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2008 FORD Fiesta 3 Doors OEM Service and Repair Workshop Manual

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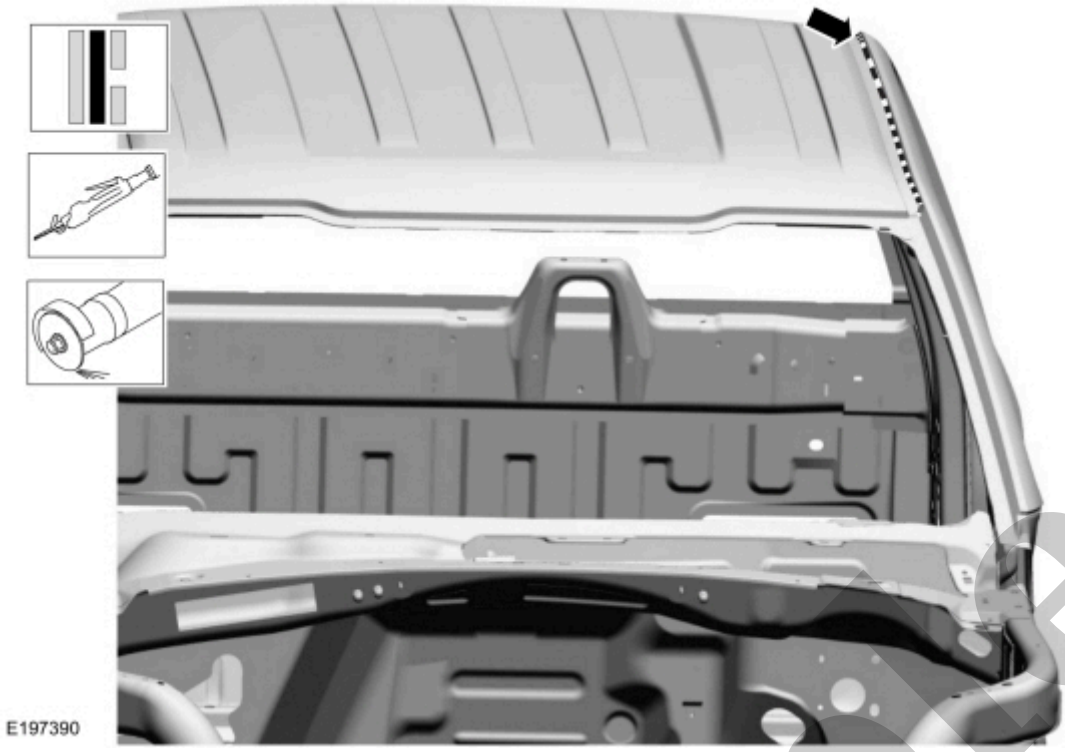

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20. **NOTE**

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.

Remove the body side panel.

Use the General Equipment: Hot Air Gun

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

Partial panel replacement:

- Determine repair and trim service panel accordingly.
- In butt weld area(s) create a backer plate from unused portion(s) of service panel.

