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2005 FORD Fiesta 3 Doors OEM Service and Repair Workshop Manual

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E198312

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5. Install and clamp the front rocker panel inner reinforcement.

Use the General Equipment: Locking Pliers

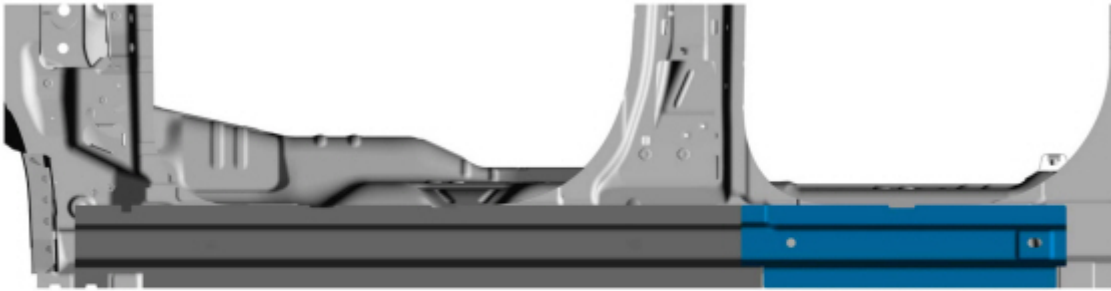


E198313

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6. 80-120 grit sand paper.

Sand to remove e-coat from the rear rocker panel reinforcement.

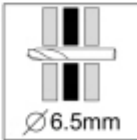
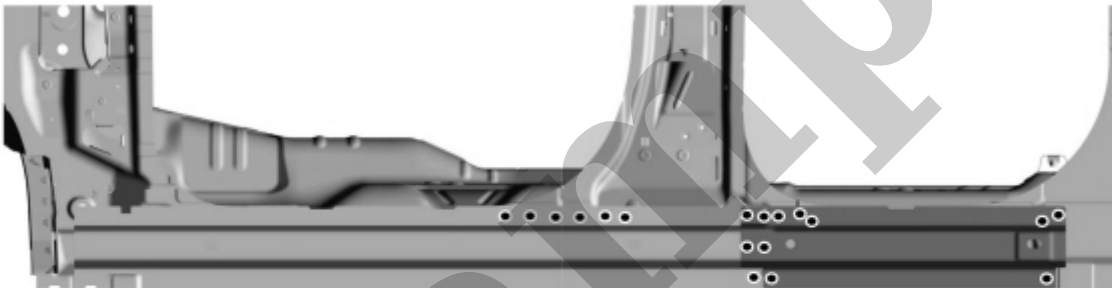


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9. Drill for blind rivet installation.

Use the General Equipment: 6.5 mm Drill Bit

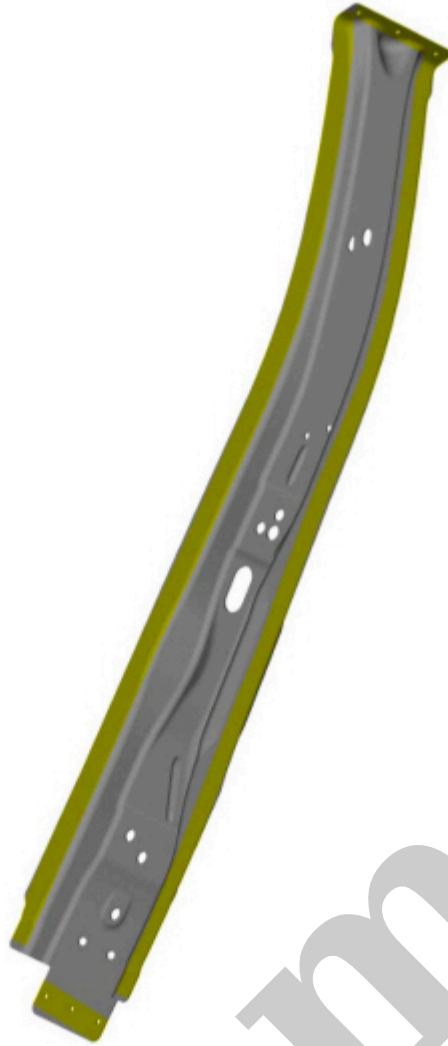
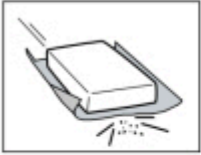


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10. Install blind rivet fasteners.

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®



E198322

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12. Apply adhesive to the B-pillar mating surfaces.

