

Trunk Front Panel

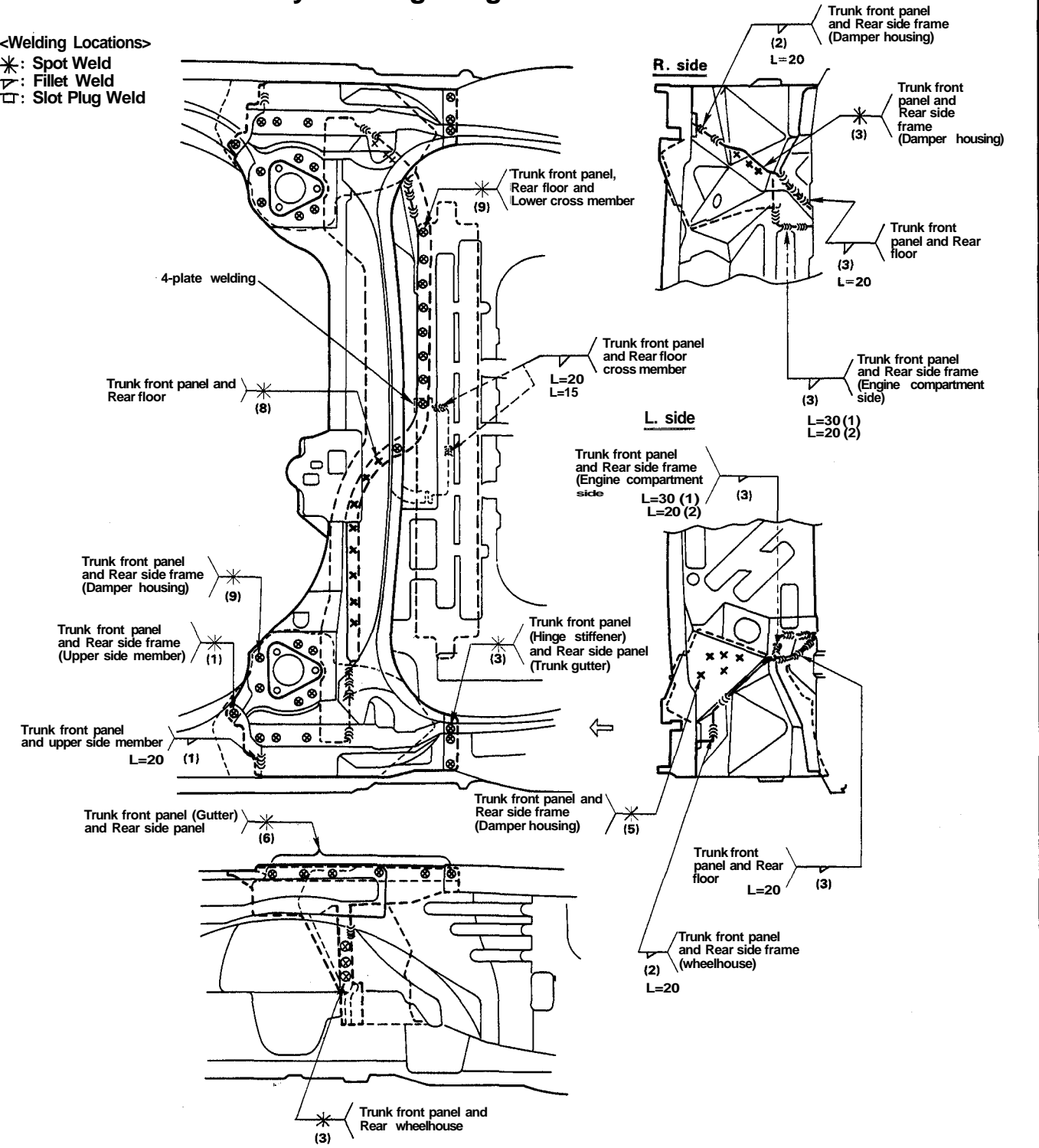
Description

The frame number of the car is stamped on the trunk front panel and is registered with local authorities. If the trunk front panel must be replaced because of damage, check with local authorities before replacement.

