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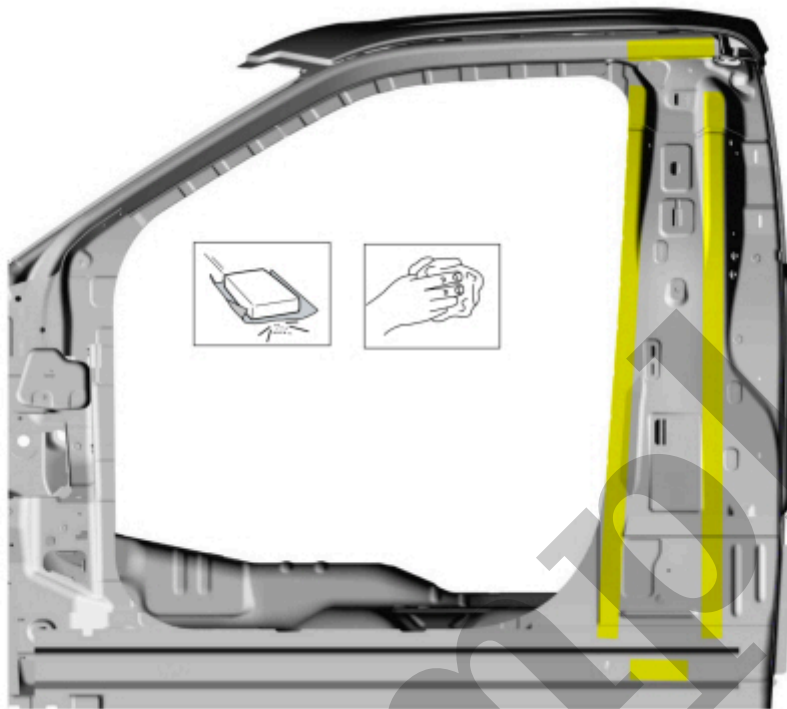
1999 FORD Fiesta 3 Doors OEM Service and Repair Workshop Manual

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Refer to: [Fender Apron Panel Reinforcement](#)(501-27 Front End Sheet Metal Repairs, Removal and Installation).

15. 80-120 grit sandpaper.

Sand to remove old adhesive and clean.



