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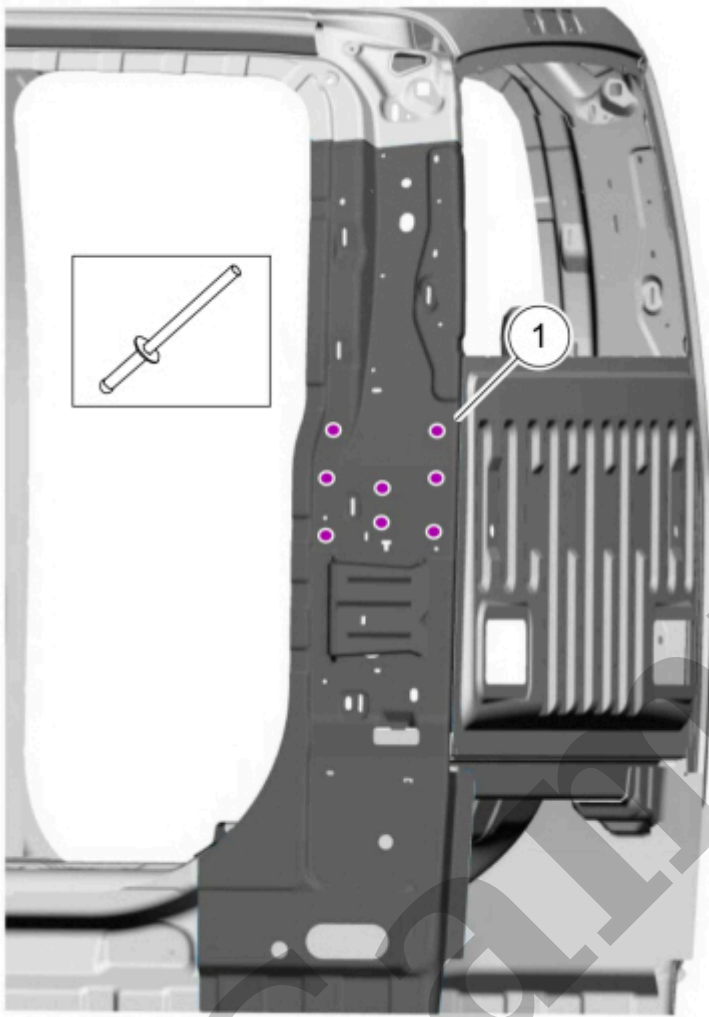
1991 FORD Fiesta 3 Doors OEM Service and Repair Workshop Manual

[Go to manual page](#)

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



E199467

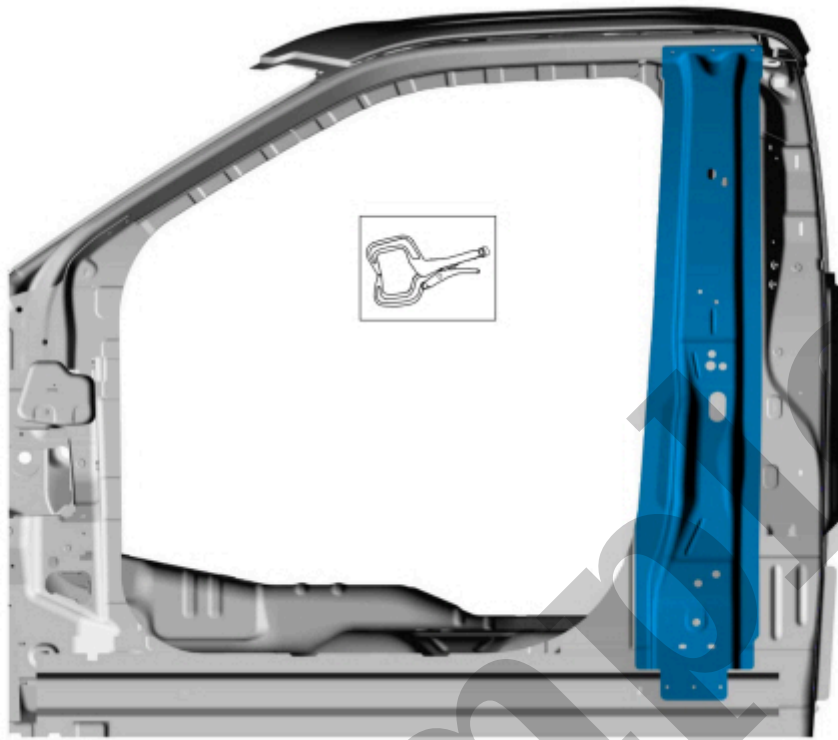
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7. Sand using 80 grit sand paper to remove e-coat and clean.

