

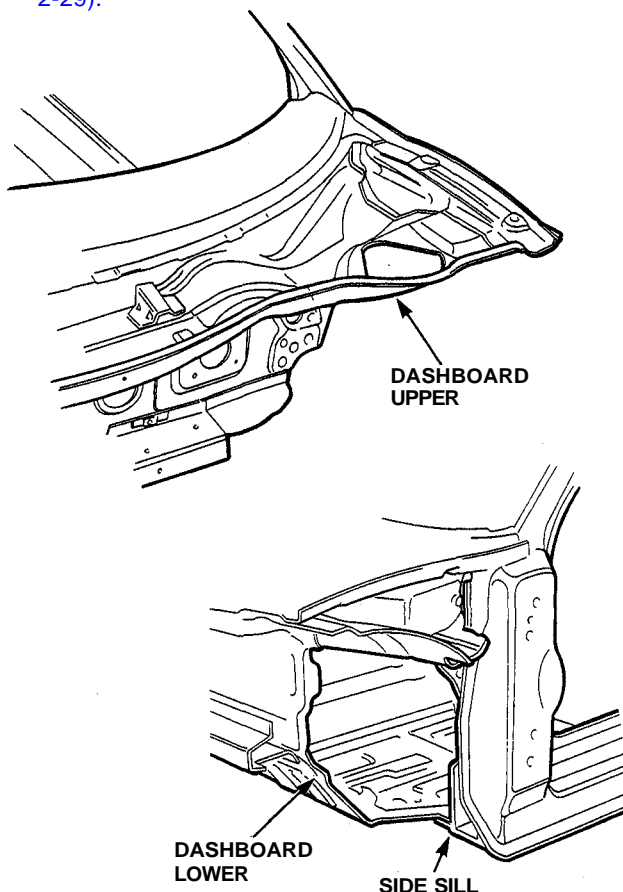
Front Side Frame

Replacement(cont'd)

7. Mold the related parts.

Reshape the dashboard lower-and-front floor joint using a hammer and dolly.

NOTE: Check the reshaped parts for cracks (see page 2-29).



8. Set the new front side frame.

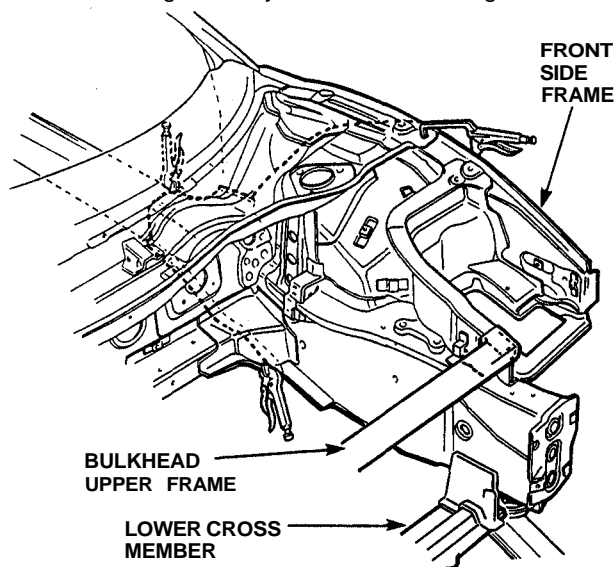
- Drill the $\varnothing 10$ (3/8") plug weld holes in the welding flange of the new front side frame.
- Remove the undercoat from the both sides of the welding section and expose the aluminum alloy base using a disc sander.

⚠ WARNING

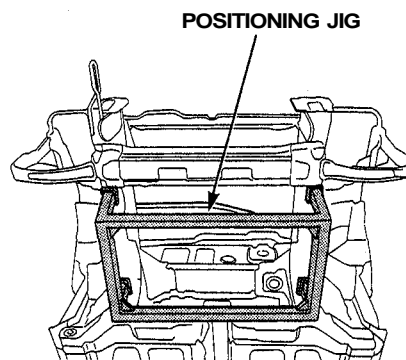
To prevent eye injury, wear goggles or safety glasses whenever sanding, cutting or grinding.

