

Replacement

1. Remove the related parts:

- Door
- Door opening trim
- Carpet
- Door switch
- Seat belt
- Side sill panel
- Windshield
- Rear hatch assembly
- Rear window
- Headliner
- Front fender
- Rear fender
- Dashboard

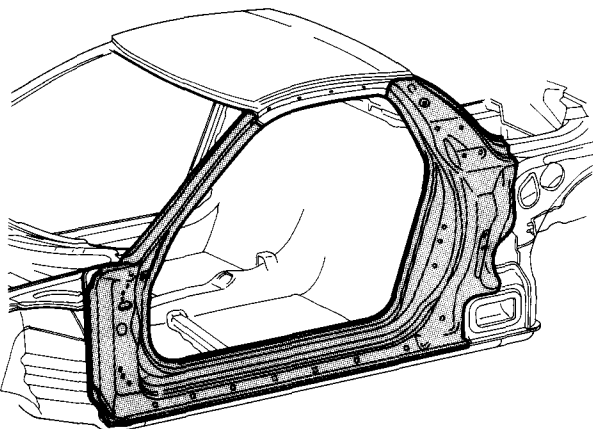
2. Pull out and straighten the damaged area.

NOTE: Make sure that the right and left pillars are parallel to the windshield surface.

- Check the door and rear hatch for proper opening and closing.
- 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 flange.

NOTE: Refer to the NSX/NSX-T Service Manual for safety sand location points.

- To protect the car body from damage, place a piece of aluminum plate on each clamping section and tighten the clamps.
- Before removing the side panel, pull out the damaged sections so that they are restored to the original shape.
- Before pulling out the damaged sections, it might be necessary to heat them with an acetylene torch (see page 2-31).



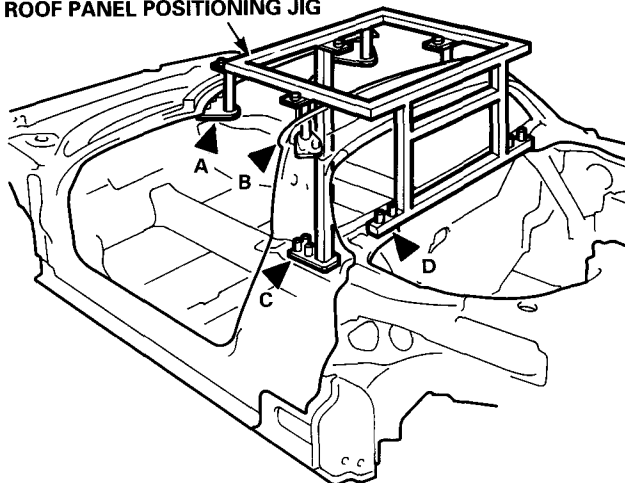
- After pulling, check the door, windshield and rear window opening using the body dimensional drawings (see section 6).

NSX-T (open top):

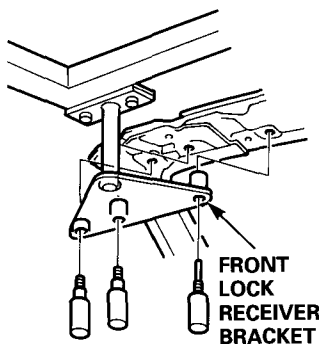
NOTE: Use of a roof panel positioning jig is recommended.