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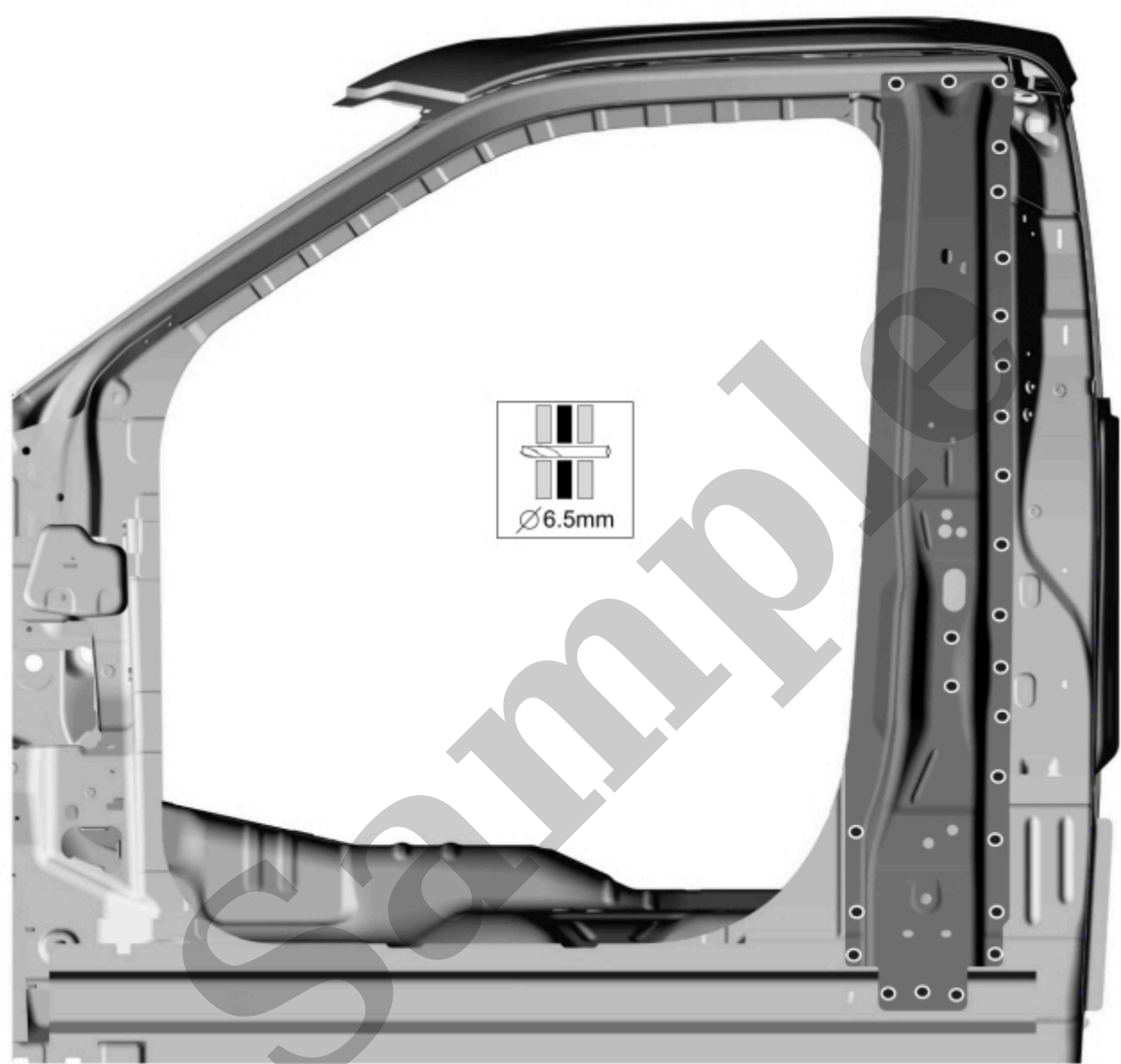
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16. Apply adhesive.

