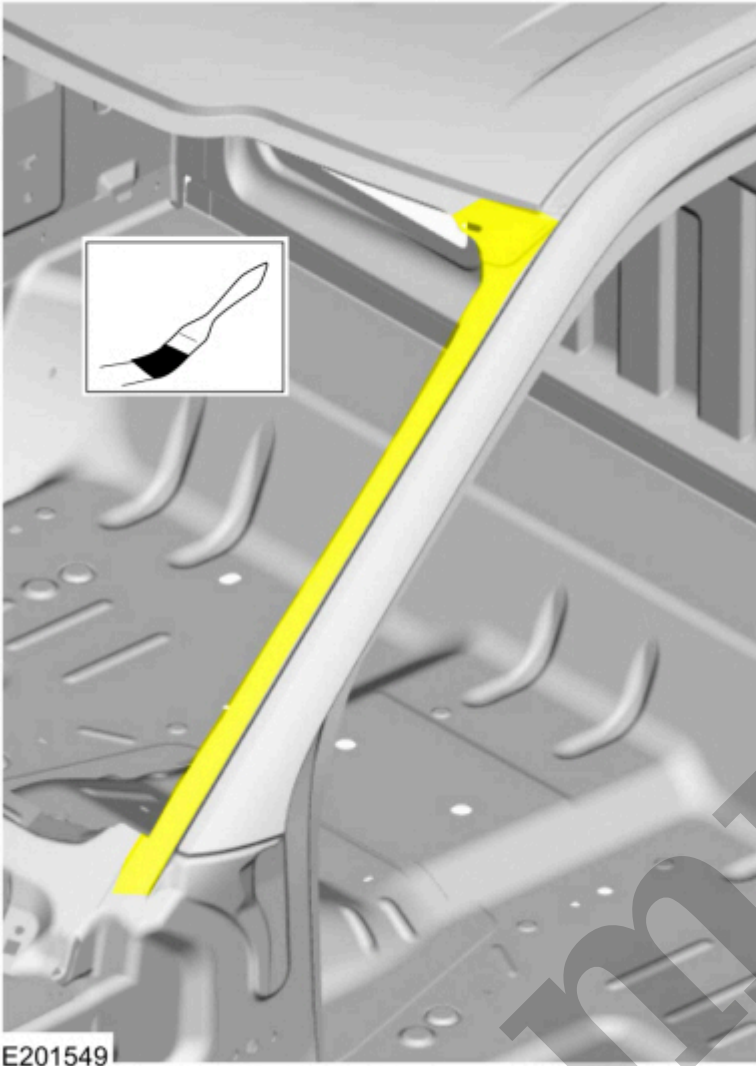


Your Ultimate Source for OEM Repair Manuals

FactoryManuals.net is a great resource for anyone who wants to save money on repairs by doing their own work. The manuals provide detailed instructions and diagrams that make it easy to understand how to fix a vehicle.

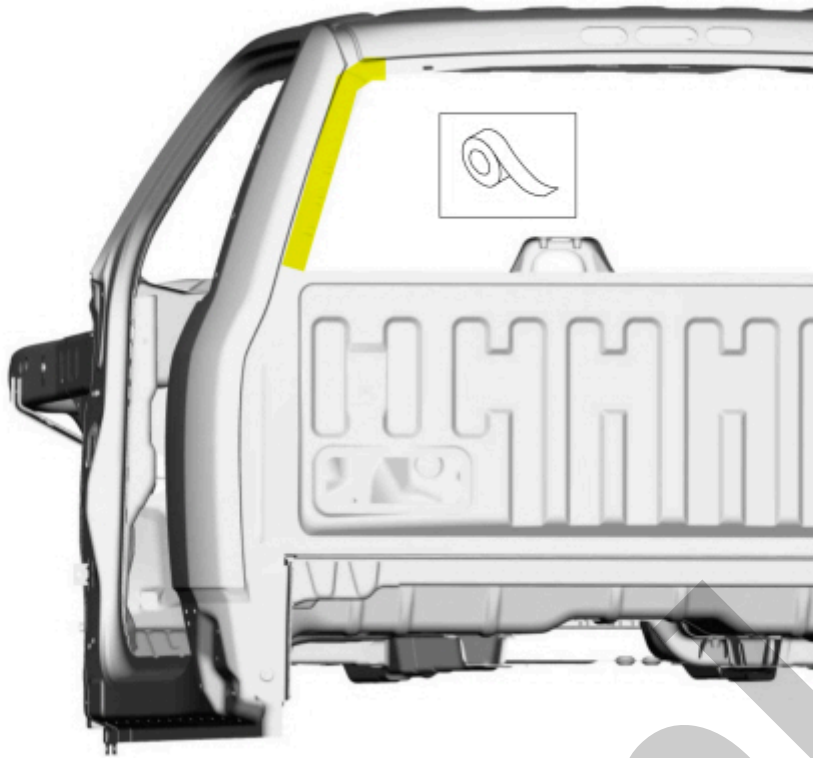
2004 FORD Fiesta 3 Doors OEM Service and Repair Workshop Manual