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9. Install the C-pillar reinforcement and clamp in position.

Use the General Equipment: Locking Pliers



E201738

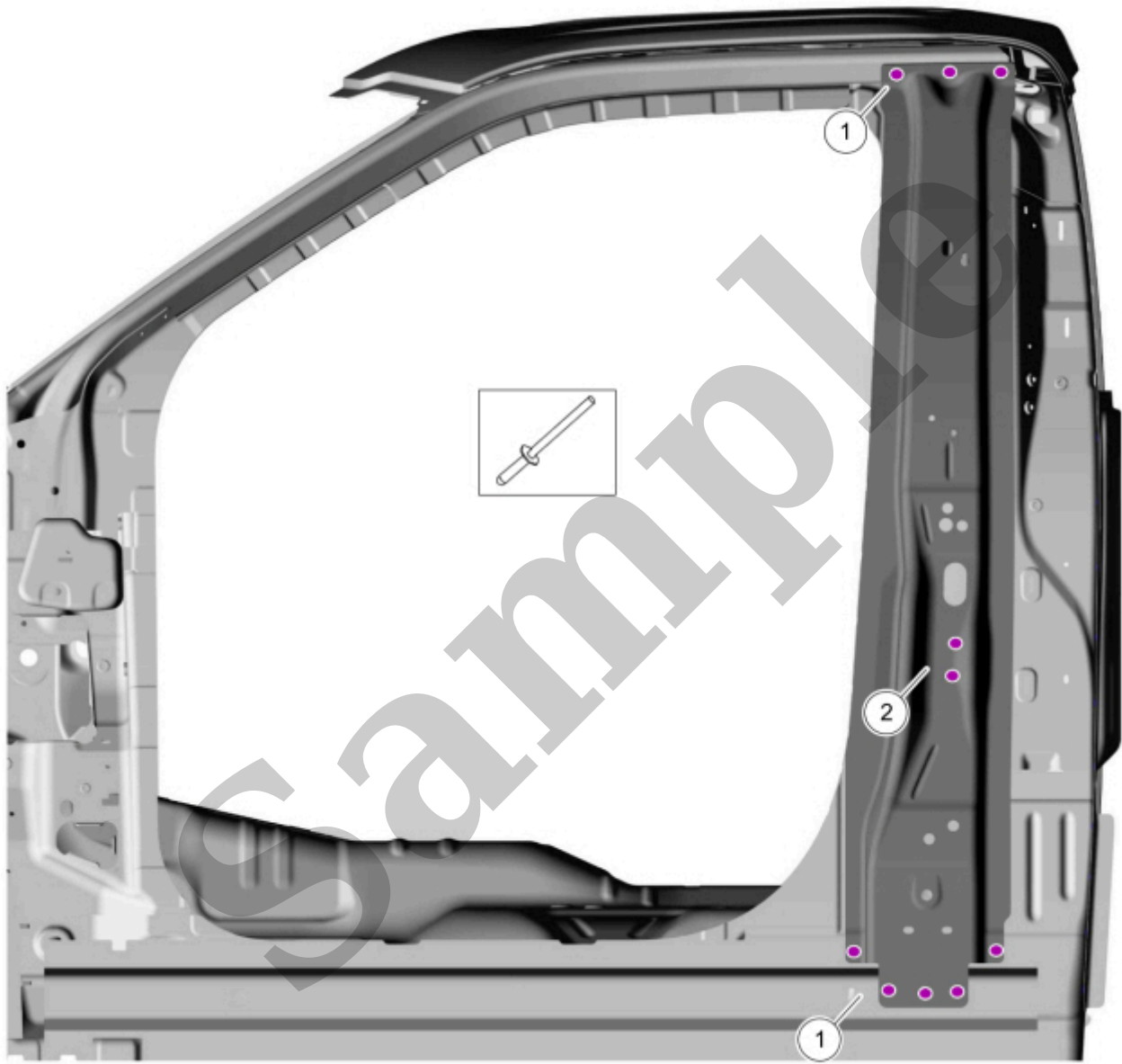
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10. Drill 6.5 mm holes for blind rivet fastener installation.

