

TECHNICAL SERVICE BULLETIN				reissue No.76/2010 21 November 2011			
Circulate to:	Service Manager	Body Shop Manager	Parts Manager	Foremen	Receptionists	Technicians	
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<p>This bulletin represents technical service information only. Without exception all gratis repairs and replacements are subject to the individual warranty and policy procedures of the supervisory Ford Company. The illustrations, technical information, data and descriptive text in this issue, to the best of our knowledge, were correct at the time of publication.</p> <p>This reissue replaces all previous versions. Please destroy all previous versions. Only refer to the electronic version of this TSB in FordEtis. The additional square mix nozzles can now be ordered from the Ford parts depot.</p>							
Subject/Concern:		Front or rear door weatherstrip loose or comes adrift on the door side frame					
Model:							
Fiesta 2008.75 (07/2008-) - 3-door and 5-door vehicles				Build Date: 06/2008-07/2011 Build Code: 8K-BS Assembly Plant: Cologne Assembly Plant: Valencia			
Markets:		Germany, Netherlands, Great Britain, France and Italy only					
Section:		501-03					
Summary							
<p>Should a customer express concern that the front or rear door weatherstrip becomes loose or adrift on the door side frame, the probable cause is insufficient adhesive applied in production.</p> <p>To rectify this concern, the affected door weatherstrip should be bonded to the door frame using the repair adhesive kit.</p> <ul style="list-style-type: none"> • NOTE: It is NOT required to install a new front / rear door frame weatherstrip. <p>For markets where FordEtis IDS is used, refer to WB 45/2009 for the policy on using FordEtis IDS for warranty repairs. If FordEtis IDS is used to diagnose a customer's concern(s), select the appropriate customer symptom(s), follow any diagnostic, repair and post repair procedures presented, and ensure the completed diagnostic session file is transmitted to Ford. Failure to follow this process may affect any associated warranty claim submission. For markets where FordEtis IDS is not available, rectify this concern by following the attached service repair instruction.</p>							
Parts Required							
Description				Finis Code	Quantity		
Repair Adhesive Kit - 2 Component (50 ml) (essential for 30 weatherstrip repairs) (includes 1 mix nozzle)				1 737 528	-		
Square Mix Nozzle (12 off)				1 760 048	-		
Labor Time							
Operation Description				Operation No. / Time			
Attach the door weatherstrip on:							
One door (Main Operation)				710030C76			
One door (Combination Operation, If Applicable)				710011C76			
Each further door				710012C76			
Repair/Claim Coding							
Causal Part:		41931 LHF; 41932 RHF; 41961 LHR; 41962 RHR					
ACES Condition Code:		33					
General Equipment				Finis Code			

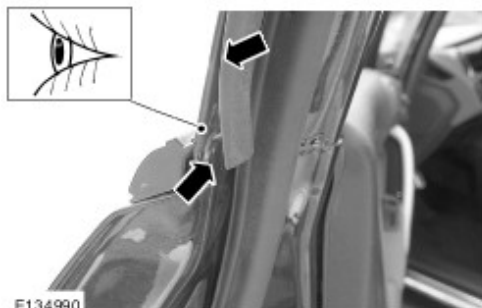
Adhesive tape	Locally procured
Cleaning agent (Isopropanol wipe or equivalent product)	
Mixer DMA 50	

Production Action

Revised door weatherstrips have been installed in production in Cologne plant since 08/2011 (build code BT) onwards.

