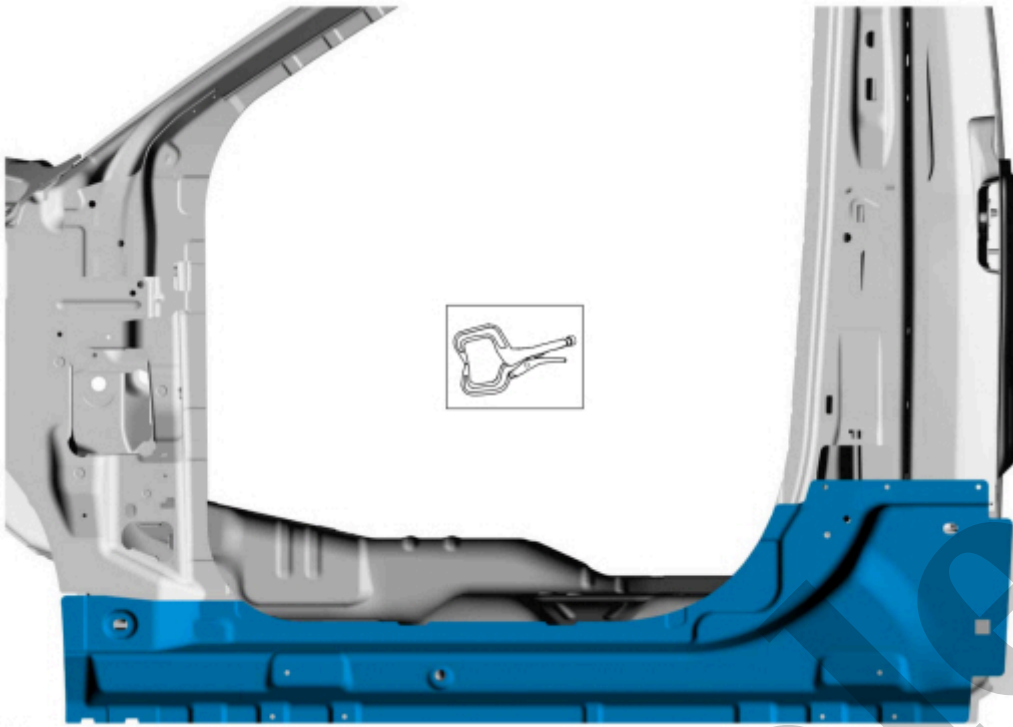


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1994 FORD Fiesta 3 Doors OEM Service and Repair Workshop Manual

