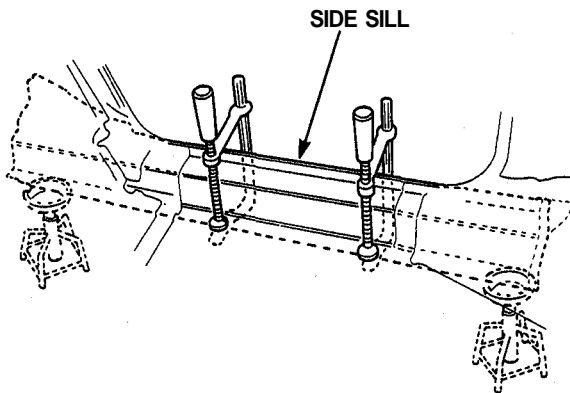


Front Floor

Replacement (cont'd)

- Clamp the front floor, side sill, dashboard lower, and rear bulkhead center with screw clamps.
- Weld the clamped sections for temporary installation.

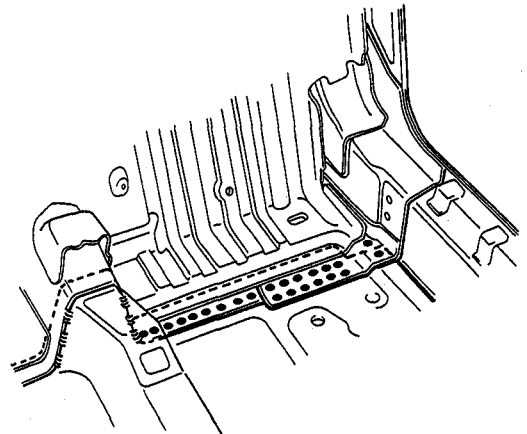
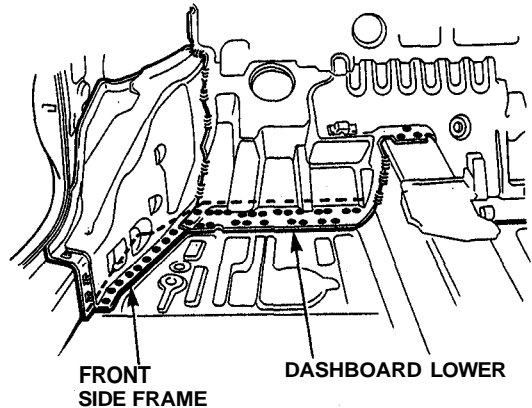
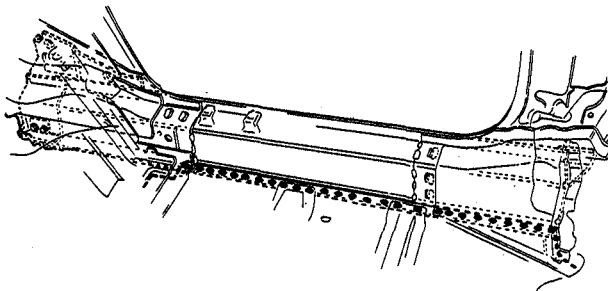
⚠ WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.



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



5. Finish the welding area.

- Roughly grind the welds using 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.

6. Apply the sealer ([see section 7](#)).
Apply sealer to the mating surface with the front floor.

7. 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.
8. Apply the undercoat ([see section 5](#)).
Undercoat the front floor, etc. and apply anti-rust agent to the inside of the welding section of the front side sill, side frame and dashboard lower.
9. Install the related parts .
10. Check and clean.
- Check the seats for movement.
 - Perform the brake test.
 - Clean the passenger compartment.