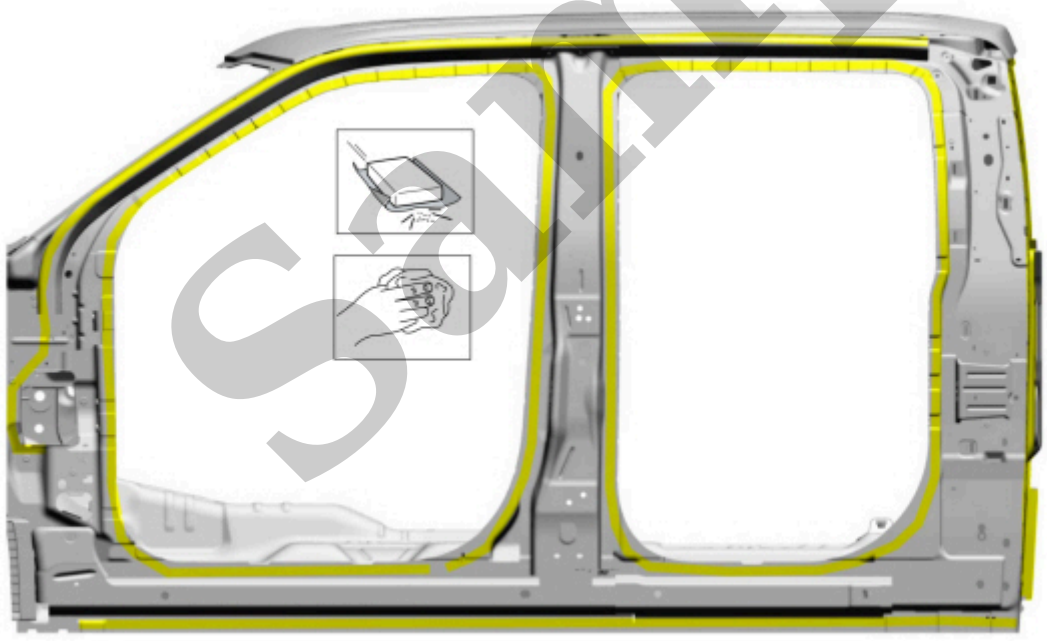
  Refer to: Joining Techniques(501-25 Body Repairs - General Information, General Procedures).
- Install backer plate to existing vehicle body panel.

2. **NOTE**

   Pay particular attention to areas where NVH (noise, vibration and harshness) foam was applied in assembly.

   80-120 grit sand paper.

   Sand to remove old adhesive from all mating surfaces and clean.



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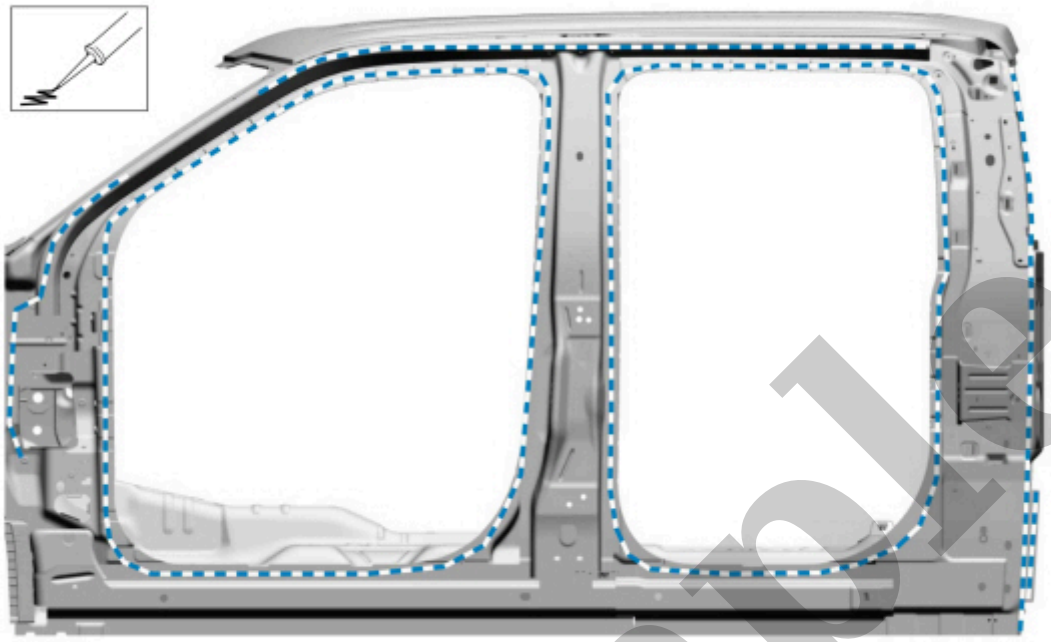
3. 80-120 grit sand paper.