- Remove the paint film from the welding section of the body and clean off any oil contaminations using a shop towel soaked with wax and grease remover.
- Just before setting the front side frame, remove the oxide film from the welding surface of the replacement part and body using a stainless steel wire brush.

- Tighten the front side frame against the front floor and side sill using the vise-grips, pliers, etc.
- Place a jack under the front side frame end and support it, and measure the positions for temporary attachment.
- Clamp the bulkhead upper frame and lower cross member
- Measure the front compartment diagonally and check the front side frame and damper base positions using the body dimensional drawings.



NOTE: Use of positioning jig as shown is recommended (see page 1-7).



9. Tack weld the front side frame, the bulkhead upper frame and lower cross member.

⚠ WARNING

To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

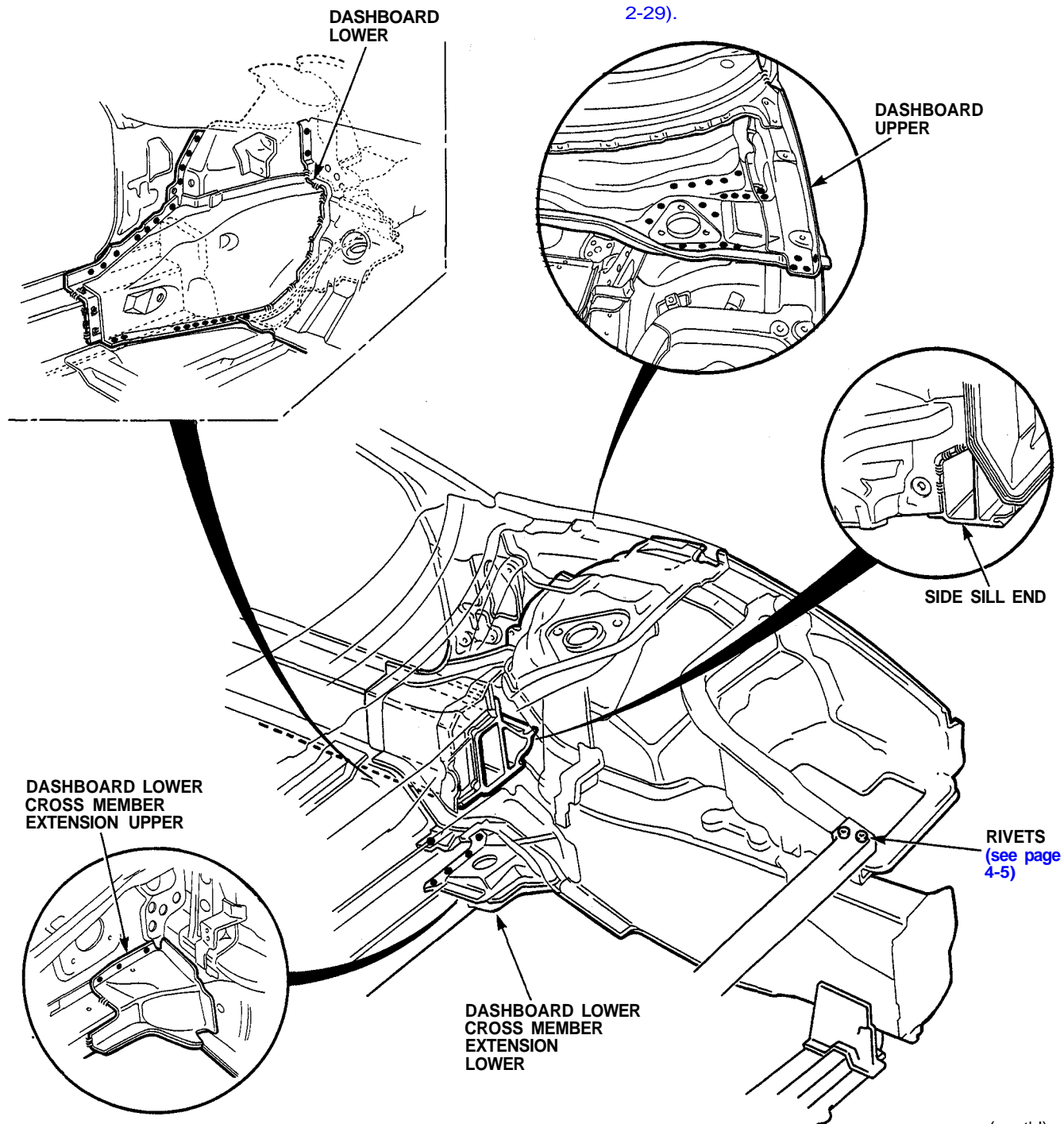
10. Measure the dimension, temporarily install the hood and fender, and check for difference in level and clearance.

