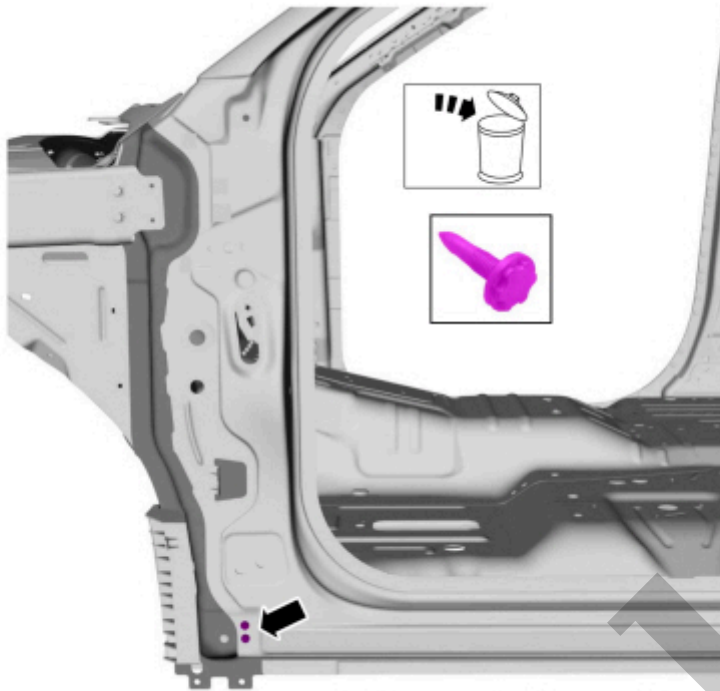


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1993 FORD Fiesta 3 Doors OEM Service and Repair Workshop Manual

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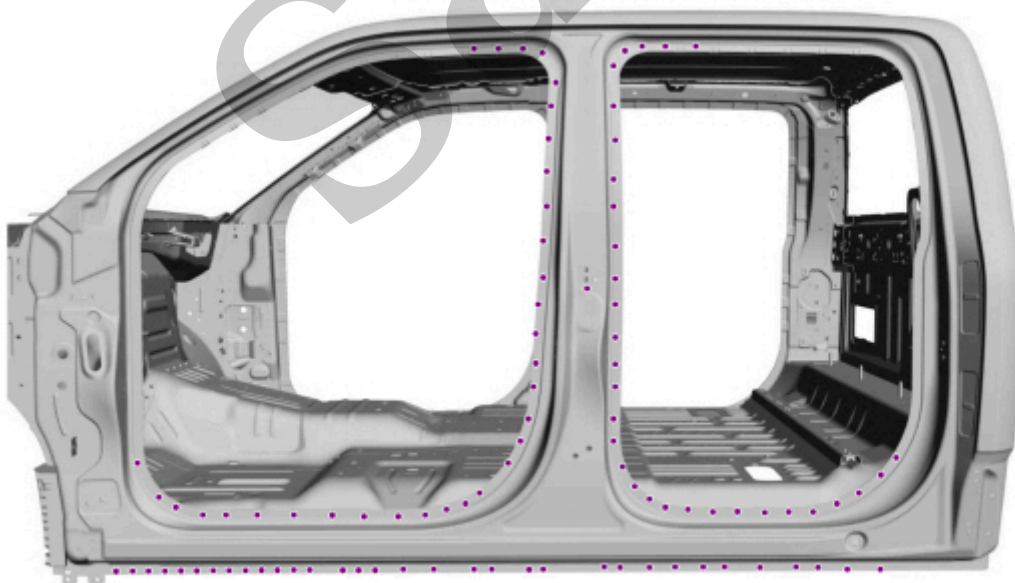
E333023

