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2012 FORD Fiesta 3 Doors OEM Service and Repair Workshop Manual

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Side Panel - Regular Cab

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

Side Panel - Regular Cab

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.

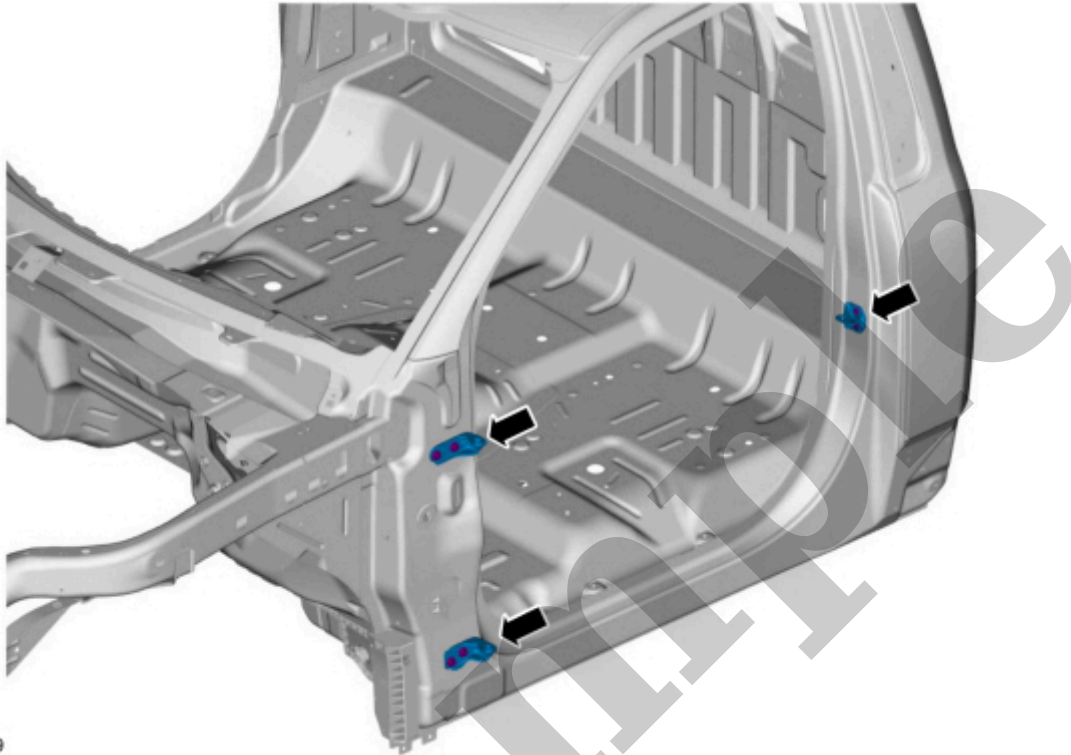
Refer to: [Health and Safety Precautions](#)(100-00 General Information, Description and Operation).

7. Remove the A and C-pillar trim.

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

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

8. Remove the door hinges and striker.



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9. Remove the windshield and rear window glass.