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

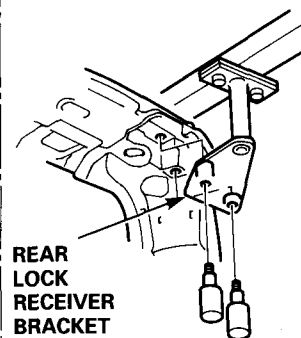
ROOF PANEL POSITIONING JIG



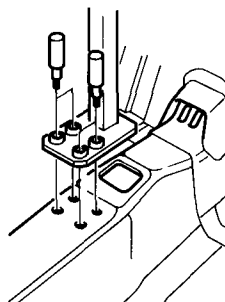
A ► location:



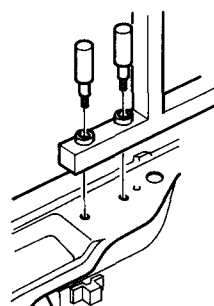
B ► location:



C ► location:



D ► location:

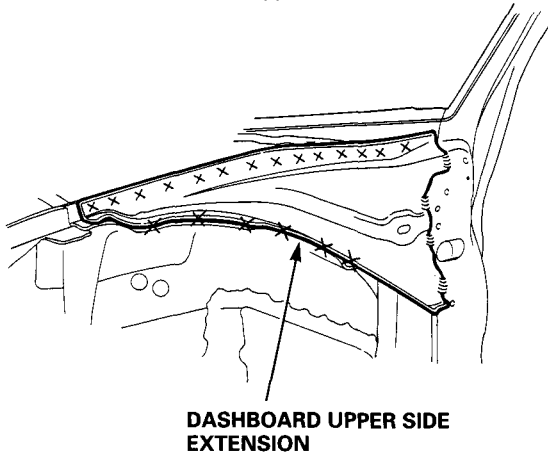


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Side panel

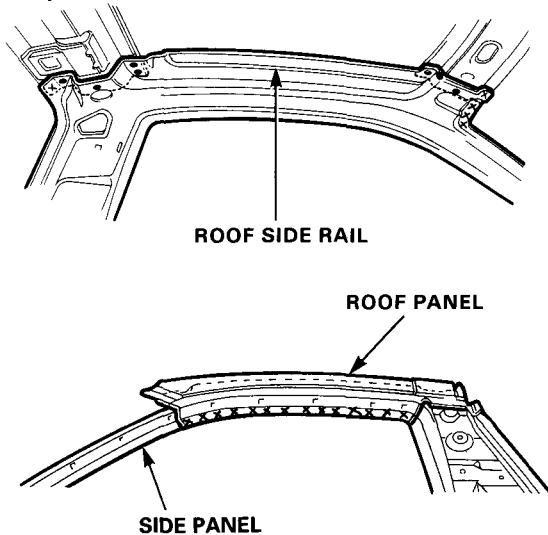
Replacement (cont'd)

3. Remove the dashboard upper side extension.

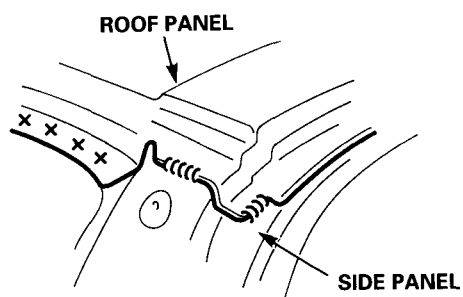


4. Remove the side panel.
 - Strike a punch in the center of the spot welds to the roof side rail, front roof rail, rear roof rail and roof panel.
 - Drill the spot welds using a 10 mm (3/8") spot cutter.

Coupe:

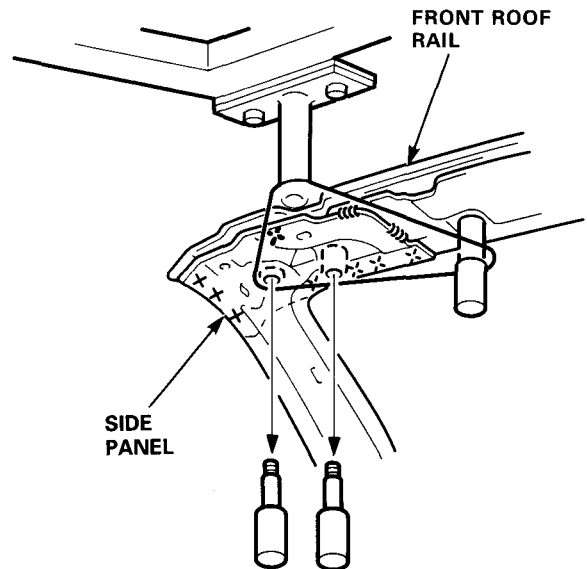


- Grind the fillet welds of the side panel and roof panel skin joint using a rotary cutter.

