

Replacement

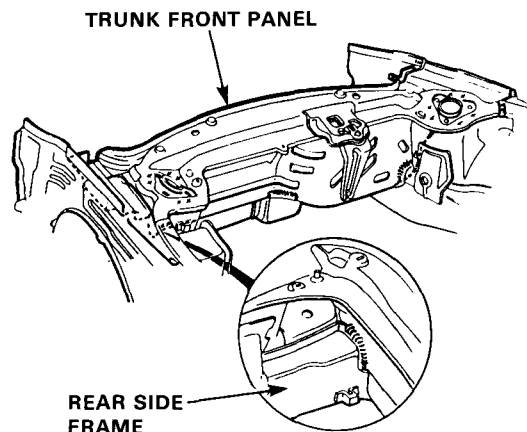
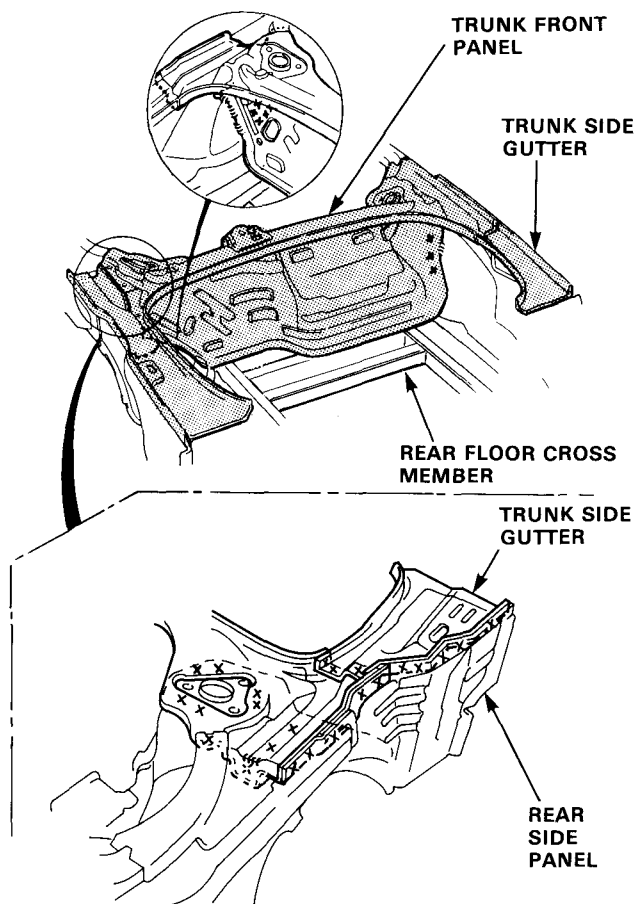
1. Remove the related parts.
 - Rear suspension assembly
 - Engine assembly
 - Trunk lid
 - Harnesses
 - Others

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 10 mm (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 8~10 mm (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.

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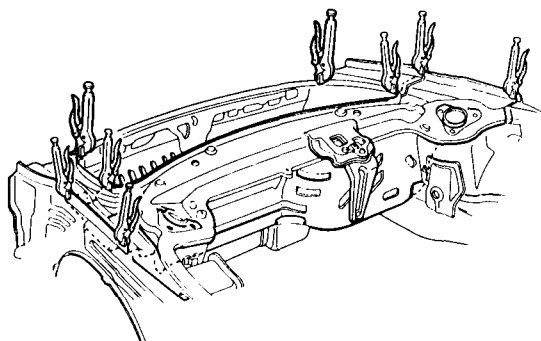
- Remove the paint film from the welding section of the body using a disc sander and clean oil contamination with a shop towel soaked with wax and grease remover.
- Before setting the trunk front panel and trunk side gutter, remove the oxide film from the welding section of the trunk front panel and trunk side gutter, and body using a stainless steel wire brush.

(cont'd)

Trunk Front Panel

Replacement (cont'd)

- 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.



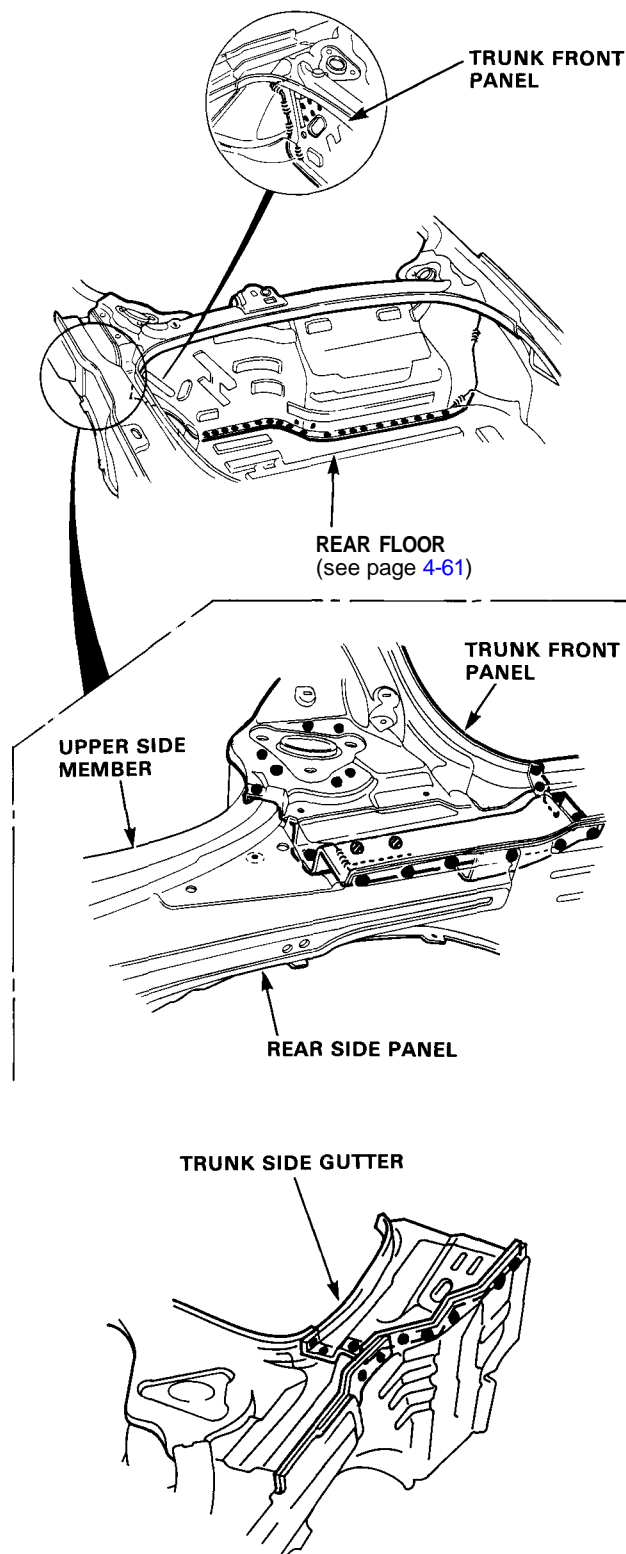
- Set the rear floor and rear panel (see pages 4-58, 4-61).
 - Check the trunk front panel position using the body dimensional drawings (see section 6).
5. Tack weld the trunk front panel and trunk side gutter.

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

- 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).



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.

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- 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.