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

10. Remove the outer cab trim.

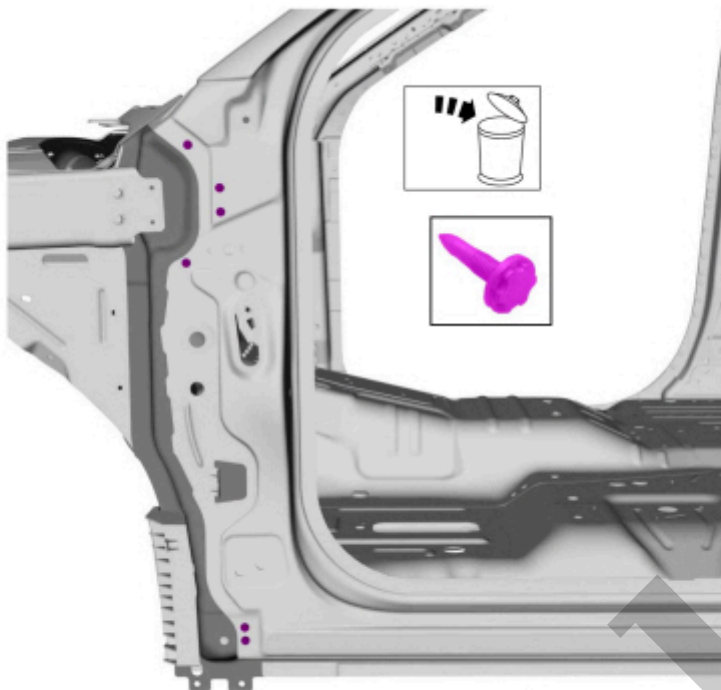
Refer to: [Roof Moulding](#)(501-08 Exterior Trim and Ornamentation, Removal and Installation).

Refer to: [Bodyside Moulding](#)(501-08 Exterior Trim and Ornamentation, Removal and Installation).

Refer to: [Front Door Upper Moulding](#)(501-08 Exterior Trim and Ornamentation, Removal and Installation).

11. Remove the door opening scuff plate and weather strips.

12. Remove the side curtain air bag.



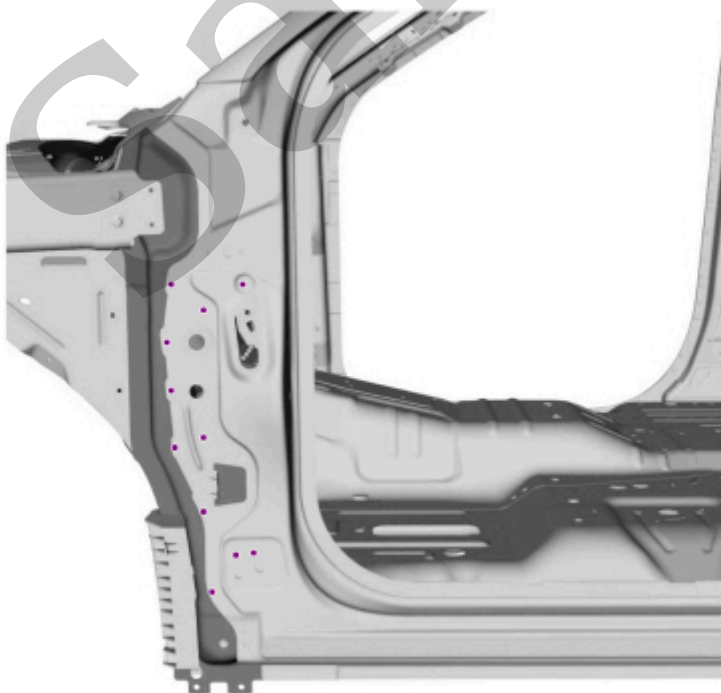
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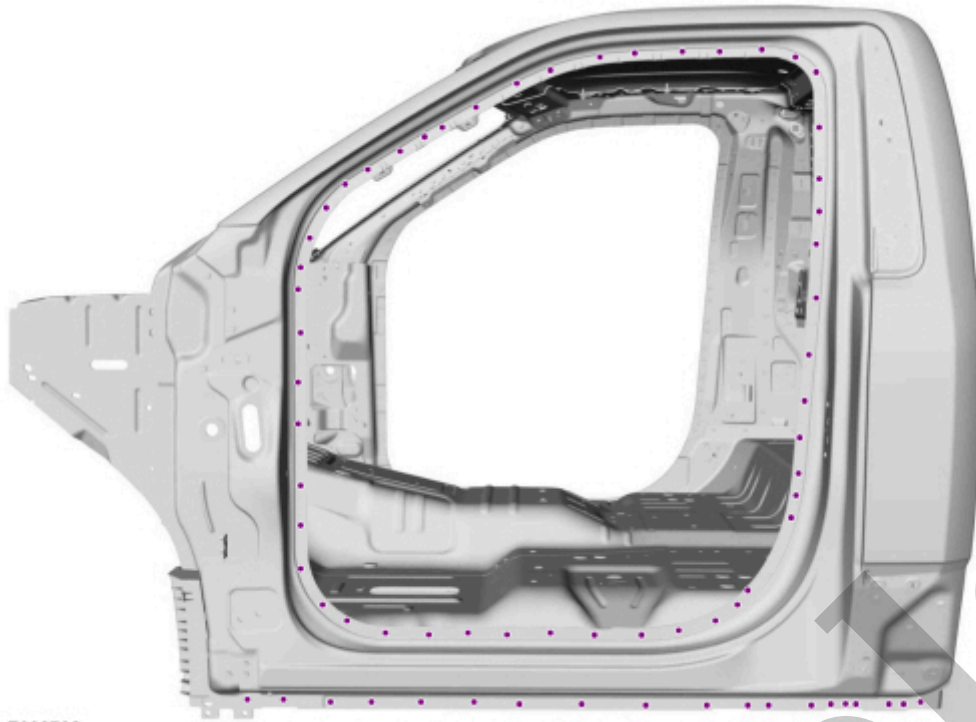
15. Remove the body side SPR (self-piercing rivet) fasteners.

