

# 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.

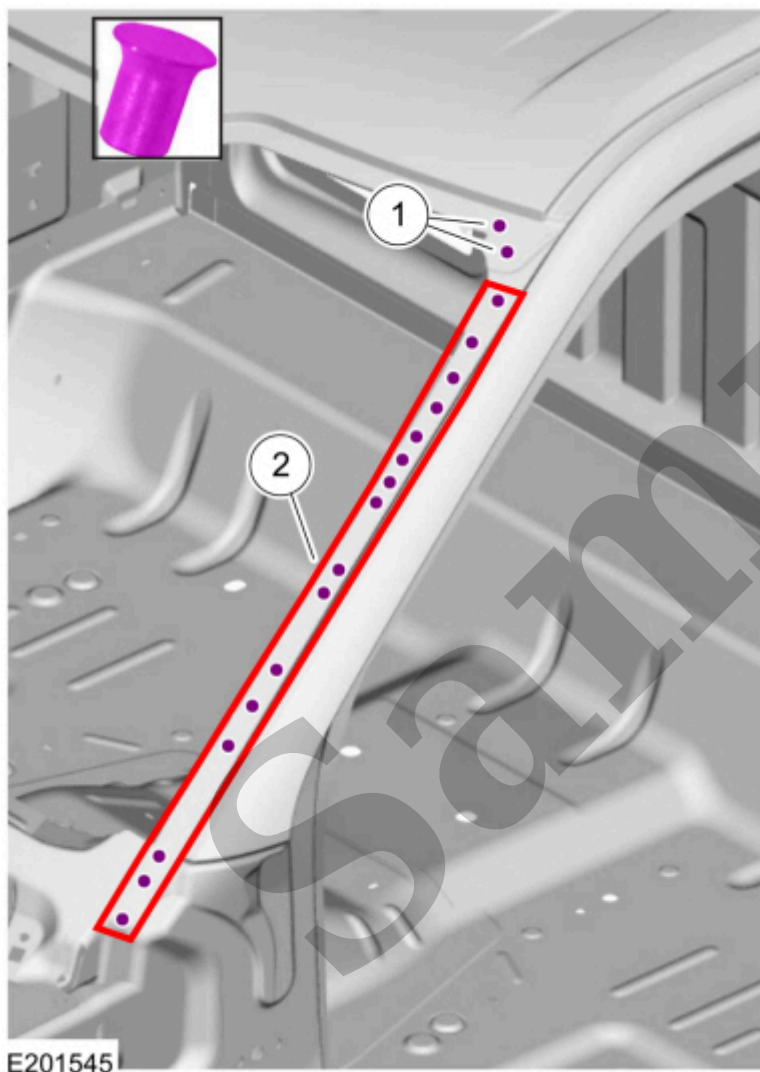
## **2011 FORD Fiesta 3 Doors OEM Service and Repair Workshop Manual**

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				0402			
2	W708713-S900	AS	DZ09-025/H	SA-0400/SA-0402	-	W790377-S900	-

