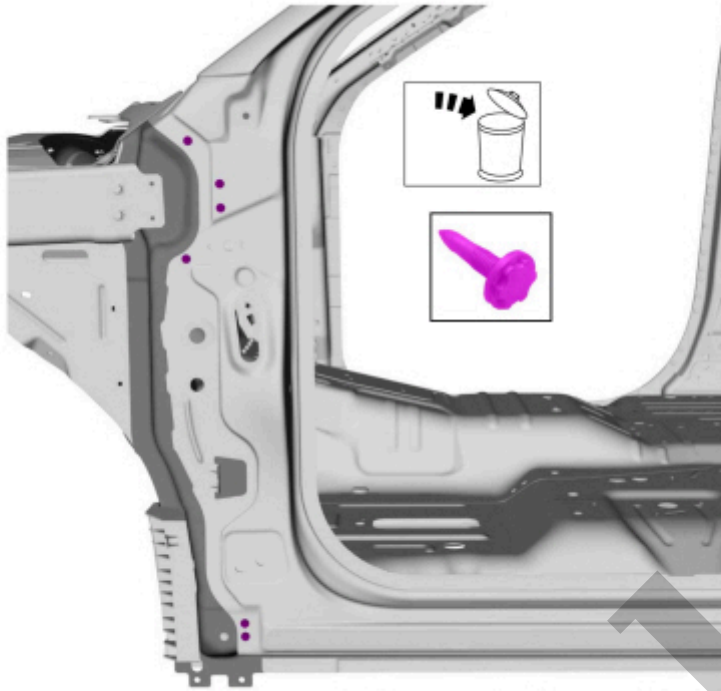


Your Ultimate Source for OEM Repair Manuals

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.

2010 FORD Fiesta 3 Doors OEM Service and Repair Workshop Manual

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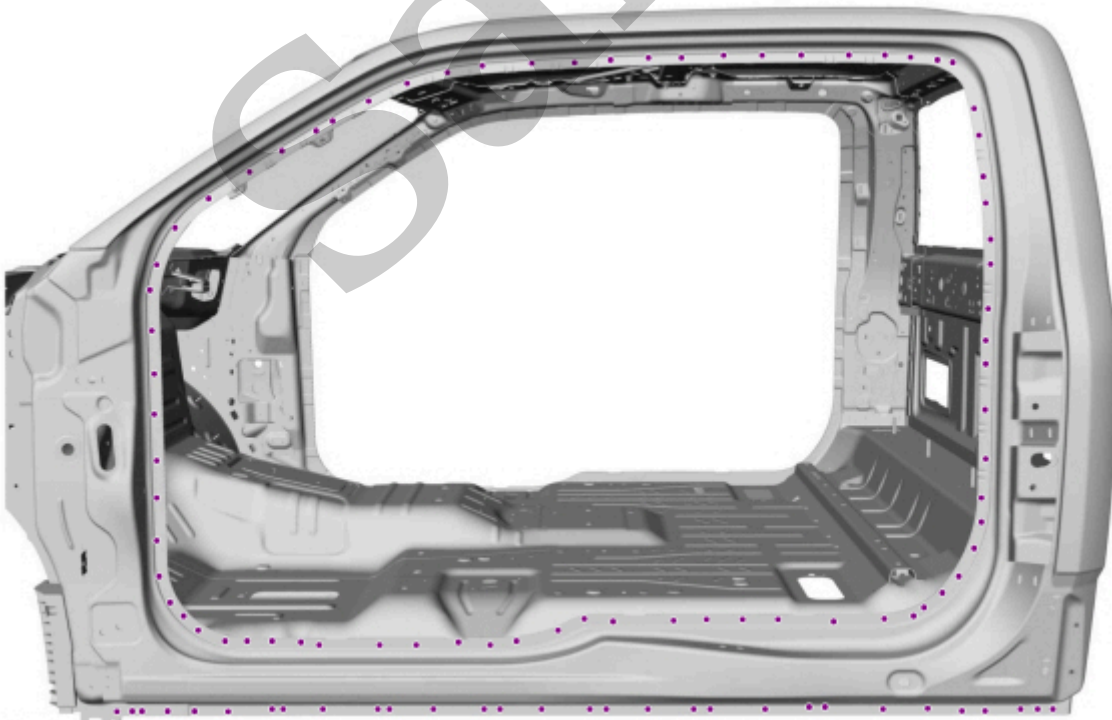
E331511

