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2000 FORD Fiesta 3 Doors OEM Service and Repair Workshop Manual

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E201723

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10. Remove the cab back seam sealer.

Use the General Equipment: Scraper for Straight Edges

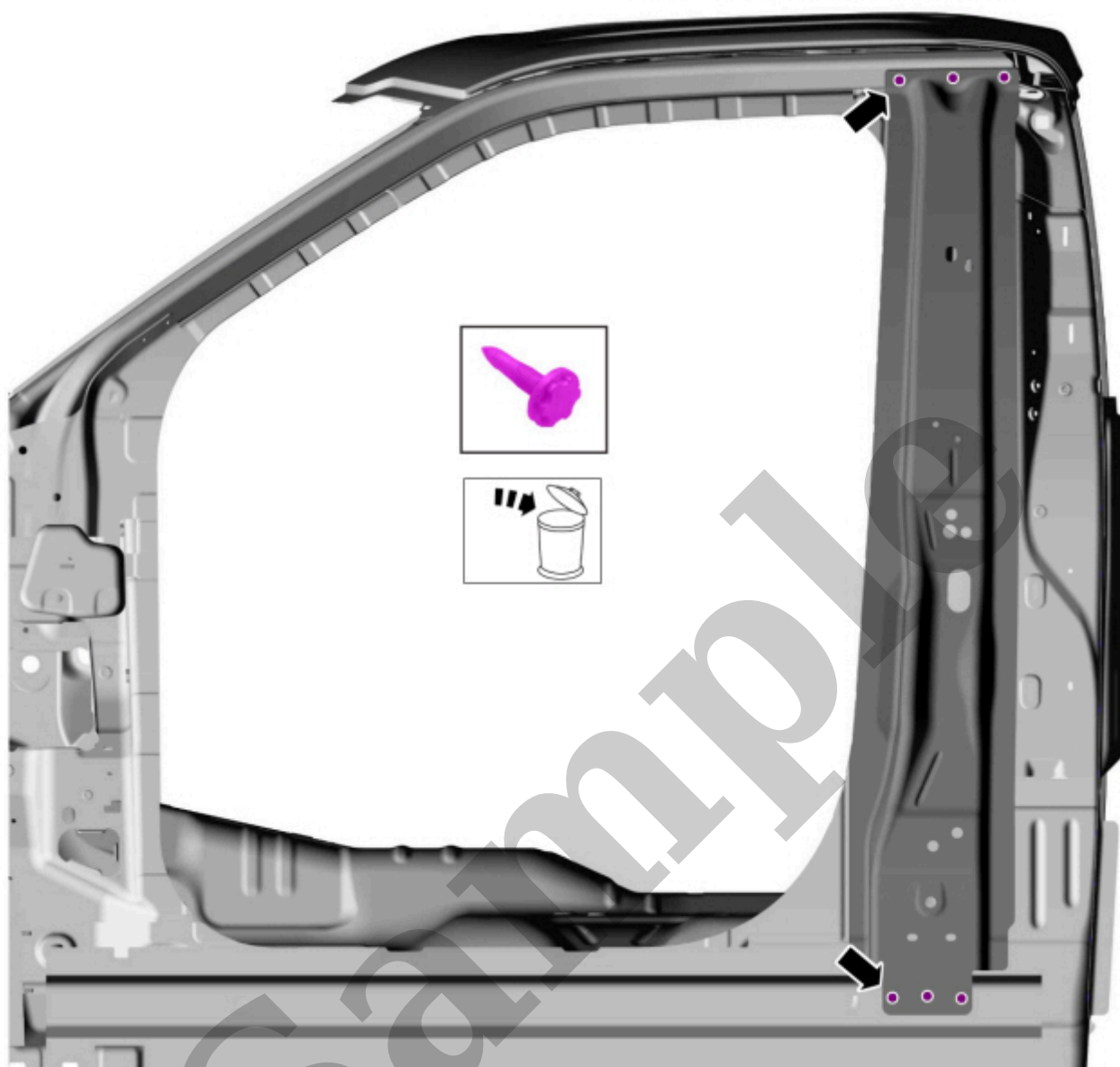
Use the General Equipment: Hot Air Gun

12. **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.

