

Replacement

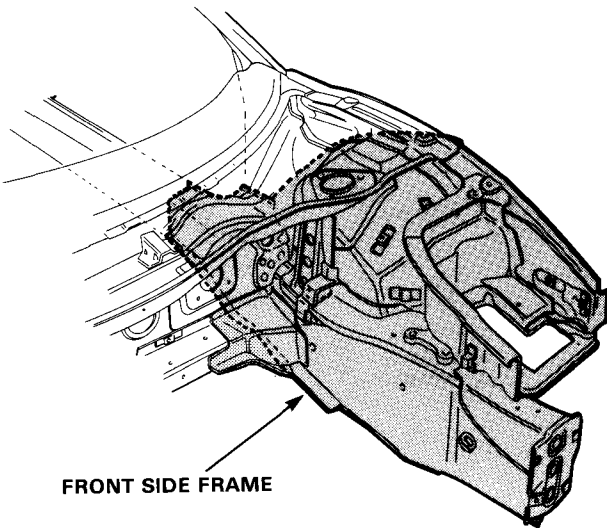
1. Remove the related parts.
 - Front suspension related parts
 - Brake hoses and pipes
 - Front compartment electrical components
 - Fittings in passenger compartment, etc.

NOTE: With the front bulkhead upper frame and lower cross member removed:

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/NSX-T 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.
- Removing the front side frame before roughly pulling out the damage makes repair of the related front floor, dashboard lower, and other related parts difficult.
- It might be necessary to heat the damaged sections with an acetylene torch before pulling them out (see page 2-31).



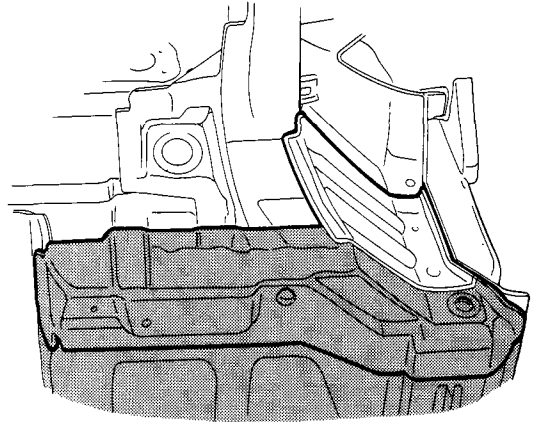
FRONT SIDE FRAME

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

3. Peel off the undercoat.

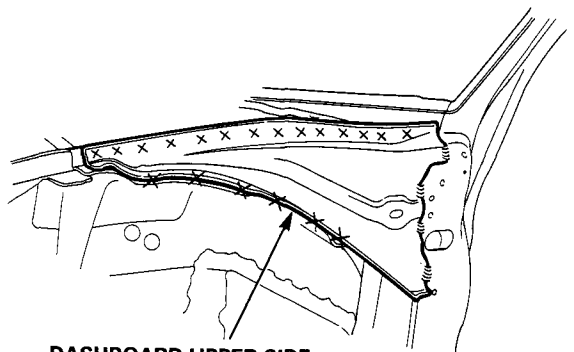
Heat the undercoat at the weld areas of the lower dashboard, from floor and side sill with a gas torch and peel off with a metal spatula.

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



4. Remove the dashboard upper side extension.
 - Strike a punch in the center of the spot welds to the wheelhouse.
 - Drill the spot welds of the dashboard upper side extension using a 10 mm (3/8") spot cutter.
 - Grind the MIG weld (fillet weld) to the front pillar using a rotary cutter.