Front Assembly

Description

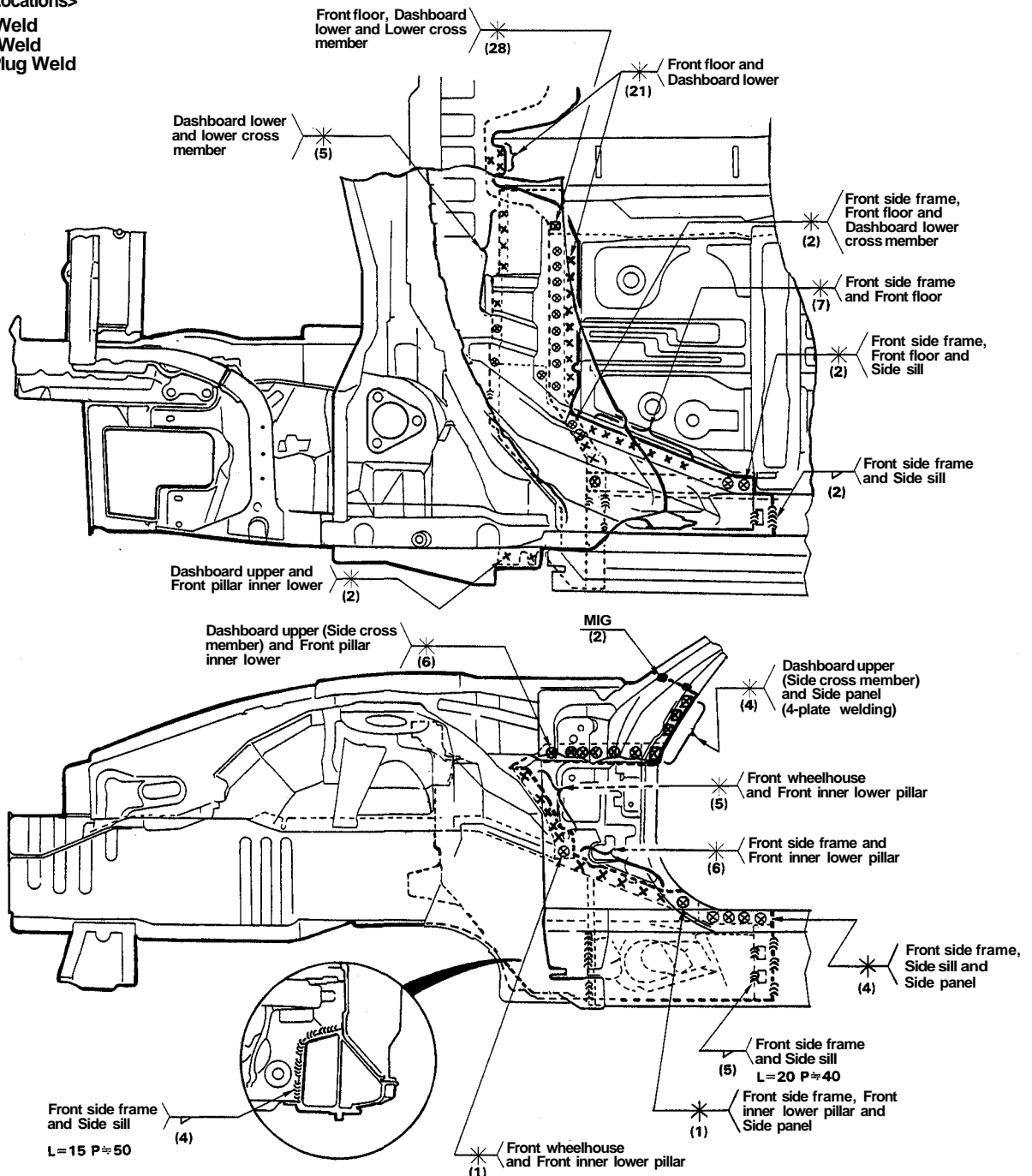
The front assembly is critical for the rigidity of the front compartment and front wheel alignment, as it is integrated with the front wheelhouse. During installation, the dimension shown in the body dimensional drawings. Welding must be performed by using the aluminum alloy MIG welder. Perform the trial welding first following the welder manufacturer's instructions, then weld properly.

