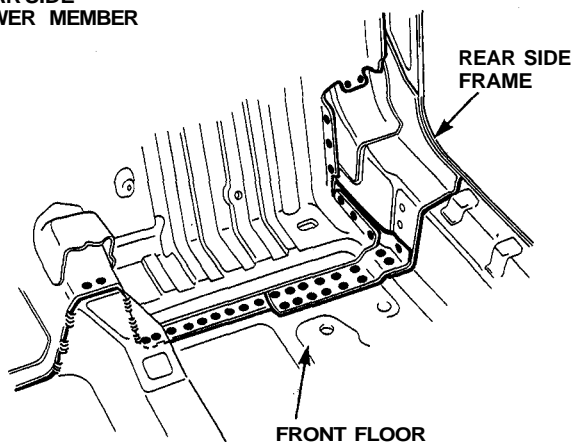
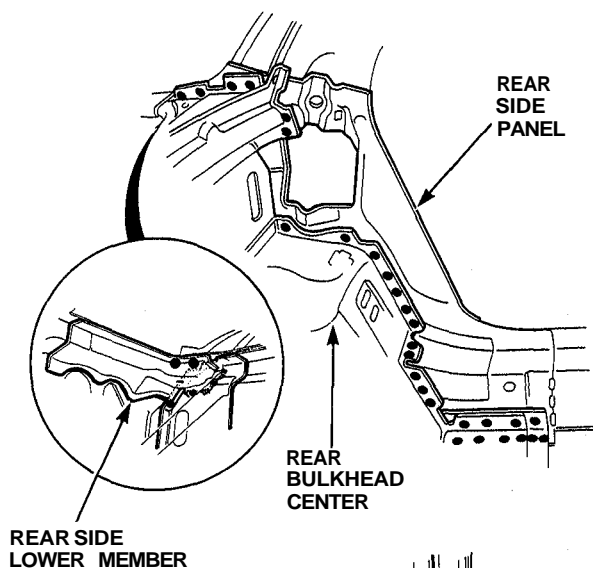
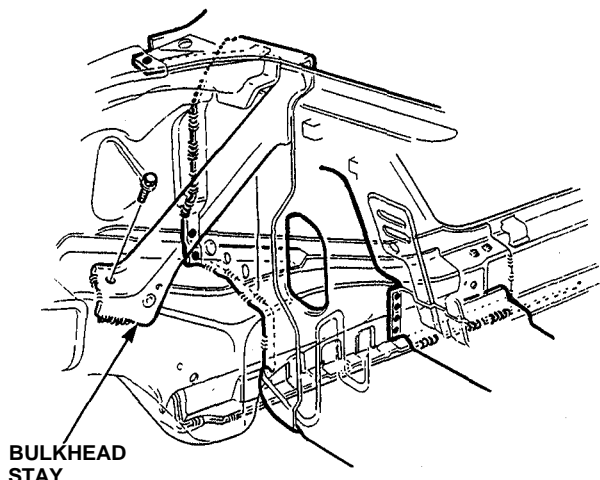


# Rear Bulkhead Center

## Replacement (cont'd)

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



8. 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.

- 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.

9. Apply the sealer (see section 5).

Apply sealer to the mating surfaces with the front floor and side inner panel.

10. 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.

11. Apply anti-rust agent (see section 7).

12. Install the related parts.

Install in the reverse order of removal.

13. Check and clean.

Start the engine and check its condition.