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

18. Drill 6.5 mm holes for blind rivet fasteners.

Use the General Equipment: 6.5 mm Drill Bit

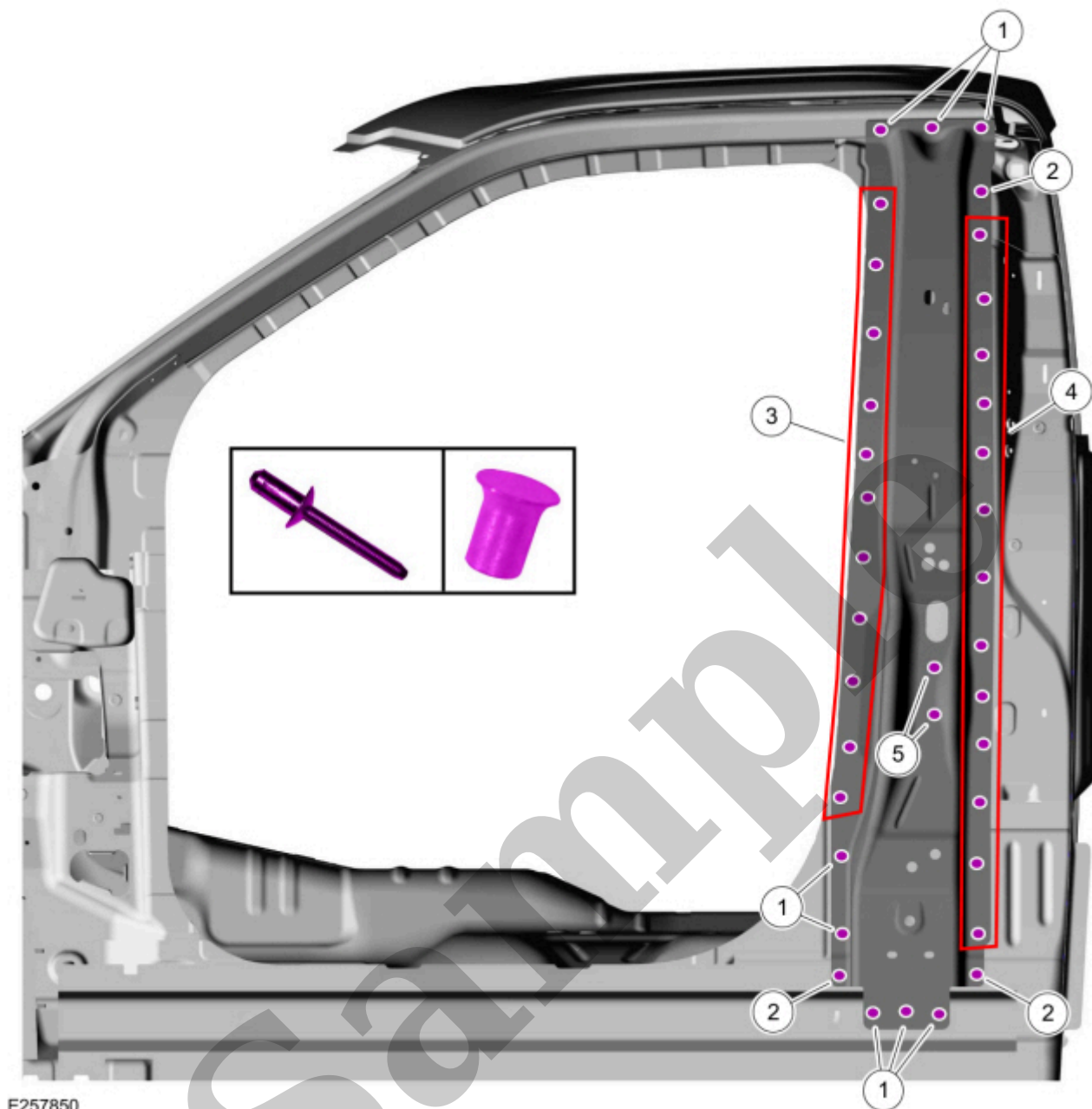


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19. Install blind rivet fasteners.

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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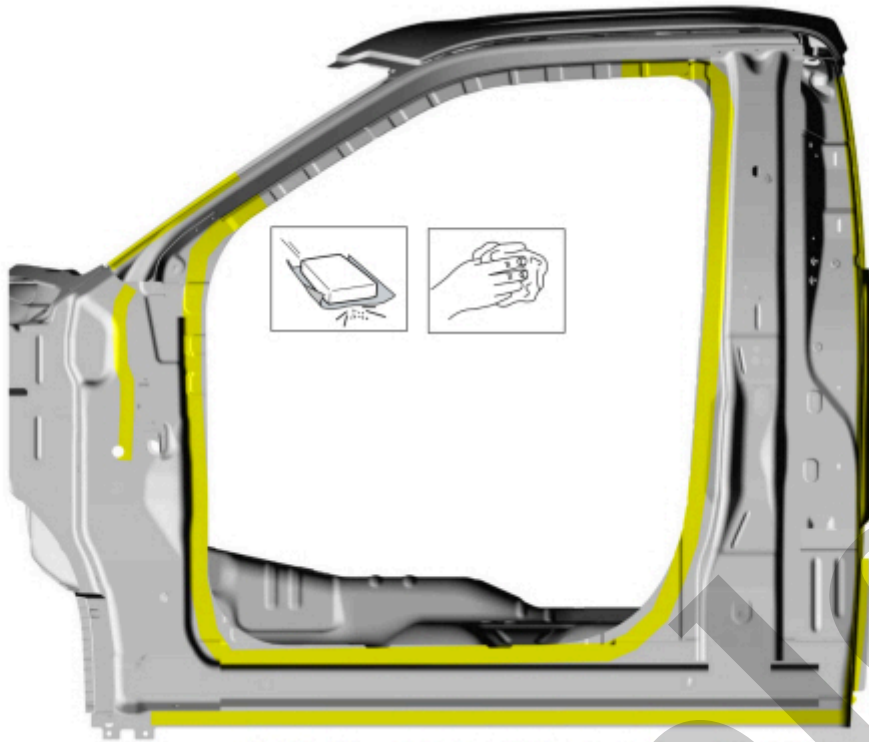


