

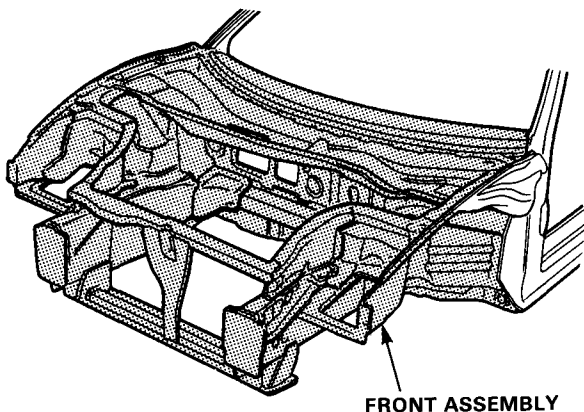
Replacement

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/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.
- 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 them out (see page 2-31).

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



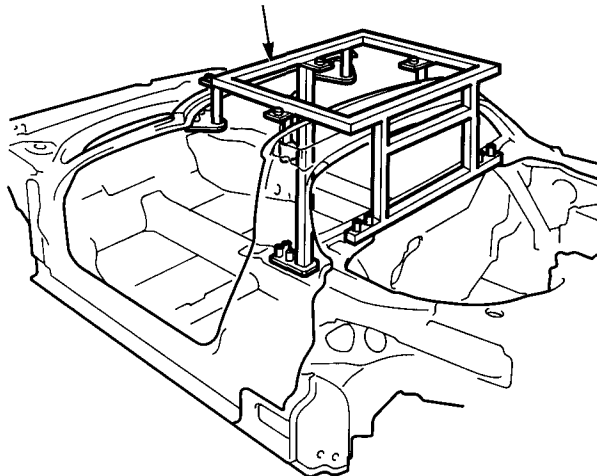
- After pulling, check the damper housing and the side frame positions using the body dimensional drawings (see section 6).

NSX-T (opentop):

NOTE: Use of a roof panel positioning jig is recommended

- Install the roof panel positioning jig as shown.
- Check for horizontal alignment of the jig with a water level.

ROOF PANEL POSITIONING JIG

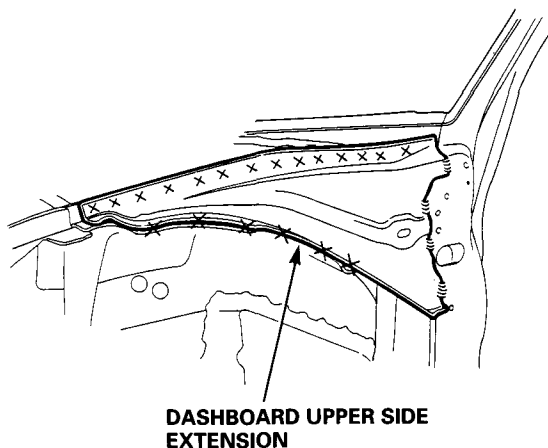


3. Peel off the undercoat.

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 side extension on each side.

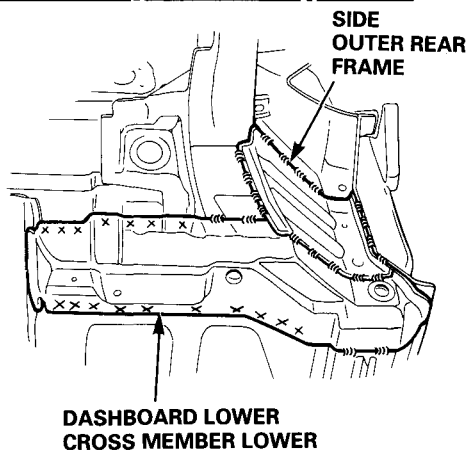
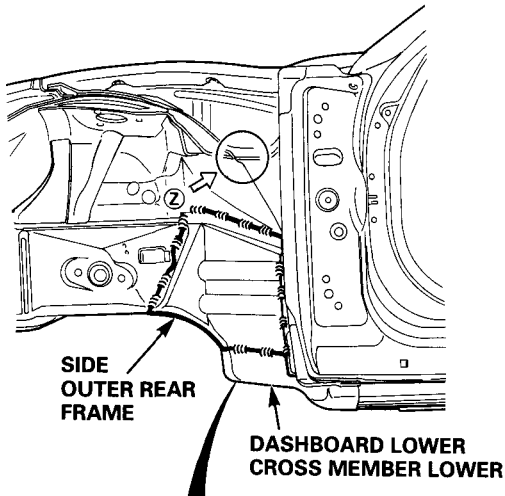