Use the General Equipment: 6.5 mm Drill Bit

2	-	-	-	-	W702512-S900C	-	-
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Use the General Equipment: Blind Rivet Gun



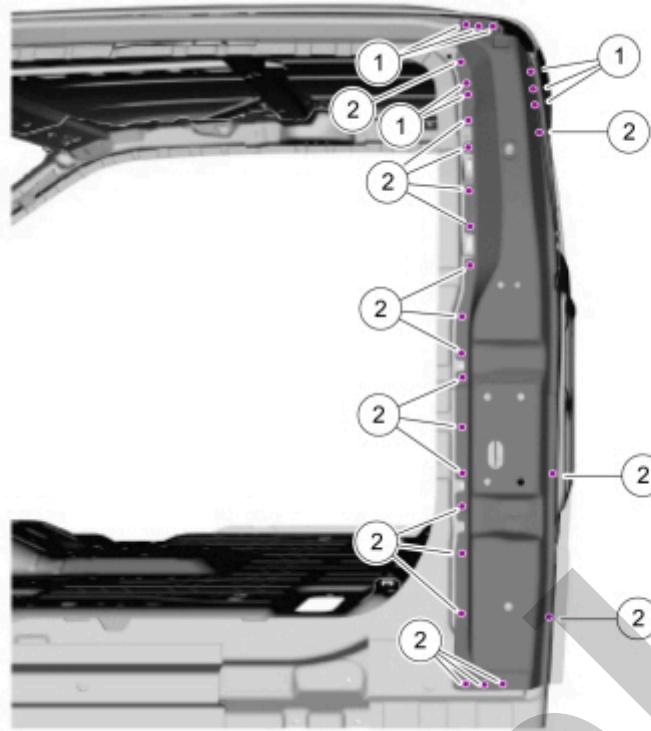
E201740

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SuperCab

12. Drill for fasteners.

Use the General Equipment: 6.5 mm Drill Bit



E257293

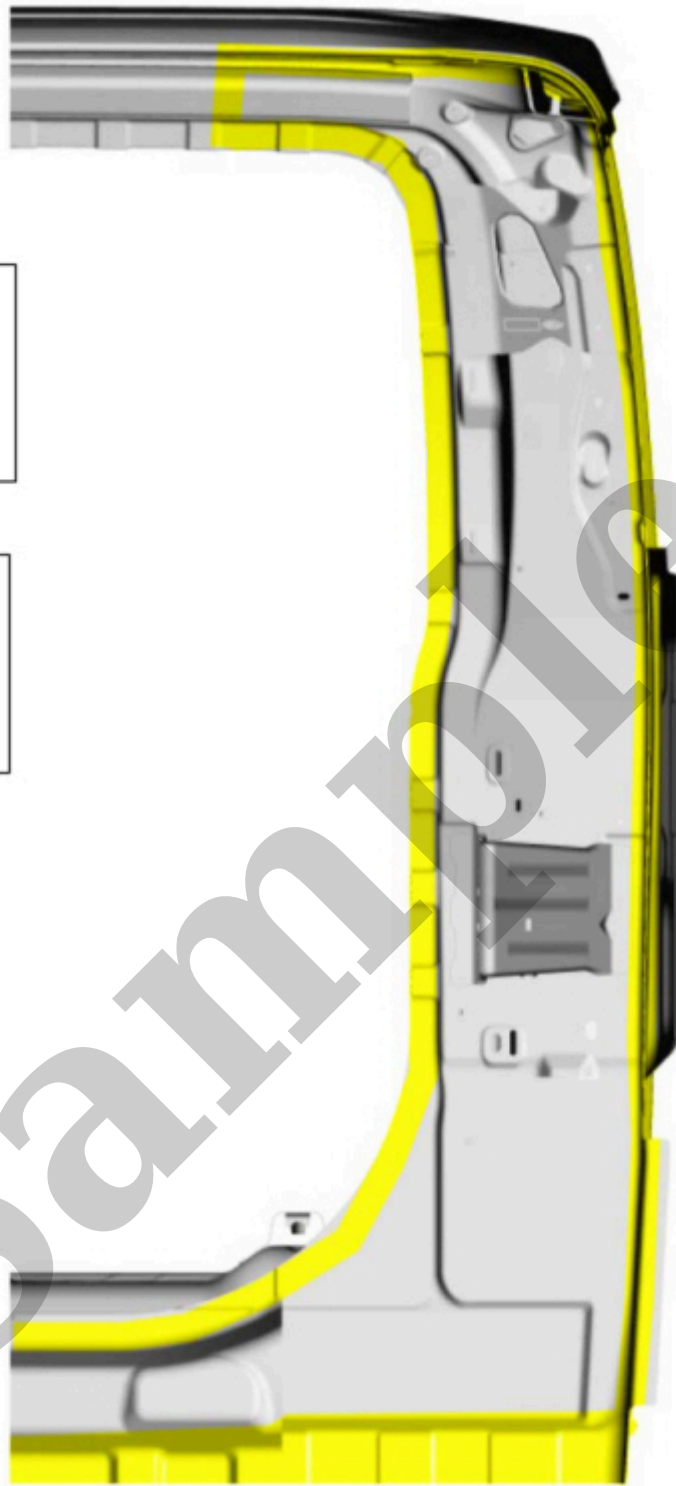
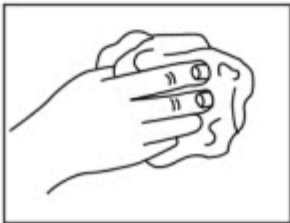
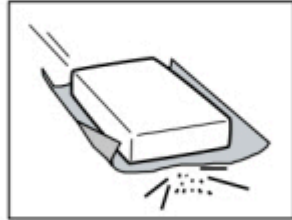
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All vehicles