   Sand to remove old adhesive from all mating surfaces and clean.

5. Apply structural adhesive as indicated.

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



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6. Apply urethane adhesive and flexible foam.

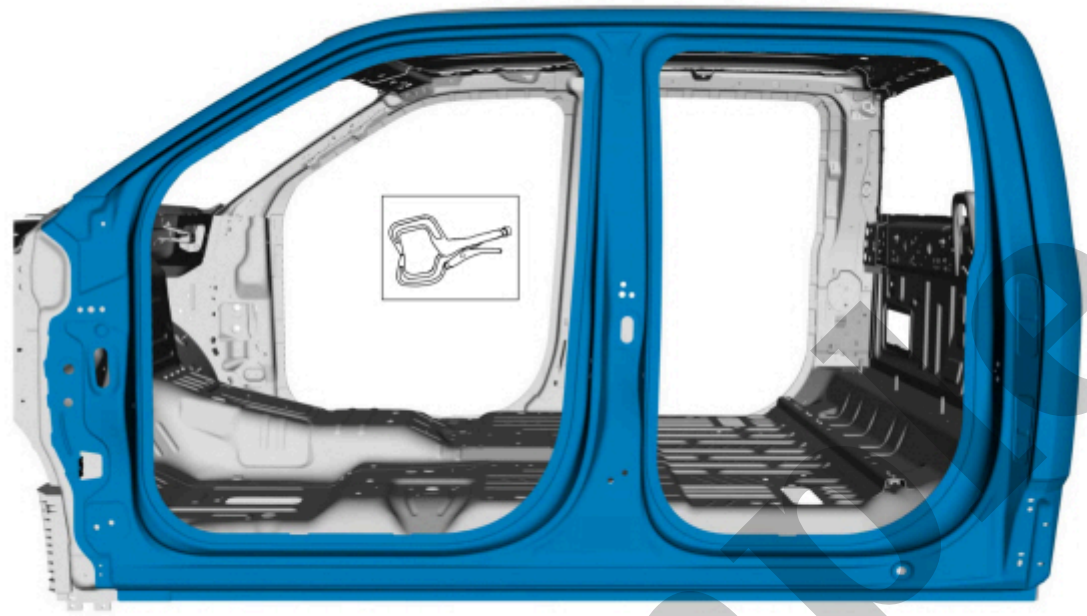
   Material : Flexible Foam Repair / 3M™ 08463, LORD Fusor® 121

   Material : Sika Tack ASAP Urethane Adhesive

Click here to learn about symbols, color coding, and icons used in this manual.

8. Install, align and clamp the service panel.

   Use the General Equipment: Locking Pliers



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9. **Partial panel replacement:**

   Complete joining of service panel to backer plate and weld the sectioning seam using a MIG (metal inert gas) welder set up for aluminum.