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



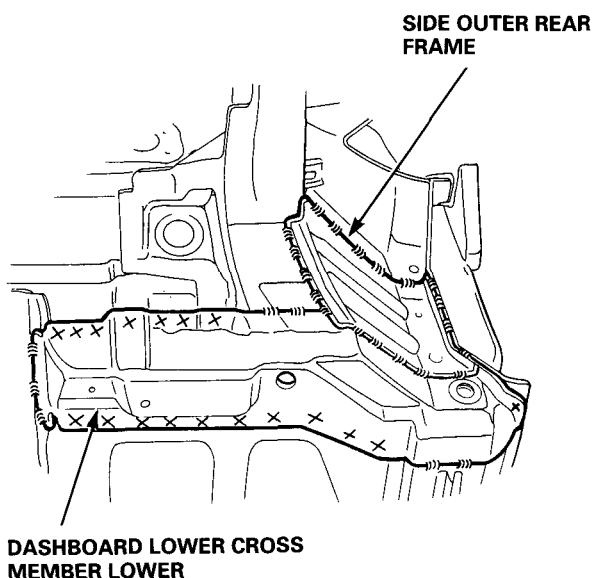
DASHBOARD UPPER SIDE
EXTENSION

(cont'd)

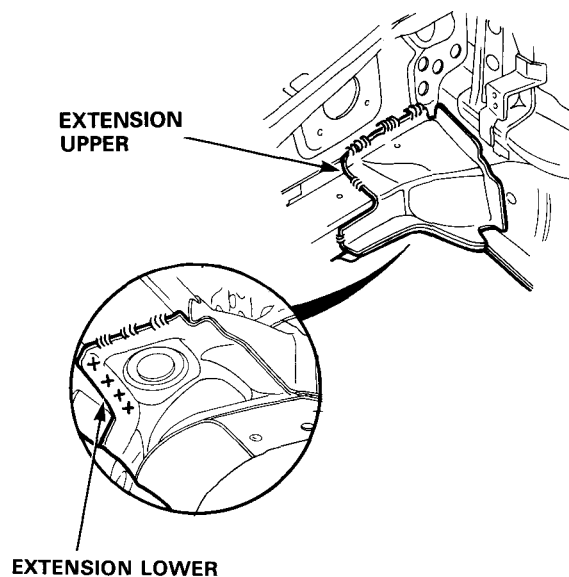
Front Side Frame

Replacement (cont'd)

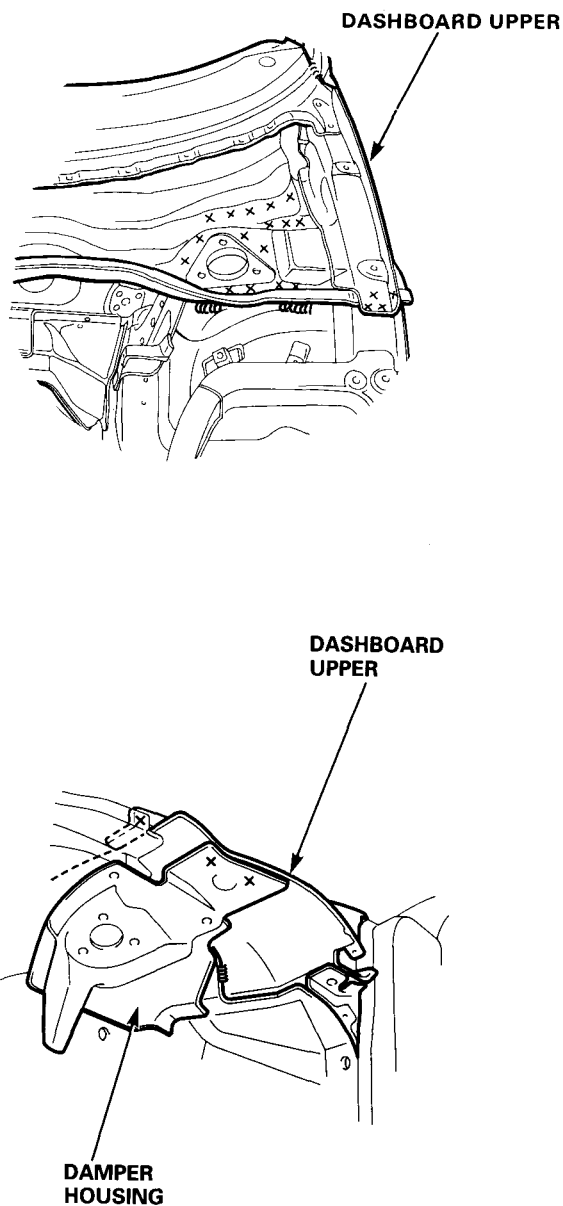
5. Remove the side outer rear frame and dashboard lower cross member lower.
- Grind the fillet welds of the side outer rear frame with a rotary cutter.
 - Drill the spot welds of the dashboard lower cross member lower using a spot cutter.
 - Remove the side outer rear frame and lower cross member lower using a chisel.



