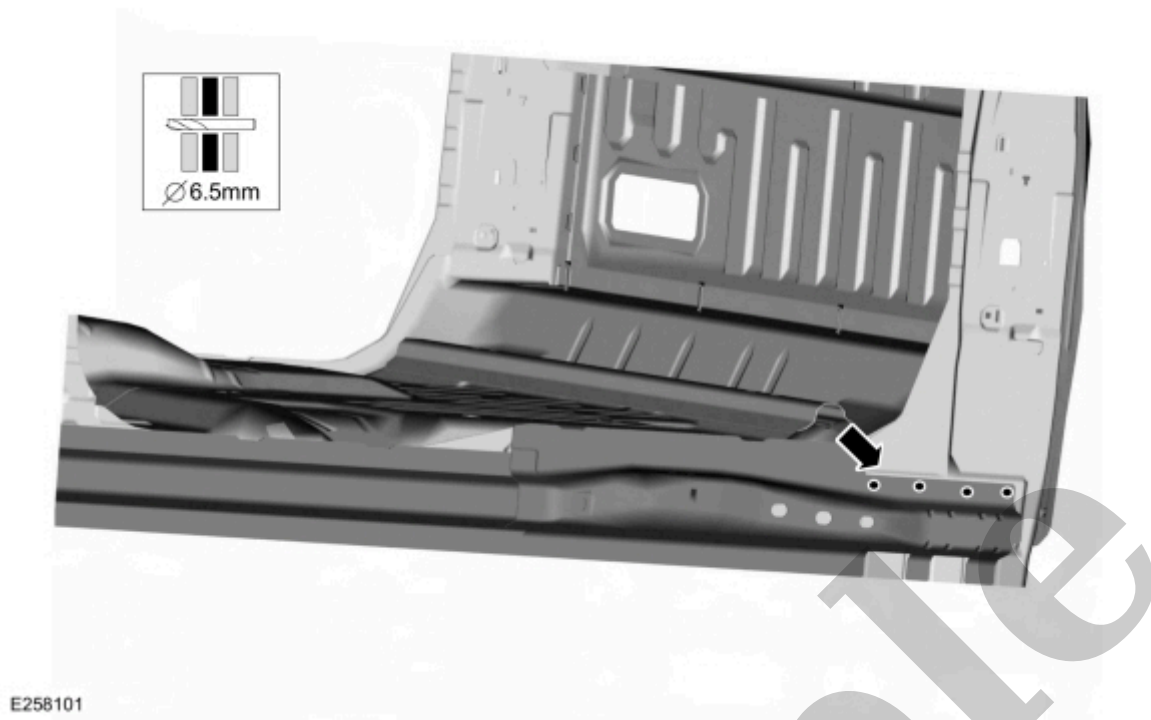


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## 2003 FORD Fiesta 3 Doors OEM Service and Repair Workshop Manual

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#### 9. NOTE

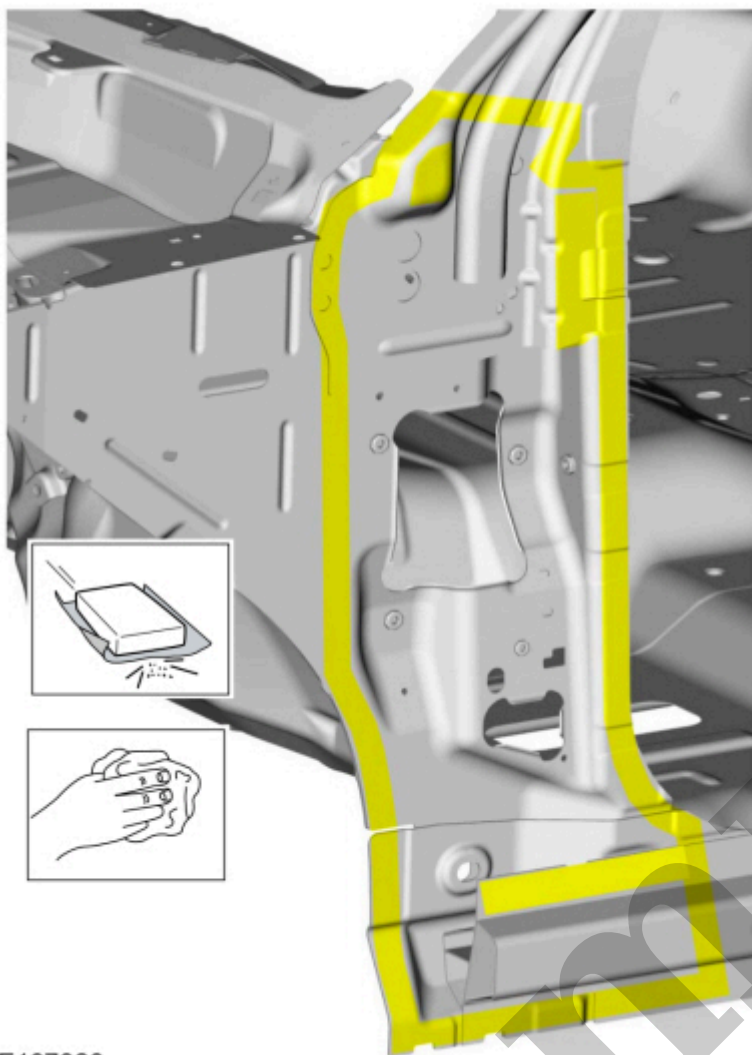
SPR (self-piercing rivet) fasteners may not be placed directly over original SPR (self-piercing rivet) location. They must be placed adjacent to original location matching original quantity.