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

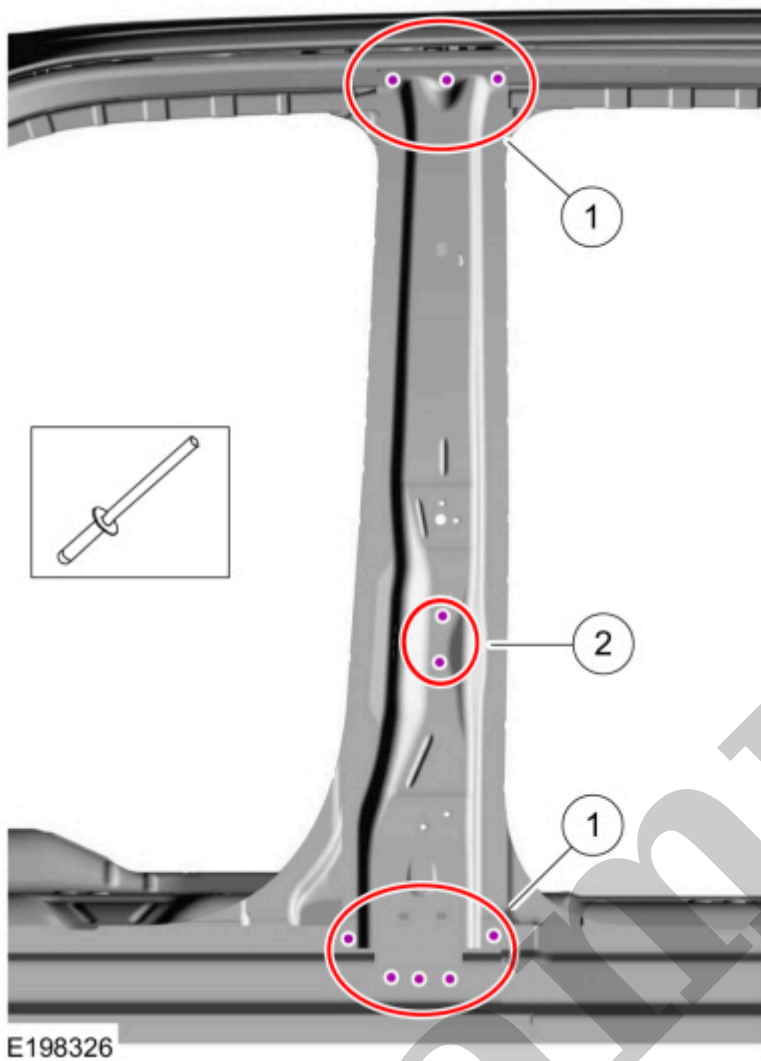


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14. Drill for blind rivet installation.

Use the General Equipment: 6.5 mm Drill Bit

Use the General Equipment: Blind Rivet Gun



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16. Cut the replacement service panel to fit repair.