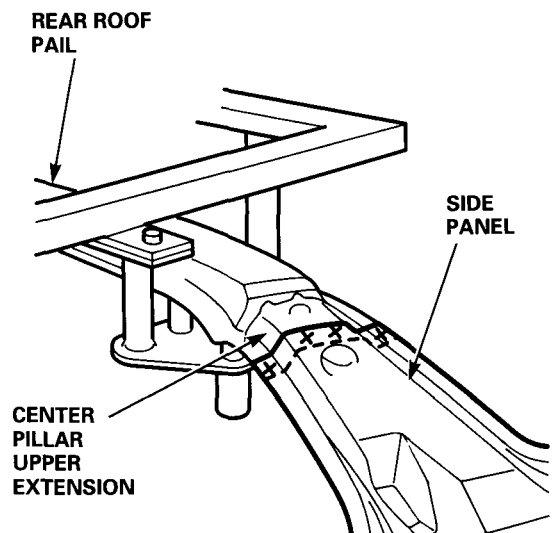


NSX-T (open top):

- Strike a punch in the center of the spot welds to the side panel and front roof rail.



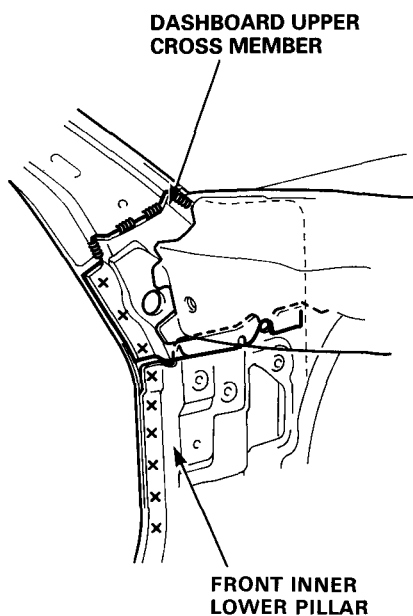
- Strike a punch in the center of the spot welds to the side panel and center pillar upper extension.



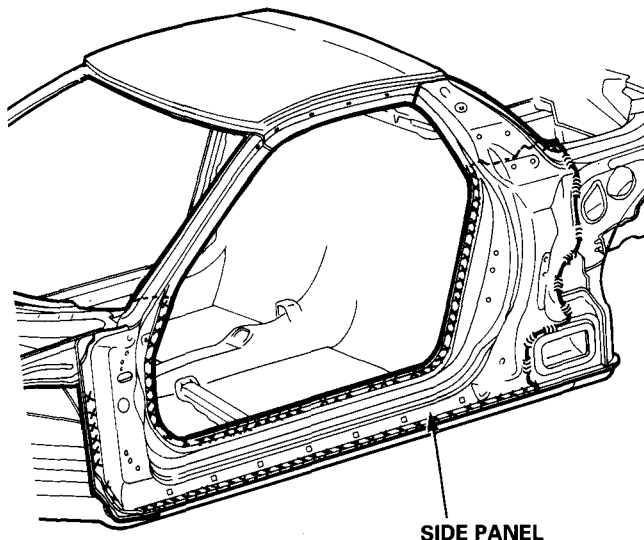
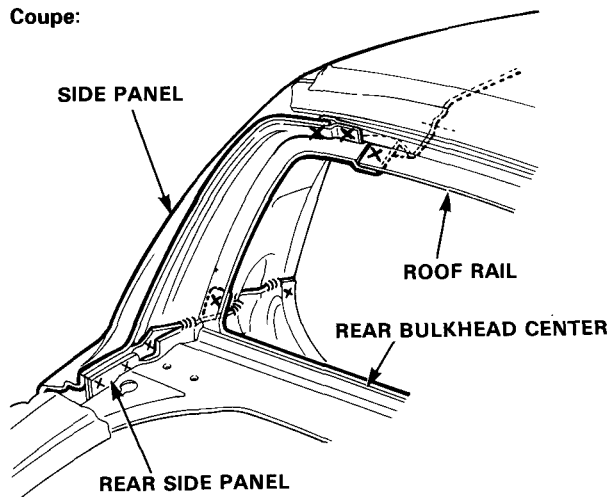
- Drill the spot welds using a 10 mm (3/8") spot cutter.