Break the adhesive bond and remove the body side section.

Use the General Equipment: Hot Air Gun



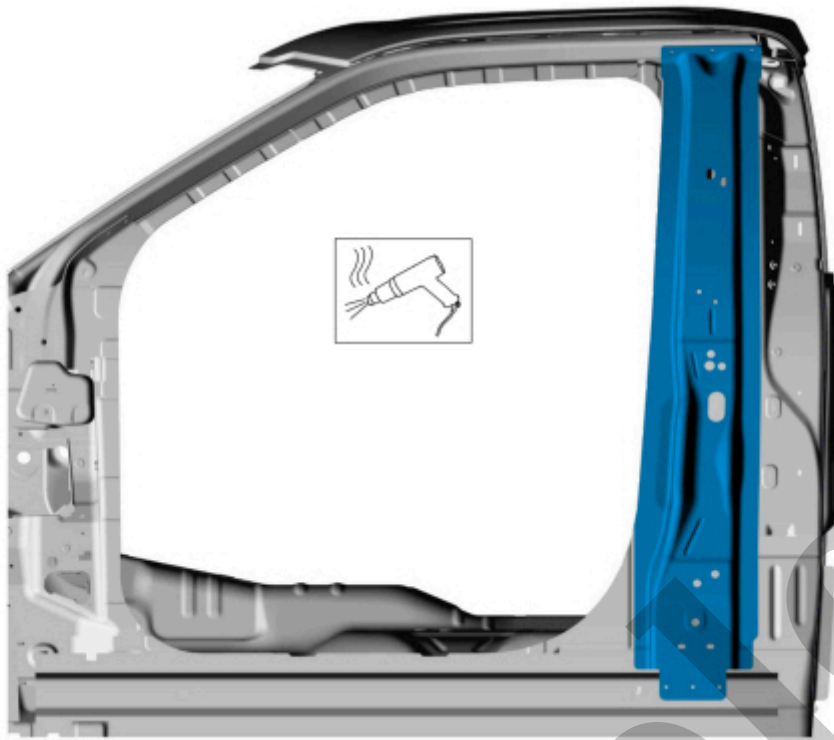
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14. Remove the SPR (self-piercing rivet) fasteners.

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

Use the General Equipment: Belt Sander



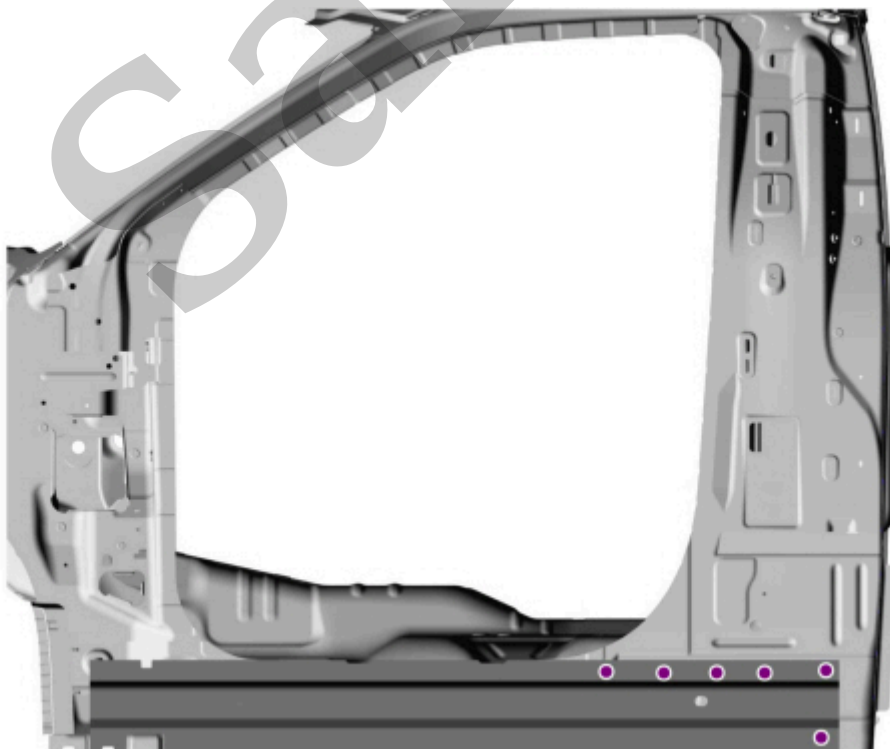
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16. Remove the SPR (self-piercing rivet) fasteners.