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

Use the General Equipment: Belt Sander



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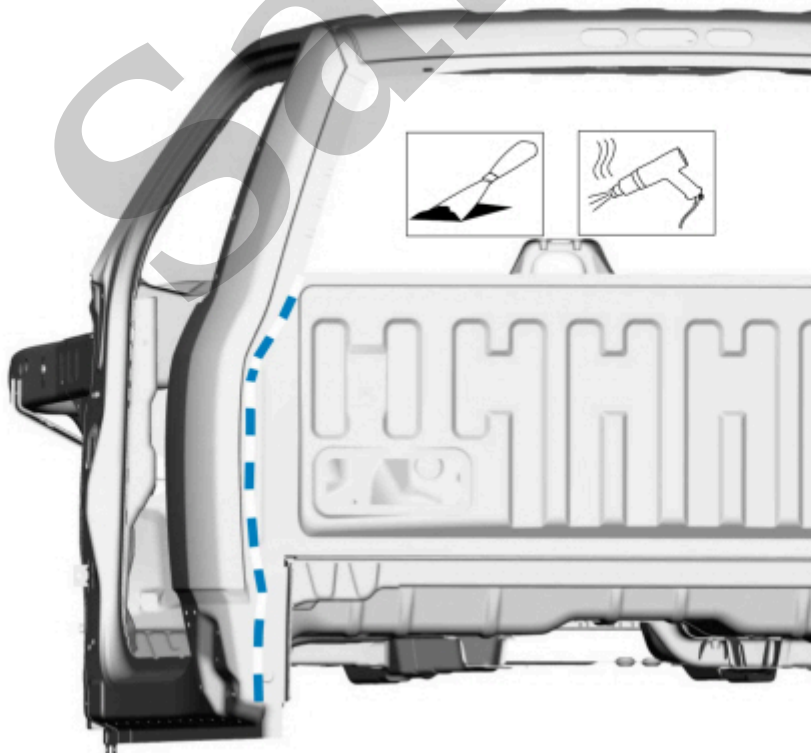
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[Click here to learn about symbols, color coding, and icons used in this manual.](#)