11. Perform the main welding.

- Weld as much as possible with the jig still mounted.

⚠ WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

- Before welding, perform the trial welding following the welder manufacturer's instructions.
- Clean the welding section with a stainless steel wire brush before welding.
- The applicable welding methods in this step shall be the MIG welding, plug welding, and fillet welding.
- Check the welding section for cracks (see page 2-29).



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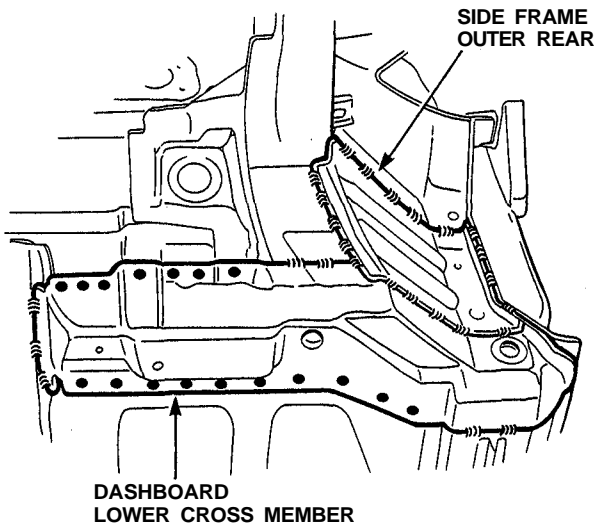
Front Side Frame

Replacement (cont'd)

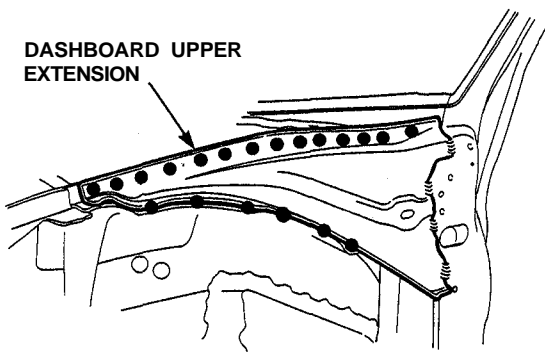
12. Install and weld the related parts.

⚠ WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

- Drill the $\varnothing 10$ (3/8") holes in the dashboard lower cross member and plug weld.
- Set the side frame outer rear, clean the welding section with a stainless steel wire brush, and fillet weld.



- Plug weld the dashboard upper extension and wheelhouse by drilling the $\varnothing 10$ (3/8") holes, and the fillet weld the front pillar.



- Check the welding sections for cracks (see page 2-29).

13. Apply the sealer (see section 5).

Apply sealer to the mating surfaces of the dashboard lower, etc.

14. Apply the paint.

See Paint Repair section.

⚠ WARNING

- Ventilate when spraying paint. Most paint contains substances that are harmful if inhaled or swallowed. Read the paint label before opening paint container.
- Avoid contact with skin. Wear an approved respirator, gloves, eye protection and appropriate clothing when painting.
- Paint is flammable. Store in a safe place, and keep it away from sparks, flames or cigarettes.

15. Apply the undercoat (see section 7).

Undercoat the front floor, etc. and apply anti-rust agent to the inside of the welding section of the front side sill, front pillar, etc.

16. Install the related parts.

Install in the reverse order in which they were removed.