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

Use the General Equipment: Belt Sander



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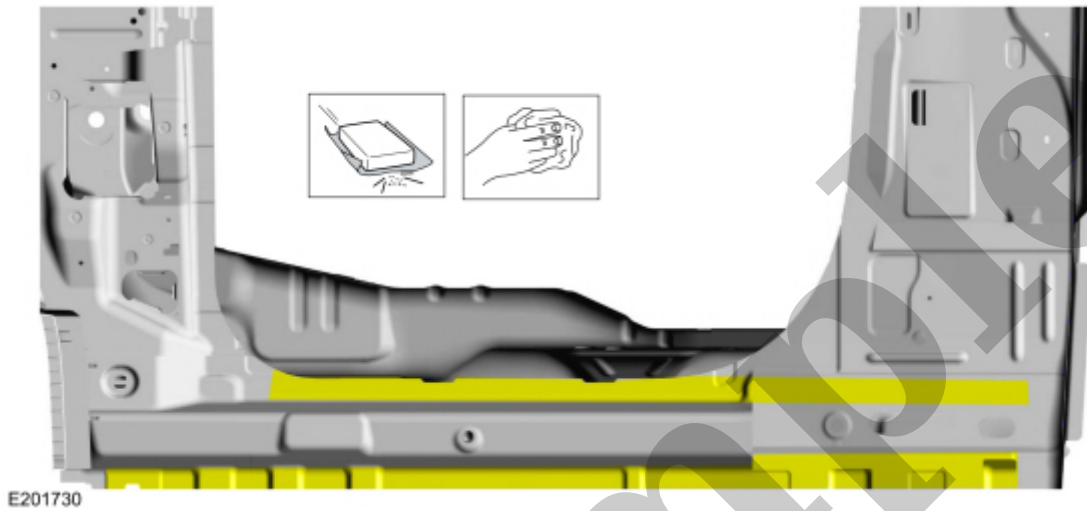
holes to 6.5 mm.

NOTE

The use of a backer panel when creating butt welds will produce a stronger and more uniform repair.

1. 80-120 grit sandpaper.

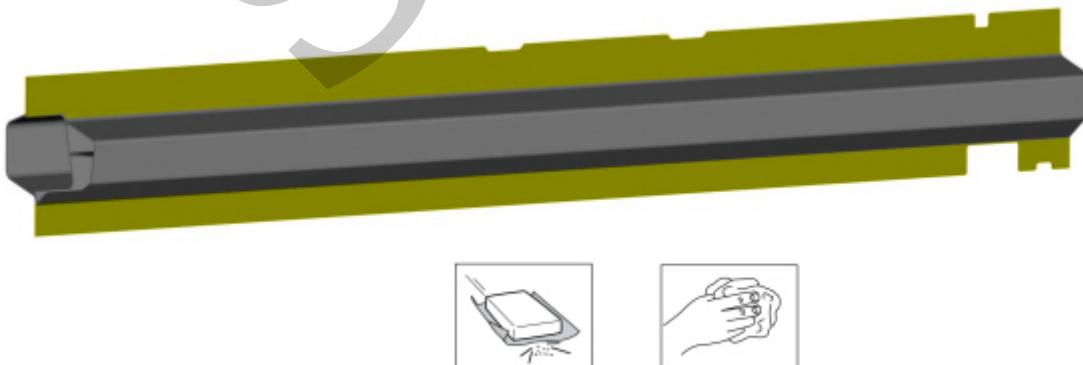
Sand to remove adhesive on the mating surfaces and clean.



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2. 80-120 grit sandpaper.