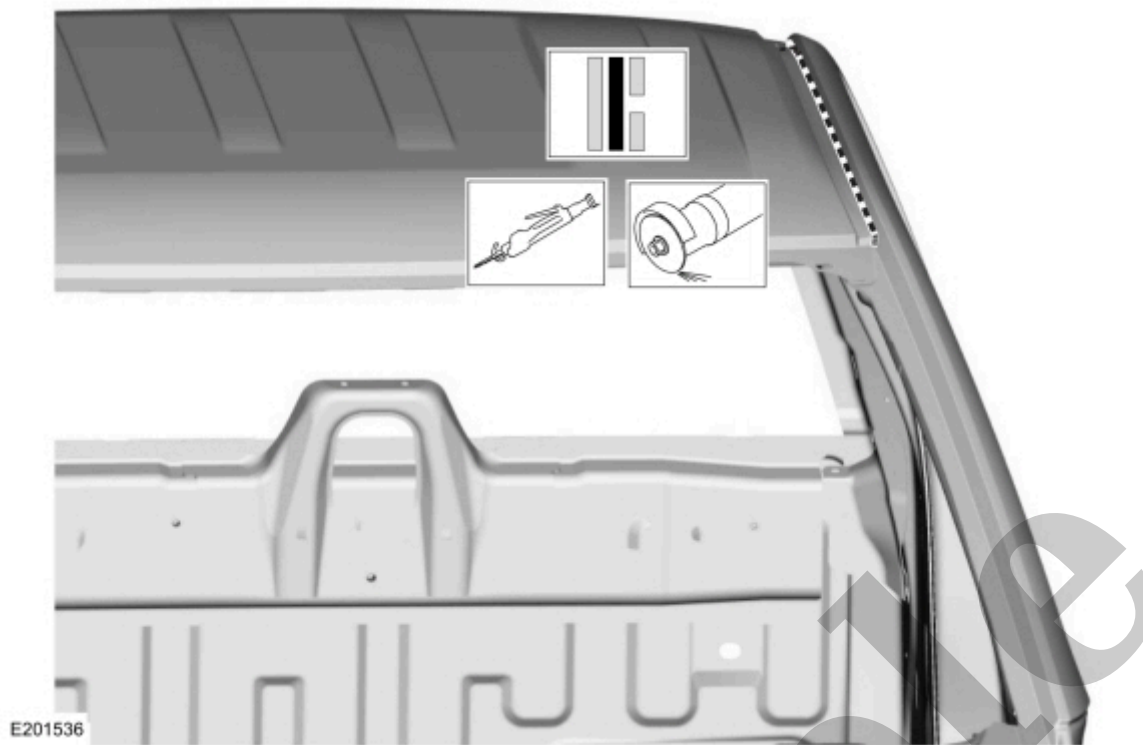
18. Remove the cab back seam sealer.

Use the General Equipment: Scraper for Straight Edges

Use the General Equipment: Hot Air Gun



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21. **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.

NOTE

Pay particular attention to NVH (noise, vibration and harshness) baffle and foam locations to aid in assembly.

Break the adhesive bond and remove the body side panel.

Use the General Equipment: Hot Air Gun

The use of a backer panel when creating butt welds will produce a stronger and more uniform repair.

1. Partial panel replacement:

Determine repair and trim service panel accordingly.