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38. Mask the windshield glass opening channel.

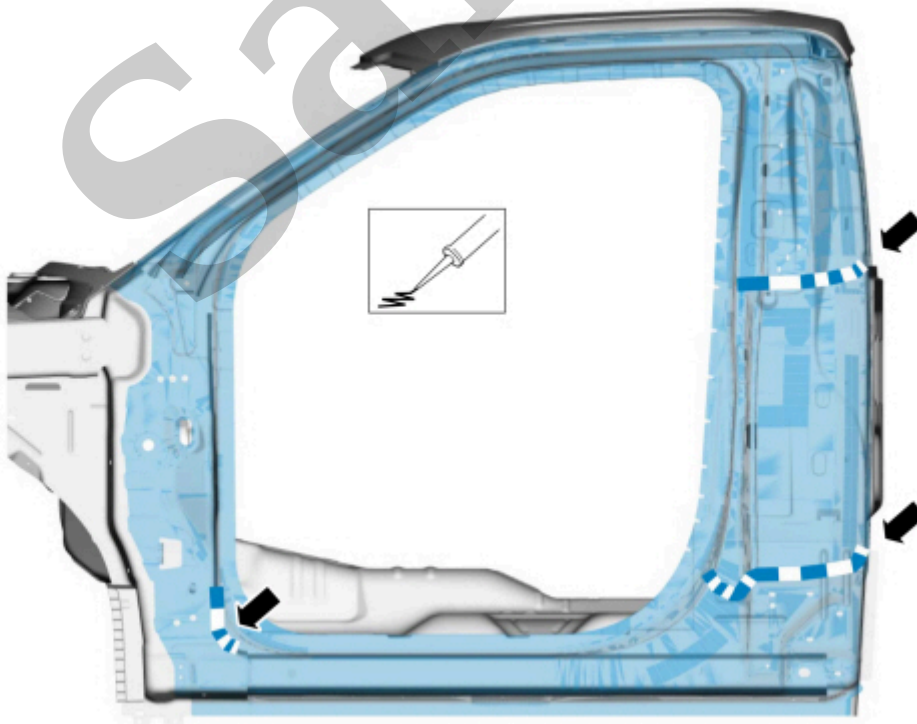


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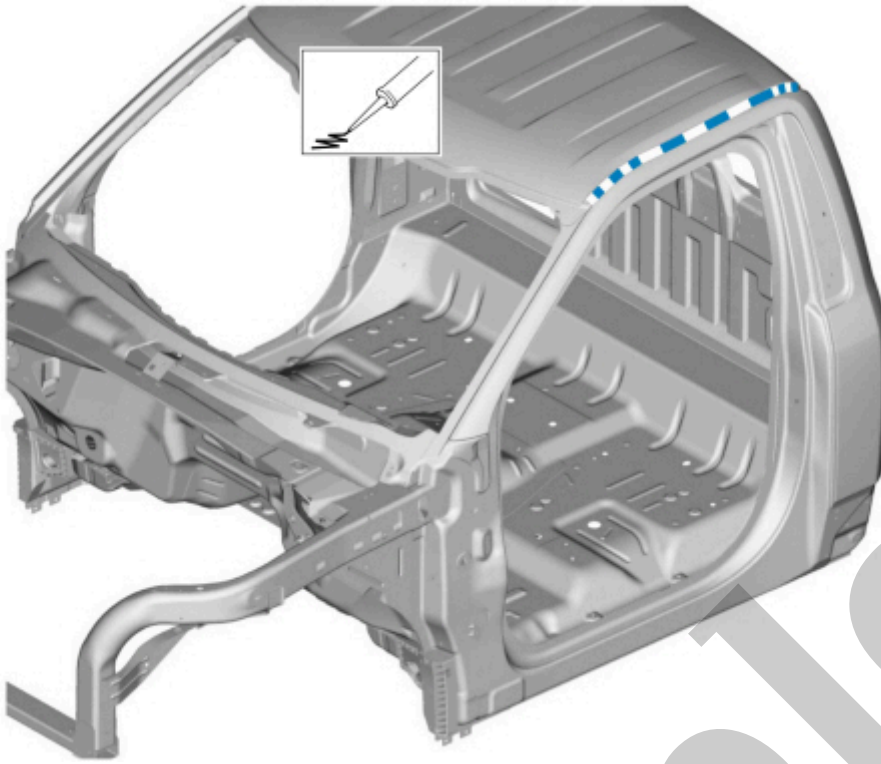
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40. Apply NVH (noise, vibration and harshness) foam to all locations noted during removal to assure complete sealing.