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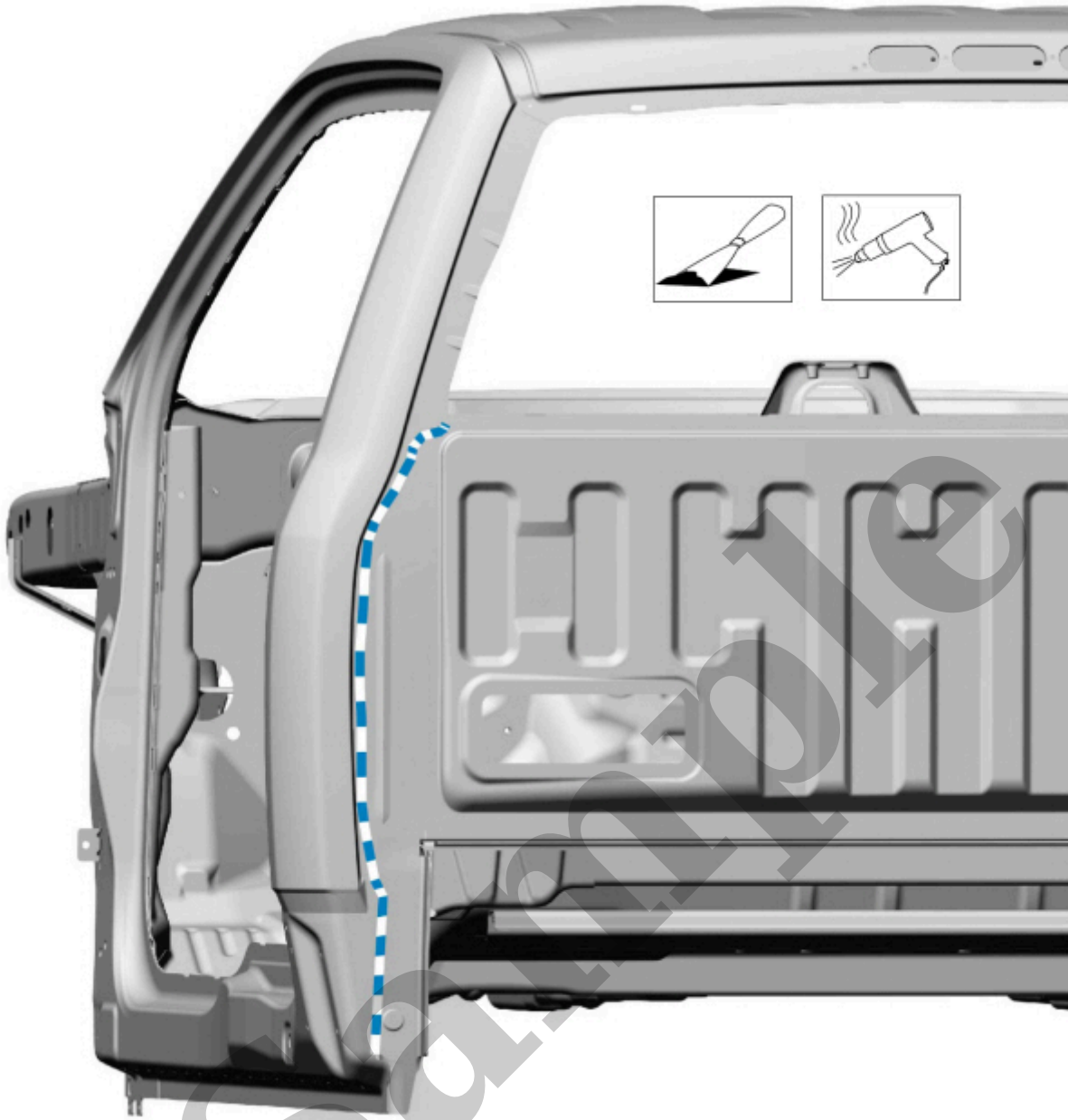
15. Remove the SPR (self-piercing rivet) fasteners in the repair area.