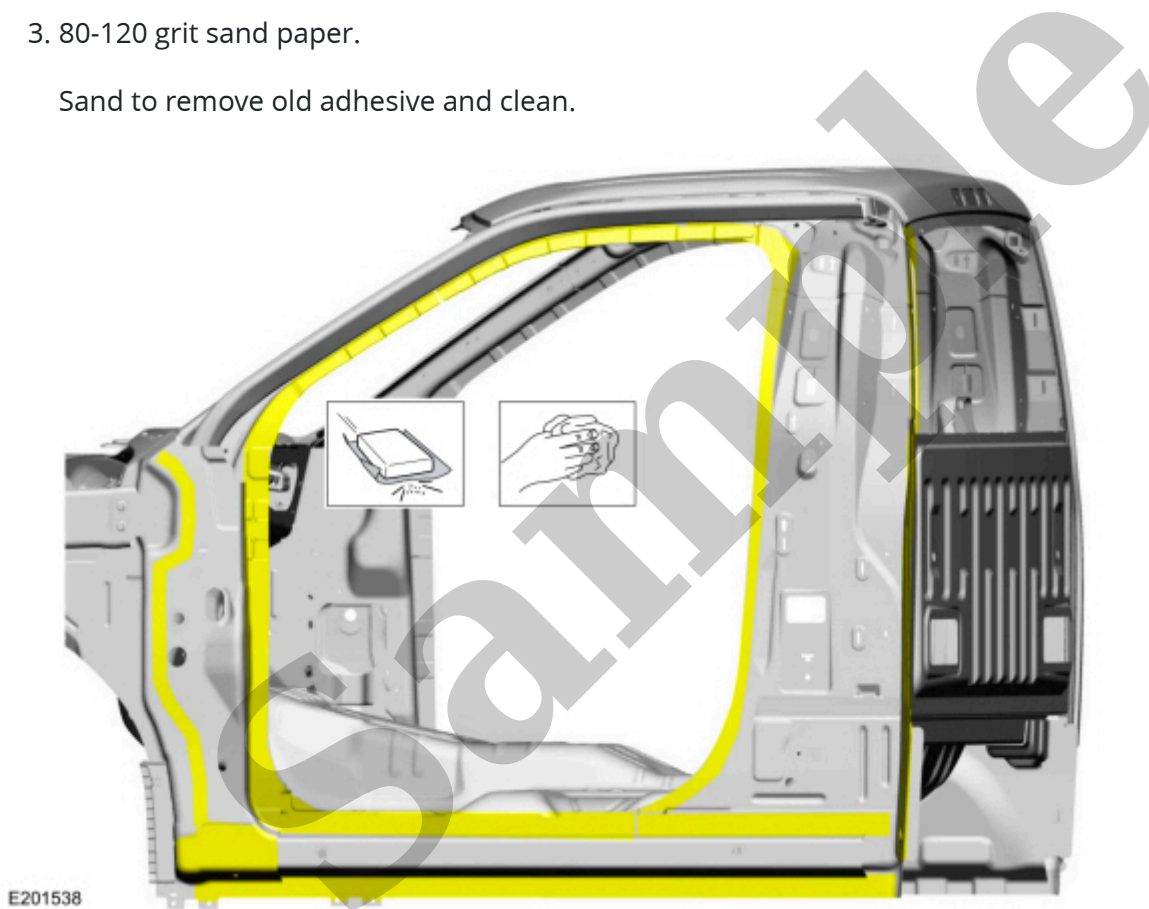
2. In butt-weld area(s), create a backer panel from unused portion(s) of the service panel and attach to the vehicle using a MIG (metal inert gas) welder set up for aluminum repair.

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

Use the General Equipment: MIG/MAG Welding Equipment

3. 80-120 grit sand paper.