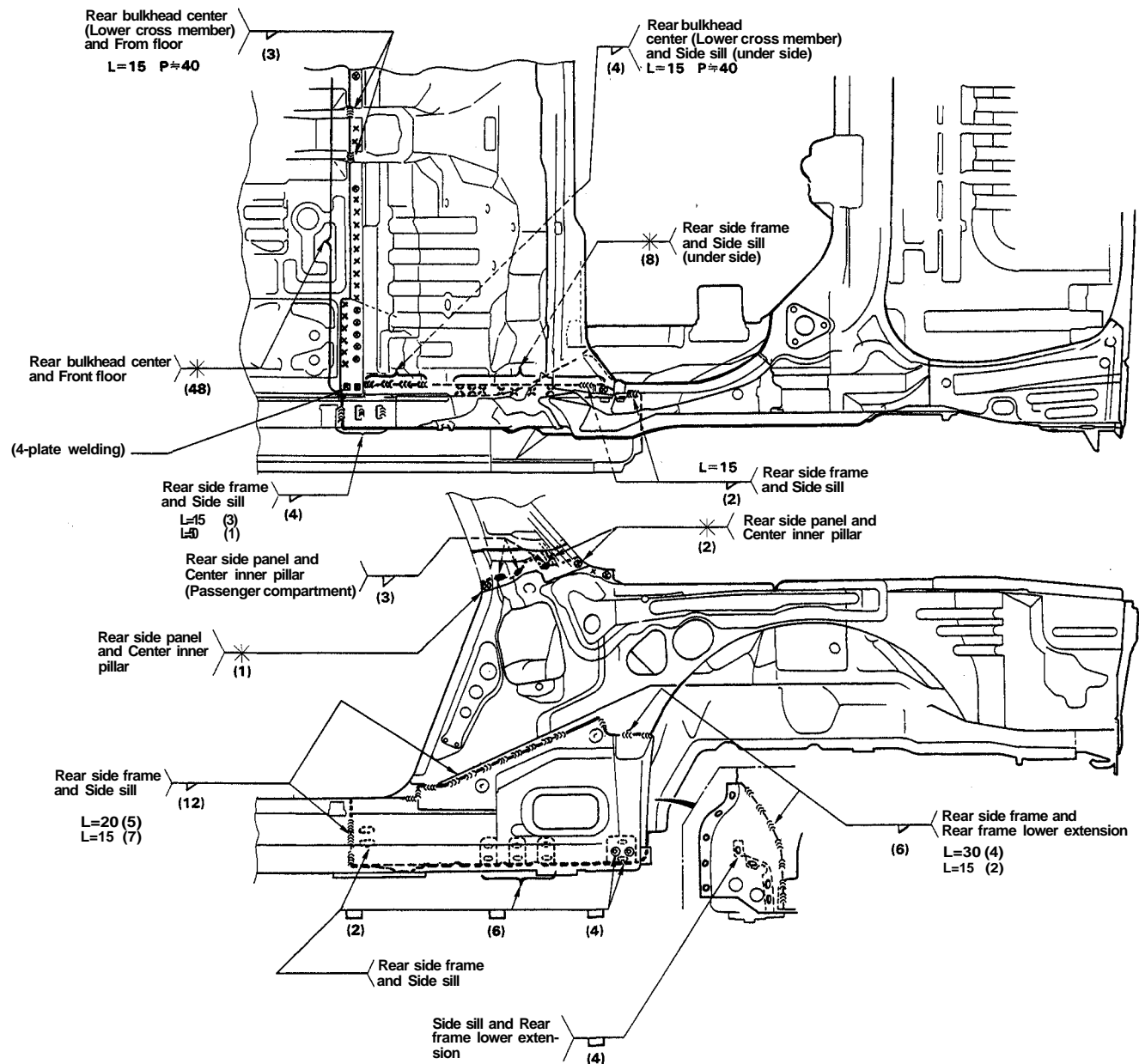
# Rear Assembly

## Description

The rear assembly is critical for the rigidity of the rear body and for the installation of the rear wheel, suspension, and engine. During installation, the dimension shown in the body dimensional drawings (see section 6). Welding must be performed by using the aluminum alloy MIG welder. Perform the trial welding first following the welder manufacturer's instructions, then weld properly.

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

## Mass Production Body Welding Diagram



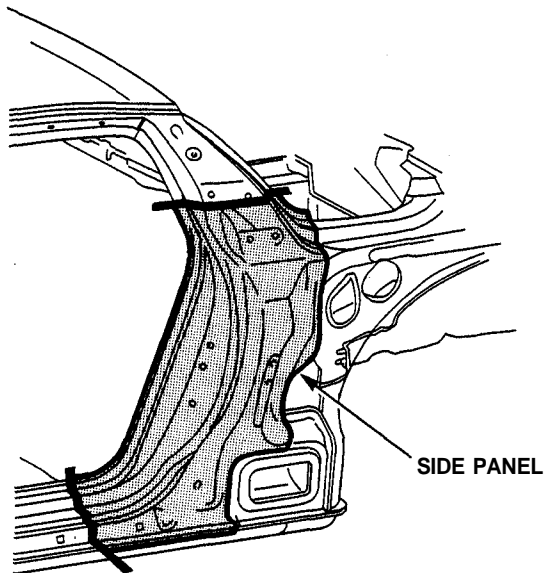
<Welding Locations>  
\* Spot Weld  
▽ Fillet Weld  
□ Slot Plug Weld

NOTE: Side panel removed (see page 4-21).