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

Use the General Equipment: Belt Sander



E332830



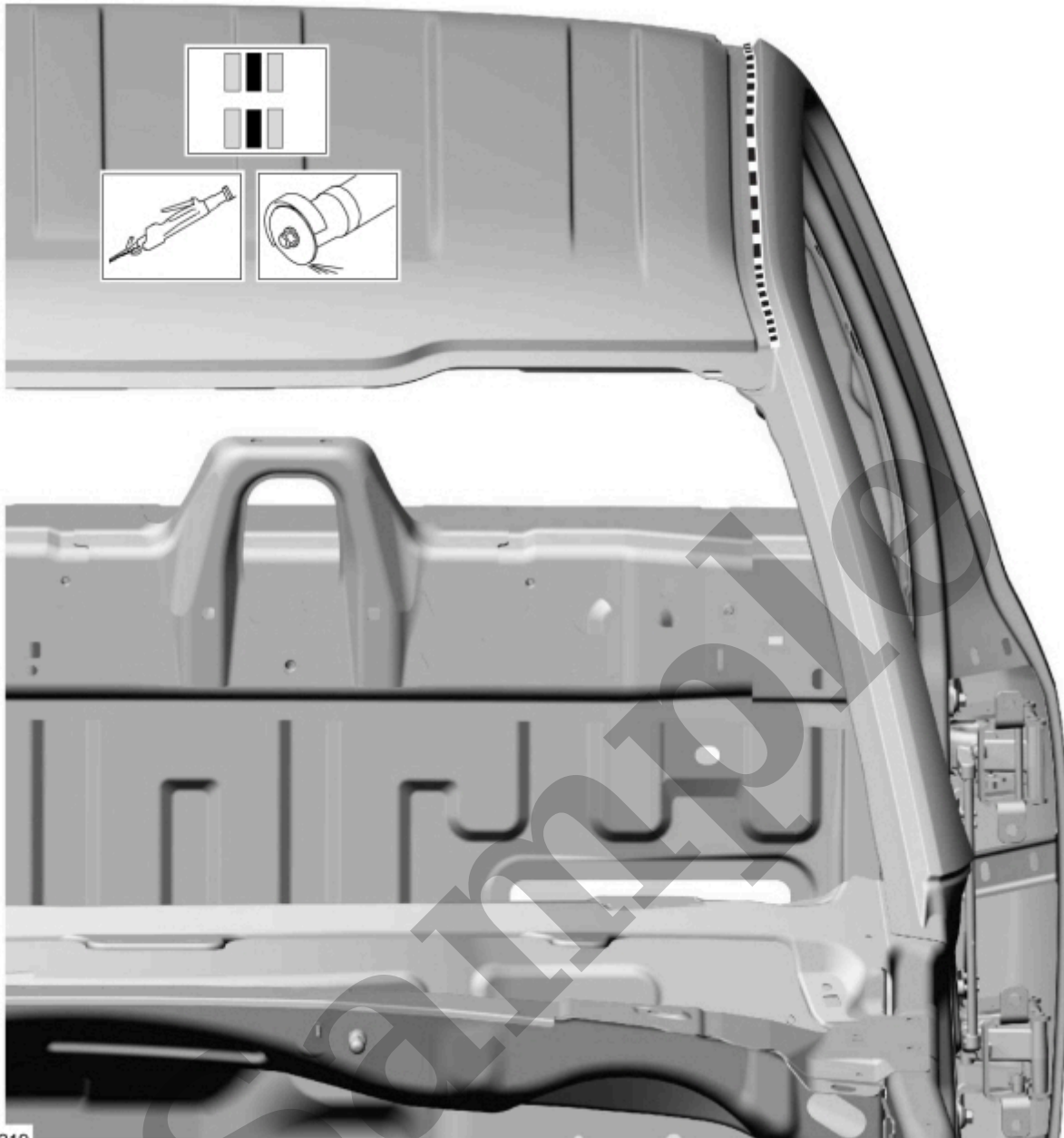
E201217

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18. Remove the cab back SPR (self-piercing rivet) fasteners.

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

Use the General Equipment: Belt Sander



E201219

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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.