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

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

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

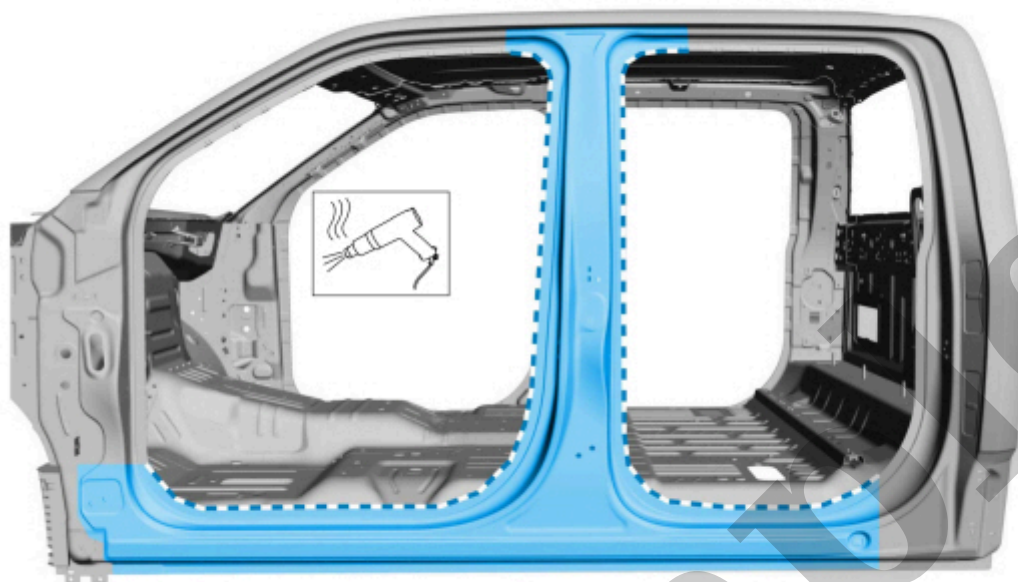
Use the General Equipment: Belt Sander



E333025

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

Break the adhesive bond and remove the outer sheet metal.

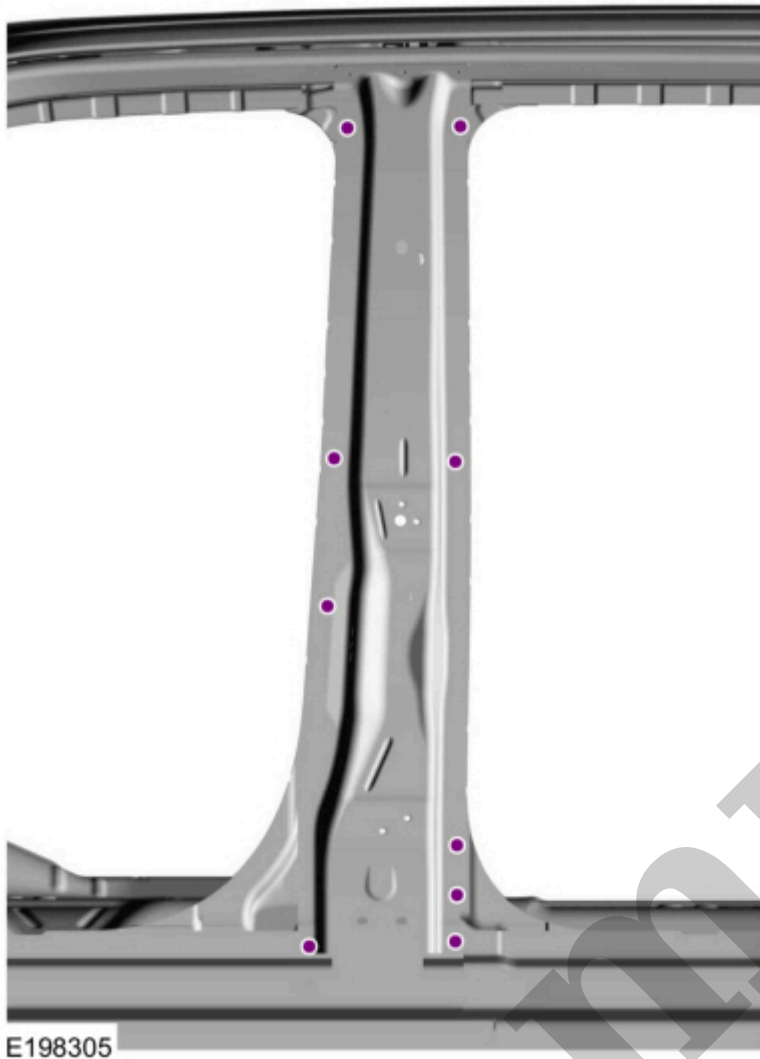


E333026

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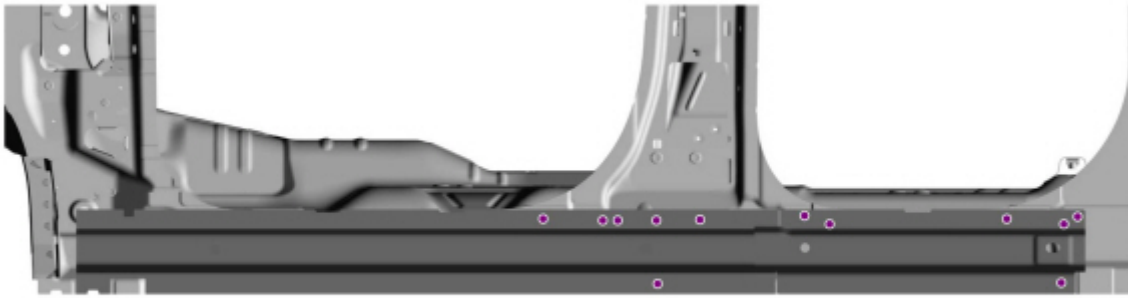
12. Remove and discard the B-pillar reinforcement FDS (flow drill screw) fasteners.