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E201886

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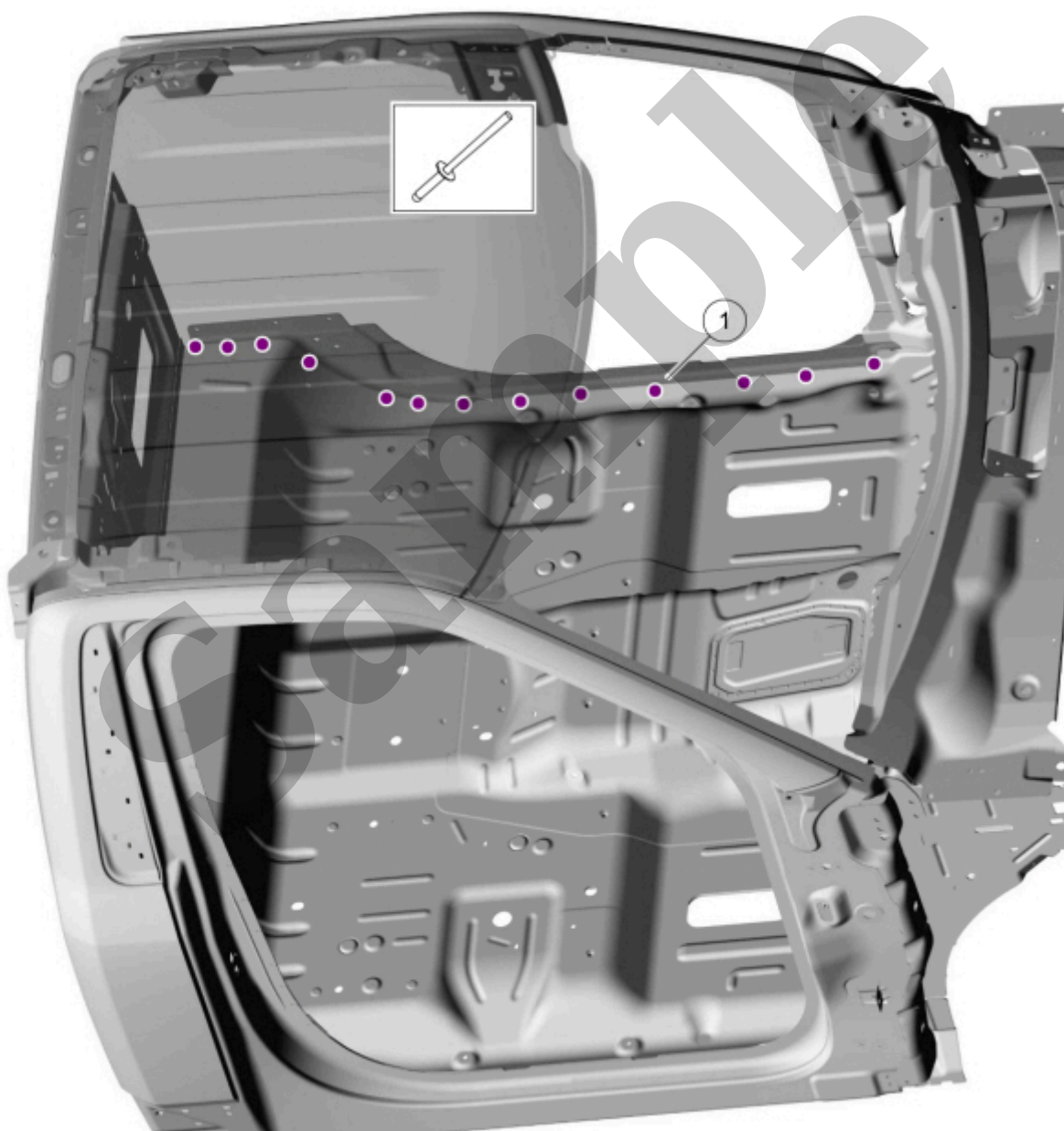
5. Drill for blind rivet fastener installation.

Use the General Equipment: 6.5 mm Drill Bit

	rivet) Number	rivet) Code	Chief®, Spanesi® Wielande and Schill® Mandrel				
1	-	-	-	-	W702554- S900C	-	-

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

Use the General Equipment: Blind Rivet Gun



E201891

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Refer to: [Rocker Panel Inner Reinforcement - Regular Cab](#)(501-29 Side Panel Sheet Metal Repairs, Removal and Installation).

10. Install the safety belt and shoulder height adjuster.

Refer to: [Front Center Seatbelt Retractor - Regular Cab](#)(501-20A Seatbelt Systems, Removal and Installation).

Refer to: [Seatbelt Shoulder Height Adjuster - Regular Cab](#)(501-20A Seatbelt Systems, Removal and Installation).

11. Reposition the wiring harness and carpet.

12. Install the seat.

Refer to: [Front Seat](#)(501-10A Front Seats, Removal and Installation).

13. Repower the SRS (supplemental restraint system) .

Refer to: [Supplemental Restraint System \(SRS\) Repowering](#)(501-20B Supplemental Restraint System, General Procedures).

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

NOTICE

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

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

The following procedure assumes full component replacement.

NOTE

The rocker panel may be sectioned at any point providing restraints, door hinge and door striker restrictions are met. Adjust sectioning point to meet repair requirements.

2. Remove the rocker panel inner reinforcement.

Refer to: [Rocker Panel Inner Reinforcement - SuperCab](#)(501-29 Side Panel Sheet Metal Repairs, Removal and Installation).