- Strike a punch in the center of the spot welds to the front pillar, side sill, and rear pillar.
- Drill the spot welds using a 10 mm (3/8") spot cutter.
- Grind the MIG welding section using a rotary cutter.
- Remove the remaining welding flanges using a chisel.
- Remove the burrs from the drilled section using a disc sander.

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

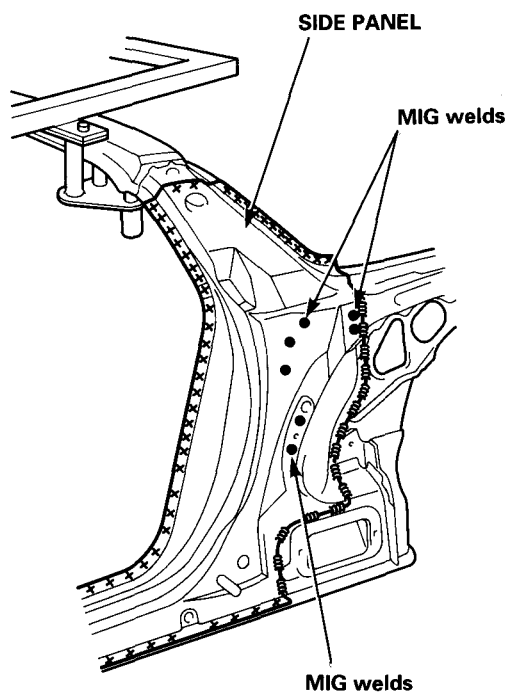


Coupe:



NSX-T (open top):

- Grind the MIG welds of the side panel and center pillar upper reinforcement.



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Side Panel

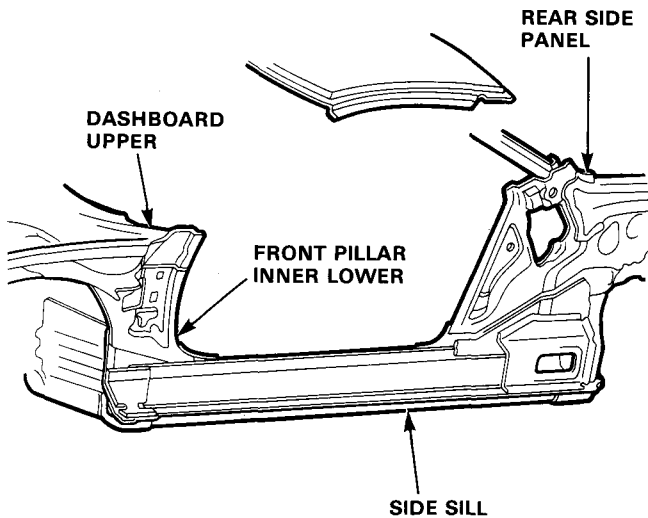
Replacement (cont'd)