#### 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 the rear reinforcement 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	-	-

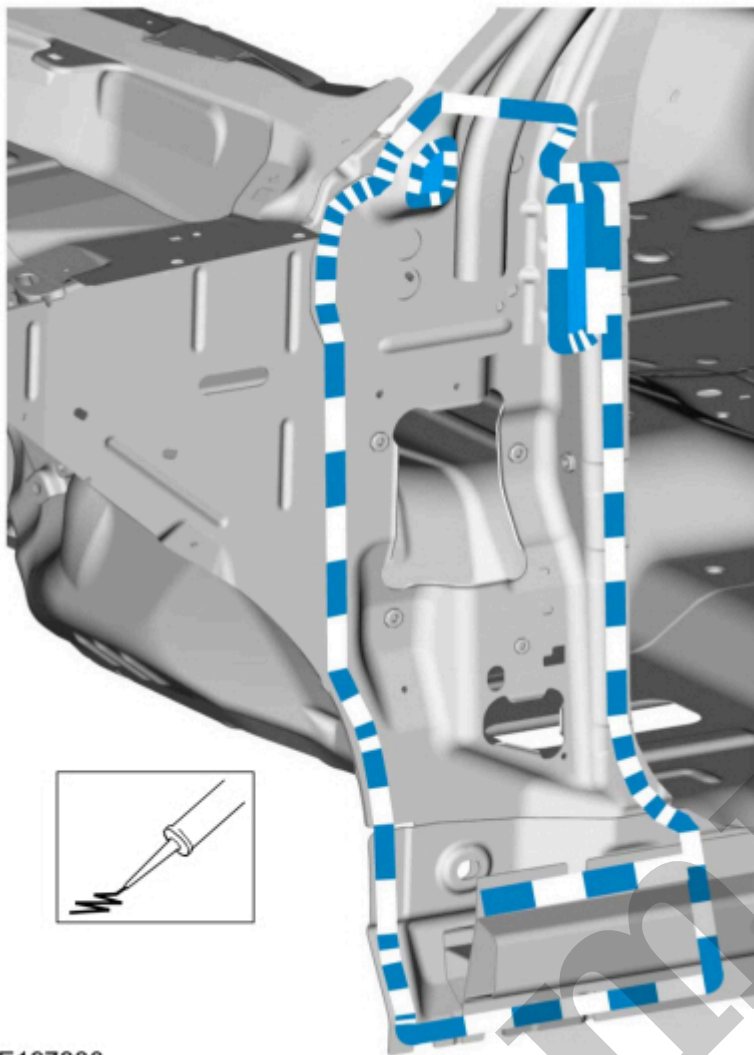


E197828

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11. 80-120 grit sand paper.

Sand to remove e-coat and clean.