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

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



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

14. Drill for fasteners.

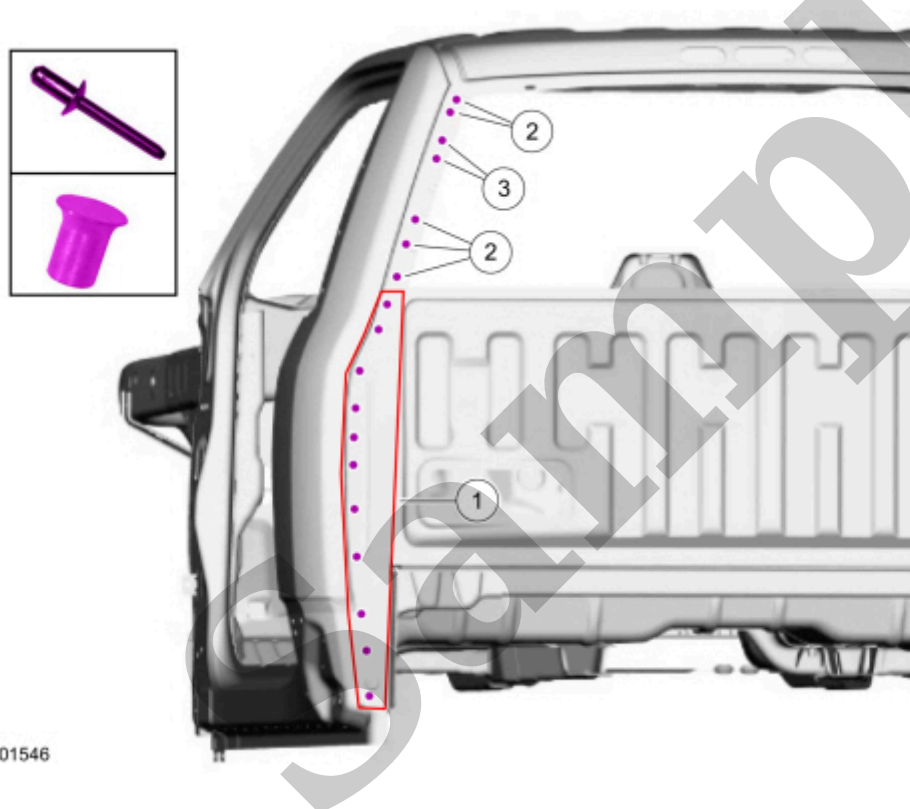
Use the General Equipment: 6.5 mm Drill Bit

2	W708713-S900	AS	DZ09-025/H	SA-0400/SA-0402	-	W790377-S900	-
3	W708717-S900	AW	DG10-220/H	SA-0400/SA-0402	-	W790377-S900	-

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

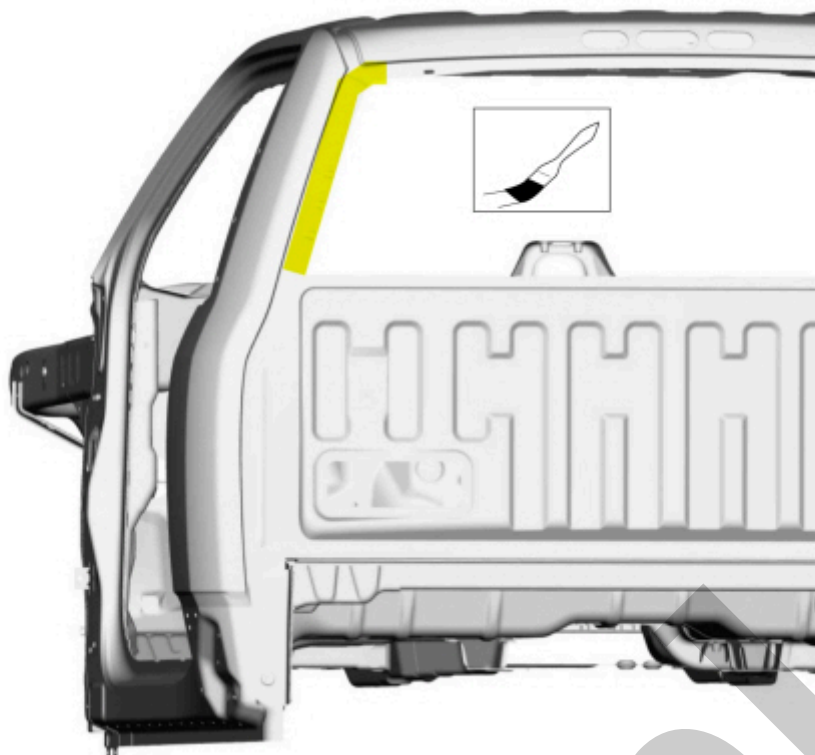


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16. Seam weld the roof to body side joint using a MIG (metal inert gas) welder set up for aluminum repair.