6. Remove the spot welds and fillet welds of the dashboard lower-dashboards lower cross member extension upper-extension upper with a spot cutter and rotary cutter.



7. Remove the spot welds and fillet welds of the dashboard upper-and-damper housing.

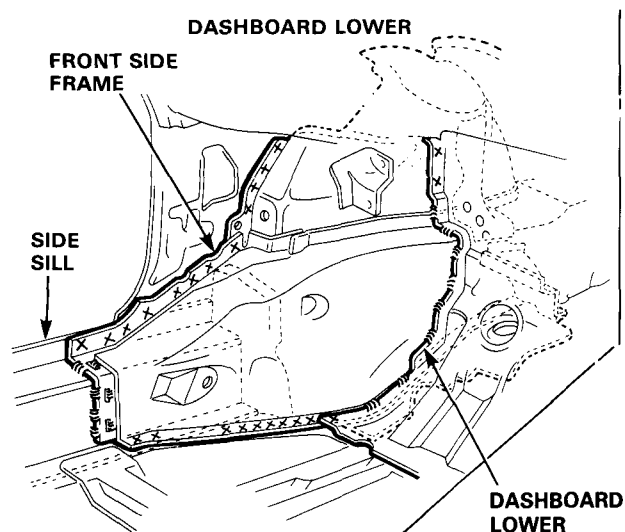


8. Remove the front side frame.

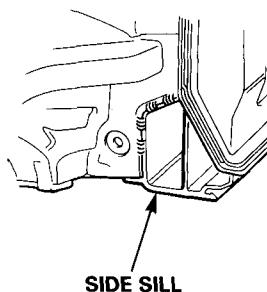
- Strike a center punch around the spot weld imprints with the dashboard upper, dashboard lower and front floor.
- Drill the MIG welds (plug welding) using a 15 mm (5/8") spot cutter (hole saw type).
- Drill the spot welds using a 10 mm (3/8") spot cutter.
- Grind the fillet welds of the side frame-and-side 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.