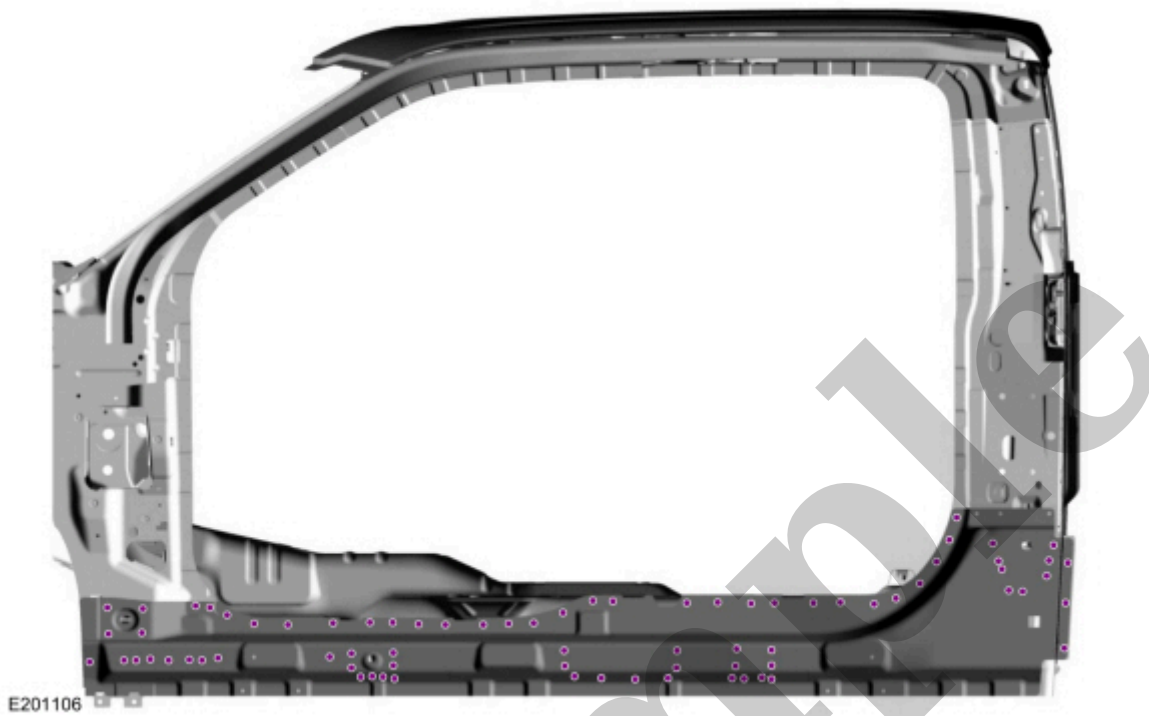
3. Remove the seam sealer.

Use the General Equipment: Hot Air Gun

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

5. Remove the rocker panel outer SPR (self-piercing rivet) fasteners.

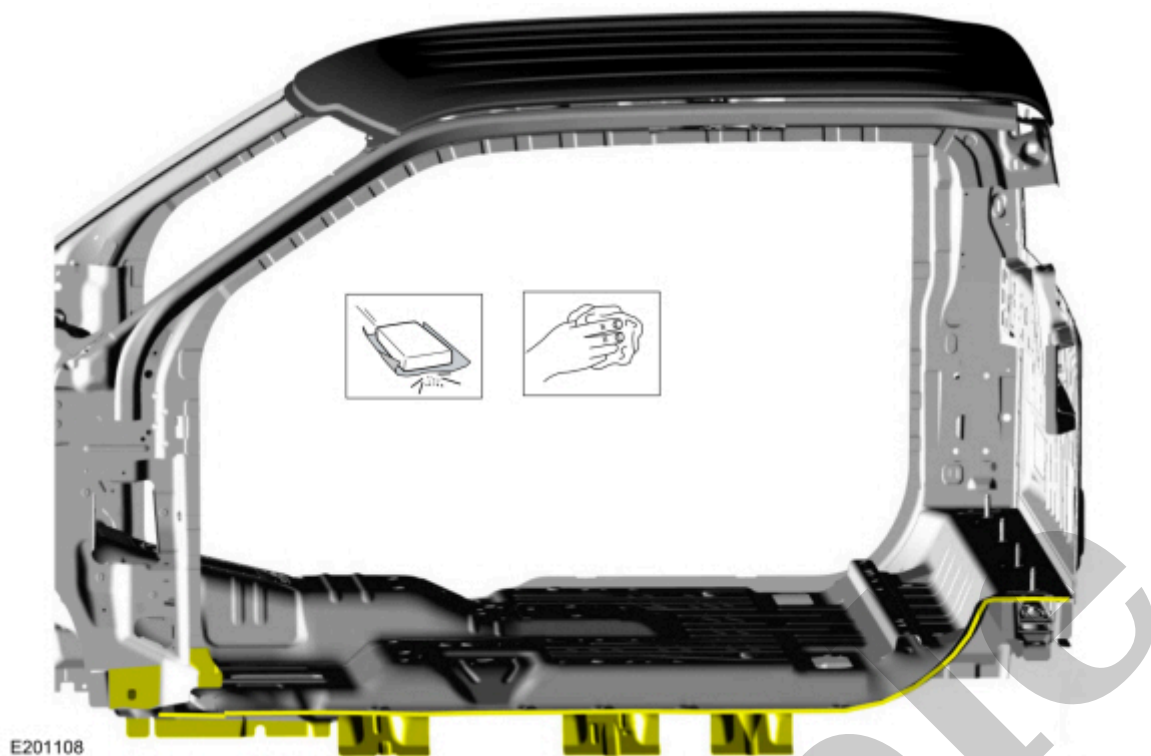
Use the General Equipment: Spot Weld Drill Bit