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20. Cut the body side service panel to fit repair.

Use the General Equipment: Air Body Saw

Use the General Equipment: Spherical Cutter

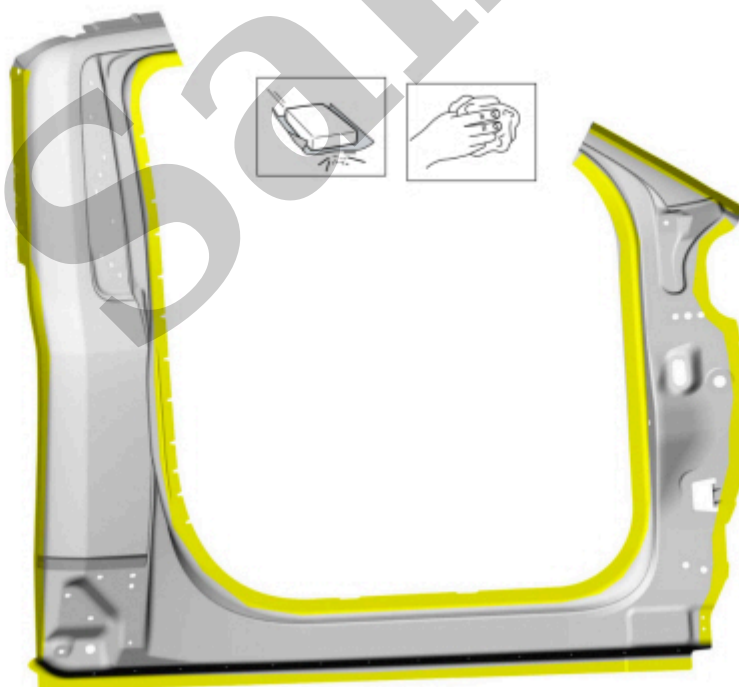


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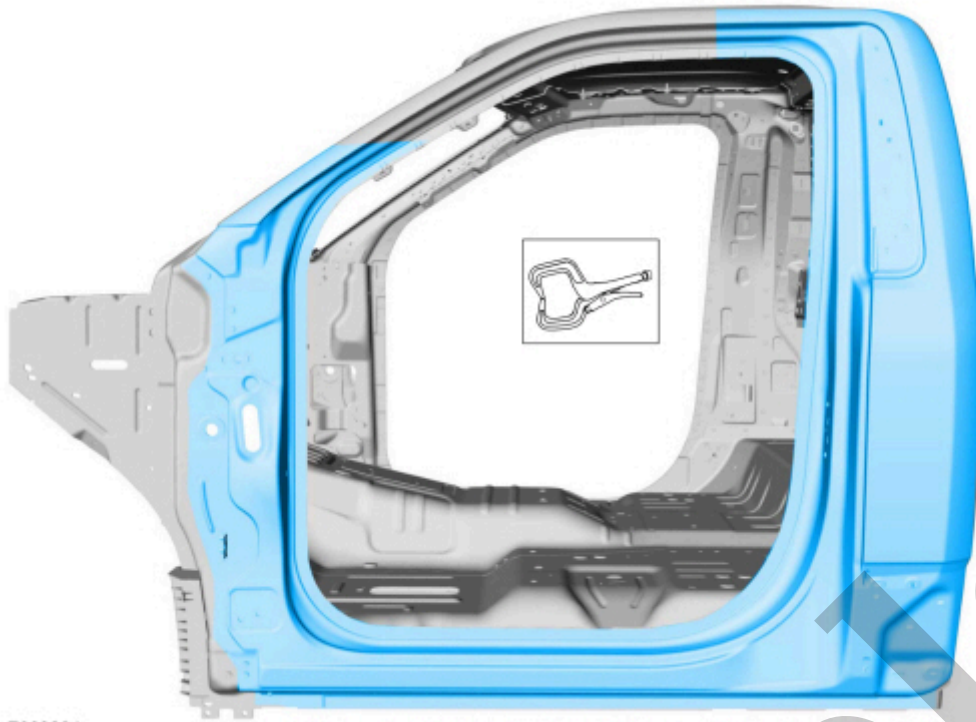
23. 80-120 grit sandpaper.