Service Information


Root area on the front door frame (front door shown, rear door similar)



Item	Description
-	Front door outer weatherstrip loose or adrift

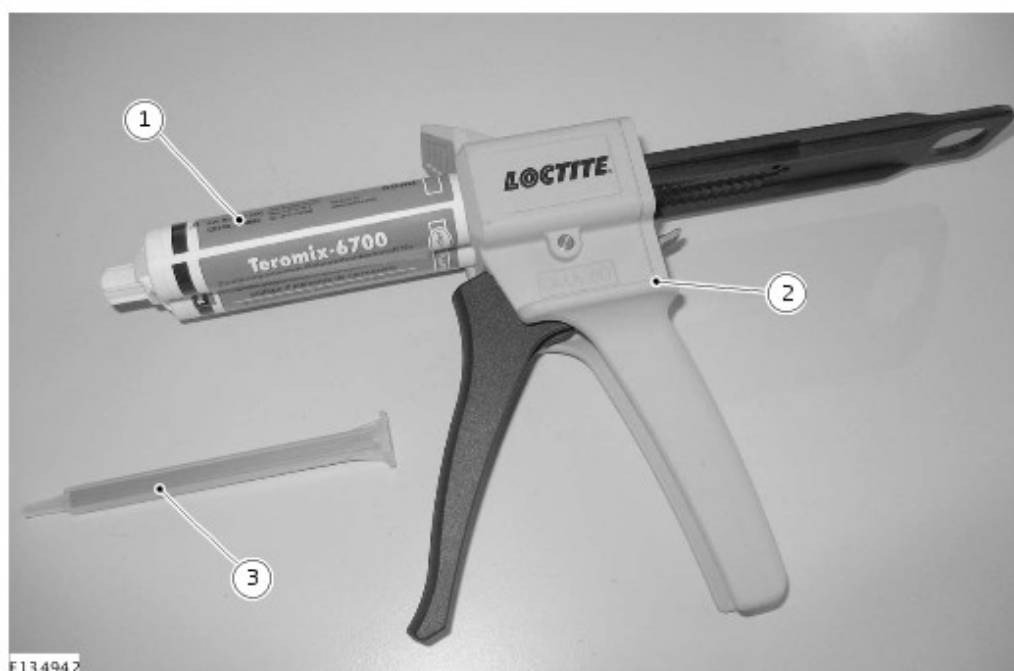
Service Instruction

Attach the door outer weatherstrip to the door frame

1.  **WARNING:** Safety instructions of material equipment provided by the manufacturer must be observed.

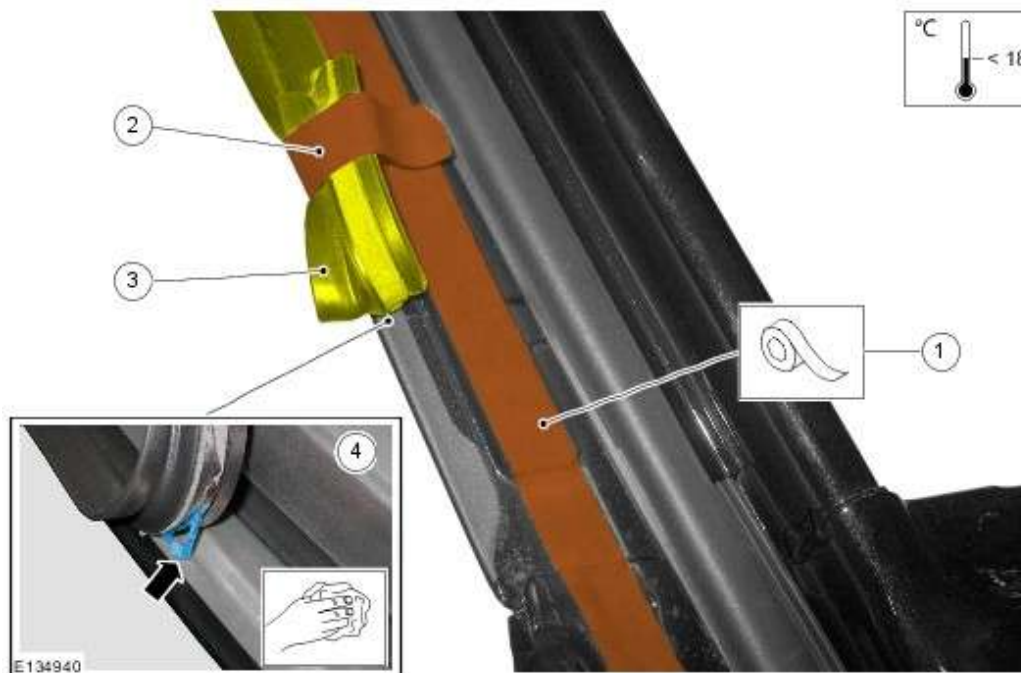
Prepare the repair adhesive kit. Refer to the manufacturer's directions.