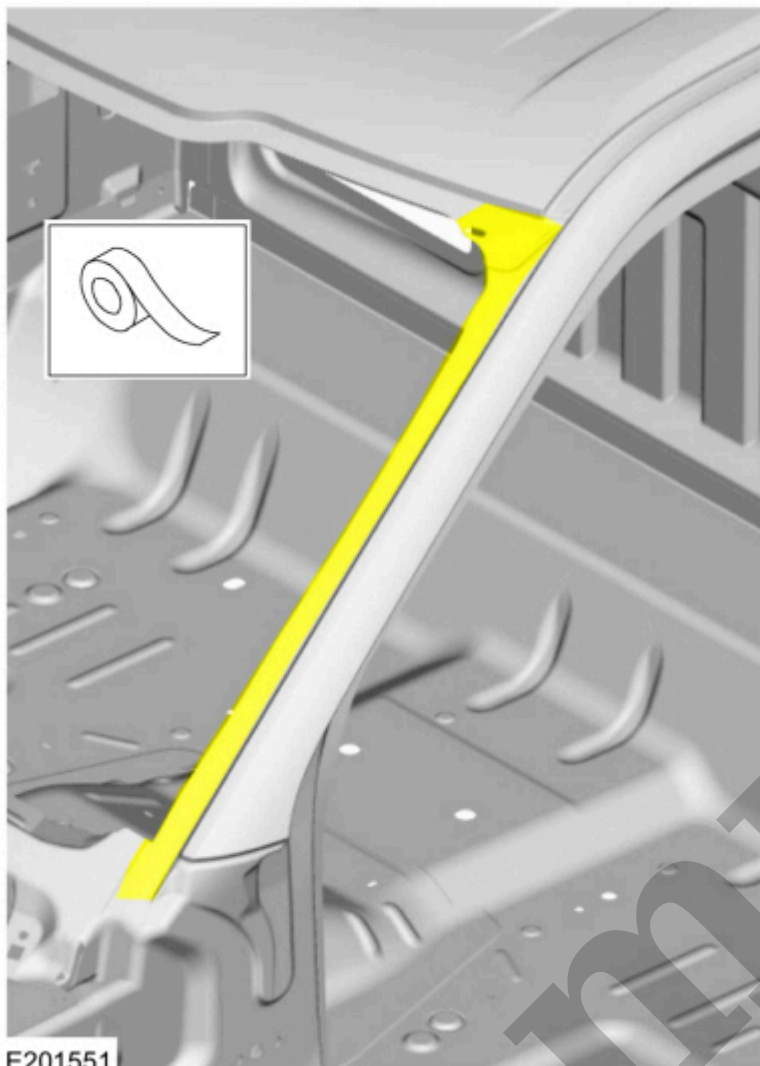
Use the General Equipment: MIG/MAG Welding Equipment



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19. Apply a Ford approved epoxy-based primer to the windshield opening channel.



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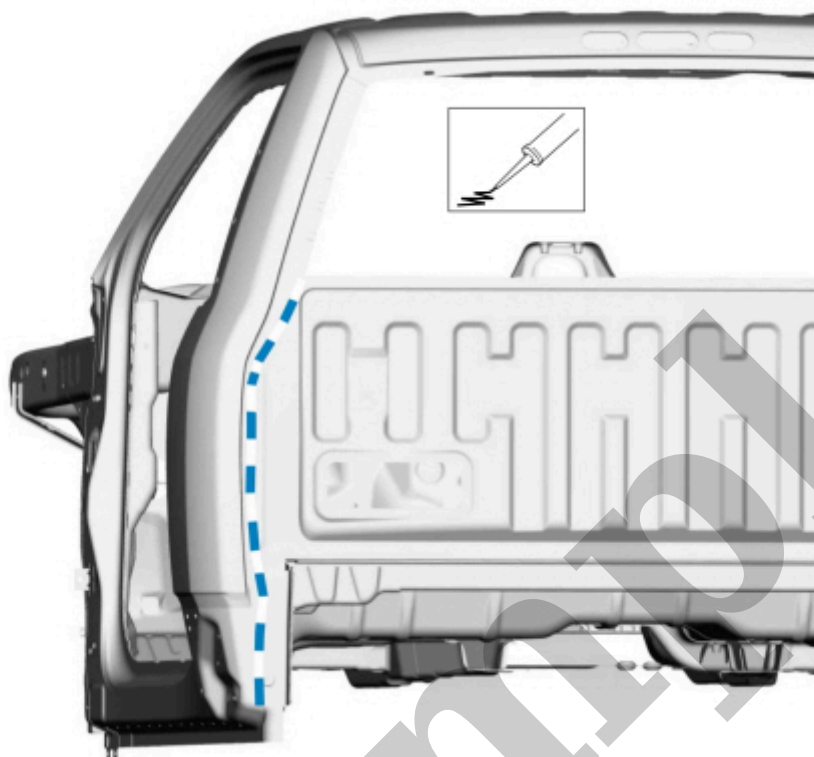
21. Mask the rear window glass opening channel.