NOTE

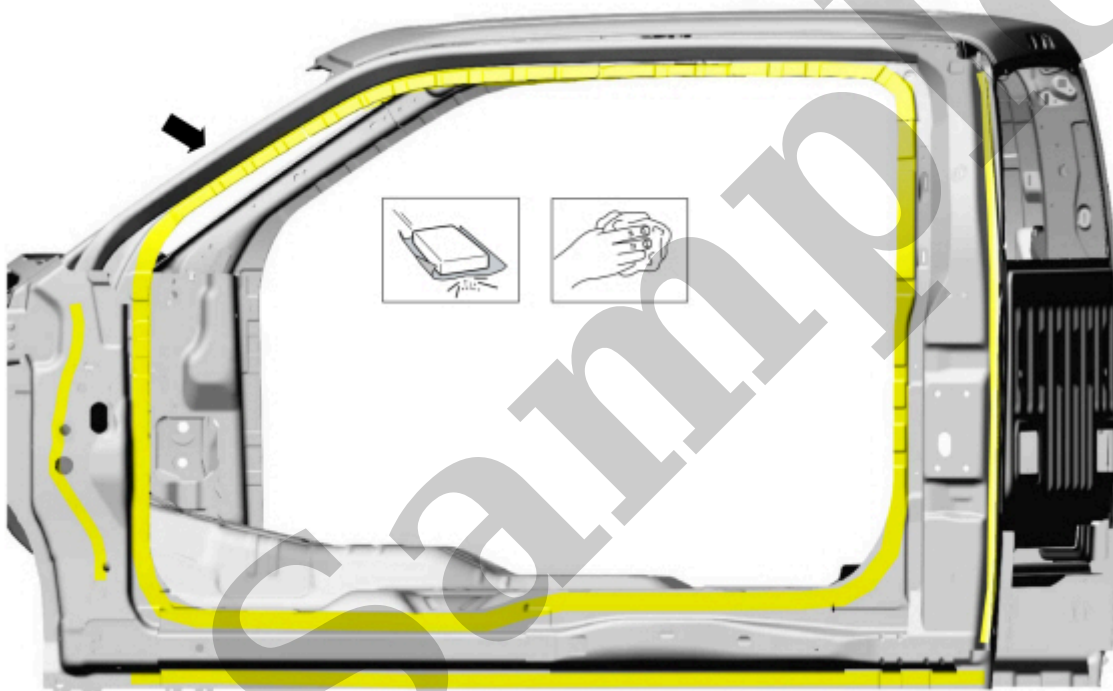
Blind or solid rivet fasteners may be used in place of SPR (self-piercing rivet) fasteners after enlarging holes to 6.5 mm.

NOTE

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

1. 80-120 grit sand paper.

Sand to remove old adhesive and clean.



E201221

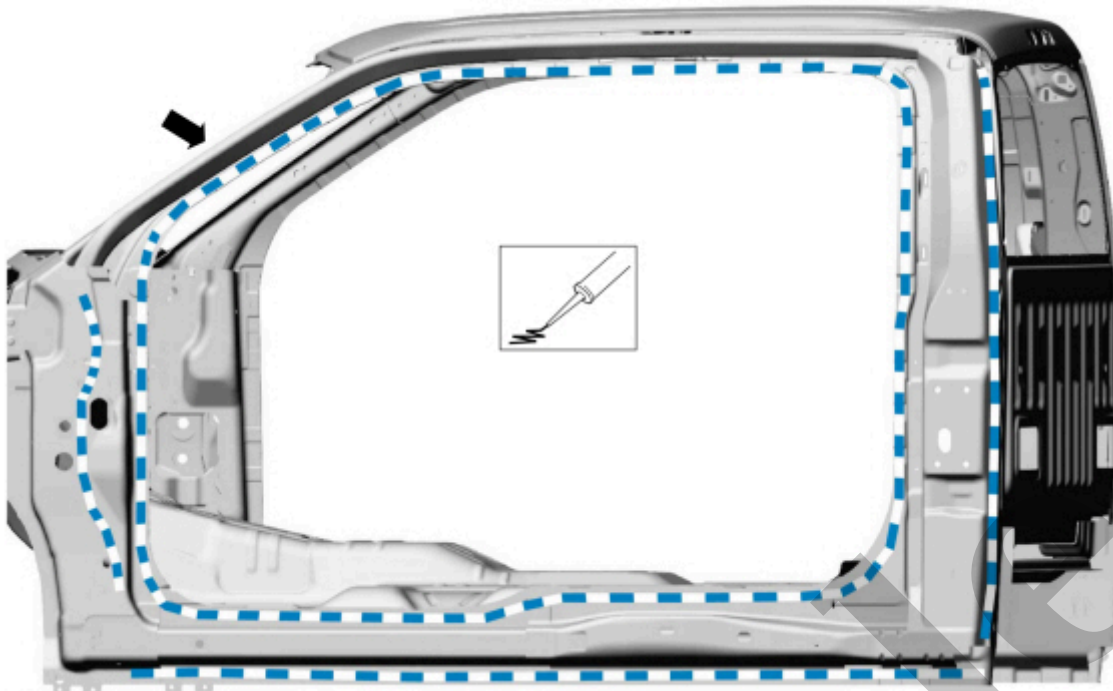
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2. NOTE

