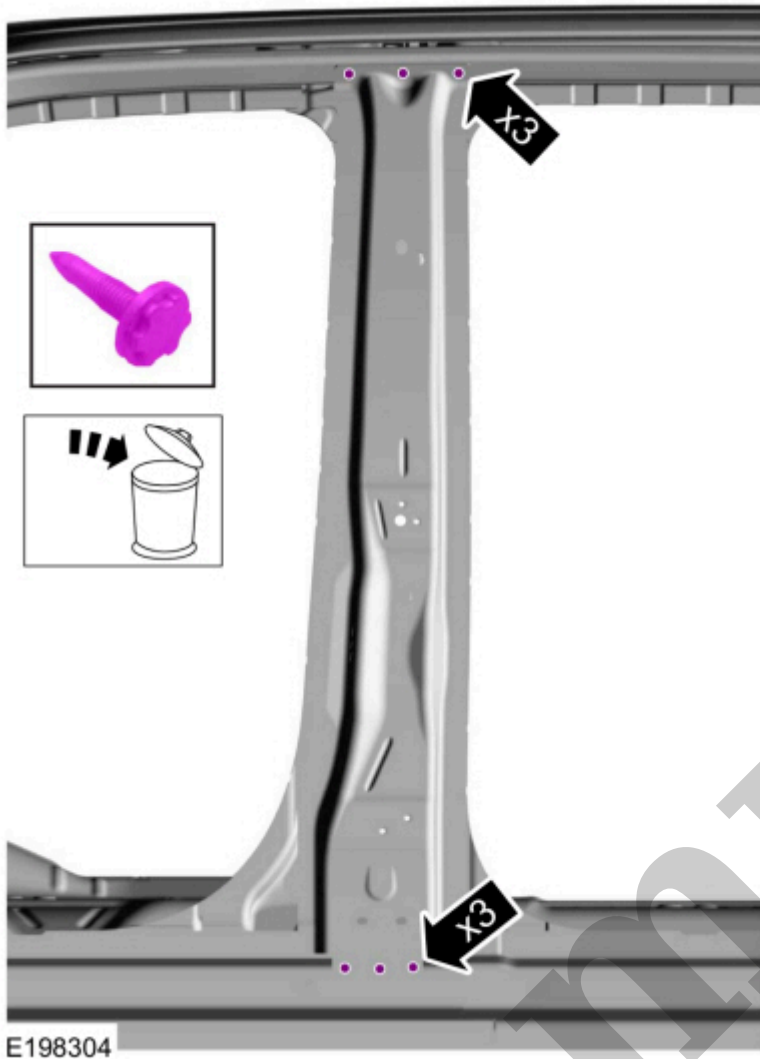
E333025

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

11. **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 outer panel sheet metal.



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

13. Remove the SPR (self-piercing rivet) fasteners in the B-pillar reinforcement.

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

Use the General Equipment: Belt Sander



E198306

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

15. Remove the SPR (self-piercing rivet) fasteners in the rocker panel inner reinforcement.

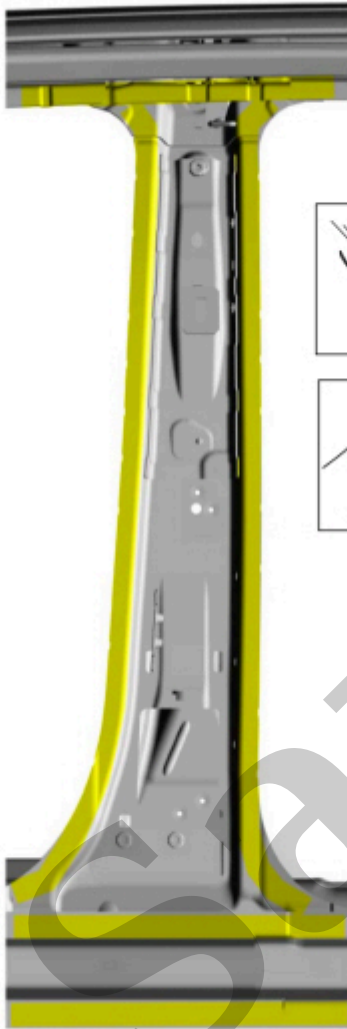
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer

Use the General Equipment: Belt Sander

SPR (self-piercing rivet) fasteners may not be placed directly over original SPR (self-piercing rivet) location. They must be placed adjacent to original location matching original quantity.

1. 80-120 grit sand paper.

Sand to remove old adhesive and clean the B-pillar reinforcement mating surfaces.



E198309

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

2. 80-120 grit sand paper.

Sand to remove old adhesive and clean the inner rocker panel reinforcement mating surfaces.