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### 23. Seam Sealing:

All seams must be sealed to production level.

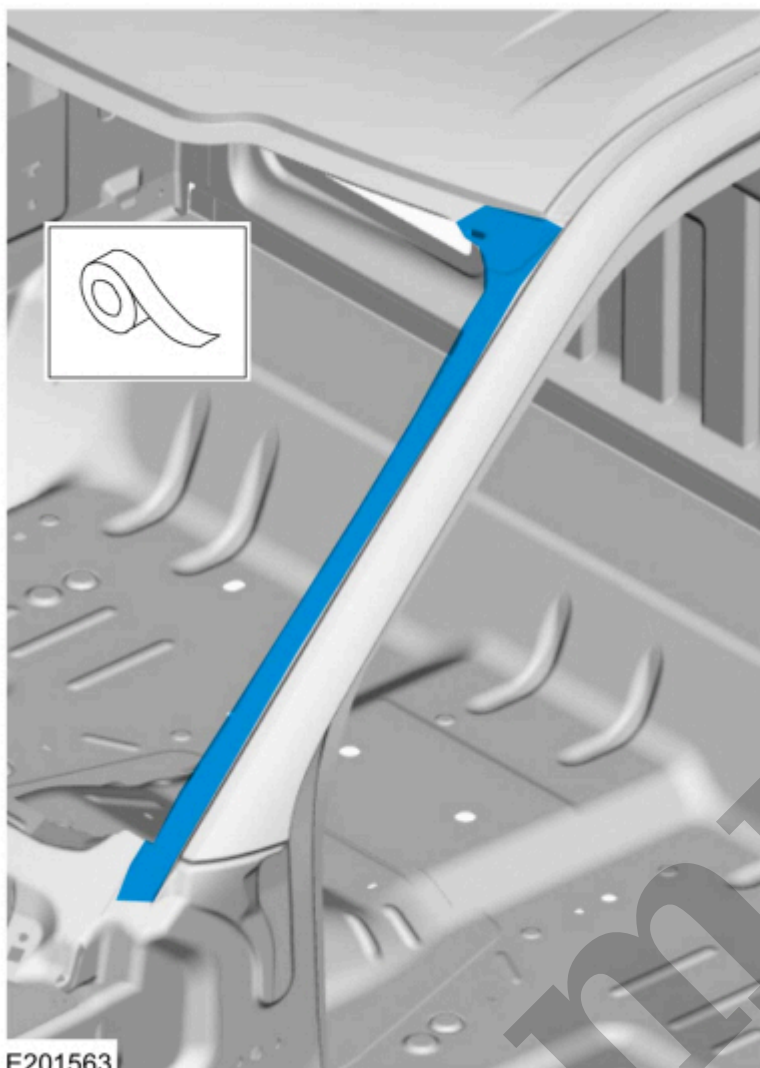
**Material** : Seam Sealer / TA-2-B, 3M™ 08308, LORD Fusor® 803DTM