   Use the General Equipment: MIG/MAG Welding Equipment

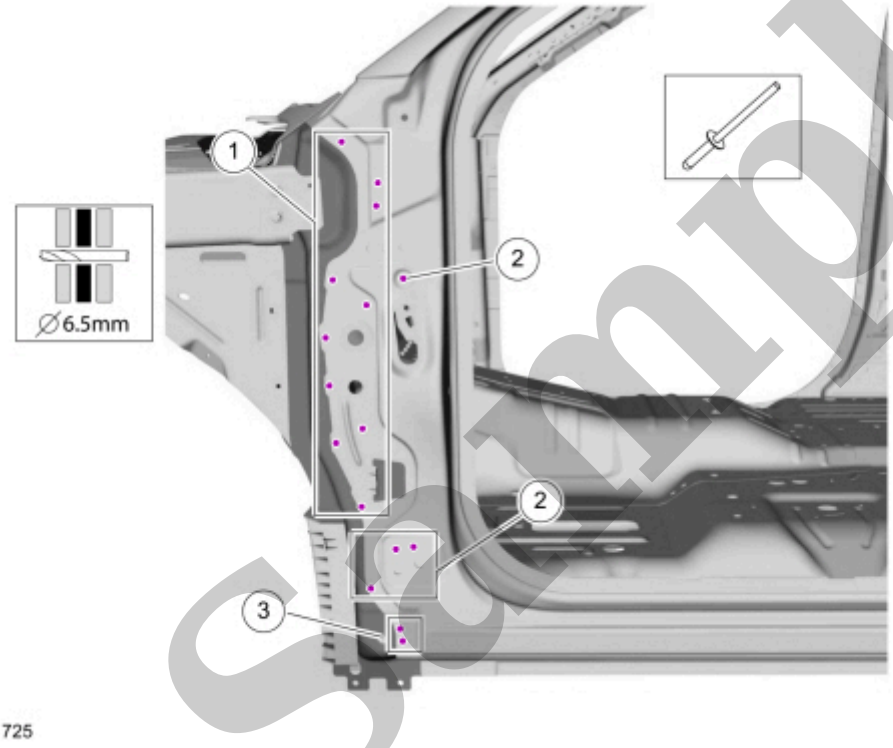
10. Drill 6.5 mm holes as indicated.

    Use the General Equipment: 6.5 mm Drill Bit

1	-	-	-	-	W707638-S900C	-	-
2	-	-	-	-	W708777-S900C	-	-
3	-	-	-	-	W702554-S900C	-	-

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

Use the General Equipment: Blind Rivet Gun



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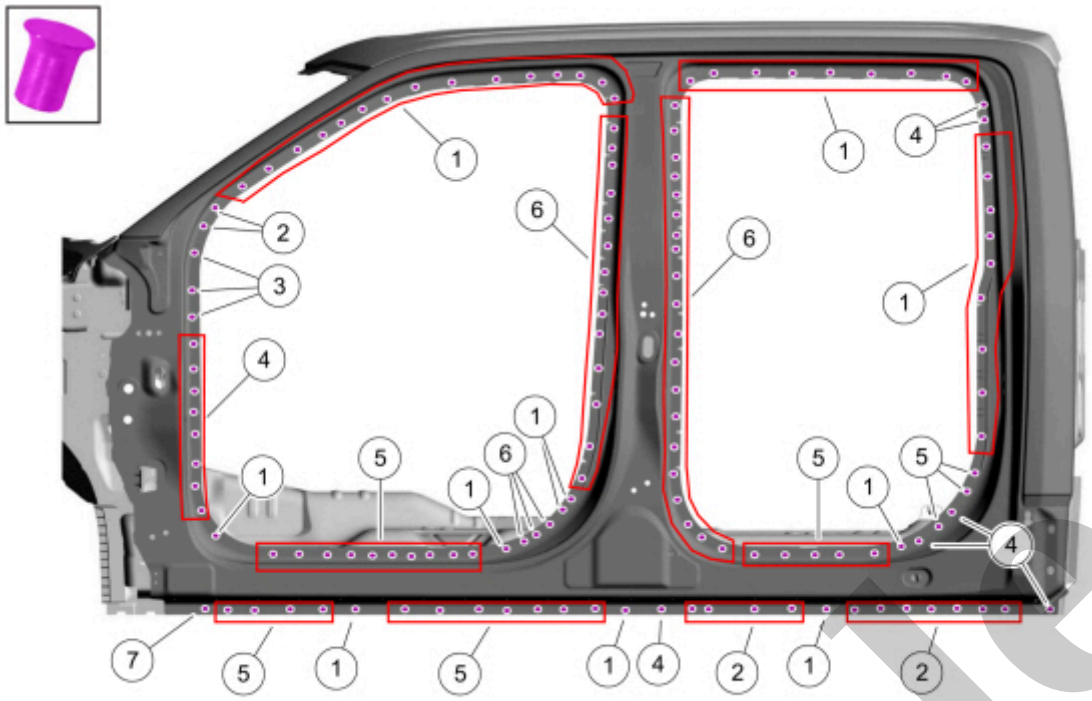
12. **NOTE**

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.