1. Repair adhesive kit
2. Mixer DMA 50
3. Square mix nozzle



2. Clean the repair area on the door frame.

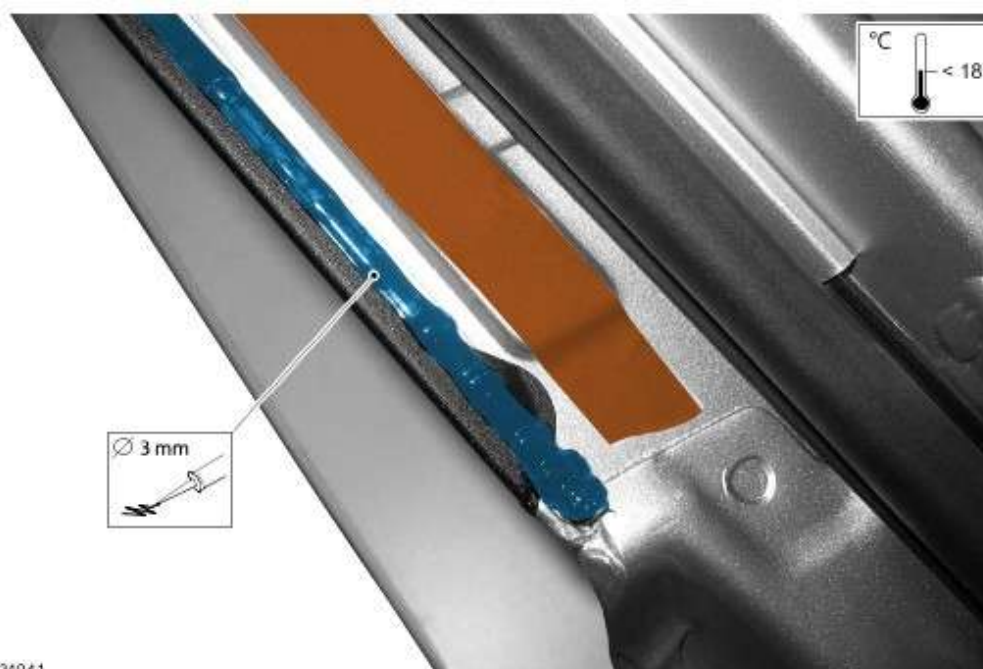
1. Mark the installation position of the door outer weatherstrip with adhesive tape for installation.
2. Tape back the detached part of the door outer weatherstrip.
3. Door outer weatherstrip.
4. Dry the adhesive surfaces of the door frame.
Clean off any remaining traces of adhesive from the door frame by rubbing with a clean cloth and dry the adhesive surface. Thoroughly clean the repair area with an Isopropanol wipe or equivalent product.



3. NOTE: Allow the repair adhesive to dry (drying time ≥ 1 hour). Apply repair adhesive ($\varnothing 3$ mm) in the shown area only. Make sure that the mating faces are clean and free of foreign material.

Apply repair adhesive (see Parts Required) to the door frame.

- Max. \varnothing of adhesive bead: 3 mm



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4. NOTE: If the ambient temperature falls below 10°C, apply warm air (25°C) continuously.

Place the door outer weatherstrip on the door frame in the correct position. Press the door outer weatherstrip home for at least one minute in order to obtain complete adhesion.

- Properly remove any access material.
- Secure the door outer weatherstrip on the door frame using tape.
- Allow the repair adhesive to dry in reference to the manufacturers' directions but not less than 5 hours.
- Remove any used tape.

5. If required, repeat steps 2 to 4 on the remaining doors.