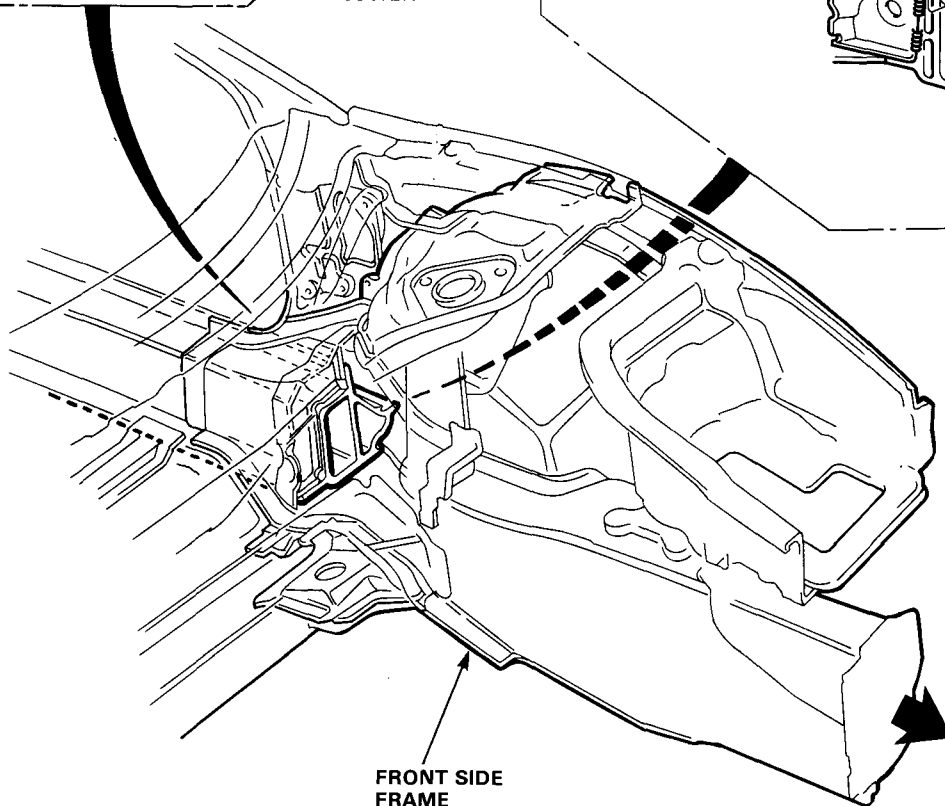
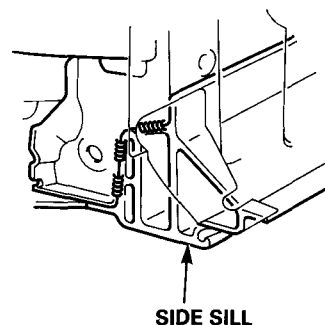
⚠ WARNING To prevent eye injury, wear goggles or safety glasses whenever sanding, cutting or grinding.



Coupe:



NSX-T (open top):



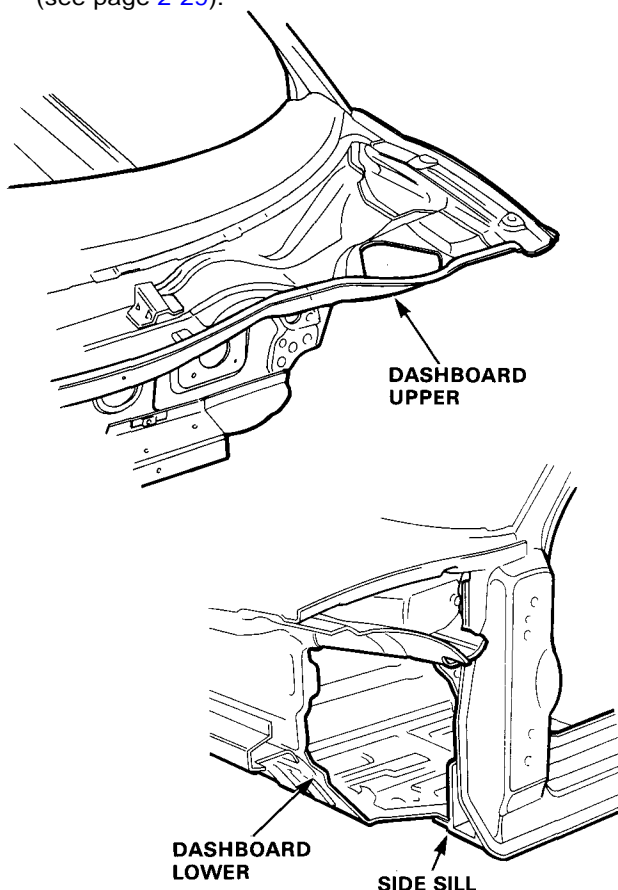
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Front Side Frame Replacement (cont'd)

9. 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).