NOTE: Do not section frame rails except at manufacturers seams.

Mass Production Body Welding Diagram

<Welding Locations>

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



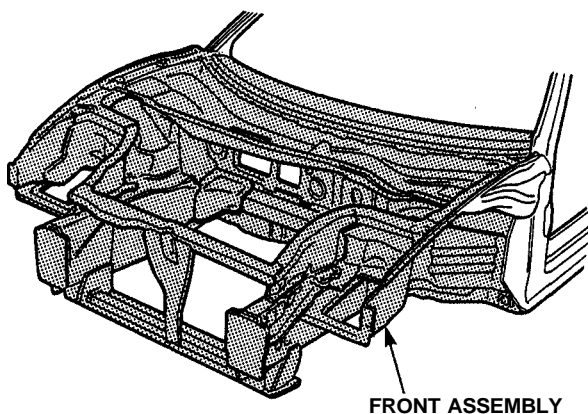
Replacement

1. Remove the related parts.
 - Front suspension related parts
 - Brake hoses and pipes
 - Front compartment electrical components
 - Fittings in passenger compartment, etc.
 - Windshield
 - Steering column
 - Windshield
2. Pull out and straighten the damaged area.
 - 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 flanges.

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

- To protect the car body from damage, place a piece of aluminum plate on each clamping section and tighten the clamps.
- Before cutting off the damaged sections, pull them out so that they are restored to the original shape.
- Cutting off front assembly before roughly pulling out the damage makes repair of the related front floor, front pillar, and other related parts difficult.
- It might be necessary to heat the damaged sections with an acetylene torch before pulling the them out (see page 2-31).

NOTE: Pull out until the pillar is lined up with the surface of the windshield.

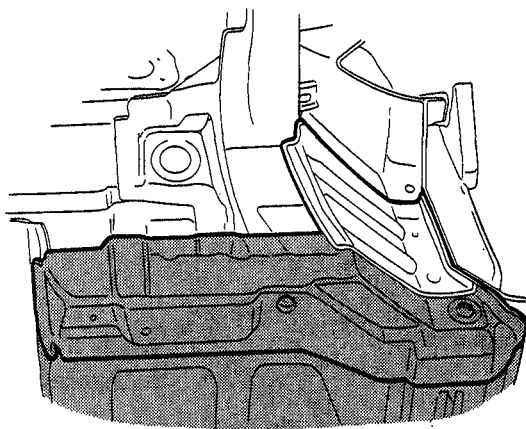


- After pulling, check the damper housing and the side frame positions using the body dimensional drawings (see section 6).

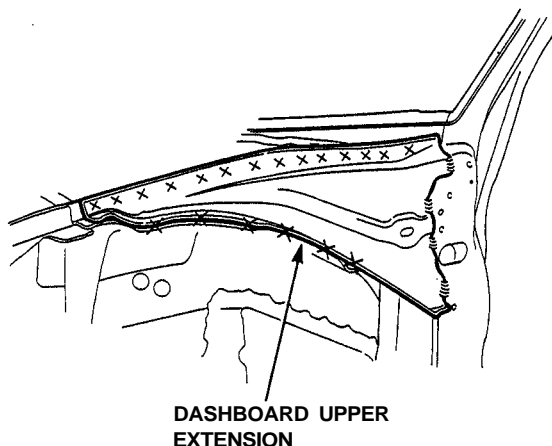
3. Peel off the undercoat.

Heat the undercoat at the weld areas of the lower dashboard, front floor and side sill with a gas torch and peel off with a metal spatula.

CAUTION: Be careful not to burn the fittings inside the passenger compartment when heating.