17. Inspect, check and make adjustment.

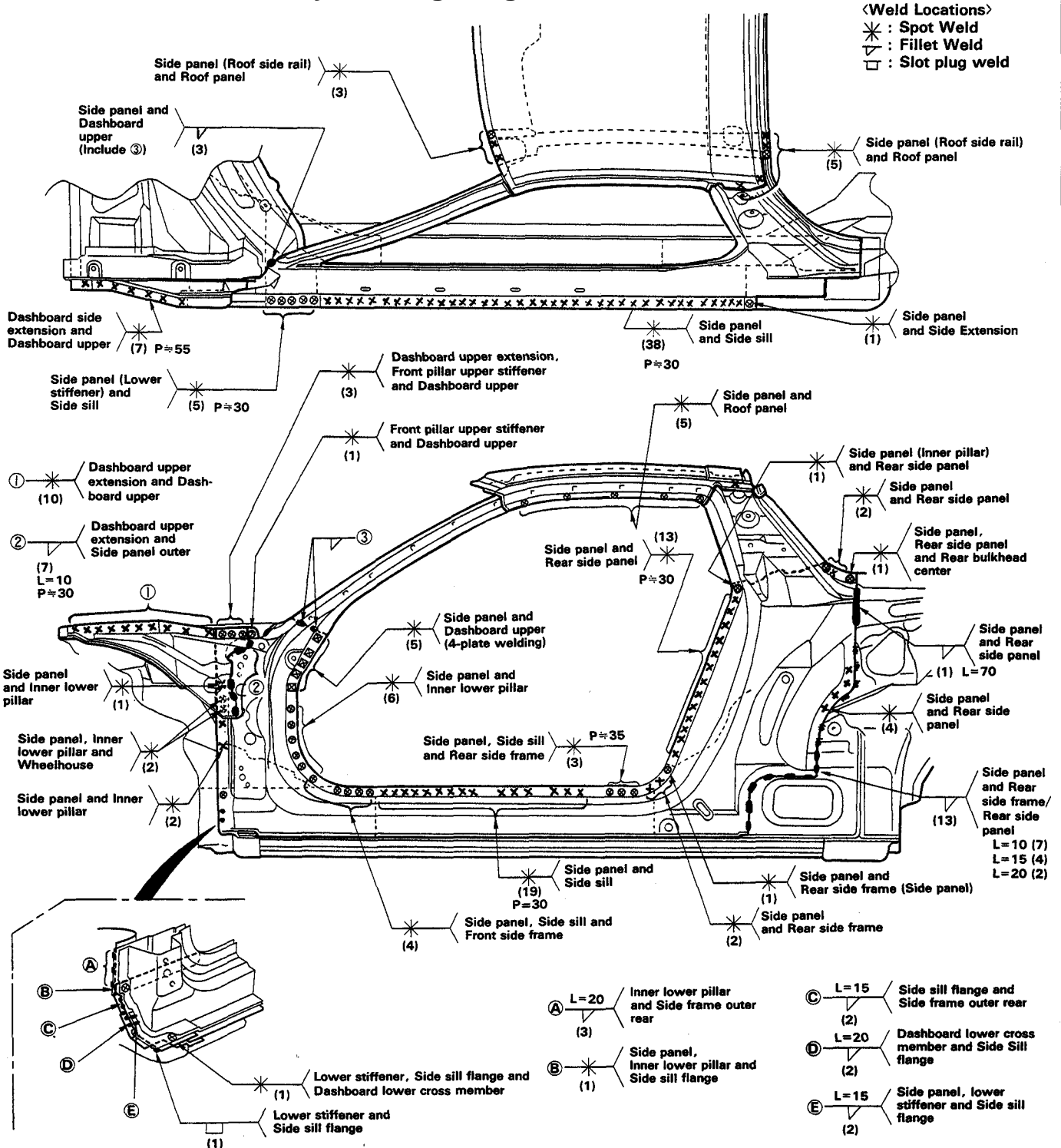
- Measure the front wheel alignment.
- Inspect the brake system.
- Adjust the headlight aim.

Side Panel

Description

The side panel is critical for proper installation of the roof, windshield, rear hatch hinge, and door hinge. It is connected to the side sill and constitutes the cabin side. Positioning of the windshield and rear hatch is affected by how they are connected to the side panel. Temporarily install the side panel, front fender, and rear hatch, and check for difference in level and clearance.