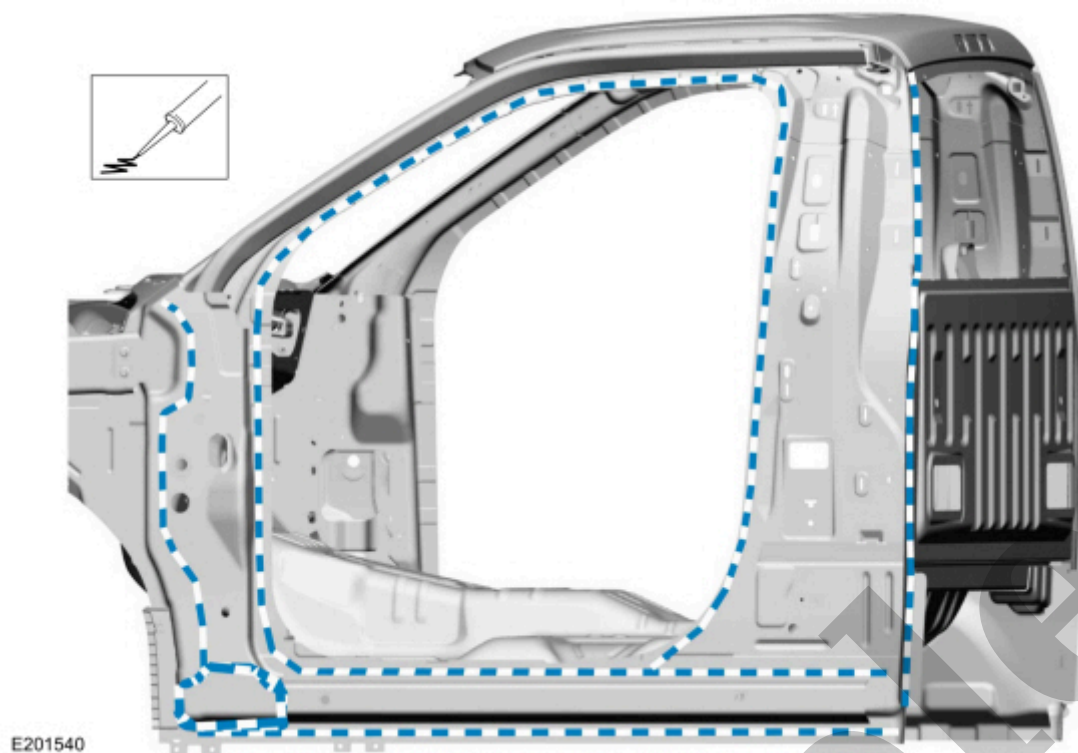
Sand to remove old adhesive and clean.



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

4. 80-120 grit sand paper

Sand to remove e-coat and clean.