Mass Production Body Welding Diagram

<Welding Locations>

- *: Spot Weld
- ▽: Fillet Weld
- : Slot Plug Weld



Trunk Front Panel

Replacement

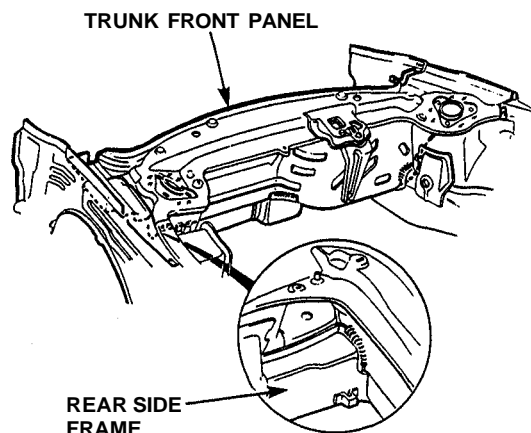
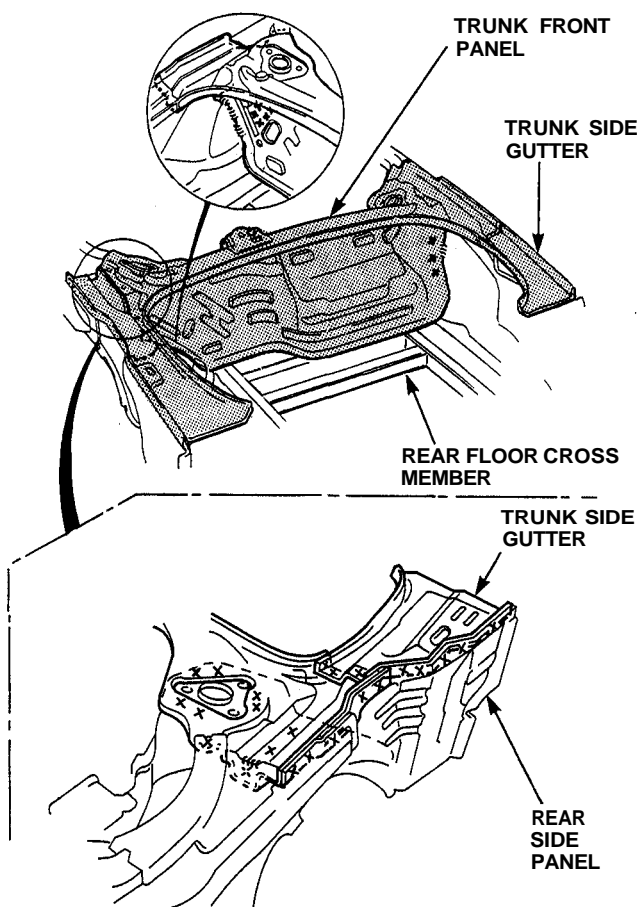
1. Remove the related parts.
 - Rear suspension assembly
 - Engine assembly
 - Trunk lid
 - Harnesses
 - Others

NOTE: With the rear panel and rear floor removed:

2. Remove the trunk side gutter and trunk front panel.
 - Strike a punch in the center of the spot welds in the trunk front panel, rear damper base, rear floor, wheel house upper member, and trunk side gutter.
 - Drill the spot welds using a $\varnothing 10$ (3/8") spot cutter.
 - Grind the MIG/fillet welds using a rotary cutter.

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

- Remove the welding flanges using a chisel.
- Remove the burrs from spot welds and MIG welds using a disc grinder.
- Smooth the welding section of the body with a hammer and dolly.



3. Mold the related parts.
Smooth the welding flange of the rear side panel, rear side frame and rear floor cross member.

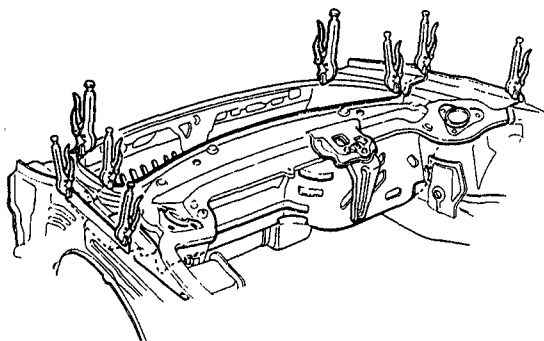
NOTE: Check the reshaped parts for cracks ([see page 2-29](#)).

