

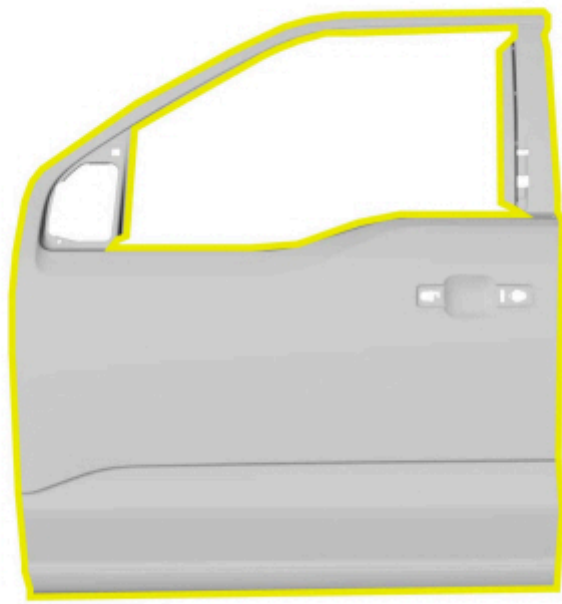
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1989 FORD Fiesta 3 Doors OEM Service and Repair Workshop Manual

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Sand to remove the e-coat from the mating surface and clean.

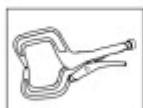


E329033

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4. Apply adhesive.

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



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6. Install the door on the vehicle.

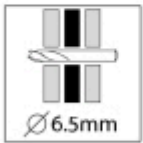


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7. Check the door panel for proper fit and alignment.

Use the General Equipment: 6.5 mm Drill Bit



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10. **NOTE**

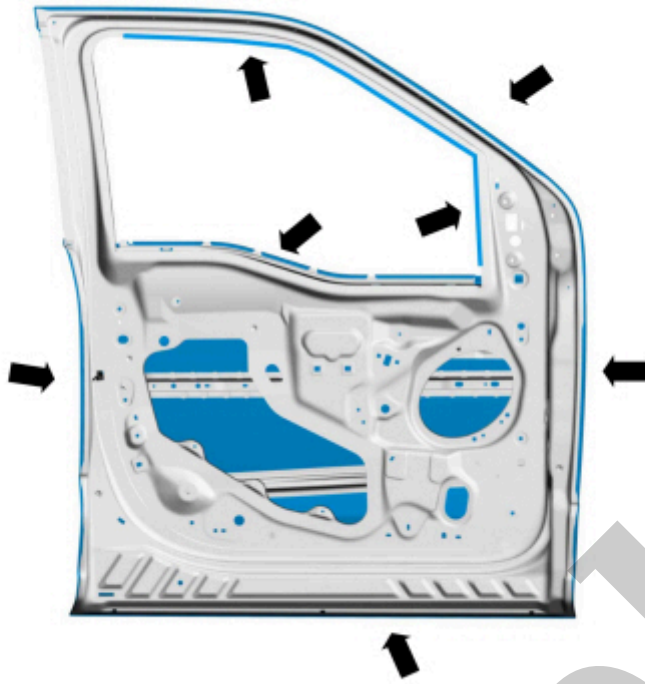
SPR (self-piercing rivet) fasteners may not be placed directly over original SPR (self-piercing rivet) location. They must be placed adjacent to original location matching original quantity.

NOTE

Blind rivet or solid rivet fasteners may be used in place of SPR (self-piercing rivet) fasteners after enlarging holes to 6.5 mm.

Install fasteners.

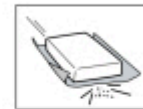
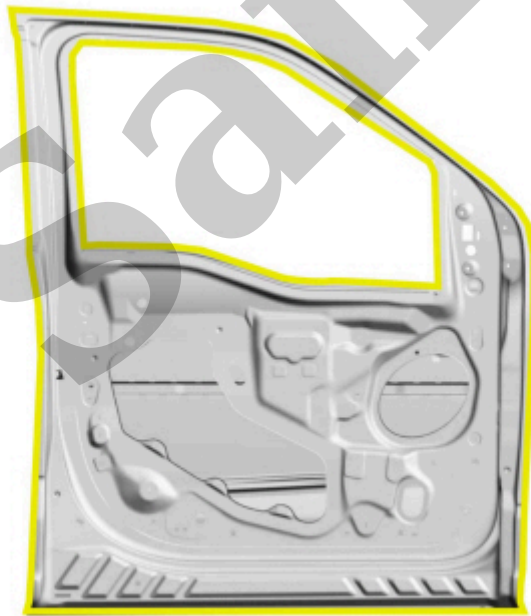
| Item | SPR (self-piercing rivet) Number | SPR (self-piercing rivet) Code | Henrob® Car-O-Liner®, CMO®, Chief®, Spanesi® Wielande and Schill® Mandrel | Pro-Spot® Mandrel | Blind Rivet | Solid Rivet | Rivnut® |
|------|----------------------------------|--------------------------------|---|-------------------|-------------|-------------|---------|
| | | | | | | | |