Use the General Equipment: Polydrive Bit Socket



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

14. Remove the B-pillar reinforcement.



E198307

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16. Remove the rocker panel inner reinforcement.



E198308

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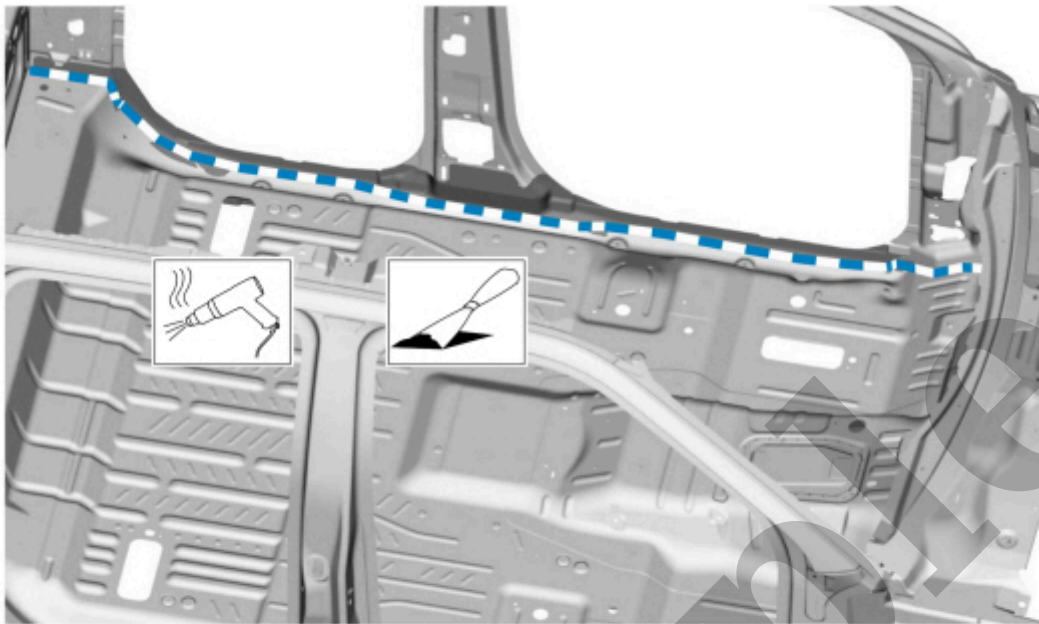
17. Remove and discard the B and C-pillar FDS (flow drill screw) fasteners.

Use the General Equipment: Polydrive Bit Socket

19. Remove the floor pan-to-rocker panel seam sealer.

Use the General Equipment: Hot Air Gun

Use the General Equipment: Scraper for Straight Edges



E199960

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20. Remove and discard the floor pan-to-rocker panel SPR (self-piercing rivet) fasteners.

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

Use the General Equipment: Belt Sander



E199963

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Installation

NOTICE

Body side sectioning is prohibited within 50 mm of door hinge, door striker and restraints anchoring points.

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.