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Front Assembly

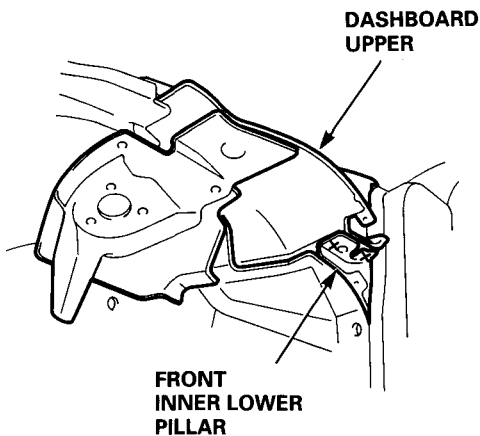
Replacement (cont'd)

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



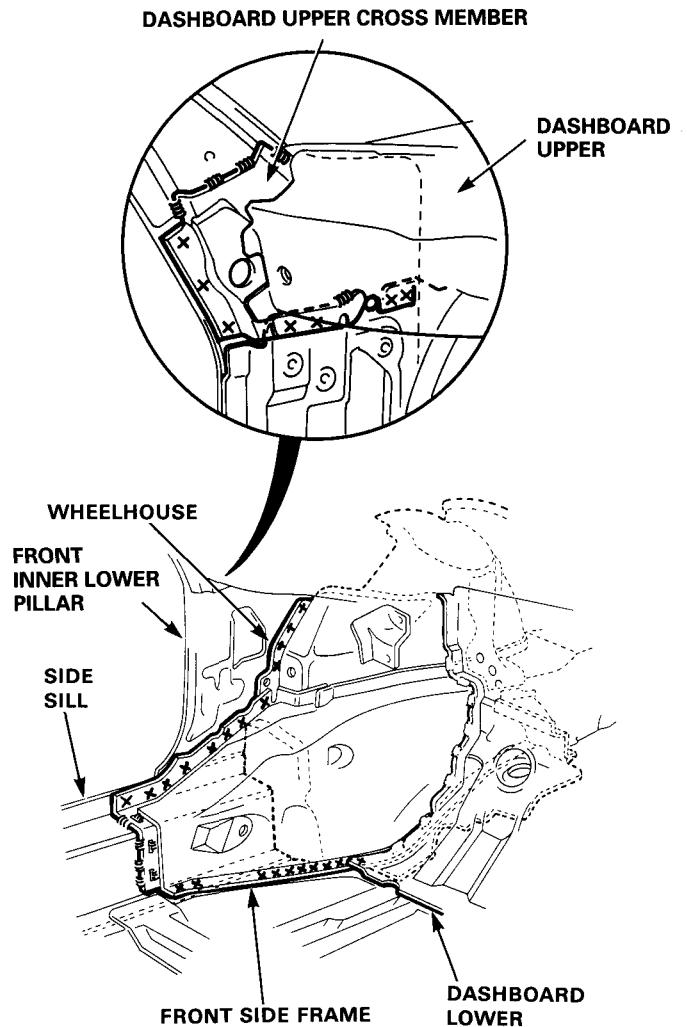
VIEW ②

- Remove the front inner lower pillar on each side.

