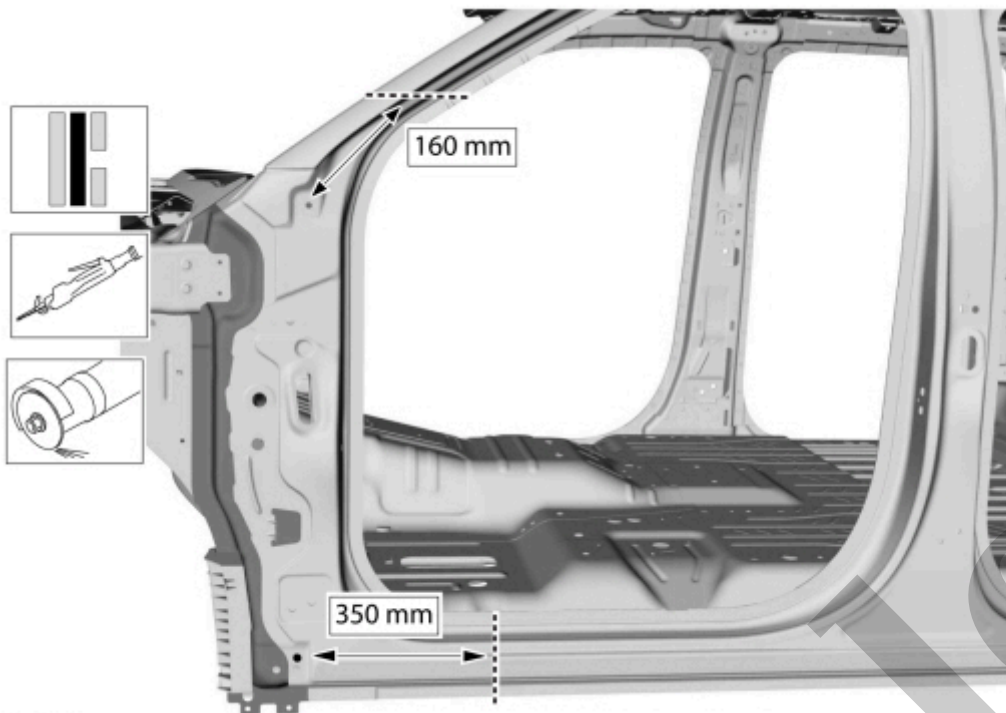


Your Ultimate Source for OEM Repair Manuals

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.

1988 FORD Fiesta 3 Doors OEM Service and Repair Workshop Manual

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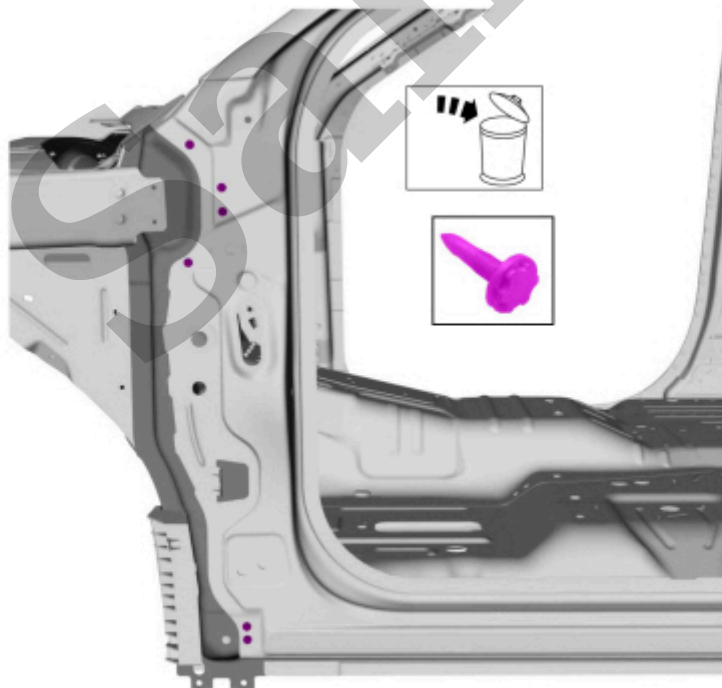