4. Set the new trunk front panel and trunk side gutter.
 - Drill the $\varnothing 8 \sim 10$ (5/16"~3/8") plug weld holes in the welding flange of the new trunk front panel.
 - Remove the undercoat from the welding flanges of the trunk front panel and trunk side gutter, 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 using a disc sander and clean oil contamination with a shop towel soaked with wax and grease remover.
- Before setting the trunk front panel and trunk side gutter, remove the oxide film from the welding section of the trunk front panel and trunk side gutter, and body using a stainless steel wire brush.

- Clamp the trunk front panel and trunk side gutter in place with vise-grips.
- Check that the rear side frame is parallel at the right and left.



- Set the rear floor and rear panel (see pages 4-50, 53).
- Check the trunk front panel position using the body dimensional drawings (see section 6).

5. Tack weld the trunk front panel and trunk side gutter.

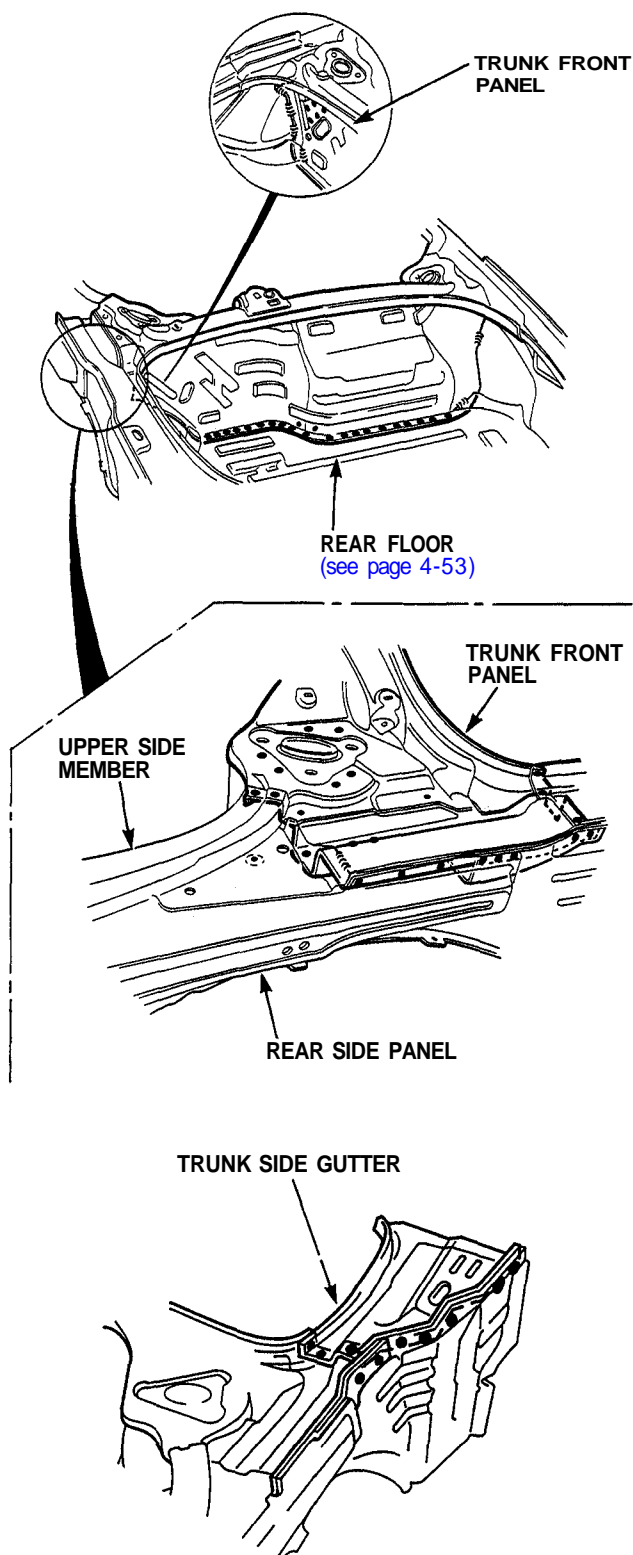
⚠ WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

- Open and close the rear hatch and trunk lid to check for proper installation.

6. Perform the 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 sections using a stainless steel wire brush.
- The applicable welding methods are MIG/plug welding and fillet welding.
- Check the welding sections for cracks (see page 2-29).