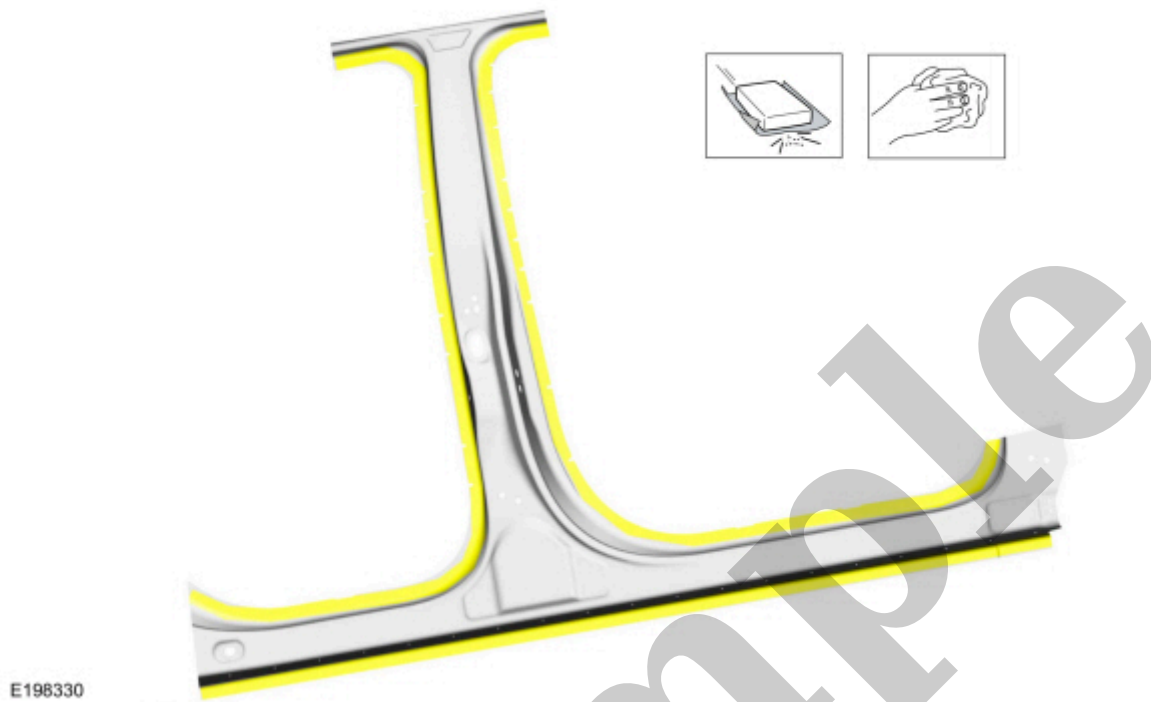
Use the General Equipment: Air Body Saw

Use the General Equipment: Spherical Cutter

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18. 80-120 grit sand paper.

Sand to remove e-coat in the replacement body side mating panel surfaces and clean.



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19. **NOTE**

The use of a backer plate when creating butt weld joints will produce a stronger and more uniform repair.

In butt-weld areas:

Create a backer plate from an unused portion of the old body panel or service replacement panel and install on the vehicle at each sectioning joint.

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

20. Apply adhesive.

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

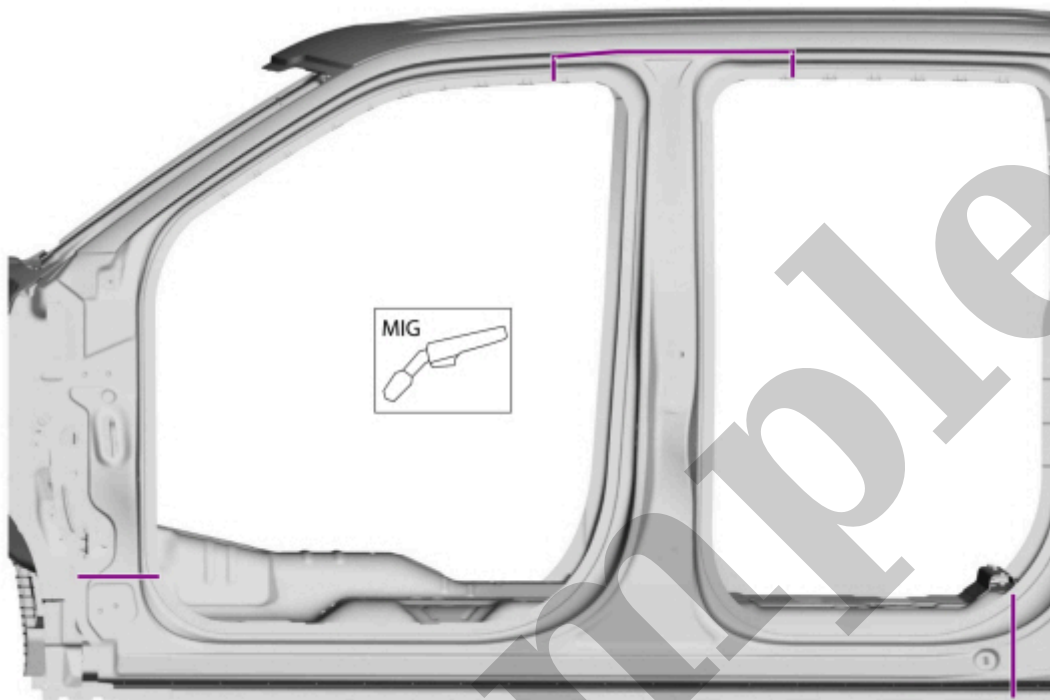
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22. Complete the backer plate attachment at all sectioning joints.