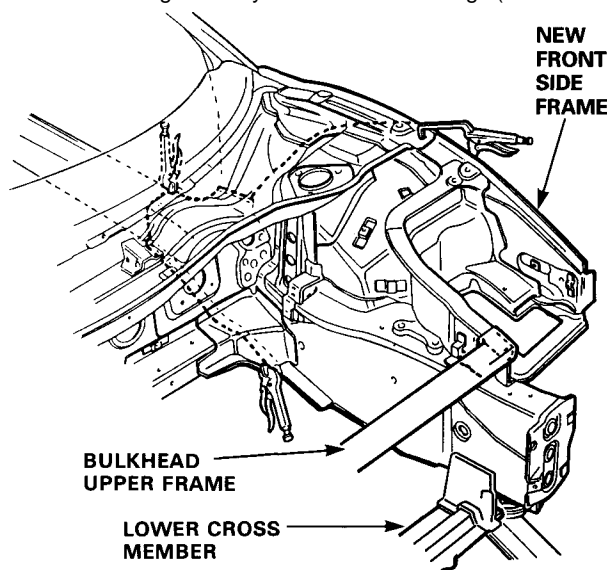
10. Set the new front side frame.

- Drill the 10 mm (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.

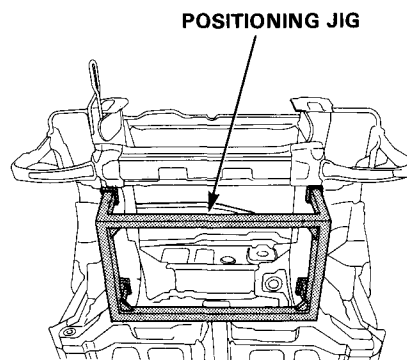
⚠ WARNING To prevent eye injury, wear goggles or safety glasses whenever sanding, cutting or grinding.

- 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 (see section 6).



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



11. 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.

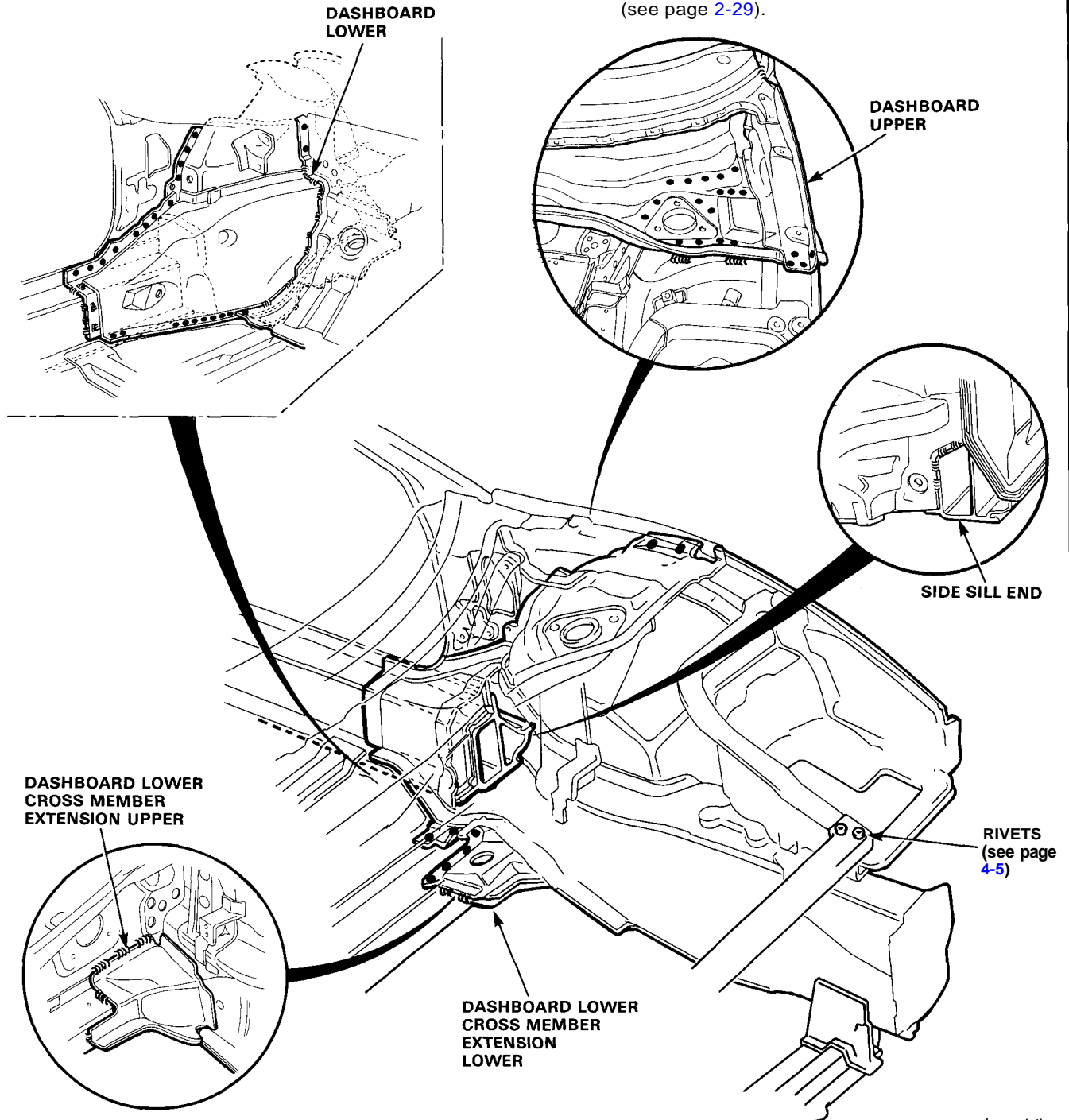
12. Measure the dimension, temporarily install the hood and fender, and check for difference in level and clearance.