Sand to remove e-coat and clean.



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27. Complete joining of backer plates to the body side service panel.

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

Use the General Equipment: MIG/MAG Welding Equipment

28. Completely seam-weld all sectioning joints using a MIG (metal inert gas) welder set up for aluminum repair.

Use the General Equipment: MIG/MAG Welding Equipment

30. **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 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®
1	-	-	-	-	W707638-S900C	-	-
2	-	-	-	-	W708777-S900C	-	-
3	-	-	-	-	W702554-S900C	-	-

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

Use the General Equipment: Blind Rivet Gun

				0401			
2	W708713-S900	AS	DP11-200/H	SA-0400/SA-0402	-	W790377-S900	-
3	W717186-S900	EN	DG11-220/H	SA-0400/SA-0402	-	W790377-S900	-
4	W717186-S900	EN	DP11-200/H	SA-0400/SA-0402	-	W790377-S900	-
5	W708717-S900	AW	DP11-200/H	SA-0400/SA-0402	-	W790377-S900	-
6	W717185-S900	EL	DG11-220/H	SA-0400/SA-0402	-	W790377-S900	-
7	W710246-S900	BN	DP10-200/H	SA-0400/SA-0402	-	W790377-S900	-

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

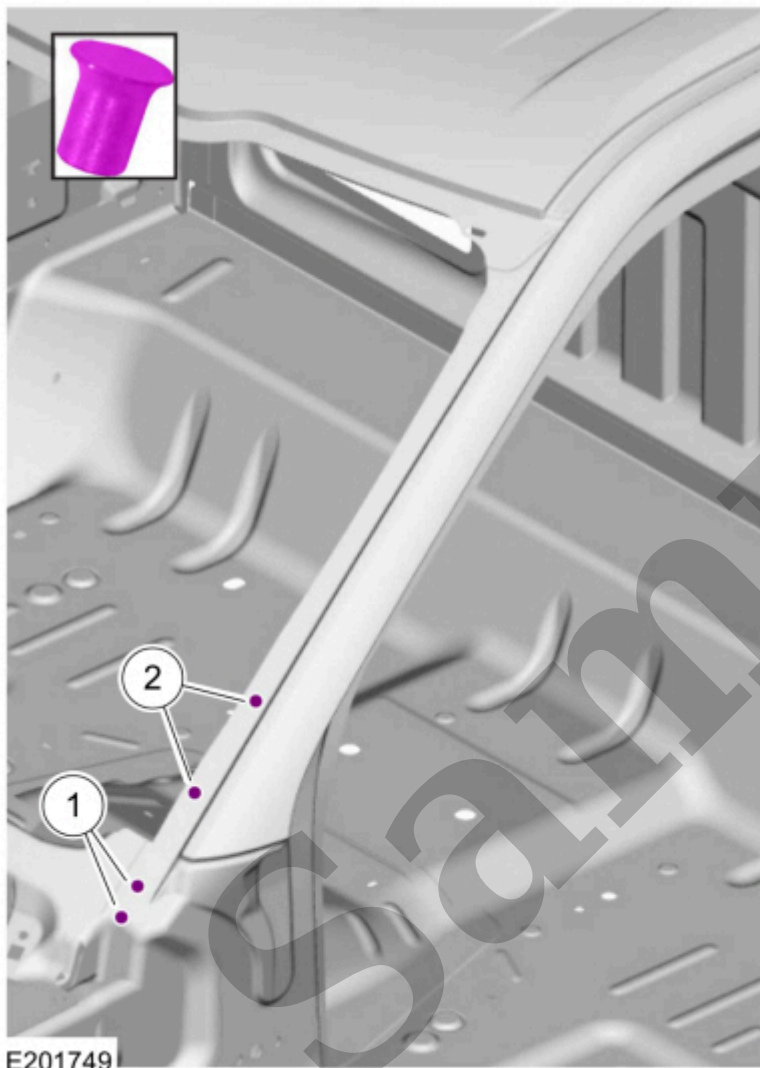
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer