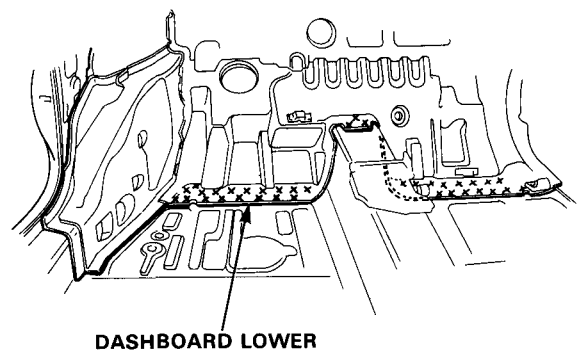


6. Remove the dashboard upper side cross member on each side.

7. Remove the wheelhouse and side frame on each side.



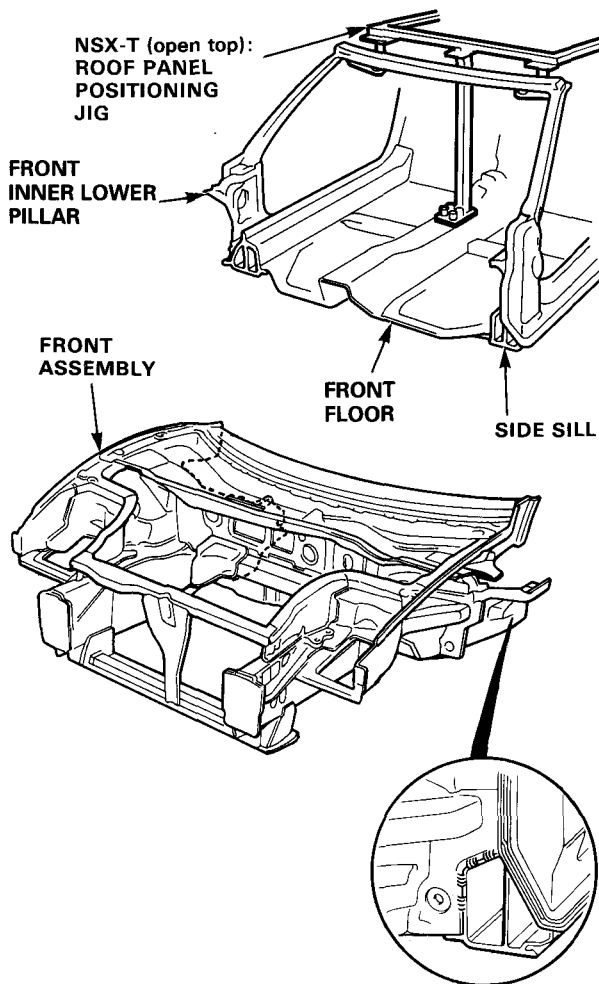
8. Remove the dashboard lower.



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).

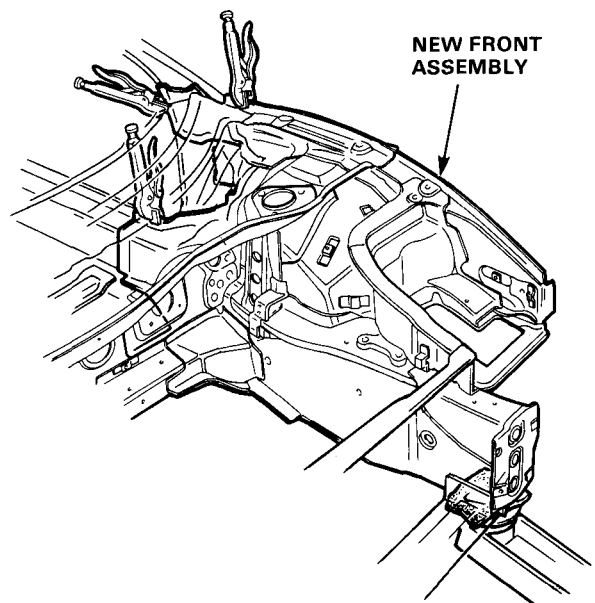
- Keep the body level.