4. Remove the dashboard upper extension on each side.

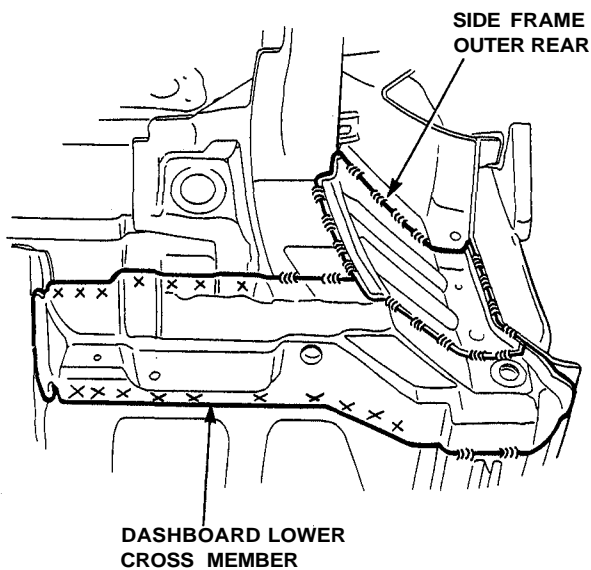
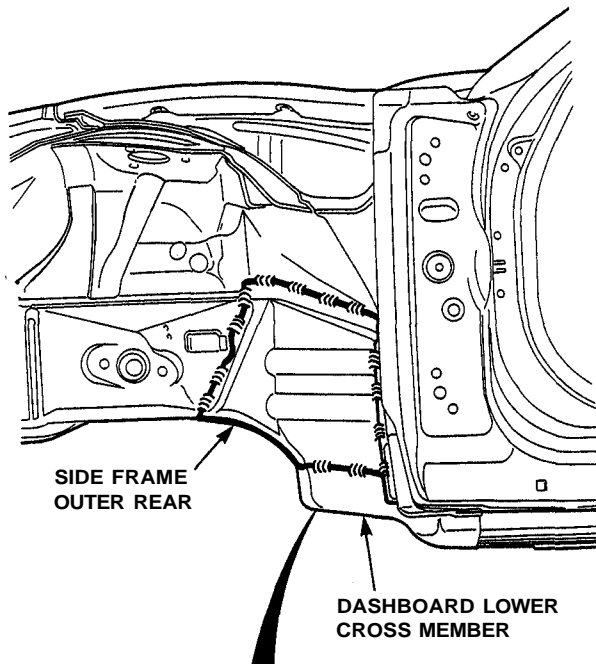


(cont'd)

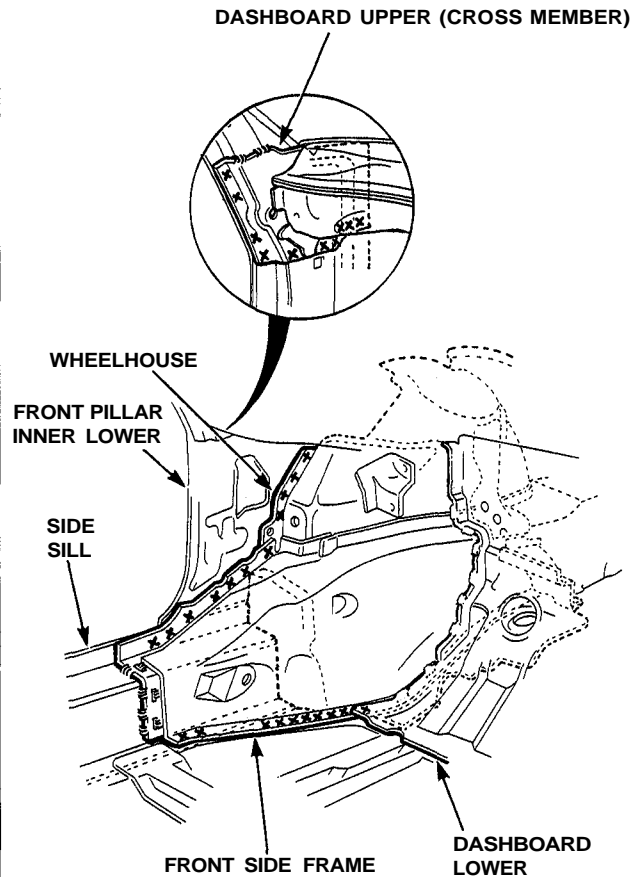
Front Assembly

Replacement (cont'd)