5. Mold the related parts.

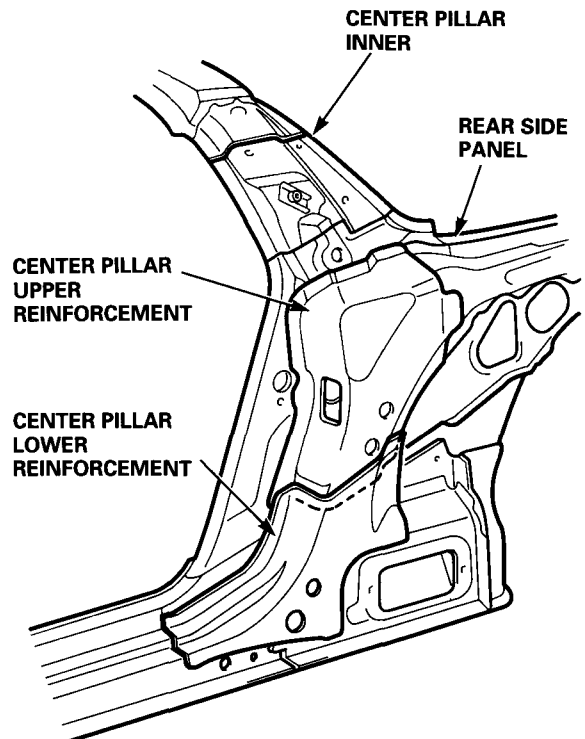
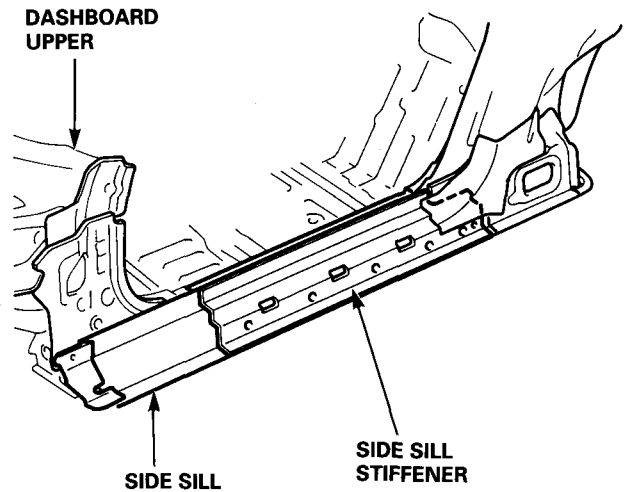
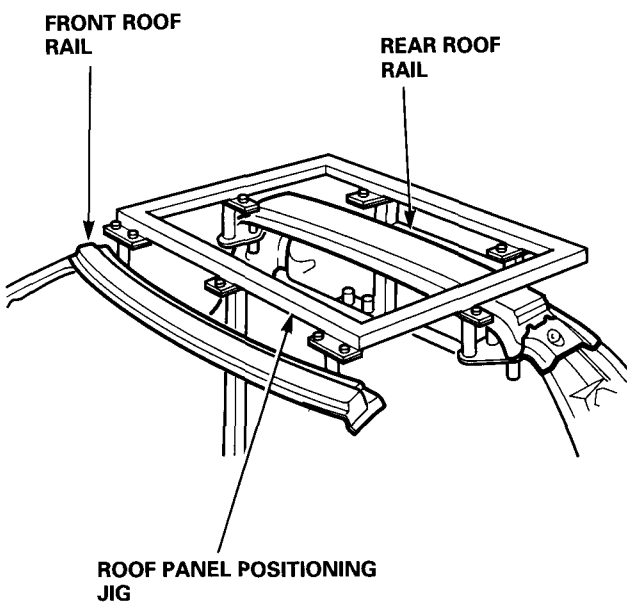
Smooth the welding flanges of the roof panel, side sill and welding section of the rear side panel with a hammer and dolly.