Mass Production Body Welding Diagram



Side Panel Replacement

1. Remove the related parts:

- Door
- Door opening trim
- Carpet
- Door switch
- Seat belt
- Side sill panel
- Windshield
- Rear hatch assembly
- Rear window
- Headliner
- Front fender
- Rear fender
- Dashboard

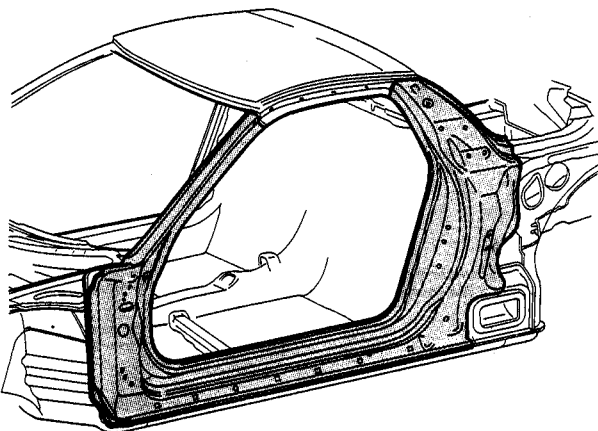
2. Pull out and straighten the damaged area.

NOTE: Make sure that the right and left pillars are parallel the windshield surface.

- Check the door and rear hatch for proper opening and closing.
- Attach the car to the frame straightener by tightening the underbody clamps located at the jack-up points on the bottom of the side sill and the side sill side flanger.

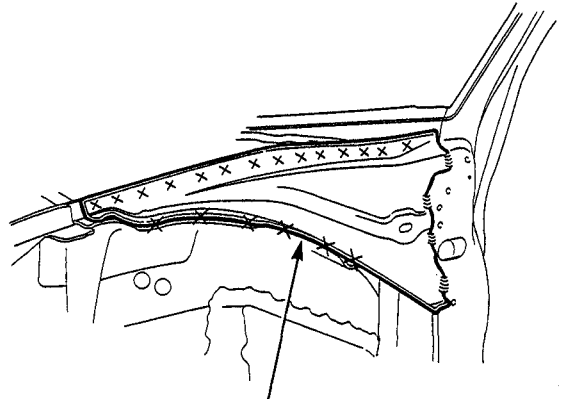
NOTE: Refer to the NSX Service Manual for safety sand location points.

- To protect the car body from damage, place a piece of aluminum plate on each clamping section and tighten the clamps.
- Before removing the side panel, pull out the damaged sections so that they are restored to the original shape.
- Before pulling out the damaged sections, it might be necessary to heat them with an acetylene torch (see page 2-31).



- After pulling, check the door, windshield and rear window opening using the body dimensional drawings (see section 6).

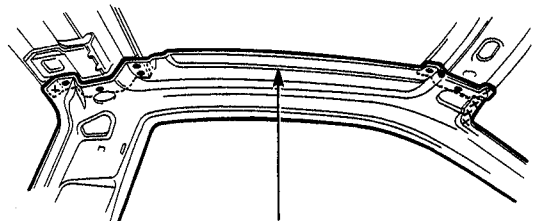
3. Remove the dashboard upper extension .



DASHBOARD UPPER EXTENSION

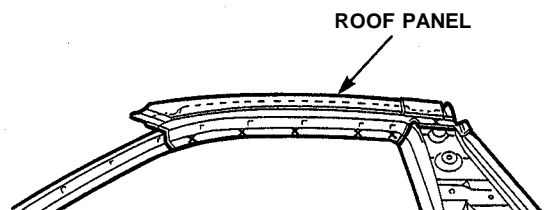
4. Remove the side panel.

- Strike a punch in the center of the spot welds to the roof side rail, front roof rail, and rear roof rail.



ROOF SIDE RAIL

- Strike a punch in the center of the spot welds to the roof panel.