5. Cut out the bottom of the side panel, and remove it on each side.

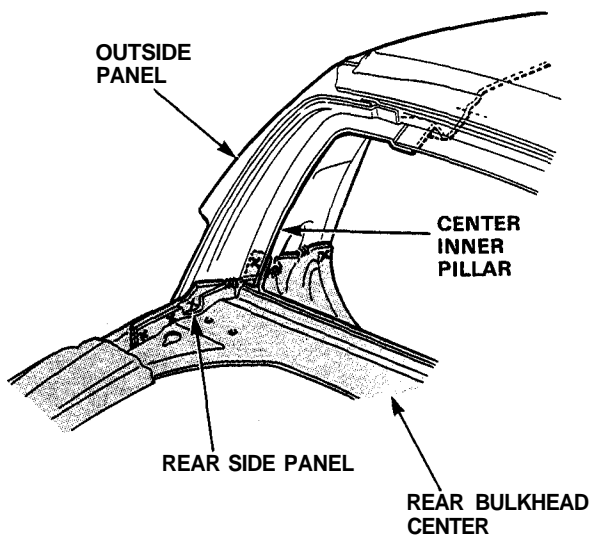
Strike a punch in the center of the spot welds of the side panel and drill the spot welds using a  $\varnothing 8$  (5/16") spot cutter.

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

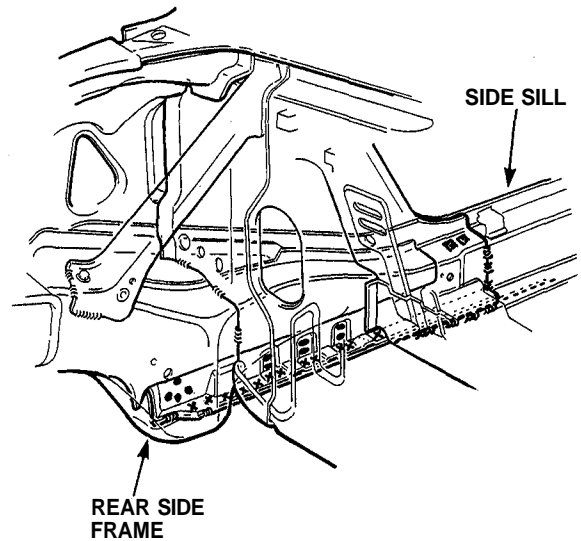


NOTE: Be careful not to cut the inner section.

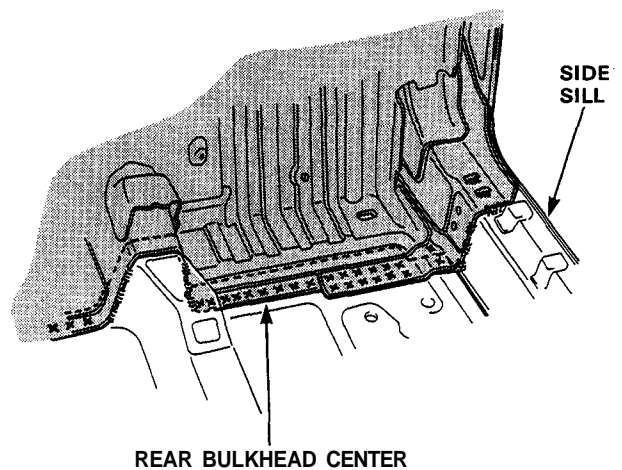
6. Remove the rear side panel and rear bulkhead center on each side.