E331510

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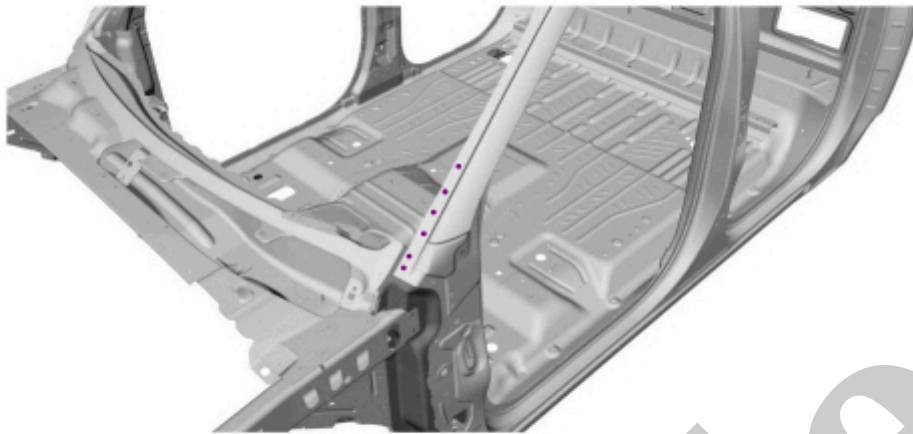
9. Remove and discard the FDS (flow drill screw) fasteners.

Use the General Equipment: Polydrive Bit Socket



E331511

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E331513

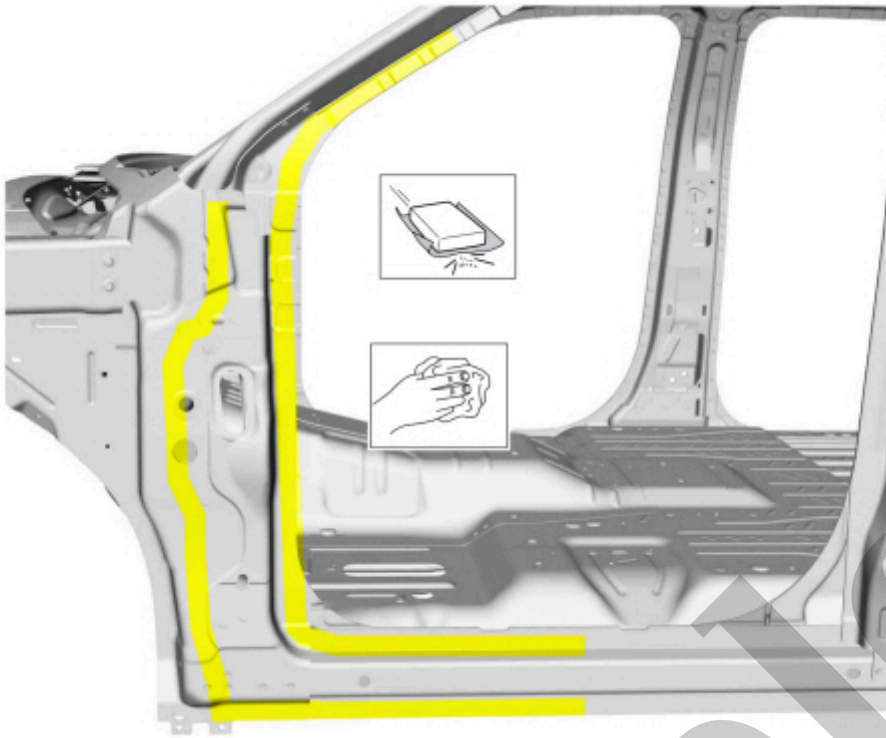
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12. **NOTE**

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 side section.