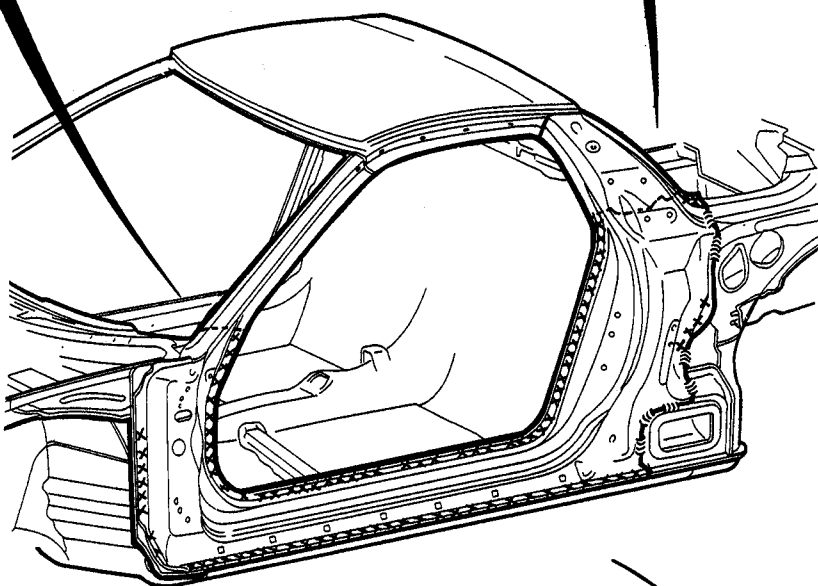
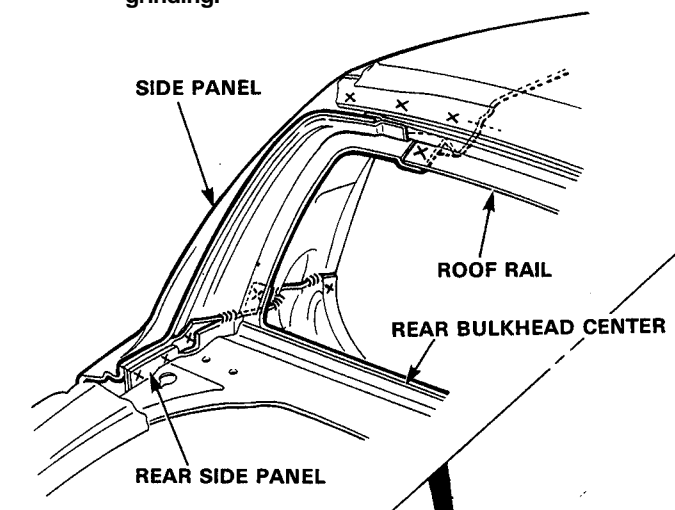
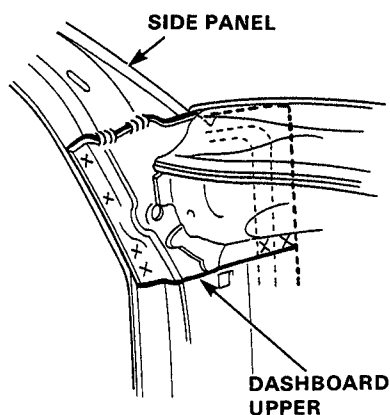


ROOF PANEL

- Strike a punch in the center of the spot welds to the front pillar, side sill, and rear pillar.
- Drill the spot welds using a $\varnothing 10$ (3/8") spot cutter.
- Grind the MIG welding section using a rotary cutter.
- Remove the remaining welding flanges using a chisel.
- Remove the burrs from the drilled section using a disc sander.

⚠ WARNING

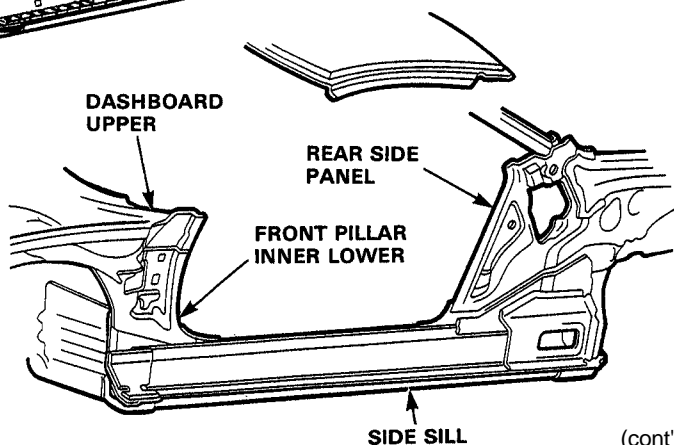
To prevent eye injury, wear goggles or safety glasses whenever sanding, cutting or grinding.