Use the General Equipment: Blind Rivet Gun

2	W708713-S900	AS	DZ09-025/H	SA-0400/SA-0402	-	W790377-S900	-
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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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33. Drill for fasteners.

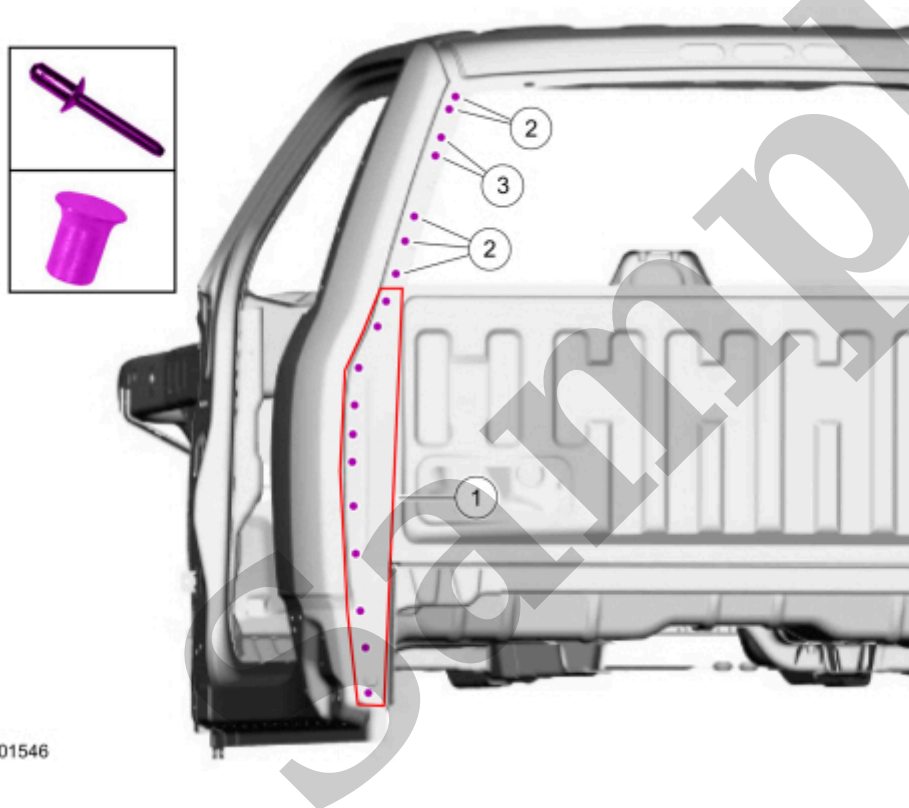
Use the General Equipment: 6.5 mm Drill Bit

2	W708713-S900	AS	DZ09-025/H	SA-0400/SA-0402	-	W790377-S900	-
3	W708717-S900	AW	DG10-220/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

Use the General Equipment: Blind Rivet Gun



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35. Metal finish all sectioning seams using typical aluminum repair techniques and a fiber-based body filler.

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

36. Epoxy prime.

Prime the rear window glass opening channel using a Ford approved epoxy-based primer.