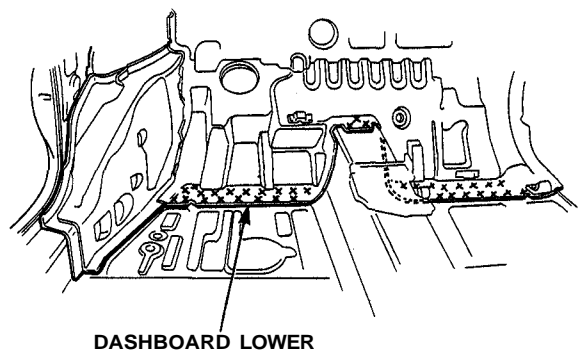
5. Remove the side frame outer rear and dashboard lower cross member on each side.



6. Remove the dashboard upper (side cross member) on each side.
7. Remove the wheelhouse and side frame on each side.



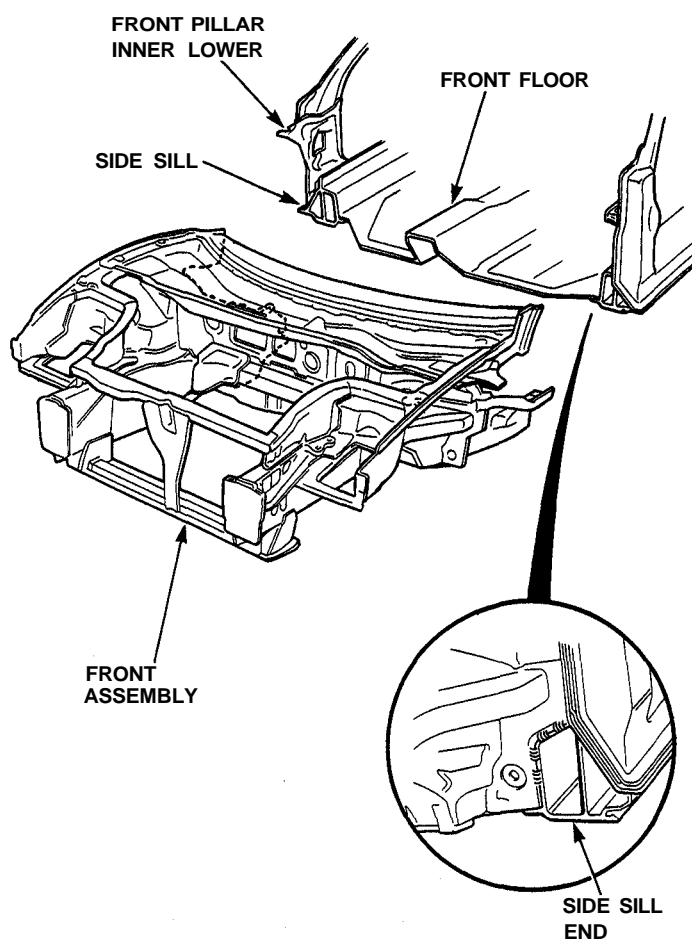
8. Remove the dashboard lower.



9. Remove the front assembly.

- Grind the fillet welds of the side frame-and-side sill joint using a rotary cutter as shown.
- Peel off the welding flange using the chisel.
- Remove the burrs from the drilled sections with a disc grinder or disc sander.