5. Mold the related parts.

Smooth the welding flanges of the roof panel and welding section of the rear side panel with a hammer and dolly.

NOTE: Check the reshaped parts for cracks ([see page 2-29](#)).



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Side Panel

Replacement(cont'd)

6. Set the new side panel.

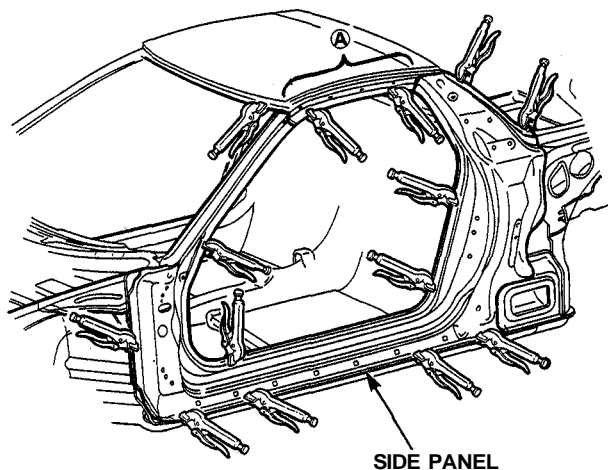
- Drill the $\varnothing 8$ (5/16") plug weld holes in the welding flange of the new side panel.

NOTE: When performing MIG welding on section ®, make fewer holes than the number of spots originally welded.

- Remove the undercoat from the both sides of the welding section and expose the aluminum alloy base using a disc sander.

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- Remove the paint film from the welding section of the body and clean oil contaminations with a shop towel soaked with wax and grease remover.
- Before setting the new side panel, remove the oxide film from the welding section of the replacement part and body using a stainless steel wire brush.
- Install the side panel and clamp it with the vise-grips, pliers, etc.



- Check the body dimensions.

7. Tack weld the side panel.

⚠ WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

Plug weld the clamped sections to temporarily install the side panel.

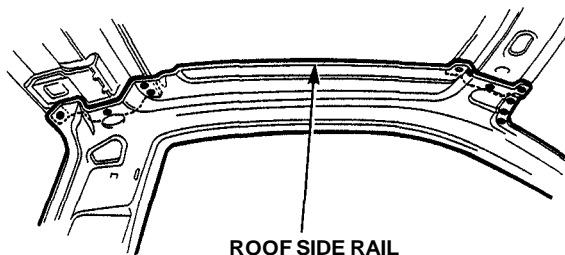
8. Remove the vise-grips and pliers and install the windshield, front fender, door, rear window, and rear fender. Check for difference in level and clearance.

NOTE: Check for flushness of the front fender, door, and rear fender. Check for smooth body line of the car.

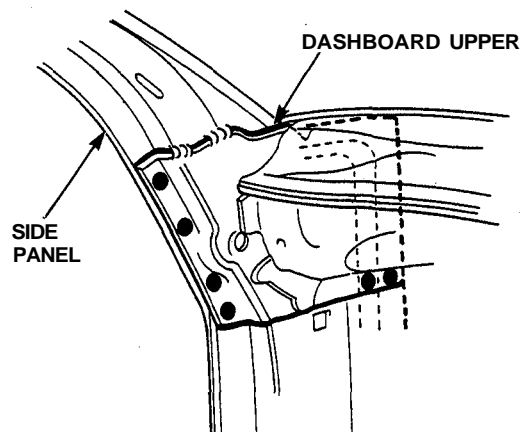
9. Perform main welding.

⚠ WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

- Before welding, perform the trial welding following the welder manufacturer's instructions.
- Remove the oxide film from the welding section using a stainless steel wire brush.
- Weld the roof side rail.