(cont'd)

Trunk Front Panel

Replacement (cont'd)

7. Finish the welding area.

- Roughly grind the welds with a disc grinder. Be sure to leave the finishing allowance this time.
- Finish grind the finishing allowance with a disc sander until it is smooth.

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

- Smooth the trunk lid opening using a hammer and dolly.
- Take care not to grind the aluminum alloy base while roughly grinding the welds.
- Take care not to grind excessively.
- Do not press on the sanding tools excessively. If the disc face is clogged with the aluminum alloy particles, replace with a new disc.

8. Apply the sealer ([see section 5](#)).

9. 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.

10. Apply anti-rust agent ([see section 7](#)).

11. Install the rear fender and trunk lid.

Install the rear fender and trunk lid and check for clearance and differences in level.

12. Install the related parts.

Install in the reverse order of removal.

13. Check and clean.

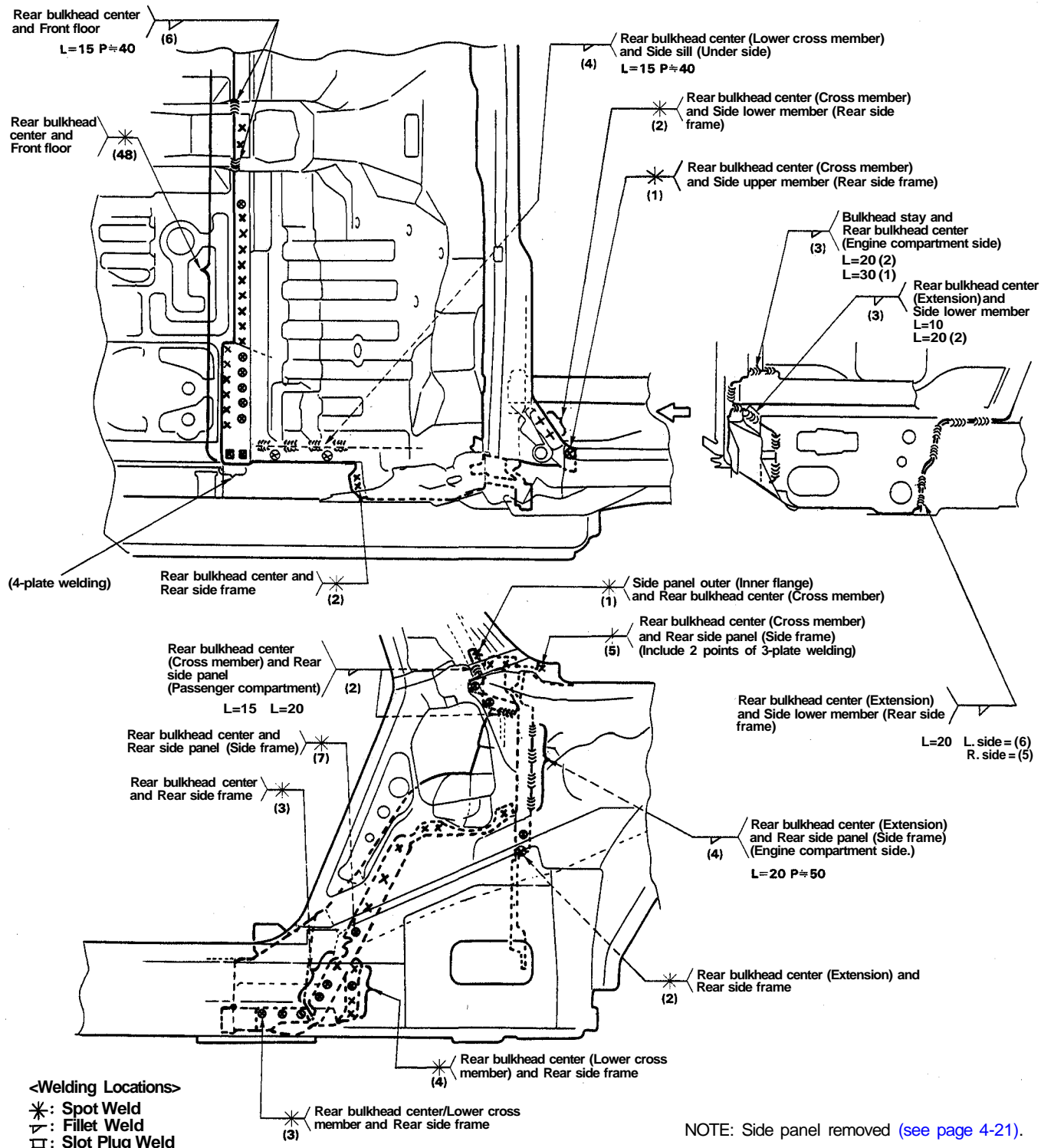
- Check the rear wheel alignment.
- Start the engine and check its condition.