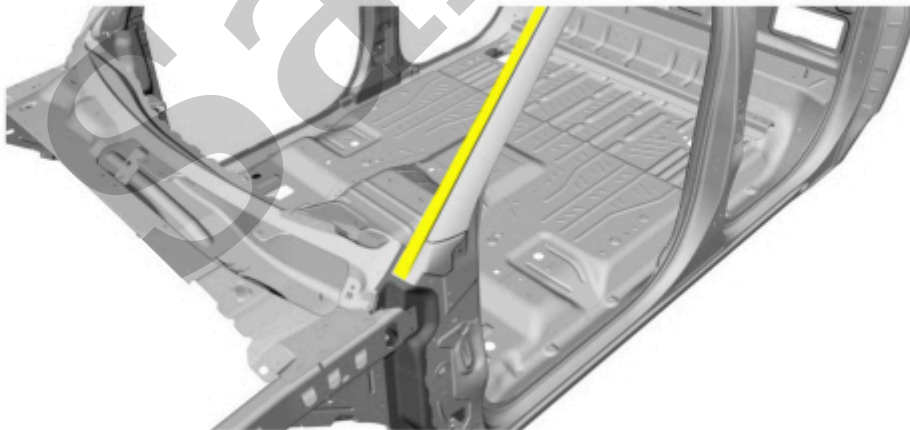
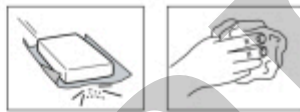
Use the General Equipment: Hot Air Gun



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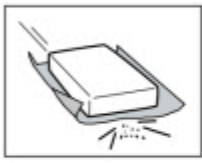
2. Sand with 80 grit sand paper to remove old adhesive from windshield opening and clean.



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3. Cut service panel to fit repair.

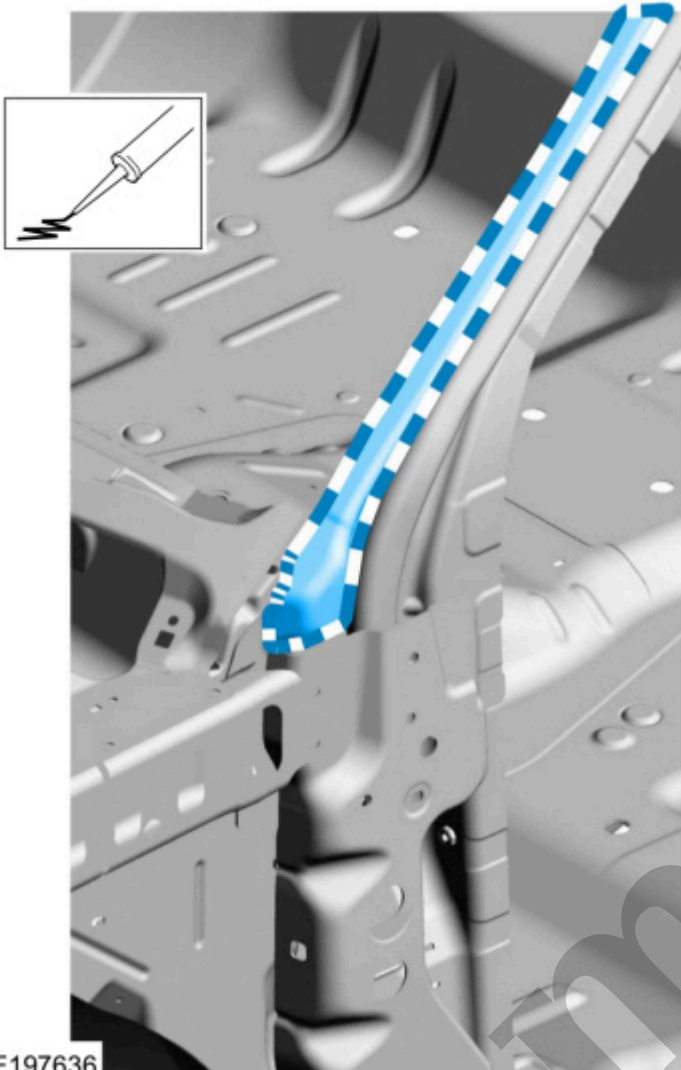


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6. Apply adhesive.