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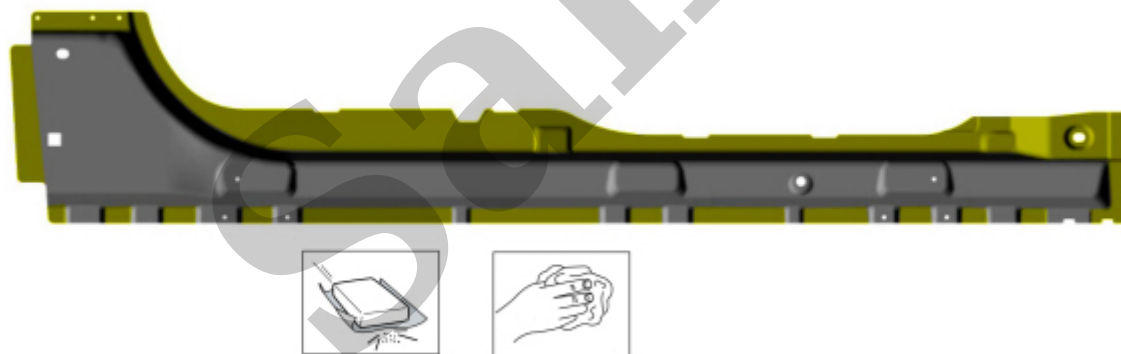
6. Break the adhesive bond and remove the rocker panel.

Use the General Equipment: Hot Air Gun



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

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



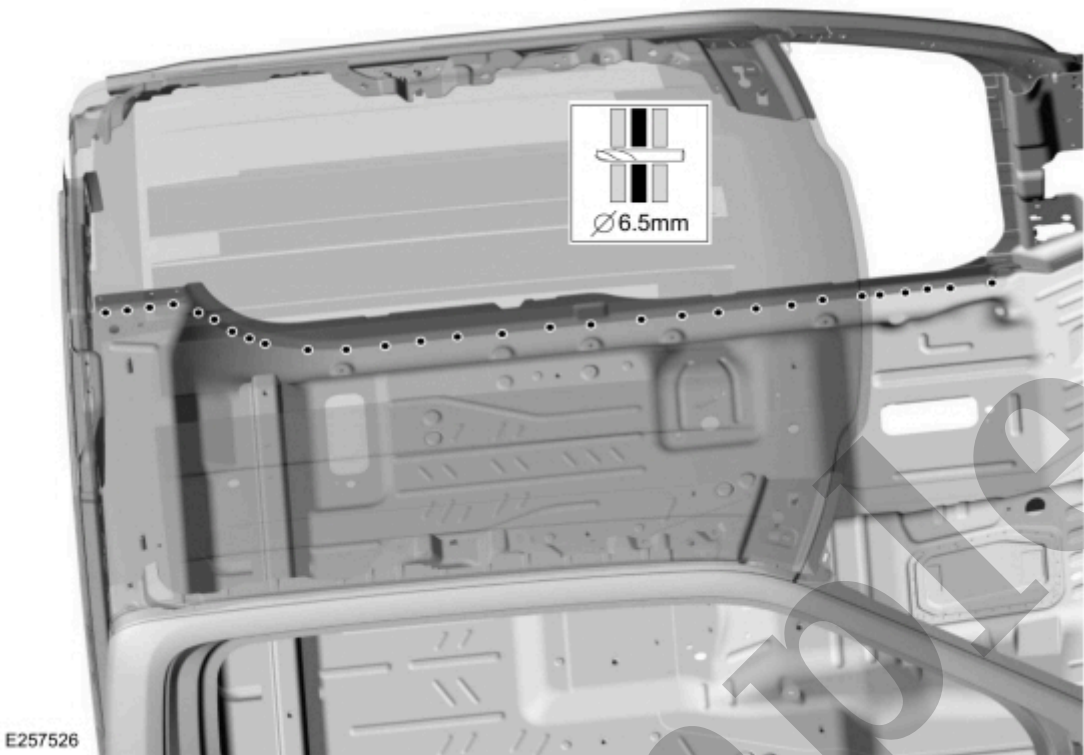
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3. Apply adhesive.