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

Coupe:



NSX-T (open top):



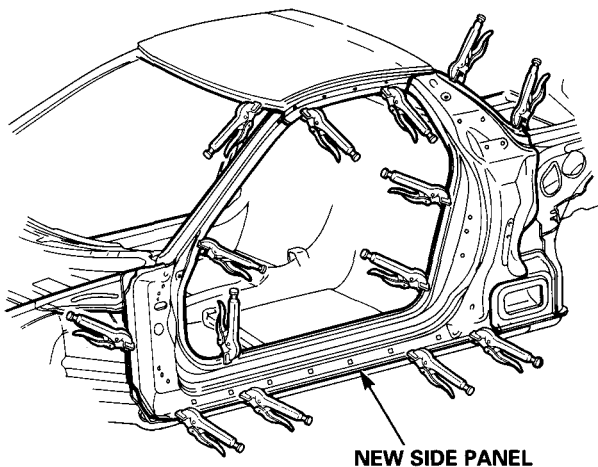
6. Set the new side panel.

- Drill the 8 mm (5/16") plug weld holes in the welding flange of the new side panel.
- 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.

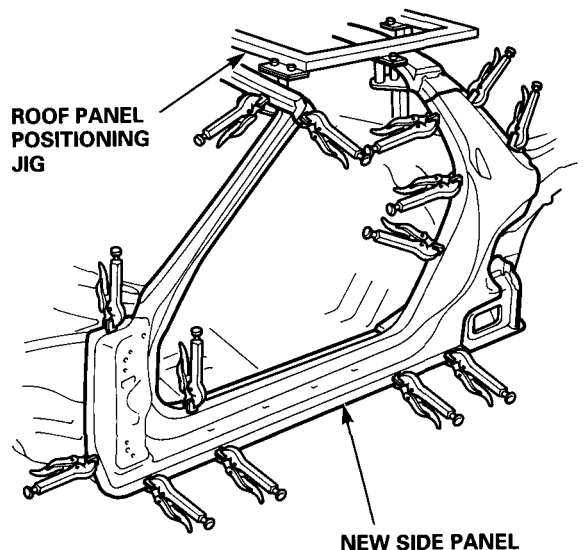
- Remove the paint film from the welding section of the body and clean oil contaminations with a shop towel soaked with wax and grease remover.
- Before setting the new side panel, remove the oxide film from the welding section of the replacement part and body using a stainless steel wire brush.
- Install the side panel and clamp it with the vise-grips, pliers, etc.

Coupe:



- Check the body dimensions (see [section 6](#)).

NSX-T (open top):



7. Tack weld the side panel.

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

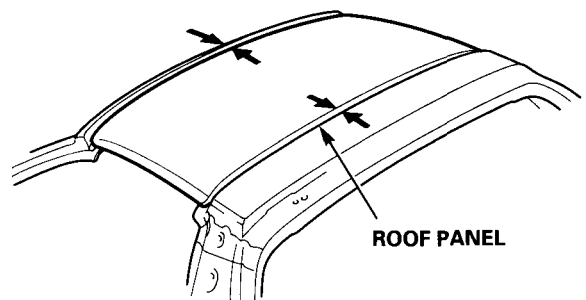
Plug weld the clamped sections to temporarily install the side panel.

8. Remove the vise-grips and pliers and install the windshield, front fender, door, rear window, and rear fender. Check for difference in level and clearance.

NOTE: Check for flushness of the front fender, door, and rear fender. Check for smooth body line of the car.

NSX-T (open top):

Remove the jig and install the front and rear lock receivers, then check the clearance and level differences of the roof panel and roof rails.