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

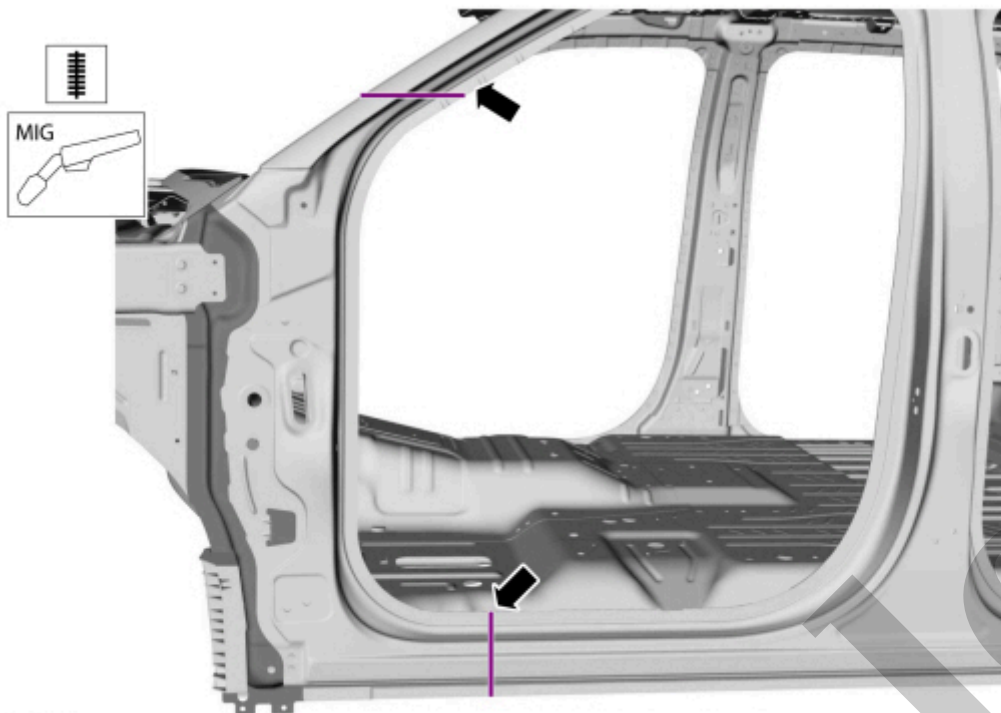


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8. Install the service panel and clamp in position.

Use the General Equipment: Locking Pliers



E331516

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11. 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.

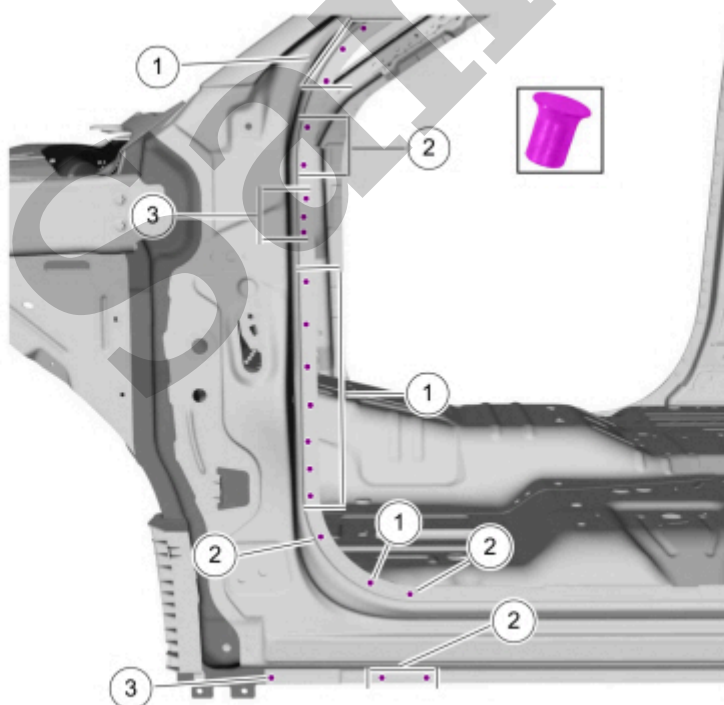
Install fasteners in windshield opening.

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®

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	W708713-S900	AS	DZ09-025/H	SA-0400/SA-0401	-	W790376-S900	-
2	W717186-S900	EN	DG11-220/H	SA-0400/SA-0401	-	W790377-S900	-
3	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