Rear Bulkhead Center

Description

The rear bulkhead center is the critical part which connects the right and left body center and where the fuel tank is mounted. Take extreme care to position the rear bulkhead center properly. Weld securely following the welder manufacturer's instructions to maintain the rigidity.

Mass Production Body Welding Diagram



Rear Bulkhead Center

Replacement

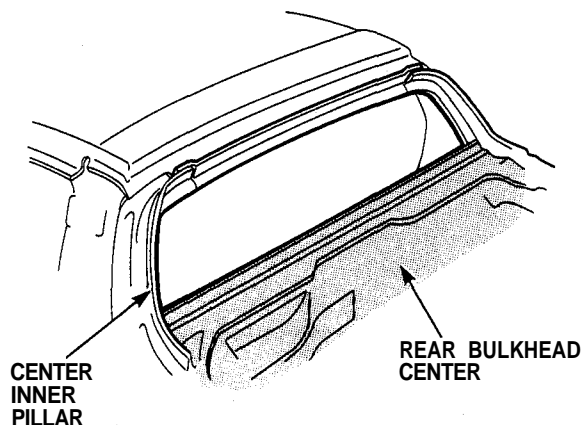
1. Remove the related parts.
 - Driver's and passenger's seats
 - Fuel tank assembly

⚠ WARNING Do not smoke while working near the fuel system. Keep open flame away from the fuel system. If necessary, remove the fuel tank and/or lines before welding nearby. Drain fuel into an approved container.

- Brake hose and pipes
- Side garnish
- Seat belt
- Engine assembly
- Electricals, and others
- Rear window

2. Pull out and straighten the damaged area.
NOTE: Make sure that the right and left center pillars are parallel to the rear window surface.

- The collision damage may extend to the rear bulkhead center as well as the side panel outer and side sill. Check for the damaged sections carefully and pull them out with the frame straightener to reshape.
- Attach the car to the frame straightener by tightening the underbody clamps located at the jack-up points on the bottom of the side and sill and the side sill side flanges.
- To protect the car body from damage, place a piece of aluminum plate on each clamping section and tighten the clamps.
- Before pulling out the damaged sections, it might be necessary to heat the sections with an acetylene torch (see page 2-31).



- After pulling, check the rear window rear side frame and rear side panel positions using the body dimensional drawings (see section 6).

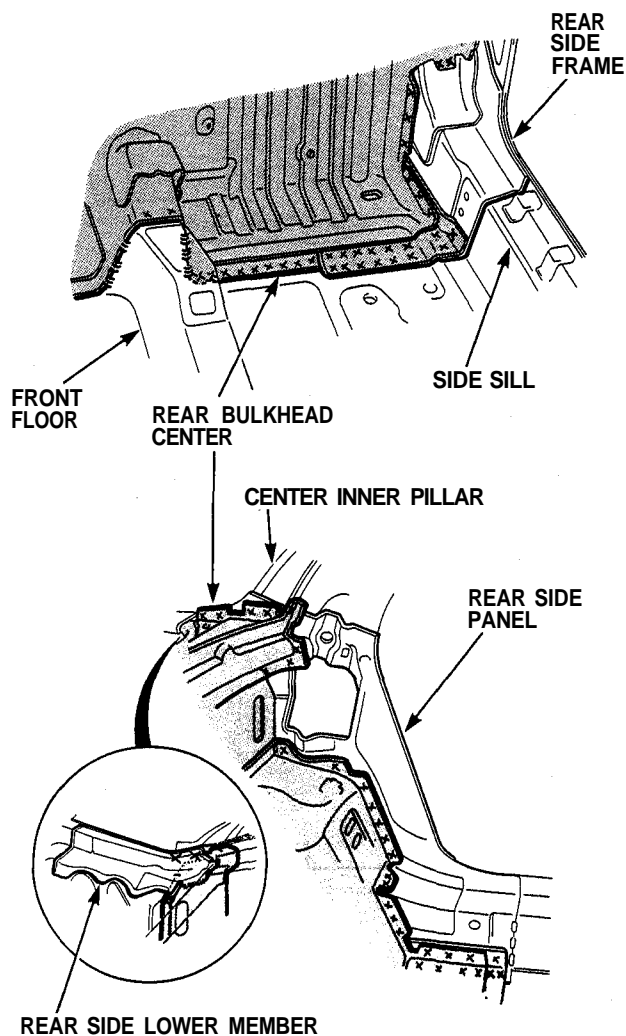
3. Remove the rear bulkhead center.
 - Strike a punch in the center of the spot welds to the front floor, side sill, and rear frame.
 - Drill the spot welds using a $\varnothing 10$ (3/8") spot cutter.