Trim service panel to fit repair area first.

80-120 grit sand paper.

Sand to remove e-coat and clean.



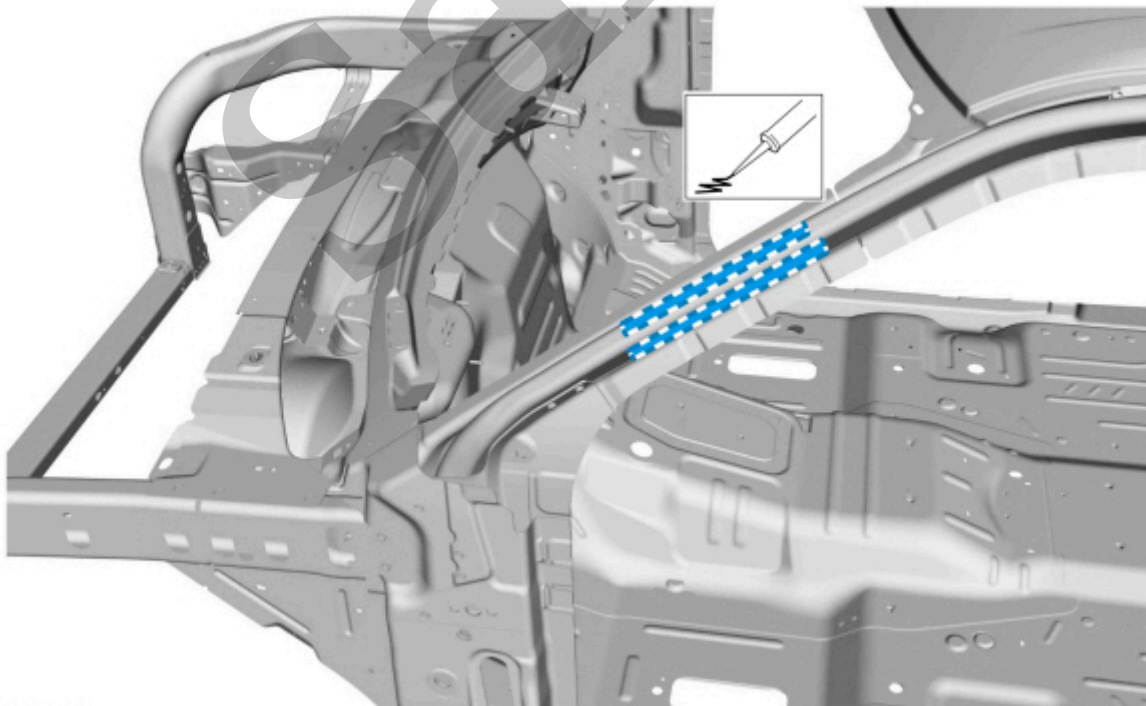
E201223

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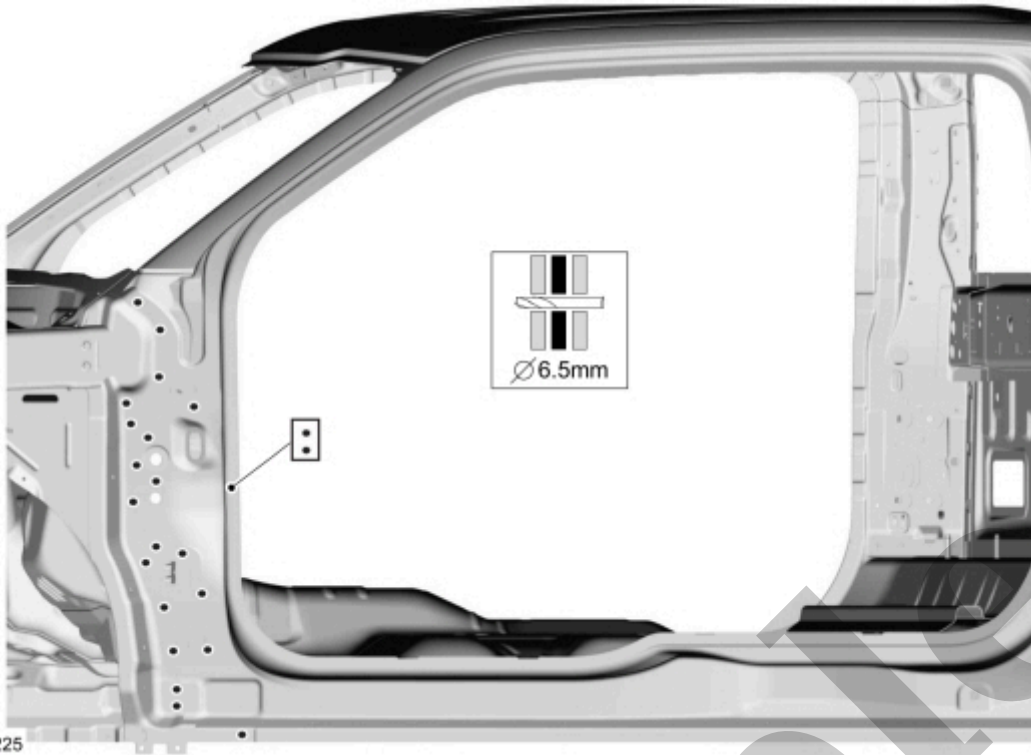
6. Apply flexible foam sealant and urethane adhesive.