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Side Panel

Replacement (cont'd)

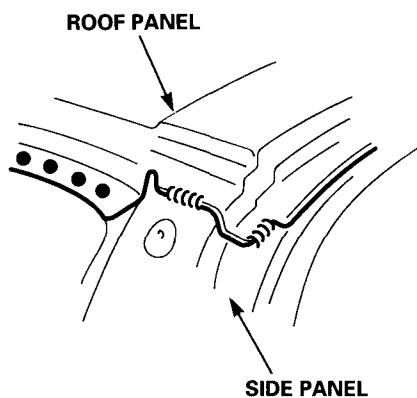
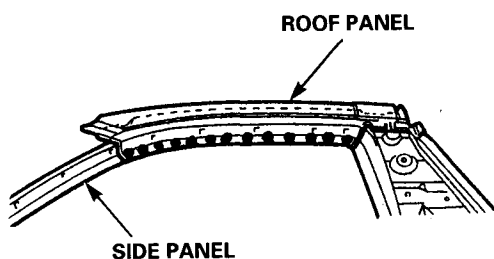
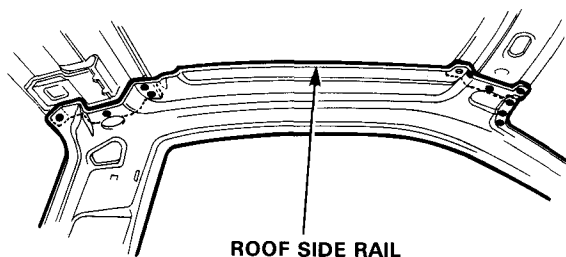
9. Perform main welding.

⚠ 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.

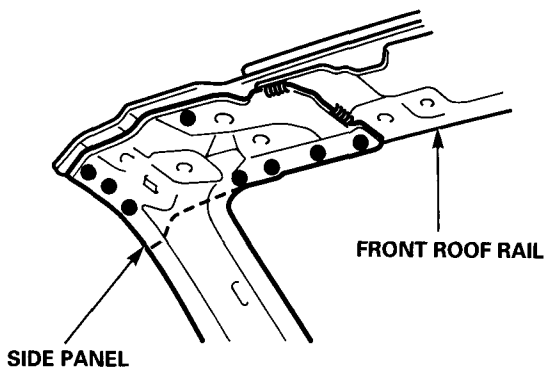
Coupe:

- Weld the roof side rail and roof panel.

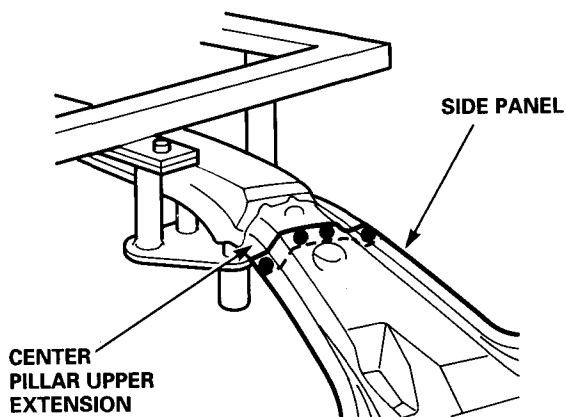


NSX-T (open top):

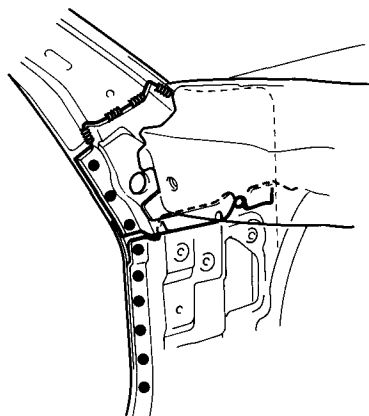
- Weld as much as possible with the jig still mounted.
- Weld the front roof rail.



- Weld the side panel and center pillar upper extension.