14. **NOTE**

SuperCrew cab shown, regular and SuperCab similar.

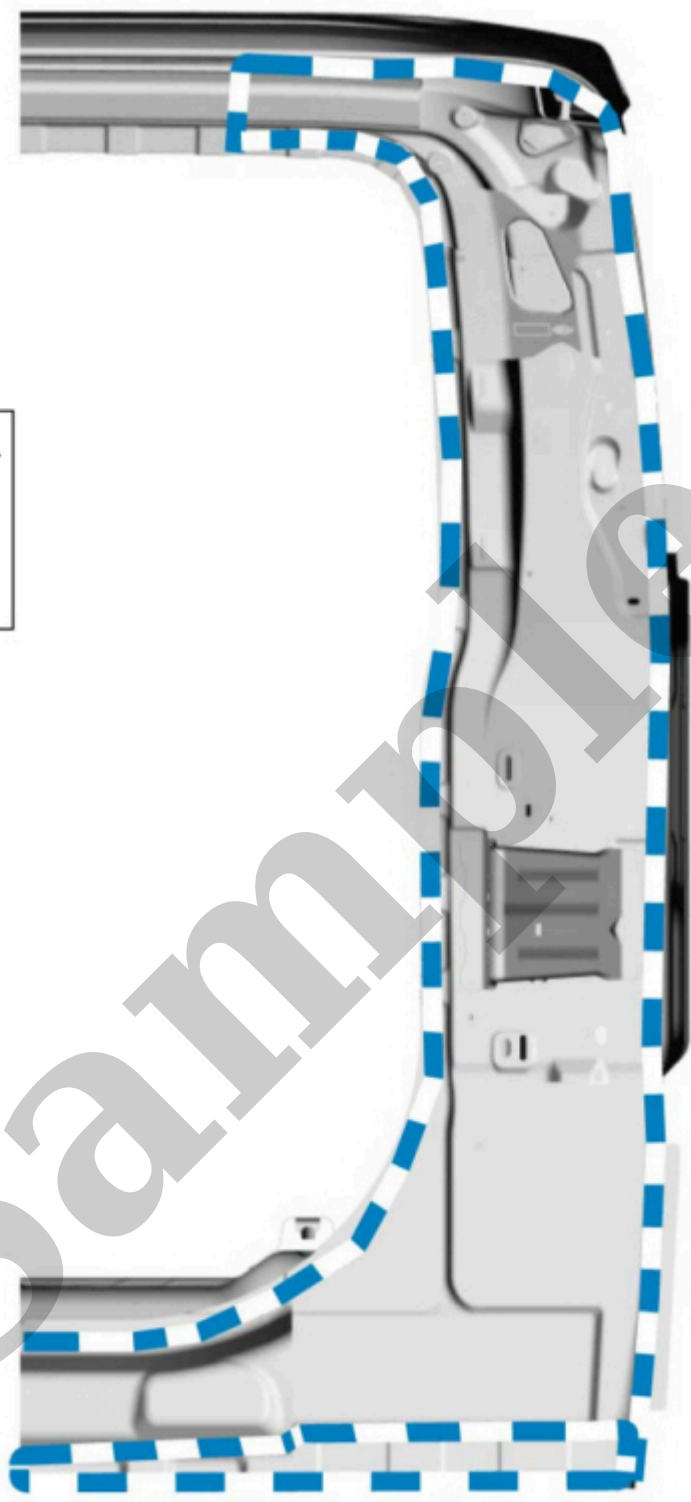
Cut the service panel to fit repair area.