Material : Flexible Foam Repair / 3M™ 08463, LORD Fusor® 121



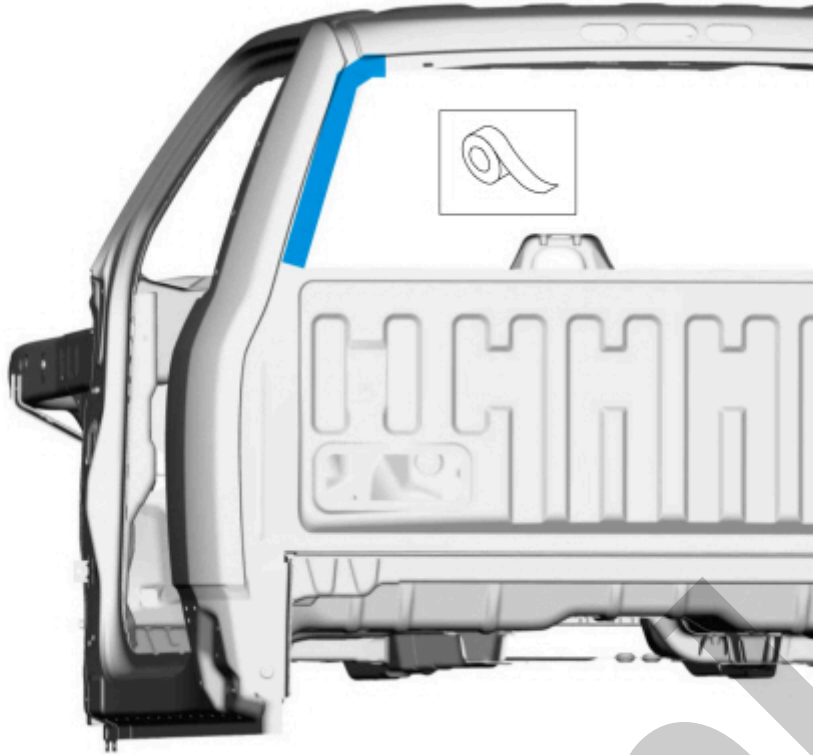
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43. Refinish the entire repair using a Ford approved paint system and typical refinishing techniques.
44. Unmask the windshield glass opening channel.



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46. Install the side curtain air bag.

Refer to: [Side Curtain Airbag - Regular Cab](#)(501-20B Supplemental Restraint System, Removal and Installation).

47. Install the door opening weather strips and scuff plate.

48. Install the windshield and rear window glass.

Refer to: [Fixed Glass](#)(501-11 Glass, Frames and Mechanisms, General Procedures).

49. Install the door hinges and striker.

- Door hinges.

Torque : 21 lb.ft (28 Nm)

- Striker.

Torque : 18 lb.ft (25 Nm)

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

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Sample

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 reinforcement on the SuperCab is a two-piece component consisting of a front and rear section. **The front portion is an extrusion casting and may not be sectioned.** The rear portion only may be sectioned using a backer plate, adhesive and blind rivets. The following procedure assumes full component replacement.