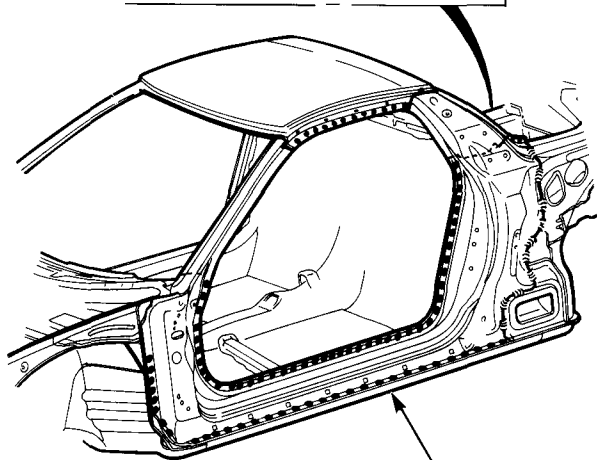
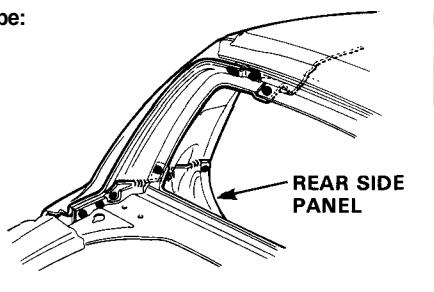


- Weld the dashboard upper cross member.



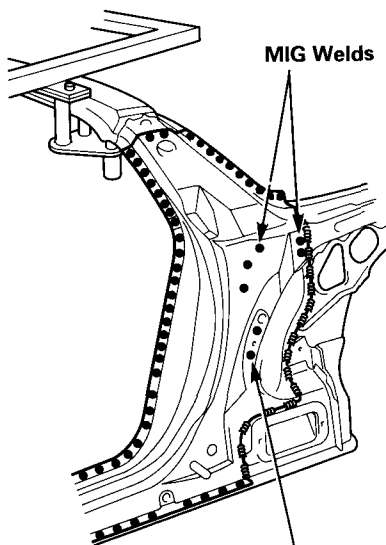
- Weld the side panel, side sill, front pillar inner lower and rear side panel.
- The applicable welding methods are MIG welding, plug welding, and fillet welding.
- Check the welding sections for cracks (see page 2-29).

Coupe:



SIDE PANEL

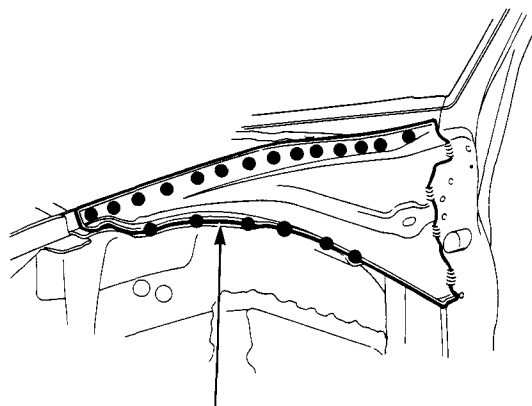
NSX-T (open top):



MIG Welds

10. Weld the dashboard upper side extension.

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



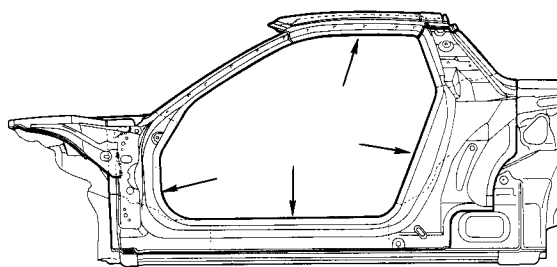
DASHBOARD UPPER SIDE EXTENSION

11. Finish the welding areas.

- 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.

- Smooth the flanged section of the door opening with 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.

(cont'd)

Side Panel

Replacement (cont'd)

12. Apply the sealer (see [section 5](#)).

13. 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.

14. Apply anti-rust agent to the inside of the side panel (see [section 7](#)).

15. Install the related parts.

- Install in the reverse order of removal.
- Check the door for proper installation and difference in level from the fenders.

16. Clean and check

- After installing the dashboard, check the lights, gauges, etc. for proper operation.
- Clean the passenger compartment and check for water leaks from the roof.

NSX-T (open top):

- Set the roof panel, then secure the roof panel by turning the roof side lock handles.
- 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.