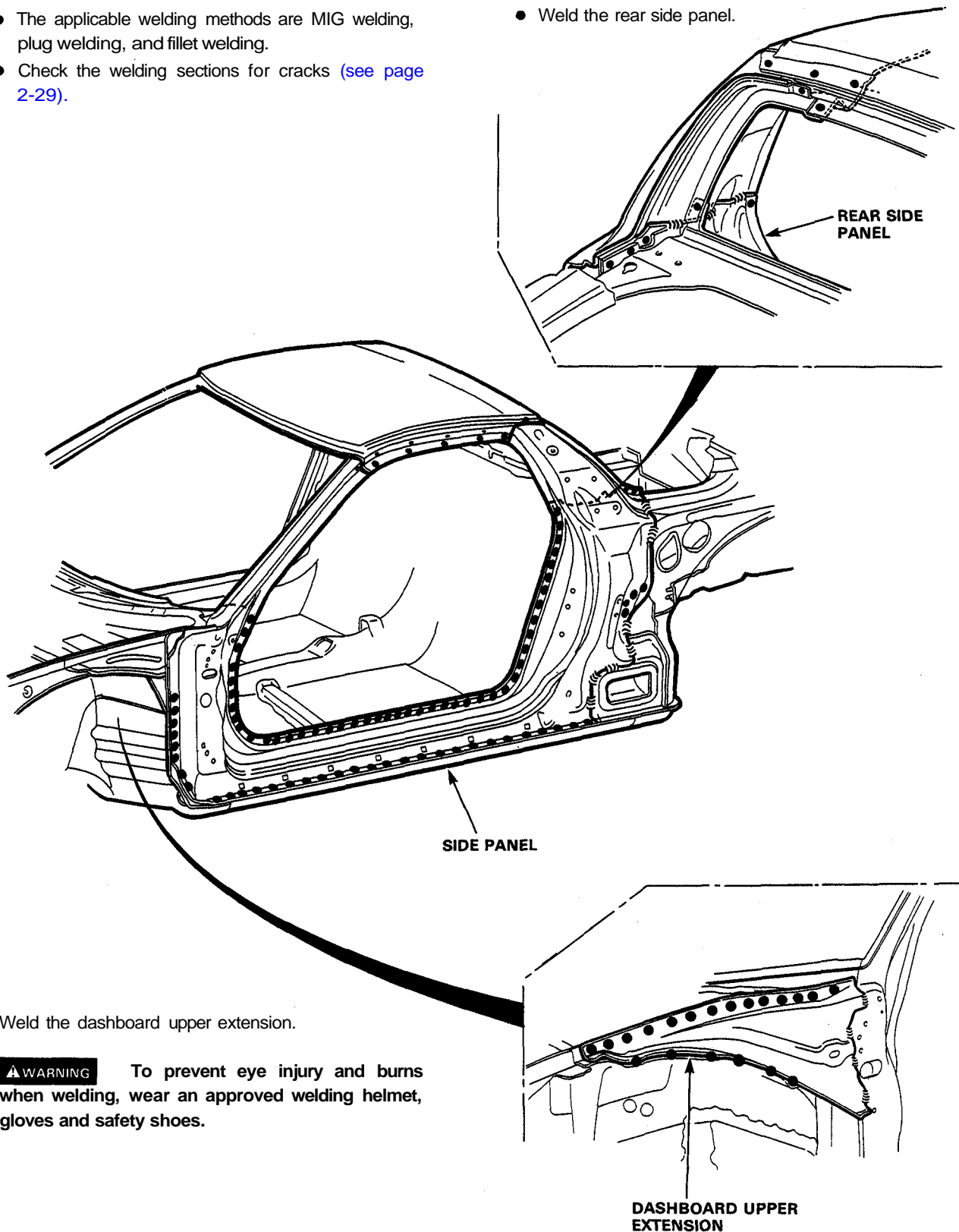


- Weld the dashboard upper.



- The applicable welding methods are MIG welding, plug welding, and fillet welding.
- Check the welding sections for cracks (see page 2-29).

- Weld the rear side panel.



10. Weld the dashboard upper extension.

⚠ WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

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