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

### 24. Apply roof ditch sealer.

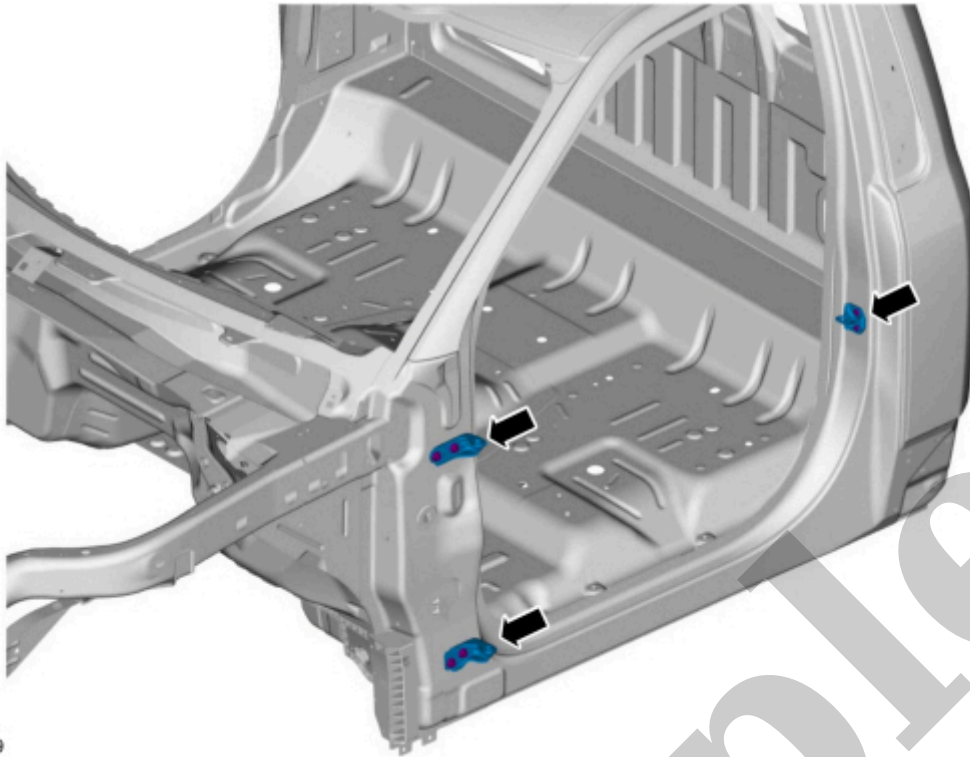
**Material** : Roof Ditch Sealer / 3M™ 08307, LORD Fusor® 129



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27. Unmask the rear window glass opening channel.

**Torque** : 18 lb.ft (25 Nm)



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33. Install the A and C-pillar trim.

Refer to: [A-Pillar Trim Panel](#)(501-05 Interior Trim and Ornamentation, Removal and Installation).

Refer to: [C-Pillar Trim Panel](#)(501-05 Interior Trim and Ornamentation, Removal and Installation).

34. Install the fender.

Refer to: [Fender](#)(501-02 Front End Body Panels, Removal and Installation).

35. Install and align the door.

Refer to: [Front Door - Regular Cab/SuperCrew](#)(501-03 Body Closures, Removal and Installation).

Refer to: [Front Door Alignment - Regular Cab/SuperCrew](#)(501-03 Body Closures, General Procedures).

36. Install the pickup box.

Refer to: [Pickup Bed](#)(501-04 Pickup Bed and Platform Body, Removal and Installation).

37. Repower the SRS (supplemental restraint system) .

Refer to: [Supplemental Restraint System \(SRS\) Repowering](#)(501-20B Supplemental Restraint System, General Procedures).