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

Material : Sika® SikaTack® MACH 60 / Sika® SikaTack® MACH 30 / Dow® BETASEAL™ Express



E339227



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10. NOTE

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

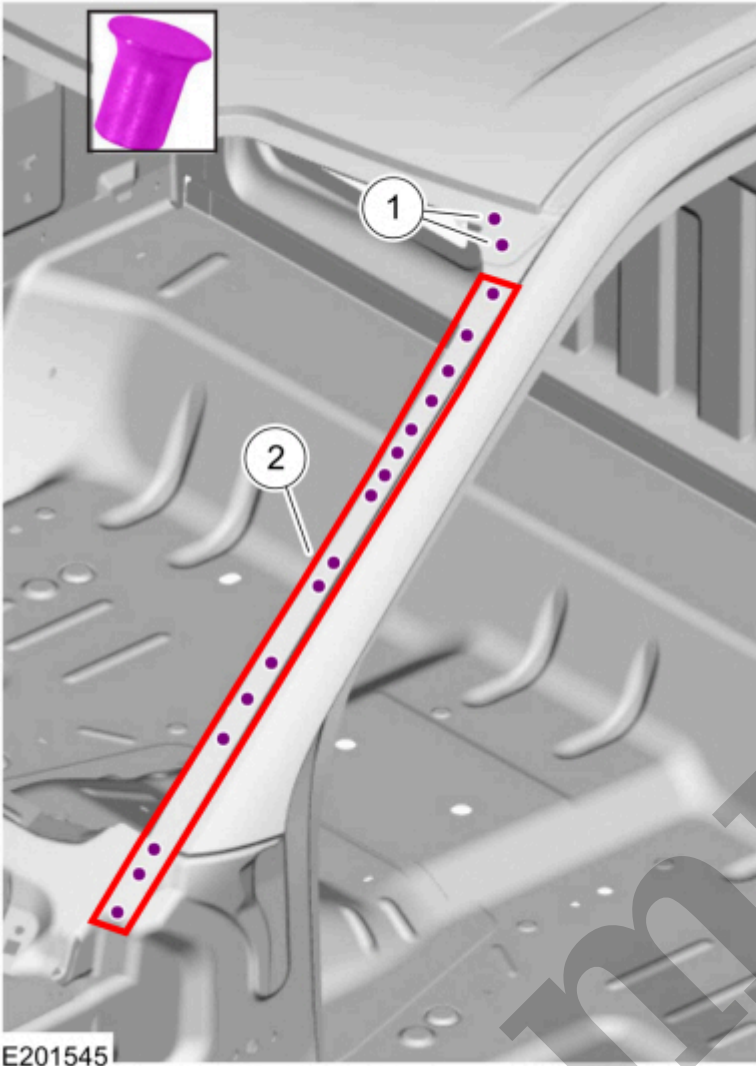
Install blind rivet fasteners.