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12. Sand and clean for primer application.



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13. Apply a Ford approved primer to the flange area.

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15. Refinish the door shell flange using a Ford approved paint system and typical refinishing techniques.

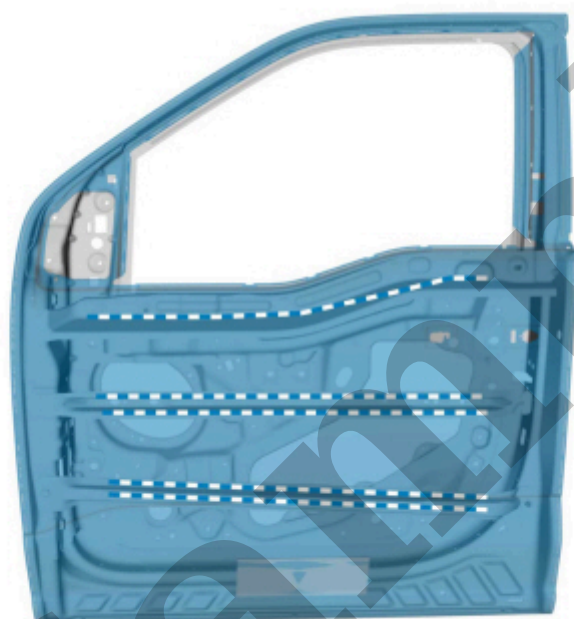
16. Install the door.

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

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

17. Apply NVH (noise, vibration and harshness) foam as indicated.

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



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18. Install a butyl NVH (noise, vibration and harshness) patch as indicated (obtain locally).

21. Install the exterior door handle.

Refer to: [Exterior Front Door Handle](#)(501-14 Handles, Locks, Latches and Entry Systems, Removal and Installation).

22. Install the exterior mirror.

Refer to: [Exterior Mirror - Vehicles With: Long Arm Mirrors](#)(501-09 Rear View Mirrors, Removal and Installation).

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

23. Install the front door window glass.

Refer to: [Front Door Window Glass](#)(501-11 Glass, Frames and Mechanisms, Removal and Installation).

24. Install the exterior door trim.

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

25. Align the door as necessary.

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

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

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

NOTE

LH (left-hand) side shown, RH (right-hand) side similar.

2. Inspect the door hinges for excessive wear or damage. Install new or rebuild as necessary.



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3. Remove the exterior door handle.

Refer to: [Exterior Rear Door Handle - SuperCrew](#)(501-14 Handles, Locks, Latches and Entry Systems, Removal and Installation).

4. Remove the door window glass.



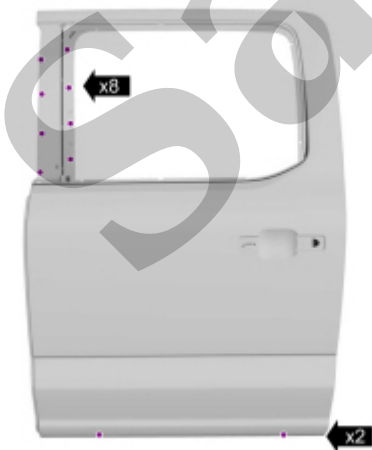
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9. Remove the SPR (self-piercing rivet) fasteners as indicated.

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

Use the General Equipment: Belt Sander



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10. Carefully grind the

outer layer only

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12. **NOTE**

The use of heat may aid in door panel removal.

Remove the door skin outer panel.

Use the General Equipment: Hot Air Gun



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13. Remove the remaining portion of the door outer panel hem flange.

Use the General Equipment: Knife

Use the General Equipment: Hot Air Gun