11. Set the new front assembly.

- Drill the 8~10 mm (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 spots 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.

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Front Assembly

Replacement (cont'd)

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

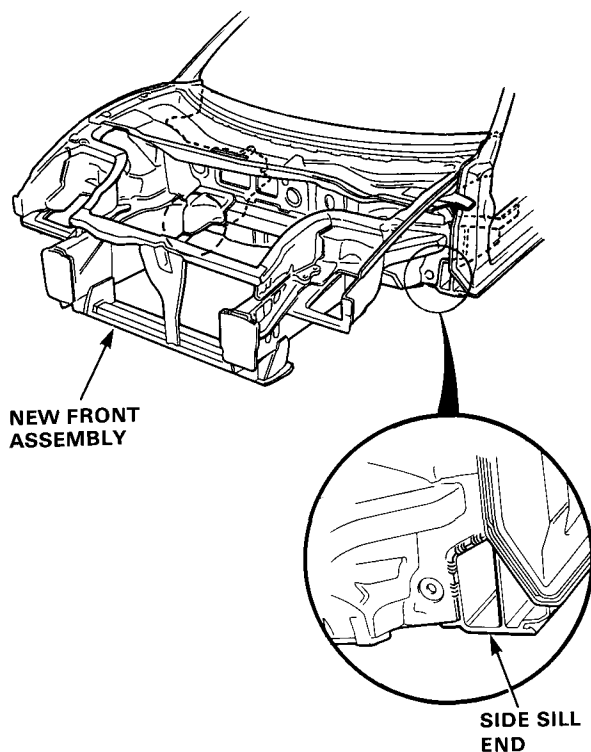
⚠ WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

- 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.

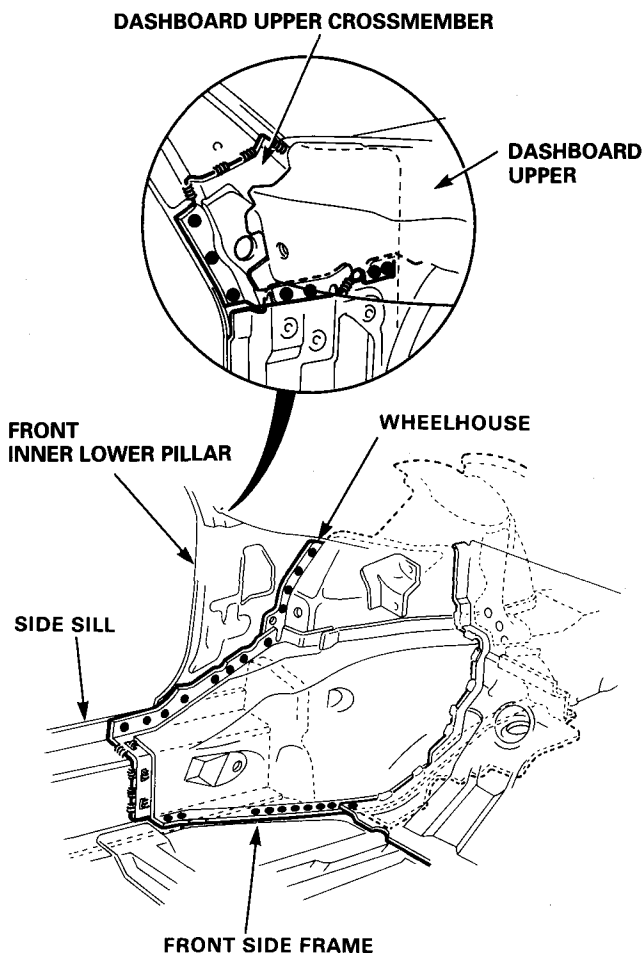
13. Perform the main welding.