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



10. Mold the related parts.

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

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

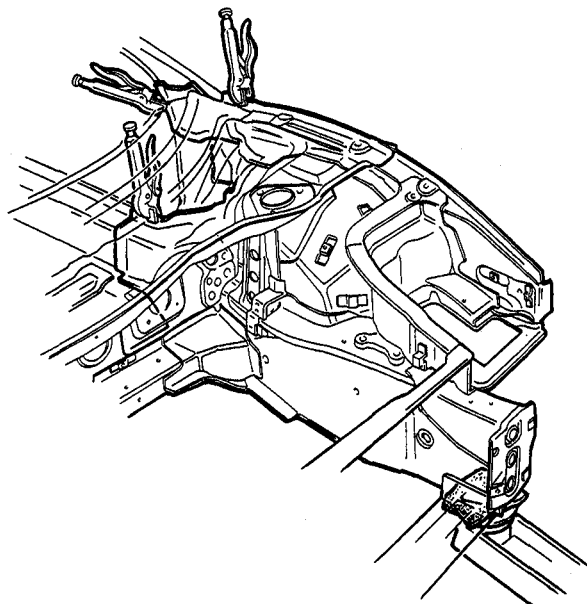
- Keep the body level.

11. Set the new front assembly.

- Drill the $\varnothing 8\sim\varnothing 10$ (5/16"~3/8") holes for spot welding in the welding flange.
- 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 assembly, remove the oxide film from the welding surface of the replacement part and body using a stainless steel wire brush.



- Tighten the front assembly against the front pillar and side sill using the vise-grips, pliers, etc.
- Place a jack under the front side frame end on each side and support it, and measure the positions for temporary attachment.
- Check over the body dimensions.

(cont'd)

Front Assembly

Replacement (cont'd)

12. MIG weld the several points in the clamped sections and temporarily fix the front assembly.

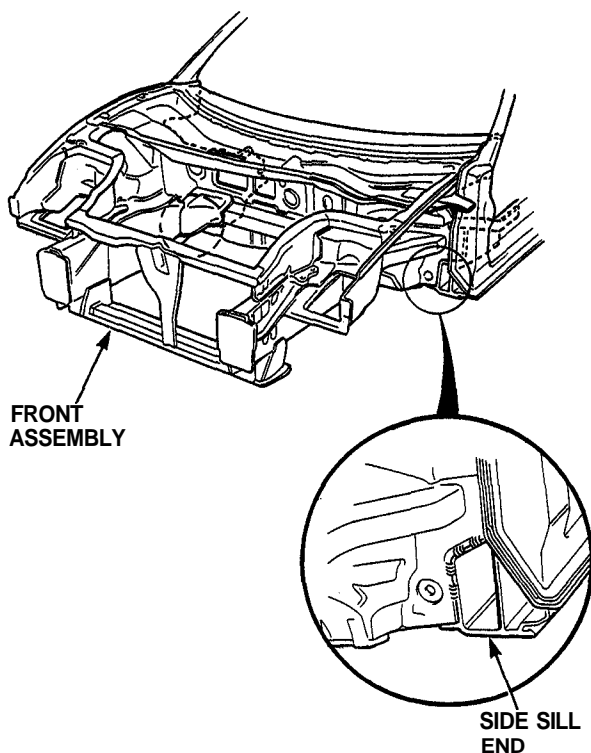
⚠ WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

- Measure the dimension, temporarily install the hood and fender, and check for difference in level and clearance.
- Install the windshield and check for proper installation and alignment.

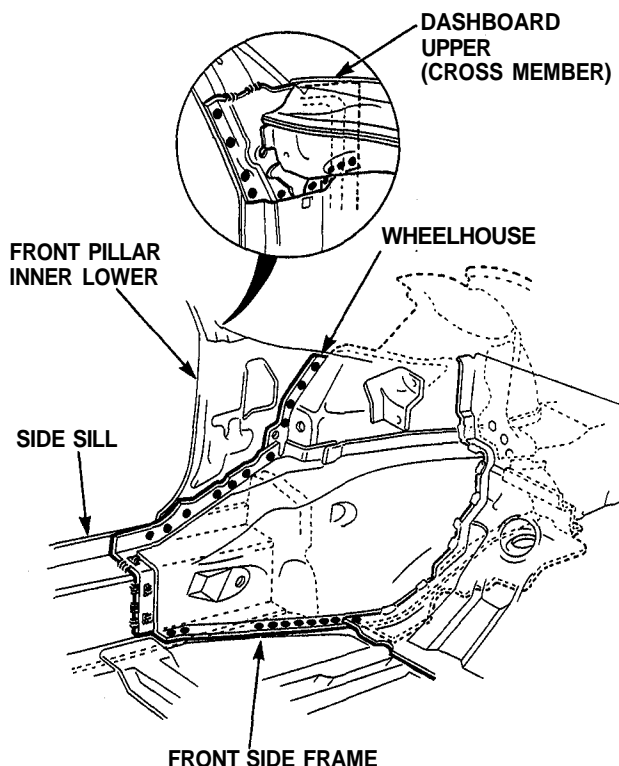
13. Perform the main welding.