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

23. Seam weld all sectioning joints using a MIG (metal inert gas) welder set up for aluminum repairs.

Use the General Equipment: MIG/MAG Welding Equipment

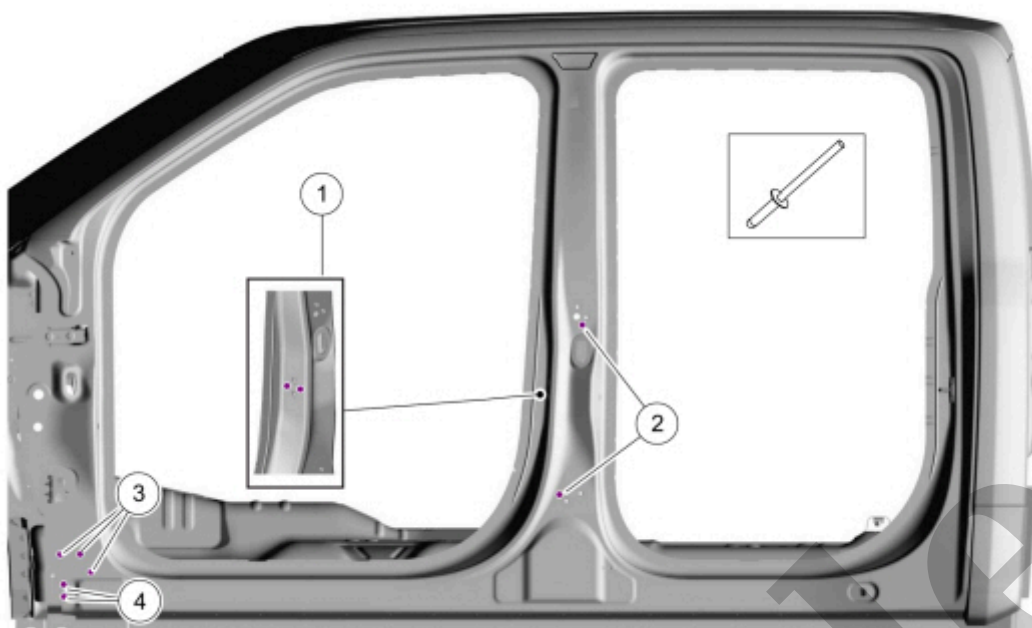


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24. Drill for fastener installation.

Use the General Equipment: 6.5 mm Drill Bit



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26. NOTE

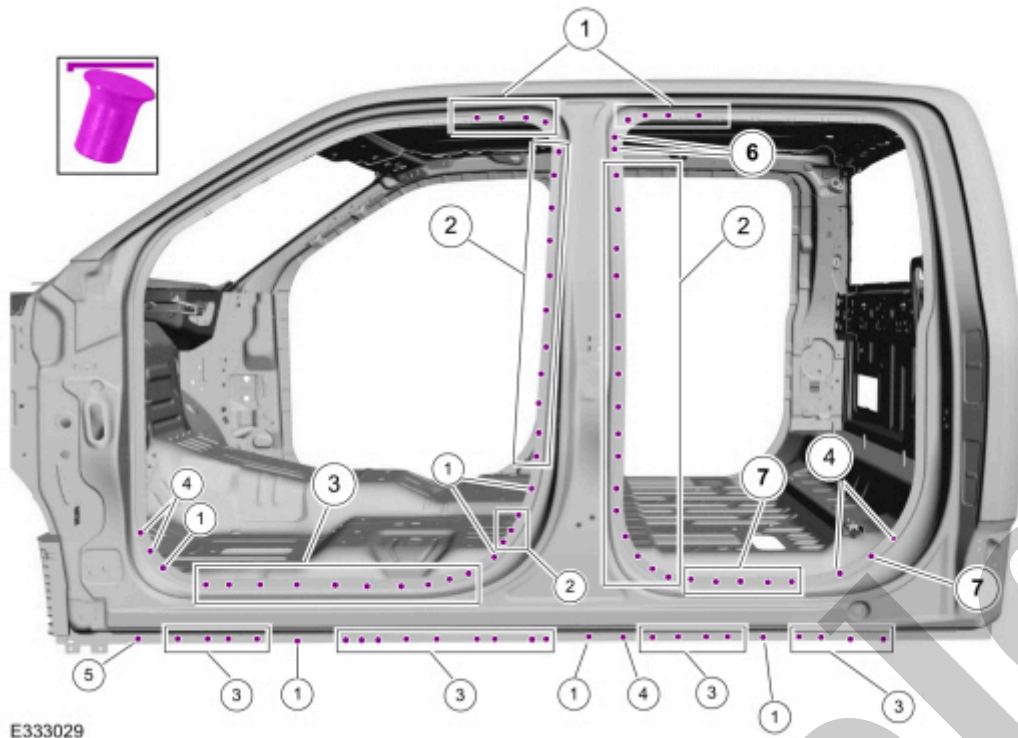
SPR (self-piercing rivet) fasteners may be replaced with solid rivets or blind rivet fasteners after enlarging hole to 6.5 mm.

NOTE

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

Install body side 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	W708713-S900	AS	DZ09-025/H	SA-0400/SA-	-	W790376-S900	-



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

27. Metal finish the repair using typical aluminum metal finishing techniques and a fiber-based body filler.

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

28. Refinish the repair area using a Ford approved paint system and typical refinishing techniques.

29. Install the front door lower door hinge, front door striker and the rear door hinges on the body.

- Front door lower hinge.

Torque : 20 lb.ft (27 Nm)

- Front door striker.

Torque : 18 lb.ft (25 Nm)

- Rear door hinges.

Torque : 22 lb.ft (30 Nm)