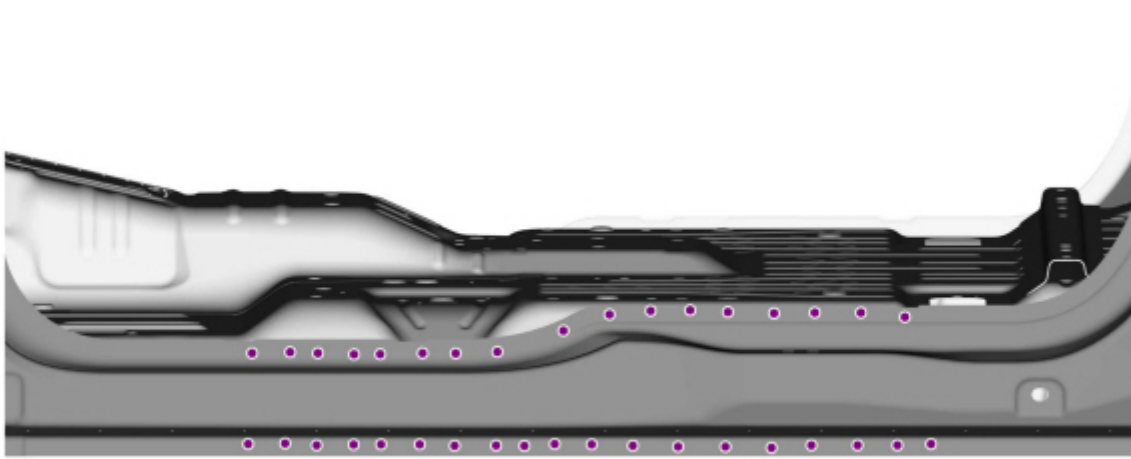
NOTE

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

NOTE

The following procedure assumes full component replacement.

2. Remove the rear door striker.



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6. Break the adhesive bond and remove the rocker outer sheet metal.

Use the General Equipment: Hot Air Gun



E200898

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7. Remove the rocker panel reinforcement SPR (self-piercing rivet) fasteners.

Installation

NOTICE

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

NOTE

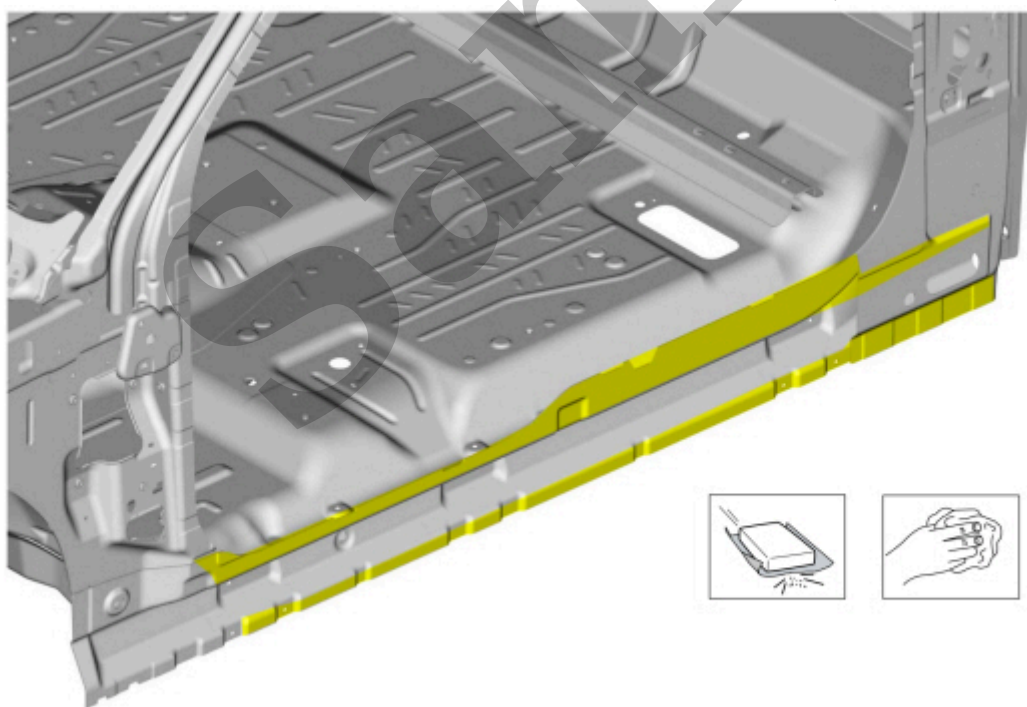
SPR (self-piercing rivet) fasteners may not be placed directly over original SPR (self-piercing rivet) location. They must be placed adjacent to original location matching original quantity.

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.

1. 80-120 grit sand paper.

Sand to remove old adhesive and e-coat and clean.