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

5. Drill for fastener installation.

Use the General Equipment: 6.5 mm Drill Bit



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

6. **NOTE**

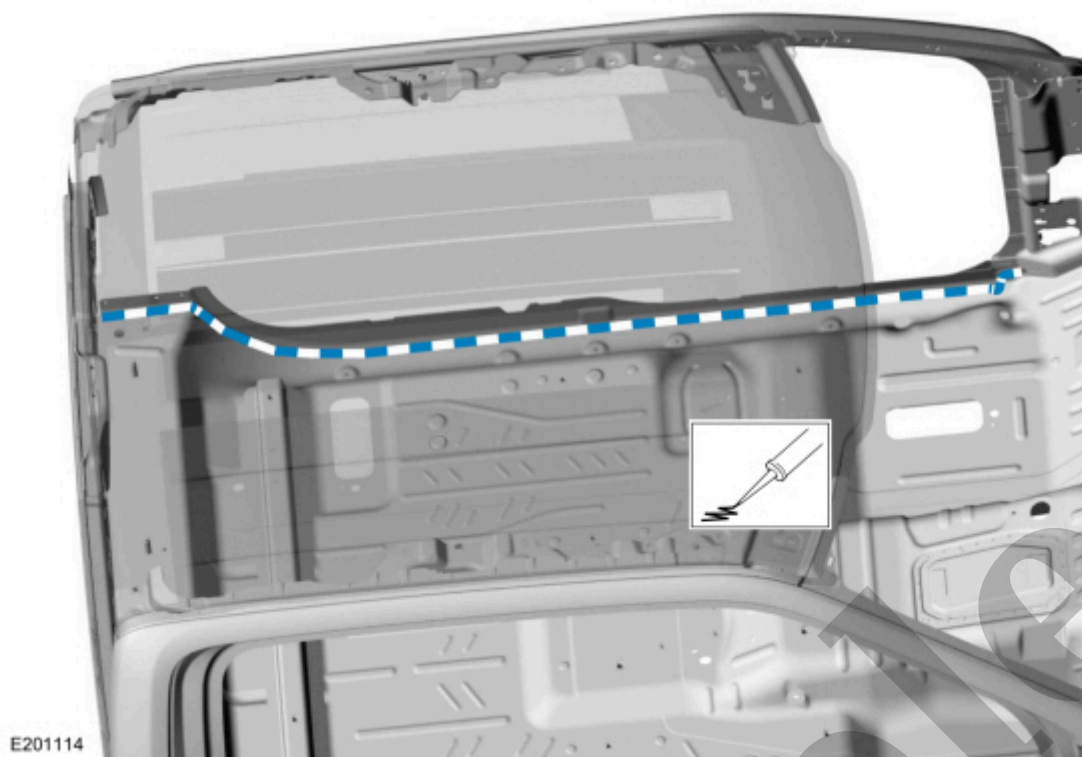
SPR (self-piercing rivet) fasteners may not be placed directly over original SPR (self-piercing rivet) location. They must be placed adjacent to original location matching original quantity.

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® Mandrel	Pro-Spot® Mandrel	Blind Rivet	Solid Rivet	Rivnut®
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[Click here to learn about symbols, color coding, and icons used in this manual.](#)

8. Install the rocker panel inner reinforcement.

Refer to: [Rocker Panel Inner Reinforcement - SuperCab](#) (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).

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

NOTICE

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

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

The rocker panel may be sectioned. The following assumes complete component replacement. Sectioning may be adjusted to meet repair requirement as long as door hinge, striker and restraints requirements are met.

2. Depower the SRS (supplemental restraint system) .

Refer to: [Supplemental Restraint System \(SRS\) Depowering](#)(501-20B Supplemental Restraint System, General Procedures).

3. Remove the front fender.

Refer to: [Fender](#)(501-02 Front End Body Panels, Removal and Installation).

4. Remove the front and rear doors.

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

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

5. Remove the front and rear door strikers and hinges.