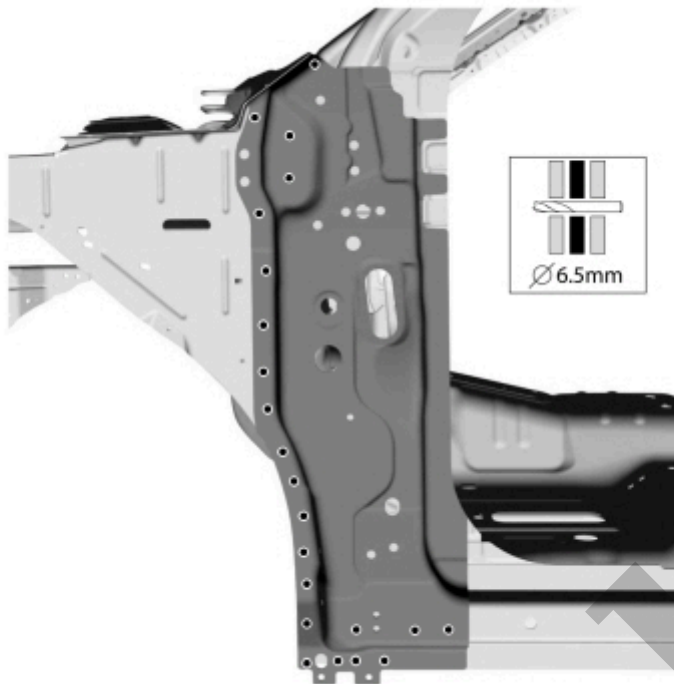


E197830

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

Use the General Equipment: Locking Pliers



E332301

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#### 15. 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.

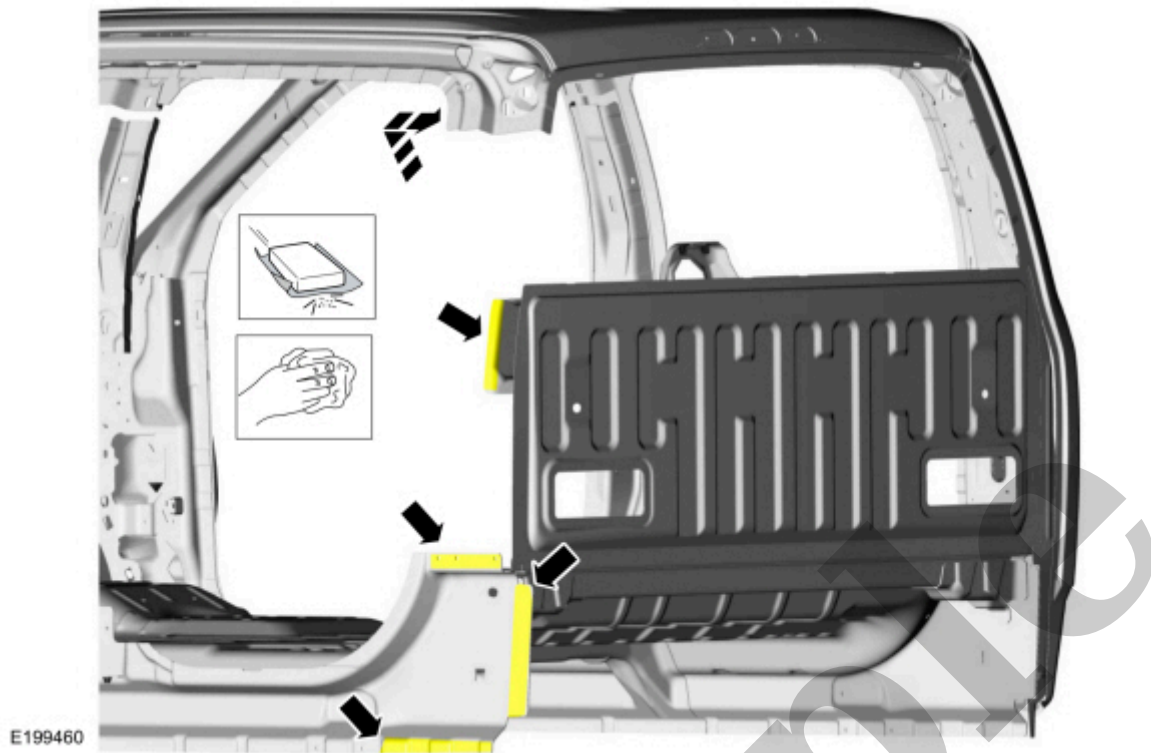
#### NOTE

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® 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-	W708777-S900C	-	-