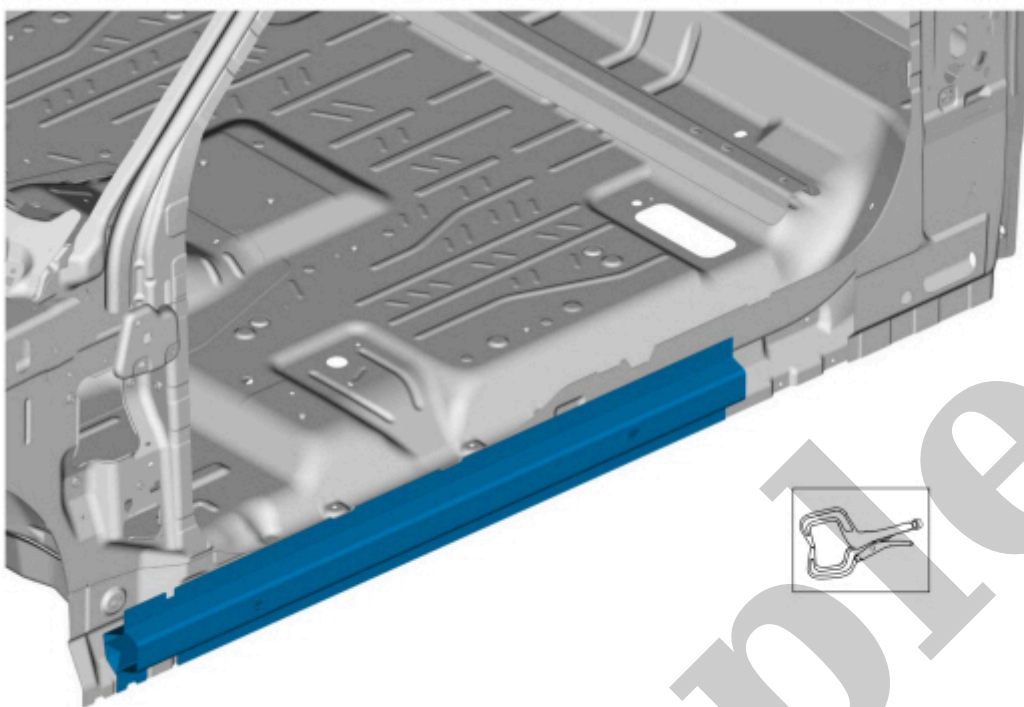


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4. Install the forward rocker panel inner reinforcement and clamp in position.

Use the General Equipment: Locking Pliers

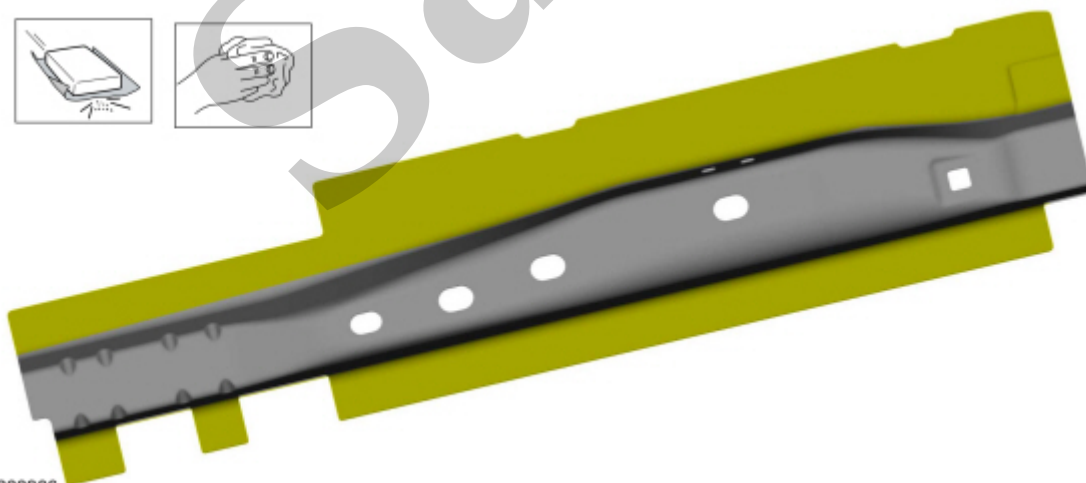
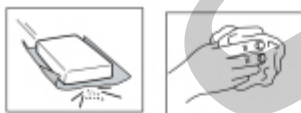


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5. 80-120 grit sand paper.

Sand the rear rocker panel reinforcement using 80 grit sand paper to remove e-coat and clean.



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6. Apply adhesive.