## Side Panel - SuperCab

<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>

### Side Panel - SuperCab

#### 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.

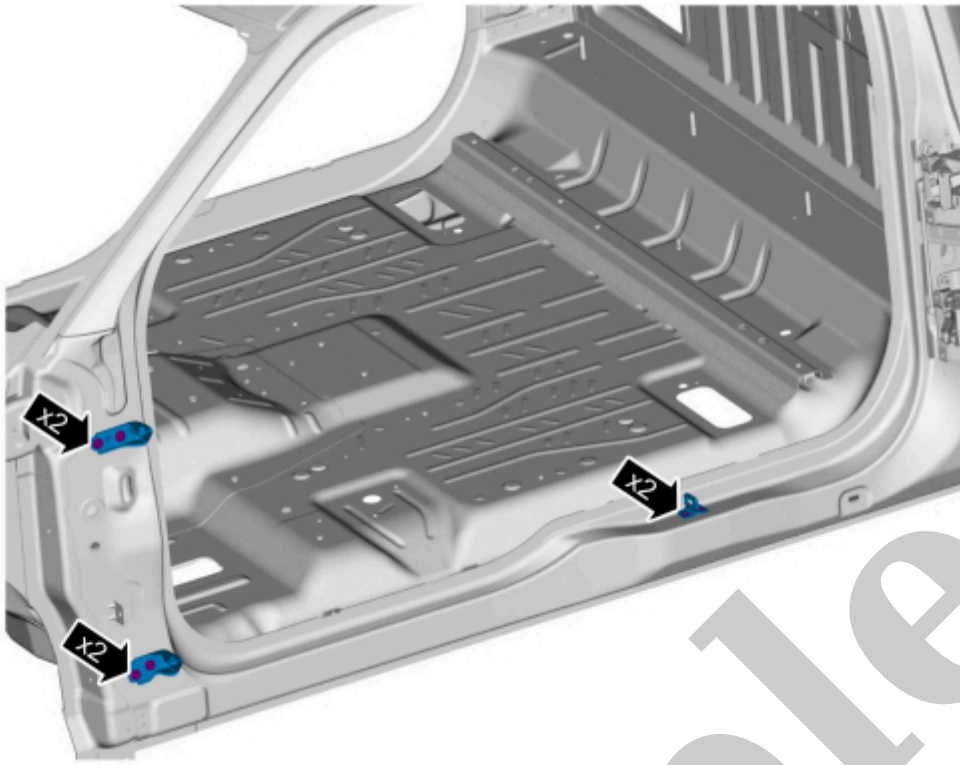
#### NOTICE

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.

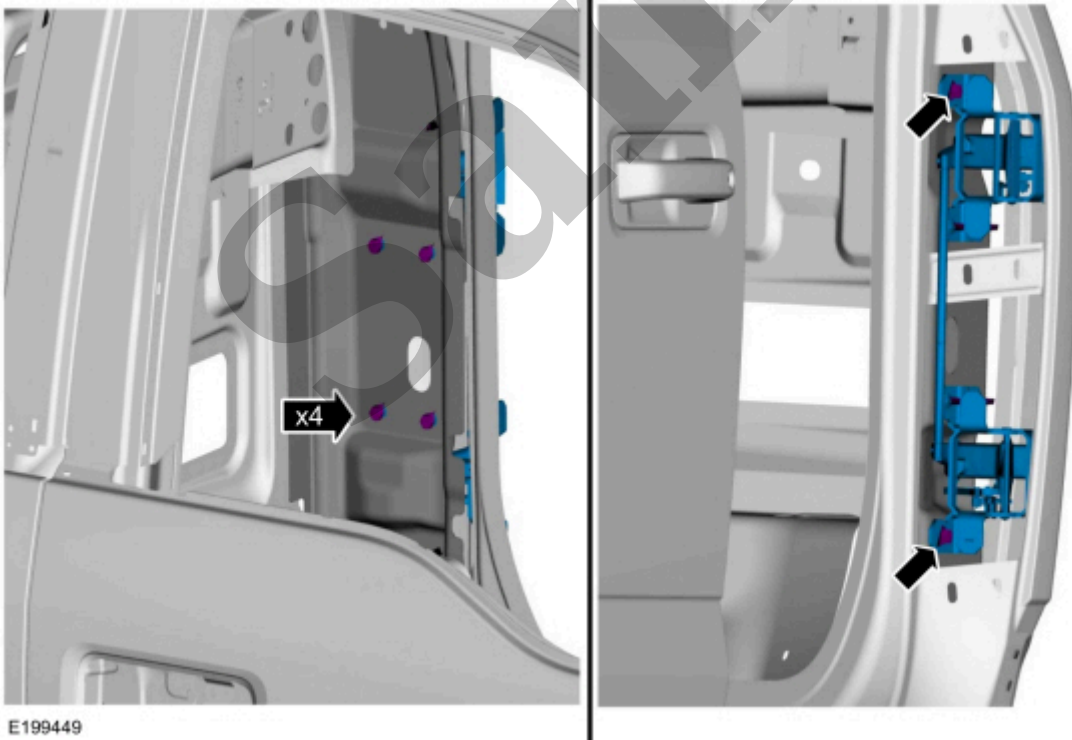
Refer to: [Health and Safety Precautions](#)(100-00 General Information, Description and Operation).



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8. Remove the rear door hinge.



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

9. Remove the windshield and rear window glass.