7. Remove the rear side frame on each side.



8. Remove the rear bulkhead center.

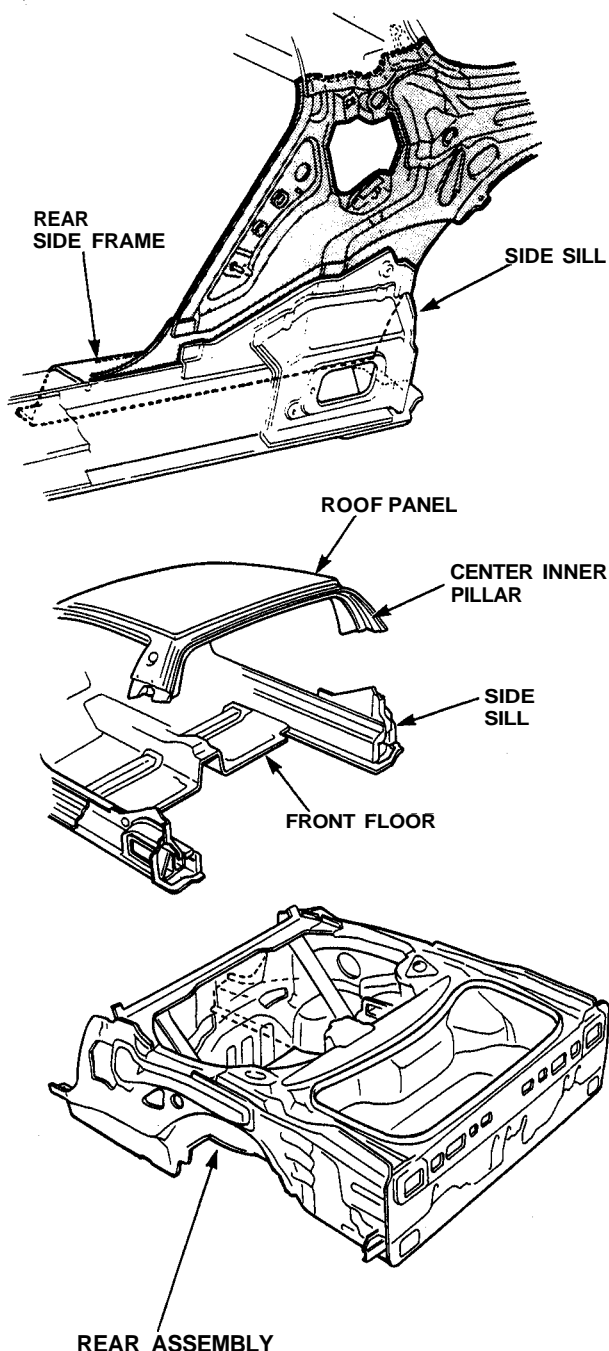


(cont'd)

# Rear Assembly Replacement (cont'd)

## 9. Remove the rear assembly.

- Remove the MIG/plug welds and fillet weld in the joint section of the rear side frame and side sill using a  $\varnothing 15$  (5/8") spot cutter (hole saw type) and rotary cutter on each side.



## 10. Mold the related parts.

- Correct the side sill and front floor using a hammer and dolly.
- Remove the burrs from the spot welds and MIG weld using a disc sander.

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

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

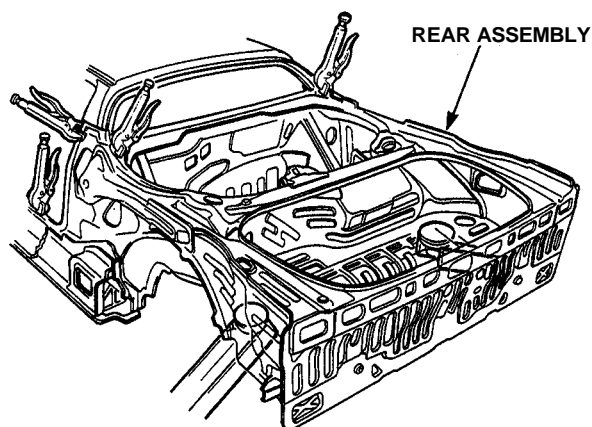
- Keep the body level.