Install fasteners.



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13. 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	W717186-S900	EN	DP11-200/H	SA-0400/SA-0402	-	W790377-S900	-
2	W708713-S900	AS	DZ09-025/H	SA-0400/SA-0402	-	W790377-S900	-

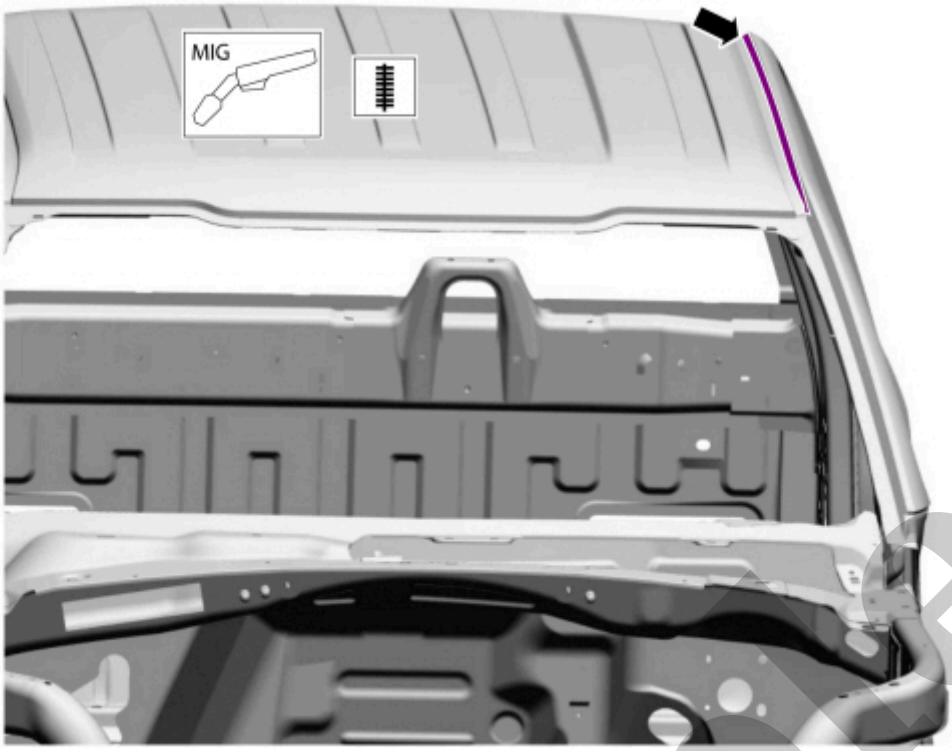
Use the General Equipment: Self-Piercing Rivet (SPR) Remover/Installer

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	-	-	-	-	W708777-S900C	-	-
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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16. Metal finishing:

    Metal finish all seams using typical aluminum metal finishing techniques.

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

17. Sand and prime the entire repair using a Ford approved paint system.

18. Apply NVH (noise, vibration and harshness) foam.

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

19. **Seam Sealing:**

    All seams must be sealed to production level.

    Material : Seam Sealer / TA-2-B, 3M™ 08308, LORD Fusor® 803DTM

20. Seal the roof joint.

    Material : Roof Ditch Sealer / 3M™ 08307, LORD Fusor® 129

27. Install the front and rear door scuff plates.

28. Install the front and rear door strikers.

    Torque : 18 lb.ft (25 Nm)

Click here to learn about symbols, color coding, and icons used in this manual.

29. Install the front and rear door hinges to the body.

    - Front door.

      Torque : 20 lb.ft (27 Nm)

    - Rear door.

      Torque : 22 lb.ft (30 Nm)