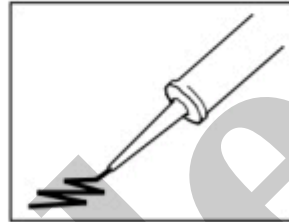
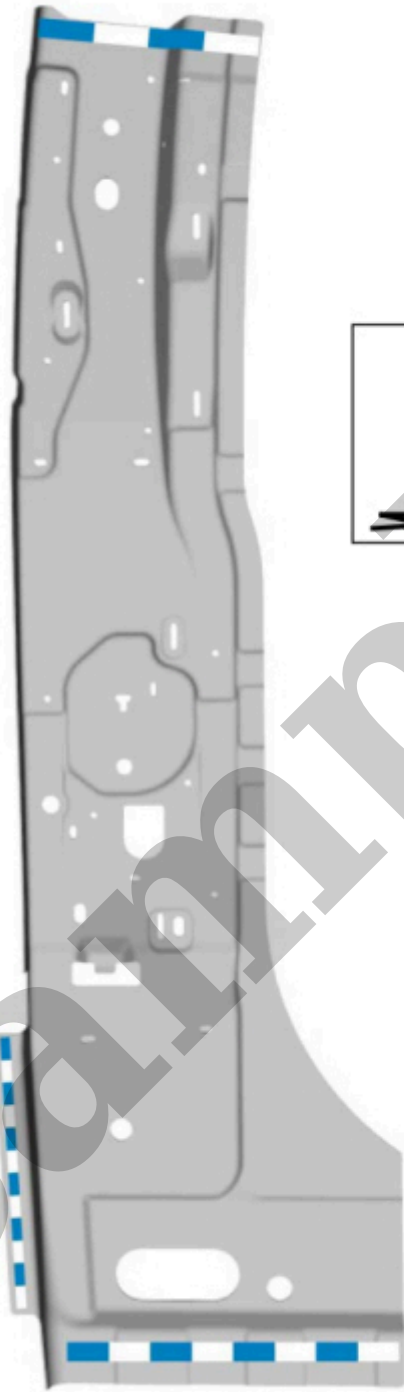
Sand to remove old adhesive and clean.



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18. 80-120 grit sand paper.

Sand to remove e-coat and clean.