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

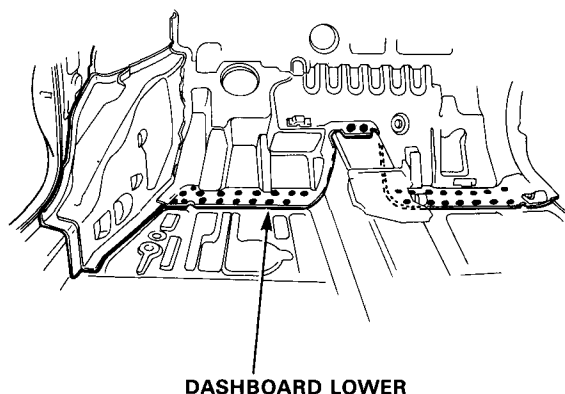
- Before welding, perform the trial welding following the welder manufacturer's instructions.
- Clean the welding section with a stainless steel wire brush before welding.
- The applicable welding methods in this step shall be the MIG welding, plug welding, and fillet welding.
- Check the welding section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



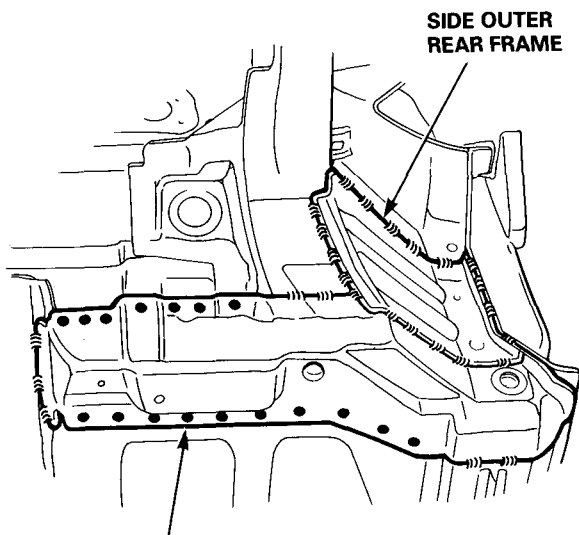
- Weld the dashboard upper (cross member) on each side.
- Weld the side frame and wheelhouse on each side.



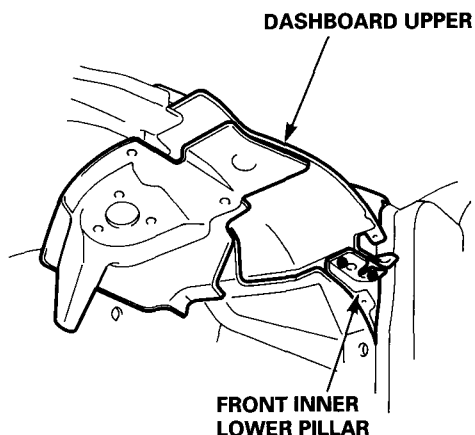
- Weld the dashboard lower.



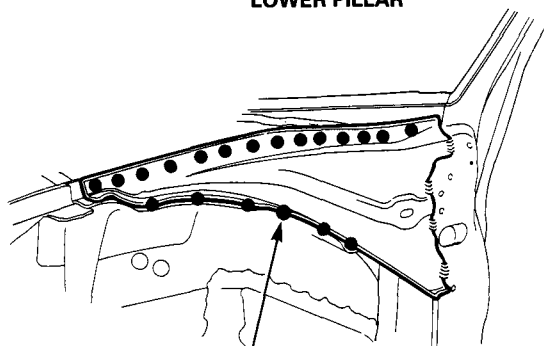
14. Install and weld the related parts on each side.



**DASHBOARD LOWER
CROSS MEMBER LOWER**



**FRONT INNER
LOWER PILLAR**



**DASHBOARD UPPER SIDE
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.

NSX-T (open top):

- Set the roof panel, then secure the roof panel by turning the roof side lock handles.
- Adjust the roof panel for a flush fit with the roof rail.
- Make sure the roof side locks are locked securely.
- Check for water leaks.

NOTE: Refer to the NSX/NSX-T Service Manual (see [section 20](#)) for roof.