NOTE: Take care not to drill through the front floor and inner side panel.

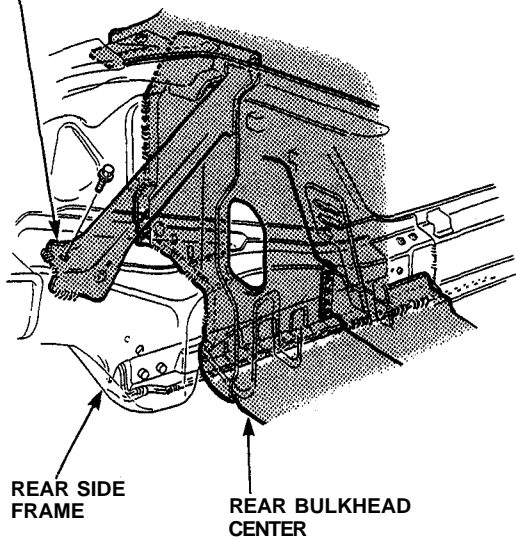
- Grind the MIG/fillet welds using a rotary cutter.

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

- Remove the spot welds and fillet welds using a chisel.



BULKHEAD STAY



4. Mold the related parts.

Correct the damaged section of the front floor and inner side panel with a hammer and dolly.

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

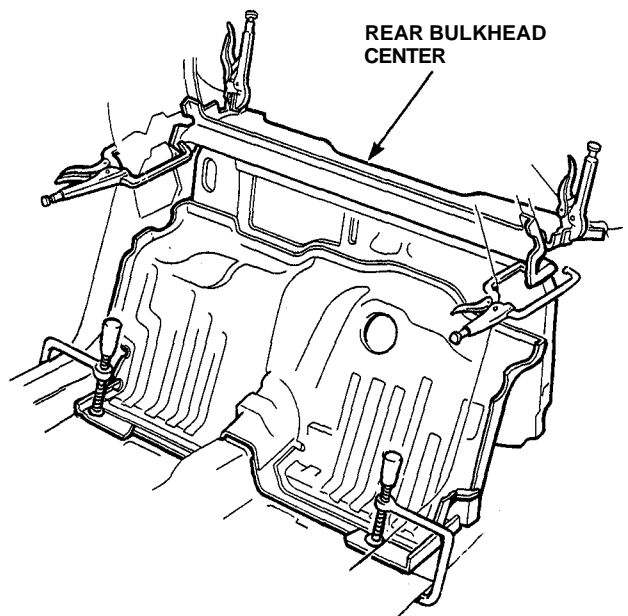
5. Set the new rear bulkhead center.

- Drill the $\varnothing 8 \sim \varnothing 10$ (5/16"~3/8") holes for MIG welding in the flanges mating with the front floor.
- Remove the undercoat from the welding section of the rear bulkhead center 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 using a disc sander and clean oil contaminations with a shop towel soaked with wax and grease remover.
- Remove the undercoat thoroughly from the underside of the front floor.
- Before setting the rear bulkhead center, clean the welding sections of the rear bulkhead center and body using a stainless steel wire brush.

- Clamp the front floor and inner panel with the vise-grips and pliers.



- Check the rear bulkhead center position using the body dimensional drawings.

6. Weld the clamped sections for temporary installation.

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

Set the rear window and rear hatch, check for proper rear bulkhead installation.

7. Perform the 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 sections using a stainless steel wire brush before welding.
- The applicable welding methods are MIG/plug welding or fillet welding.

(cont'd)