1. Sand using 80 grit sand paper to remove old adhesive and e-coat and clean.



E199964

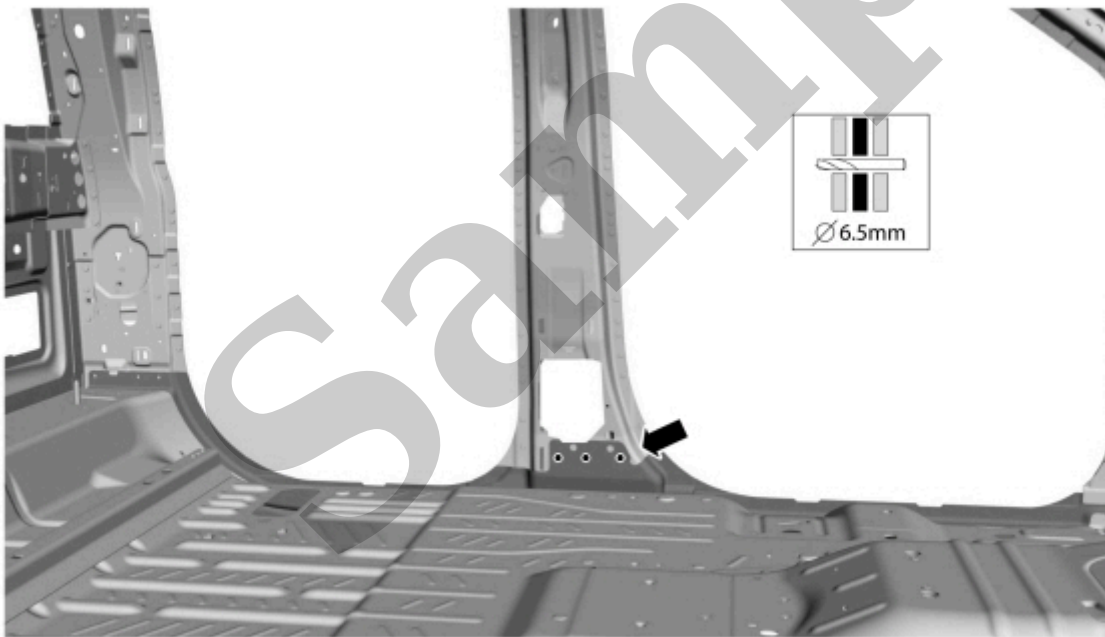


E199967

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5. Drill 6.5 mm holes for fasteners.

Use the General Equipment: 6.5 mm Drill Bit

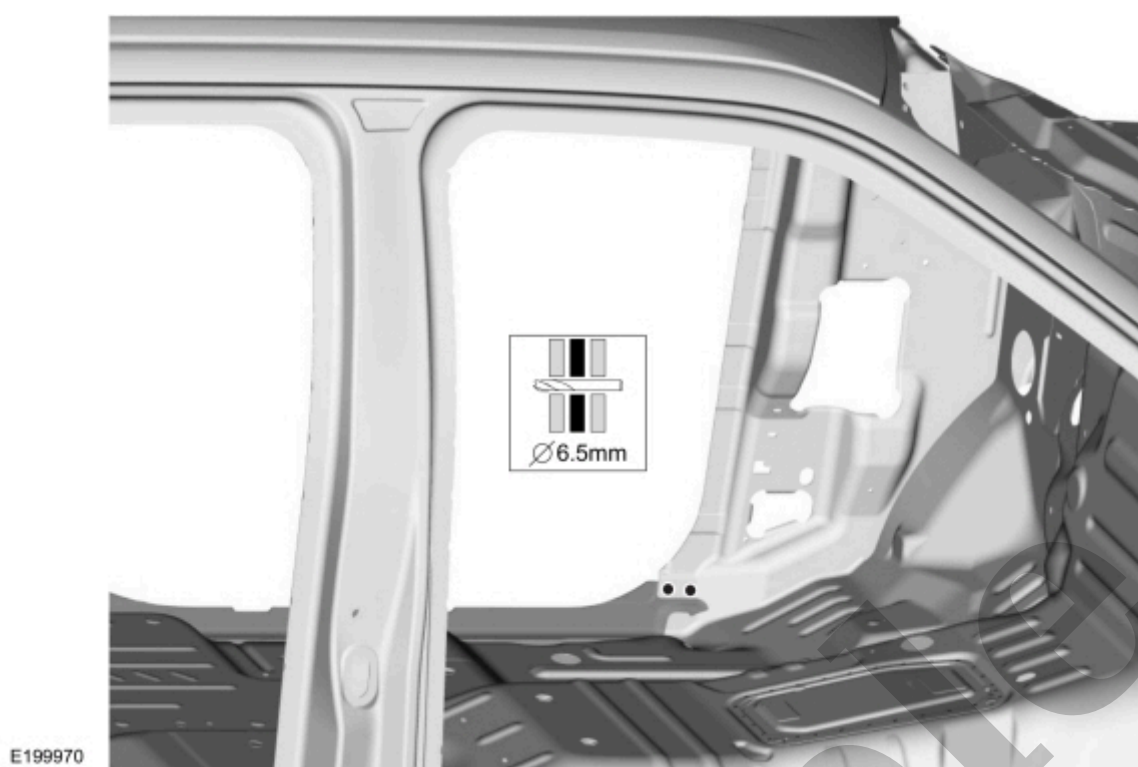


E333133

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6. NOTE

SPR (self-piercing rivet) fasteners may not be placed directly over original SPR (self-piercing rivet)



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

8. 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.

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	W717185-S900	EL	DP11-200/H	SA-0400/SA-0402	W708777-S900C	-	-

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

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

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.

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	-	-	-	-	W702512-S900C	-	-

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

Use the General Equipment: Blind Rivet Gun