13. Perform the main welding.

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

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- 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).



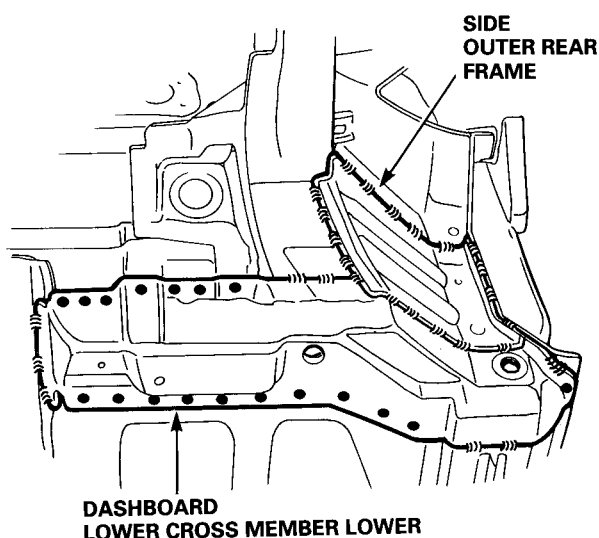
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Front Side Frame Replacement(cont'd)

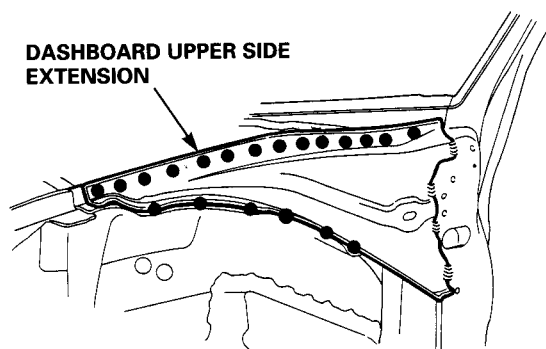
14. Install and weld the related parts.

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

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



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



- 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.