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17. Sand the service panel mating surfaces using 80 grit sand paper to remove e-coat and clean.



E199481

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19. Install service panel and clamp in position.

Use the General Equipment: Locking Pliers



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SuperCrew

22. NOTE

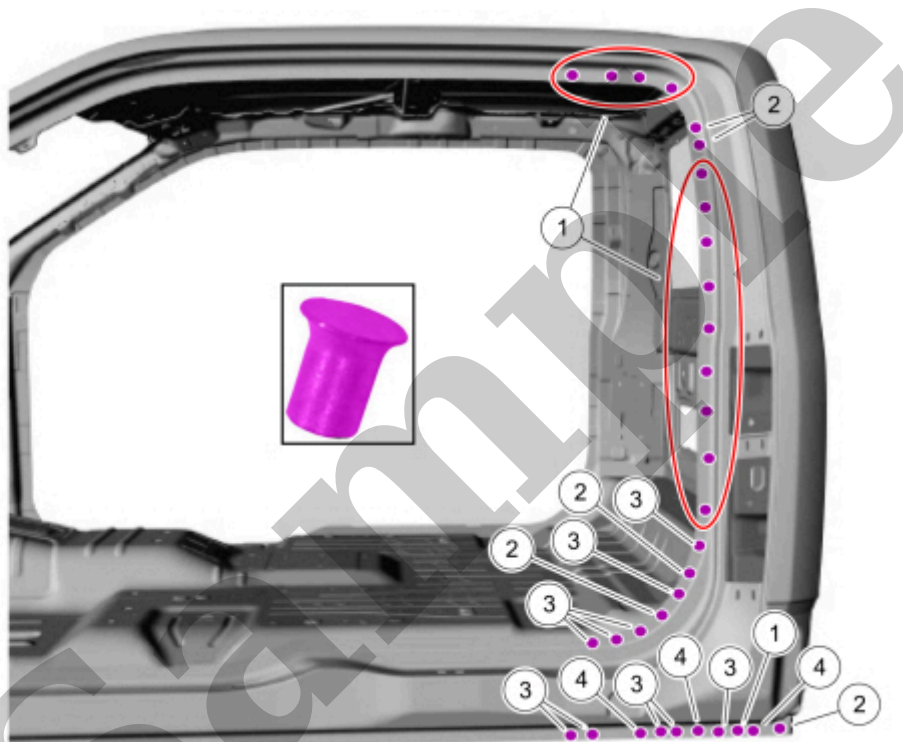
SPR (self-piercing rivet) fasteners may not be placed directly over original SPR (self-piercing rivet) location. They must be placed adjacent to original location matching original quantity.

Install the fasteners.

Item	SPR (self-piercing rivet) Number	SPR (self-piercing rivet) Code	Henrob® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
1	W708713-S900	AS	DZ09-025/H	SA-0400/SA-0401	-	W790376-S900	-
2	W708717-S900	AW	DP11-200/H	SA-0400/SA-0402	-	W790377-S900	-
3	W717186-S900	EN	DP11-200/H	SA-0400/SA-0402	-	W790377-S900	-

2	W708717-S900	AW	DG10-220/H	SA-0400/SA-0402	-	W790377-S900	-
3	W717186-S900	EN	DP11-200/H	SA-0400/SA-0402	-	W790377-S900	-
4	W710246-S900	BN	DP10-200/H	SA-0400/SA-0402	-	W790377-S900	-

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



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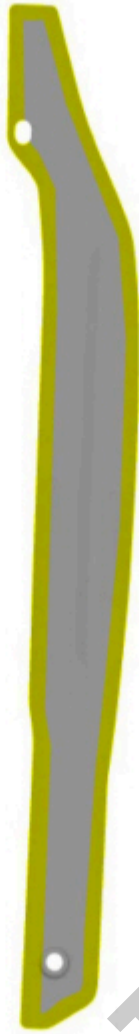
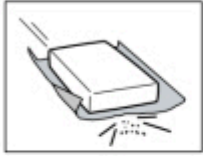
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Regular Cab

24. 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.

Install fasteners.



E199474

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26. Apply adhesive as indicated to the cab back filler panel mating surface.

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