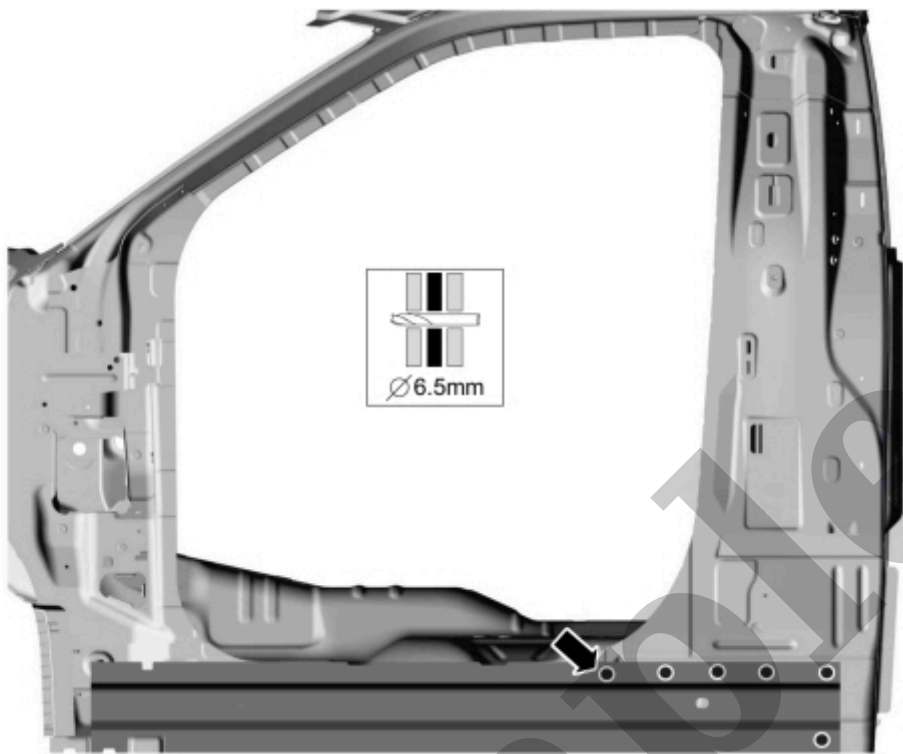
Sand to remove e-coat and clean.



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5. Drill 6.5 mm holes for blind rivet fasteners.

Use the General Equipment: 6.5 mm Drill Bit



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6. **NOTE**

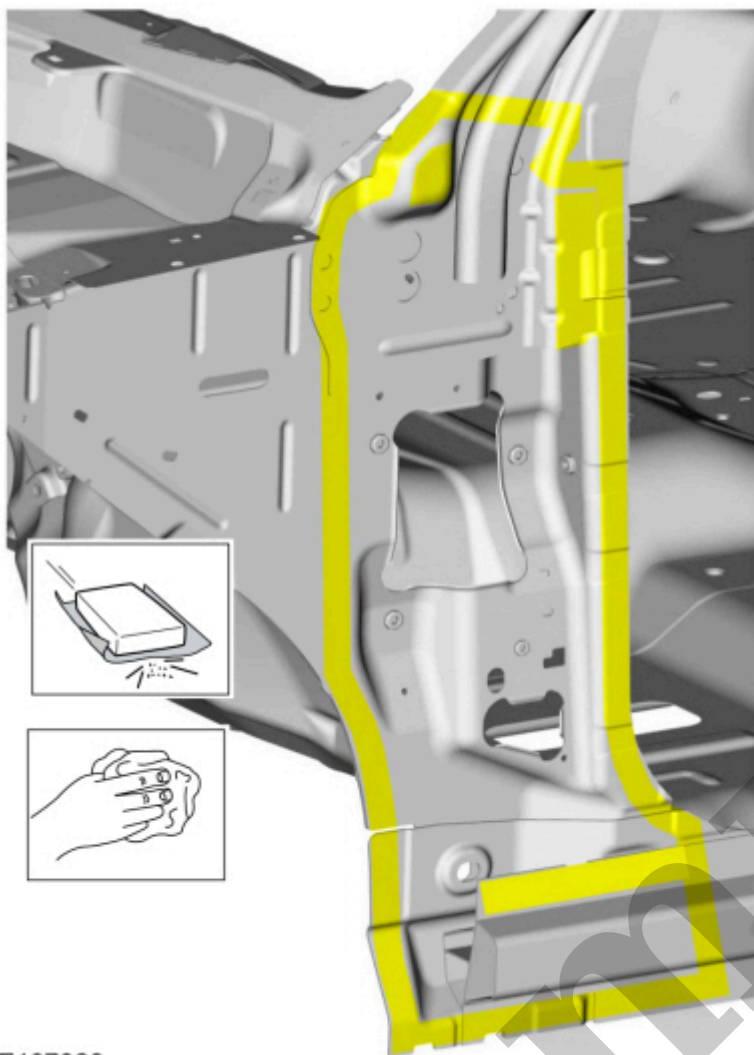
SPR (self-piercing rivet) fasteners may not be placed directly over original SPR (self-piercing rivet) location. They must be placed adjacent to original location matching original quantity.