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®
1	-	-	-	-	W707638-S900C	-	-
2	-	-	-	-	W708777-S900C	-	-
3	-	-	-	-	W702512-S900C	-	-

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-0401	-	W790376-S900	-
2	W717186-S900	EN	DG11-220/H	SA-0400/SA-0402	-	W790377-S900	-
3	W717185-S900	EL	DG11-220/H	SA-0400/SA-0402	-	W790377-S900	-
4	W708717-S900	AW	DP11-200/H	SA-0400/SA-0402	-	W790377-S900	-
5	W708717-S900	AW	DG10-220/H	SA-040/SA-0402	-	W790377-S900	-
6	W708713-S900	AS	DZ09-025/H	SA-0400/SA-0402	-	W790377-S900	-
7	W710246-S900	BN	DP10-200/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



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

13. Drill for fasteners.

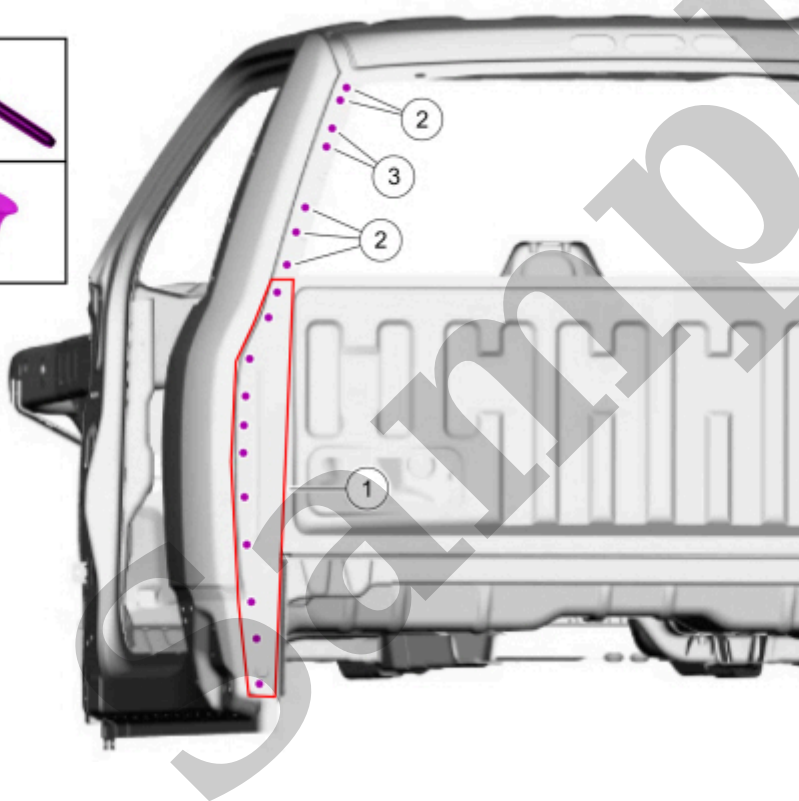
Use the General Equipment: 6.5 mm Drill Bit

2	W708713-S900	AS	DZ09-025/H	SA-0400/Sa-0402	-	W790377-S900	-
3	W708717-S900	AW	DZ09-220/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



E201546

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15. Seam weld the roof to body side seam using a MIG (metal inert gas) welder set up for aluminum repair.

Use the General Equipment: MIG/MAG Welding Equipment