## 11. Set the new rear assembly.

- Drill the  $\varnothing 8\text{--}\varnothing 10$  (5/16"~3/8") holes for spot welding in the welding flange.
- Remove the undercoat from the welding section of the rear assembly, 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 oil contaminations with a shop towel soaked with wax and grease remover.
- Before setting the rear assembly, remove the oxide film from the welding sections of the rear assembly and body using a stainless steel wire brush.
- Tighten the rear assembly against the side sill and center inner pillar flange using the vise-grips, pliers etc.
- Place a jack under the rear side frame on each side and support it, and measure the positions for temporarily attachment.
- Checked over the body dimensions.

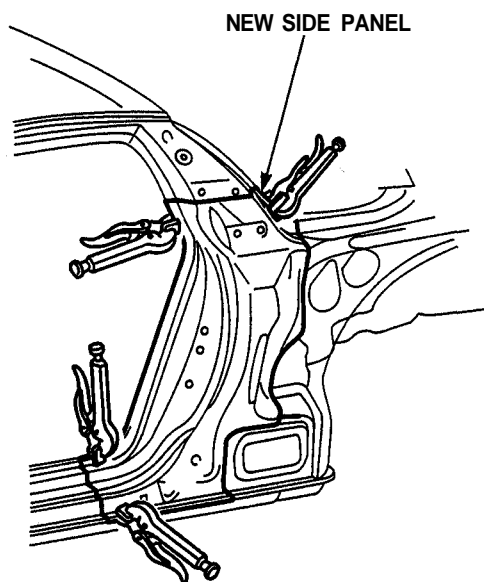


12. Temporarily install and weld the rear assembly, rear window and check for clearance and difference in level.

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

13. Set the new side panel.

- Align the new part with the top cut section, the cut it with handsaw.
- Clamp the side panel in place with vise-grips.
- Temporarily install the rear fender, rear hatch and trunk lid, and check for clearance and difference in level.

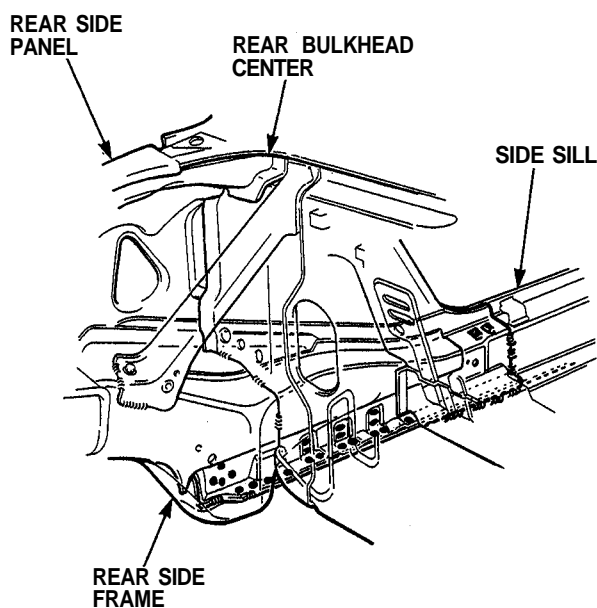
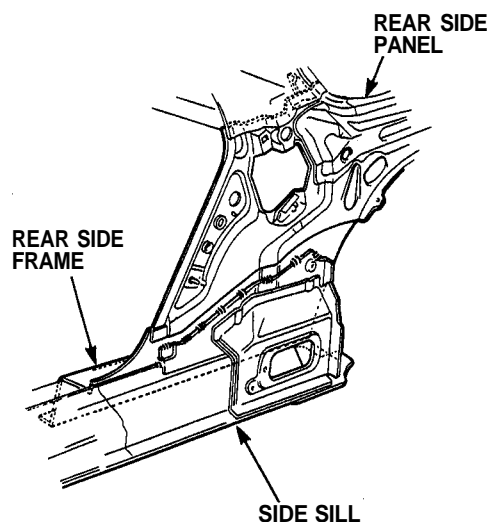


- Remove the new side panel.

14. 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 section using a stainless steel wire brush.
- 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 frame on each side.