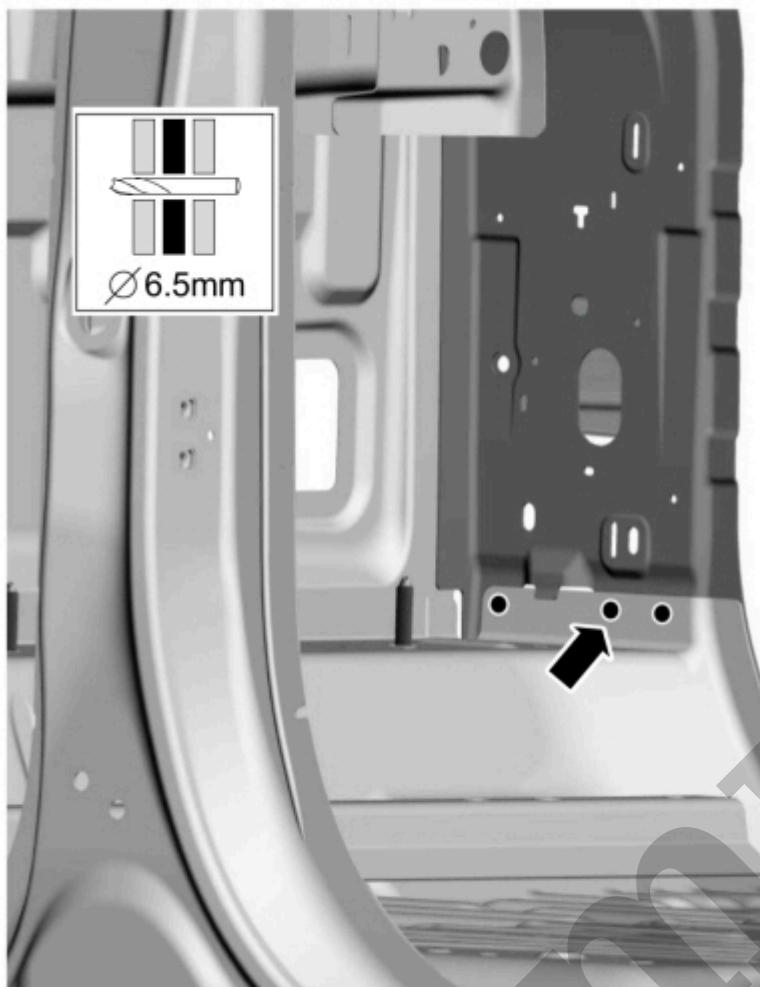


E331873

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

Use the General Equipment: Locking Pliers



E199464

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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.

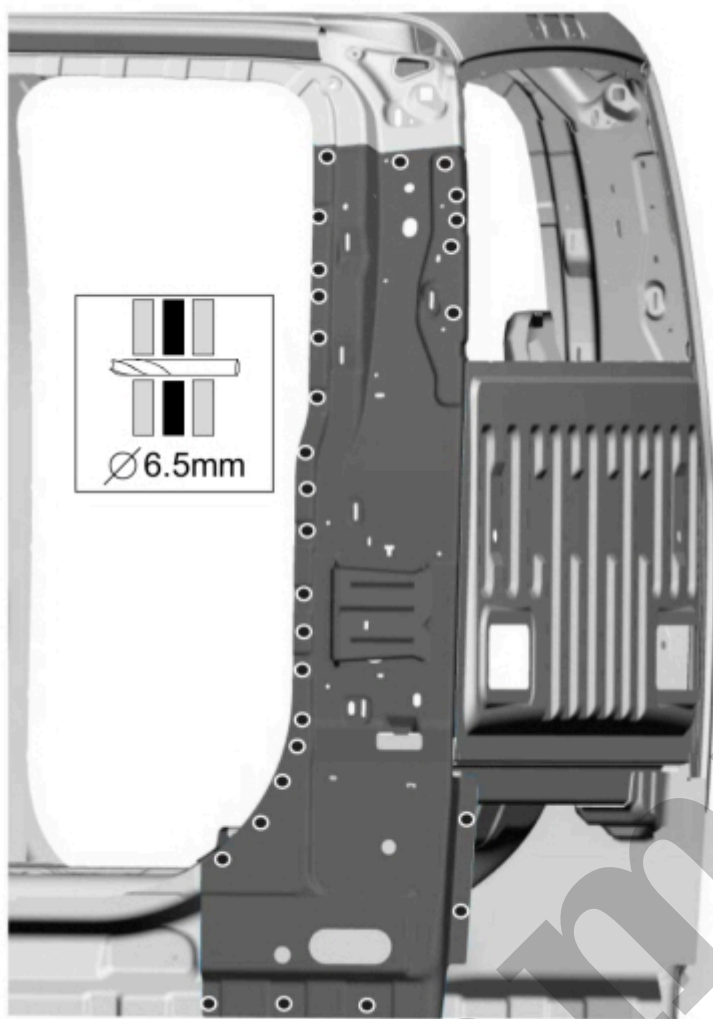
**NOTE**

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.



Use the General Equipment: 6.5 mm Drill Bit



E199466

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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.

**NOTE**

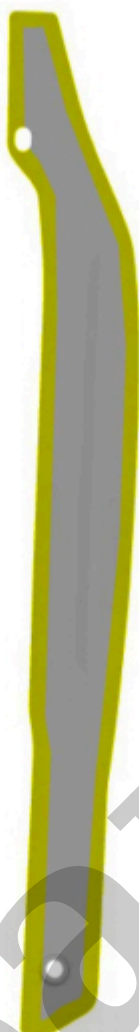
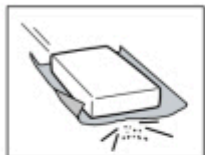
Blind rivet or solid rivet fasteners may be used in place of SPR (self-piercing rivet) fasteners after enlarging holes to 6.5 mm.

Install fasteners.

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25. 80-120 grit sand paper.

Sand the cab back filler panel to remove e-coat and clean.



E199474

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26. Apply adhesive.

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