NOTE

Blind 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®

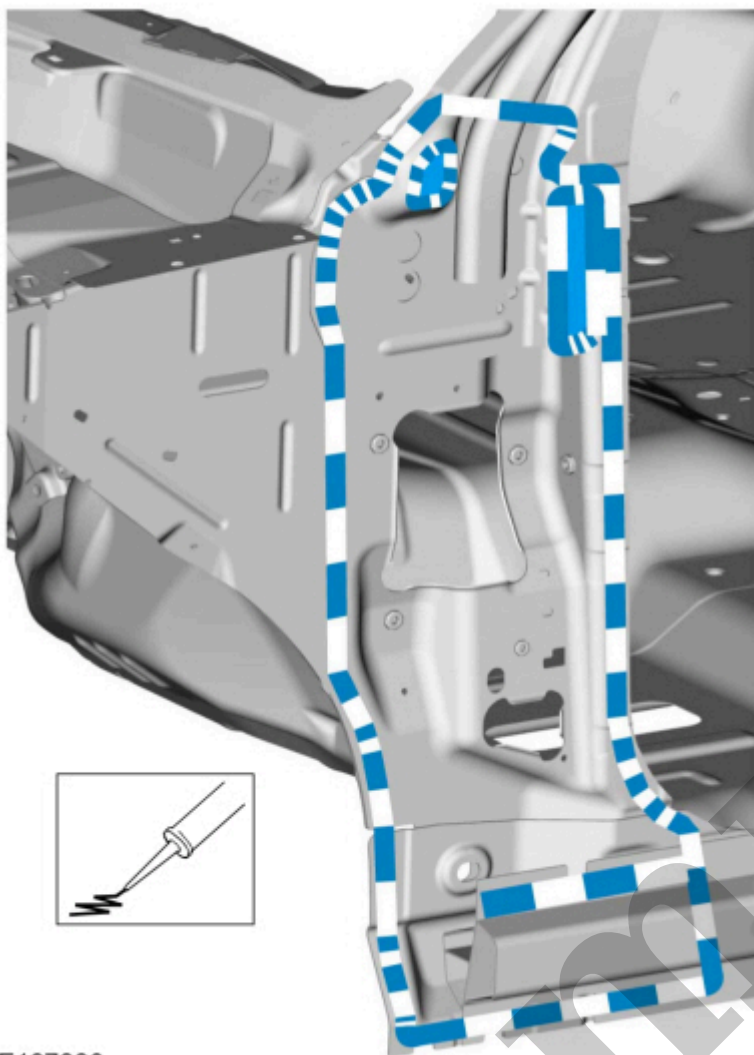


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8. 80-120 grit sand paper.

Sand to remove e-coat and clean.



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10. Install the A-pillar reinforcement and clamp in position.

Use the General Equipment: Locking Pliers

12. **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	W717182-S900	QC	DP10-200/H	SA-0400/SA-0402	W708777-S900C	-	-
2	-	-	-	-	W708777-S900C	-	-
3	W717186-S900	EL	DP11-200/H	SA-0400/SA-0402	W708777-S900C	-	-
4	-	-	-	-	W702512-S900C	-	-

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