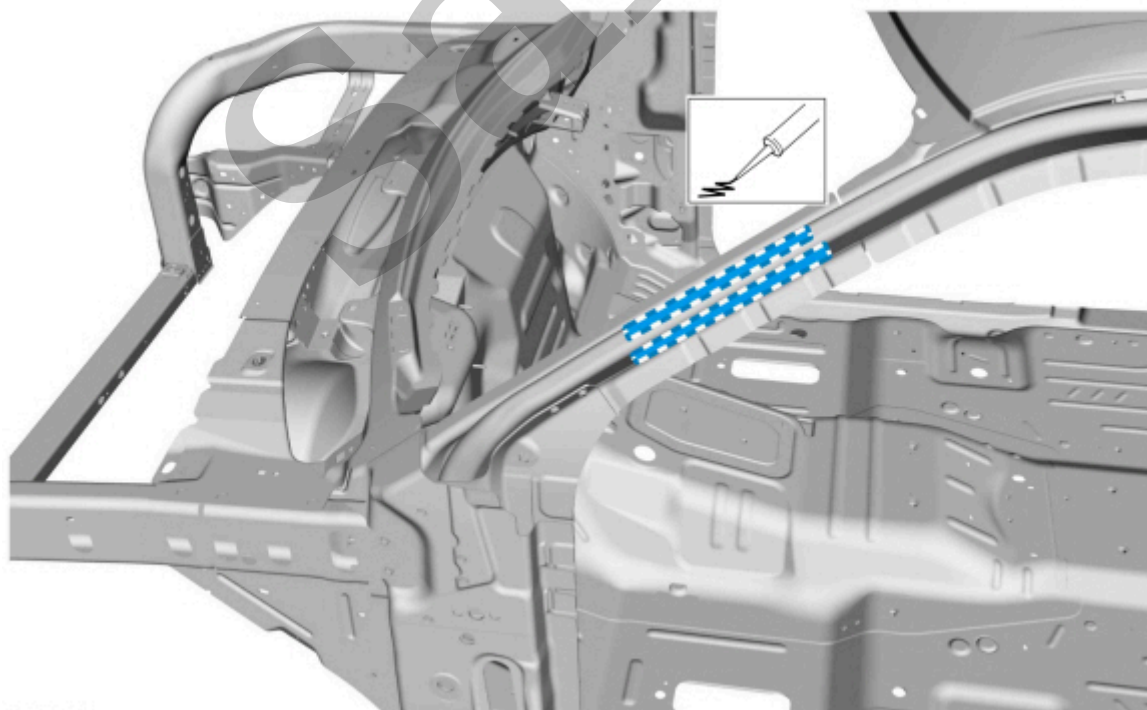


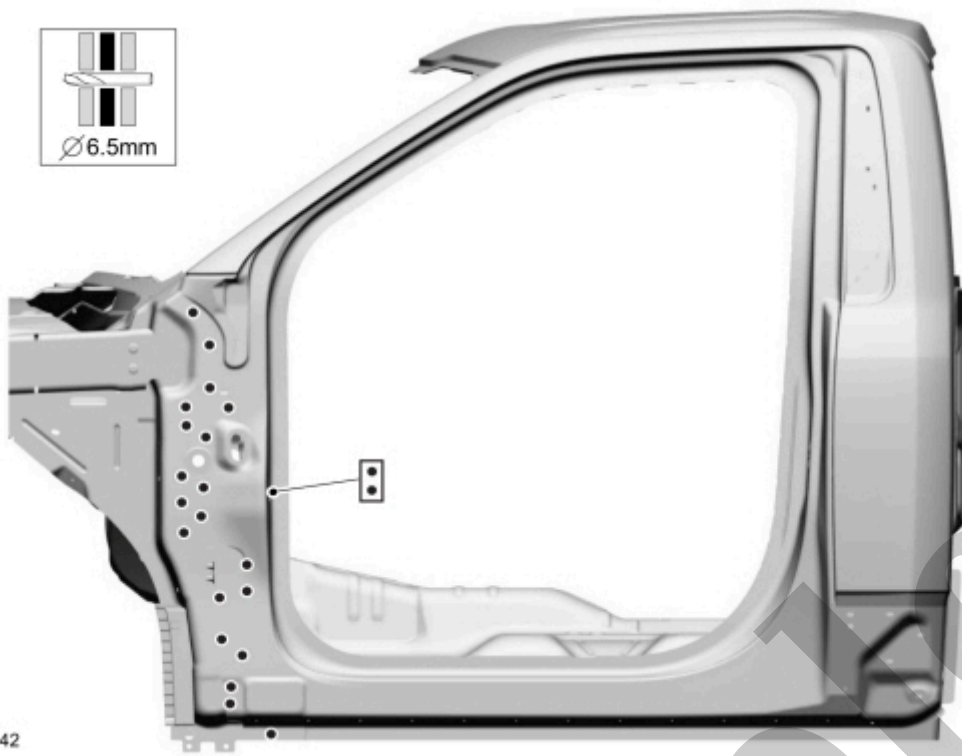
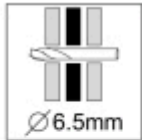
[Click here to learn about symbols, color coding, and icons used in this manual.](#)

7. Apply flexible foam sealant and urethane adhesive in locations noted in disassembly.

Material : Sika Tack ASAP Urethane Adhesive

Material : Flexible Foam Repair / 3M™ 08463, LORD Fusor® 121





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11. NOTE

Blind or solid rivet fasteners may be used in place of SPR (self-piercing rivet) fasteners after enlarging 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®
1	-	-	-	-	W708777-S900C	-	-
2	-	-	-	-	W707638-S900C	-	-
3	-	-	-	-	W702554-S900C	-	-

1	W708713-S900	AS	DZ09-025/H	SA-0400/SA-0401	-	W790376-S900	-
2	W708713-S900	AS	DP11-200/H	SA-0400/SA-0402	-	W790377-S900	-
3	W717186-S900	EN	DG11-220/H	SA-0400/SA-0402	-	W790377-S900	-
4	W717186-S900	EN	DP11-200/H	SA-0400/SA-0402	-	W790377-S900	-
5	W708717-S900	AW	DP11-200/H	SA-0400/SA-0402	-	W790377-S900	-
6	W717185-S900	EL	DG11-220/H	SA-0400/SA-0402	-	W790377-S900	-
7	W710246-S900	BN	DP10-200/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