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

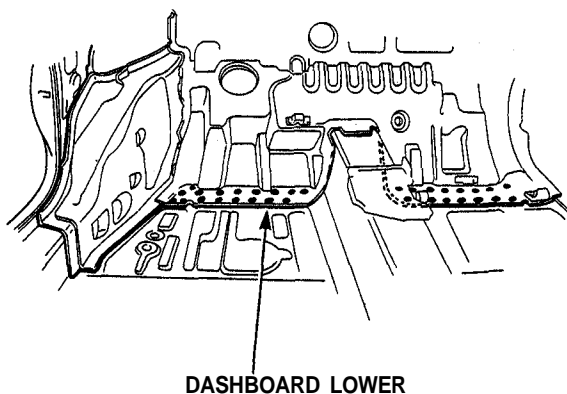
- Before welding, perform the trial welding following the welder manufacturer's instructions.
- Clean the welding section with a stainless steel wire brush before welding.
- The applicable welding methods in this step shall be the MIG welding, plug welding, and fillet welding.
- Check the welding section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



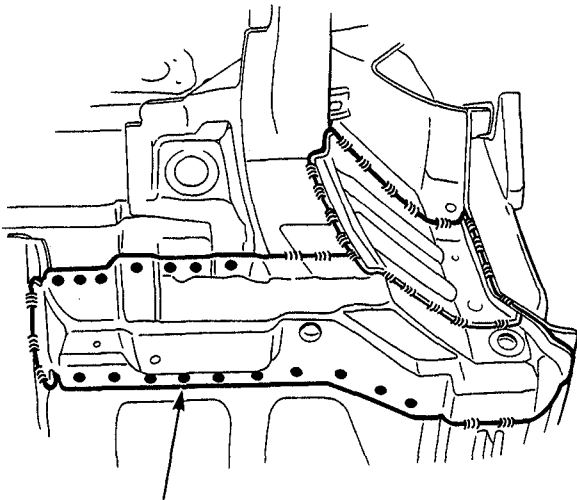
- Weld the dashboard upper (cross member) on each side.
- Weld the side frame and wheelhouse on each side.



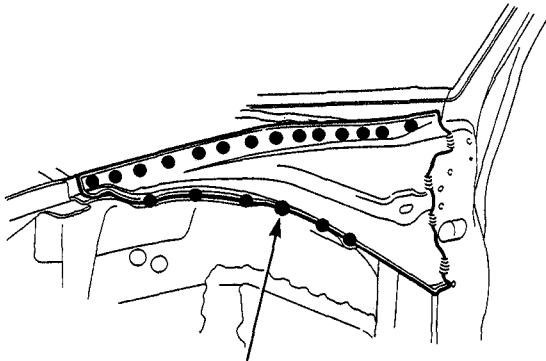
- Weld the dashboard lower.



14. Install and weld the related parts on each side.



DASHBOARD LOWER
CROSS MEMBER



DASHBOARD UPPER
EXTENSION

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

15. Apply the sealer (see section 5).

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

16. 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.

17. 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.

18. Install the related parts.

Install in the reverse order in which they were removed.

19. Inspect, check and make adjustment.

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