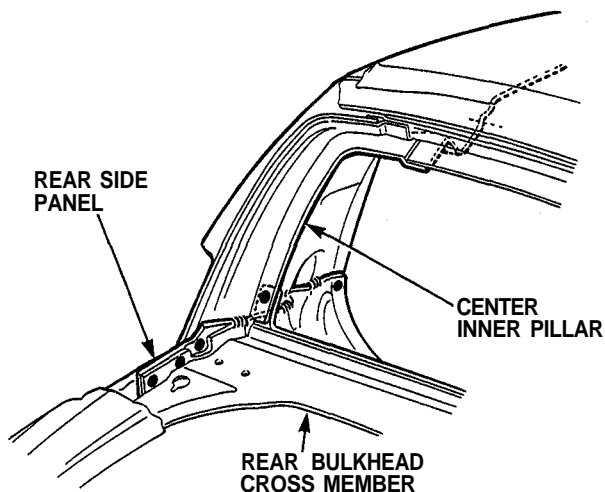


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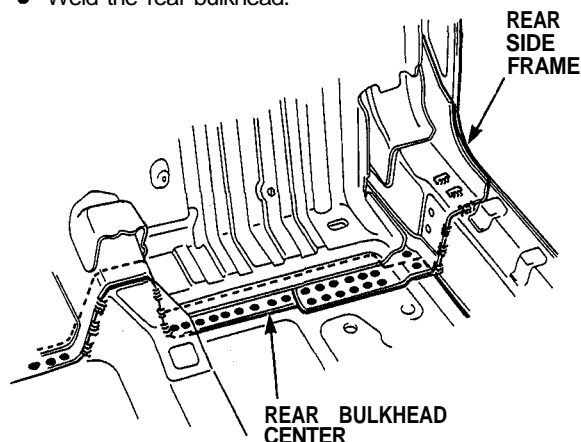
# Rear Assembly

## Replacement (cont'd)

- Weld the rear side panel and rear bulkhead cross member on each side.

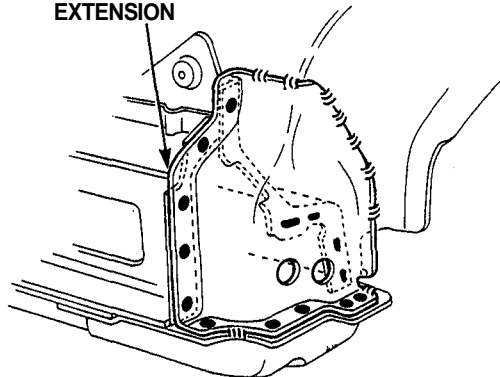


- Weld the rear bulkhead.



- Weld the rear frame lower extension on each side.

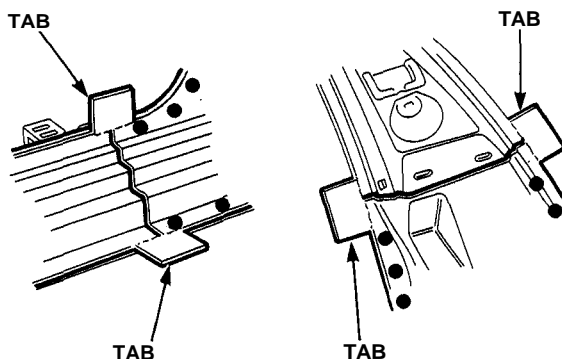
REAR FRAME LOWER EXTENSION



15. Weld the new side panel.

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

- Before welding, remove the oxide film from the welding sections using a stainless steel wire brush.
- The applicable welding methods are MIG welding, plug welding, and fillet welding.
- Attach a tab to the butt welding section as shown and weld.
- Preheating effect can be obtained by attaching a tab to the butt welding section.



16. 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.

- Finish the butt weld by removing the tab.
- 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.
- Finish the butt welded door opening of the outer panel with a disc sander and putty.

17. Apply the sealer ([see section 5](#))  
Apply sealer to each mating surface.

18. 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.

19. Apply the undercoat ([see section 7](#))  
Undercoat the front floor, etc, and apply anti-rust agent to inside of the welding section of the rear side frame, side sill and center pillars, etc.

20. Install the related parts.
- Install in the reverse order of removal.
  - Adjust the rear hatch and door strikers, and check the lock operation.

21. Check and clean
- Check the lights, etc. for proper operation.
  - Clean the passenger compartment.