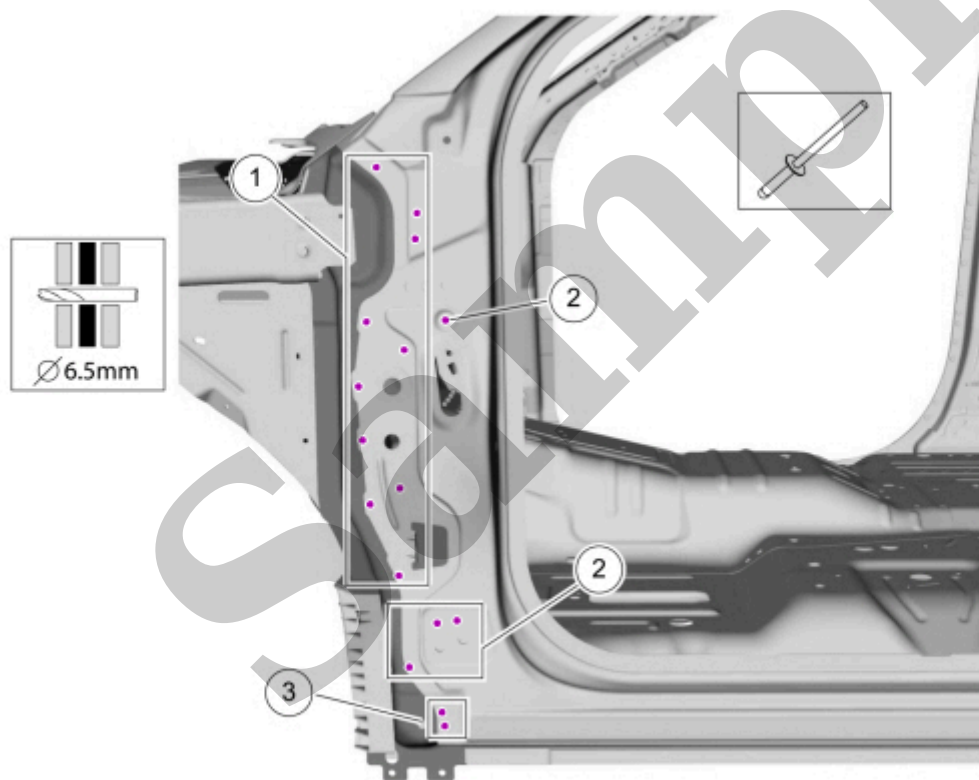
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			Wieland and Schill® Mandrel				
1	-	-	-	-	W707638- S900C	-	-
2	-	-	-	-	W708777- S900C	-	-
3	-	-	-	-	W702554- S900C	-	-

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

Use the General Equipment: Blind Rivet Gun

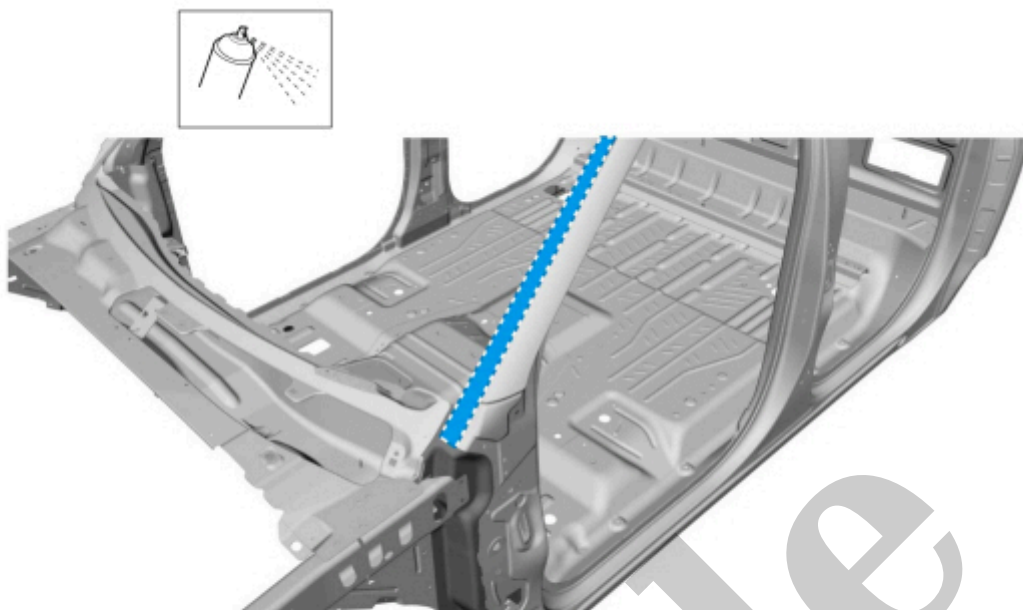


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15. Metal finish all seams using typical aluminum metal finishing techniques and a fiber-based body filler.

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



E331521

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18. Mask the glass channel as indicated.