

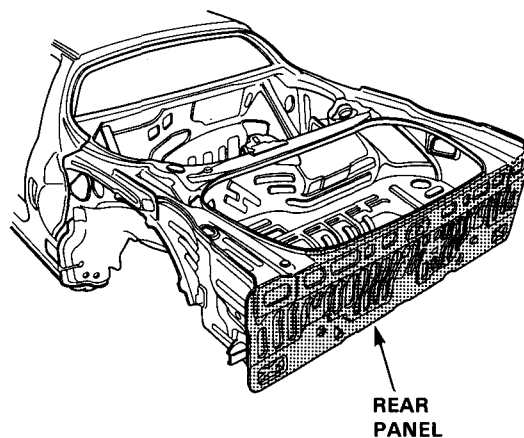
Rear Panel

Replacement

1. Remove the related parts.
 - Rear bumper
 - Trunk lid lock and its attachments
 - Other related parts
 - Taillight and rear panel garnish
 - Rear fender
2. Pull out and straighten damaged area.
 - Pull out the related rear side inner panel, rear floor, rear side frame and other damaged parts with the frame straightener.
 - 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.
 - To protect the car body from damage, place a piece of aluminum plate on each clamping section and tighten the clamp.
 - Before pulling out the damaged section, it might be necessary to heat the section with an acetylene torch (see page 2-31).
3. Keep the body level.

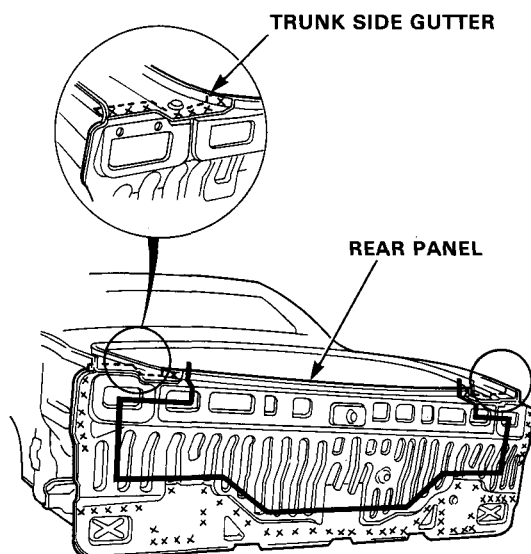
Jack up the body at the front and back and place safety stands at the four designated places of the side sills.

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

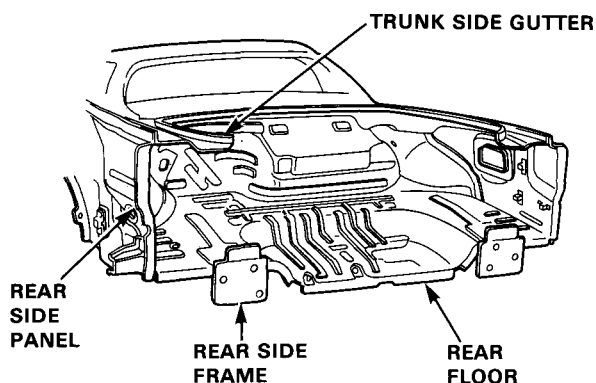


4. Cut and pry off the rear panel.
 - Strike a punch in the center of the spot welds to the rear inside panel and rear floor.
 - Drill the spot welds using a 10 mm (3/8") spot cutter.
 - Grind the MIG/fillet weld using a rotary cutter.
 - Take care not to drill to the rear floor.
 - Remove the welding flanges using a chisel.
 - Smooth the damaged sections on the rear floor, etc. with a hammer and dolly.
 - It might be necessary to replace the trunk side gutter this time.

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



5. Mold the related parts.
Smooth the welding flange of the rear side panel, rear floor and rear side frame end.



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

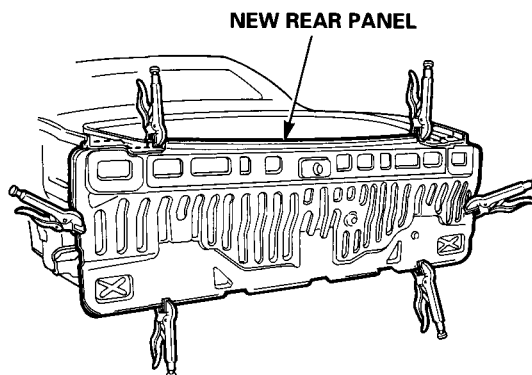
6. Set the new rear panel.
 - Paint the inside of the panel with the body color. See Paint Repair section.

⚠ 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.
- Drill the 8~10 mm (5/16"~3/8") holes for plug welding in the welding flange of the replacement panel.
- Remove the undercoat from the welding section of the panel 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 contamination with a shop towel soaked with wax and grease remover.
- Before setting the new panel, remove the oxide film from the welding section of the replacement part and body using a stainless steel wire brush.
- Install the new rear panel and clamp it with the vise-grips.



- Check the rear panel position using the body dimensional drawings (see section 6).

(cont'd)

Rear Panel

Replacement (cont'd)

7. Tack weld the rear panel.

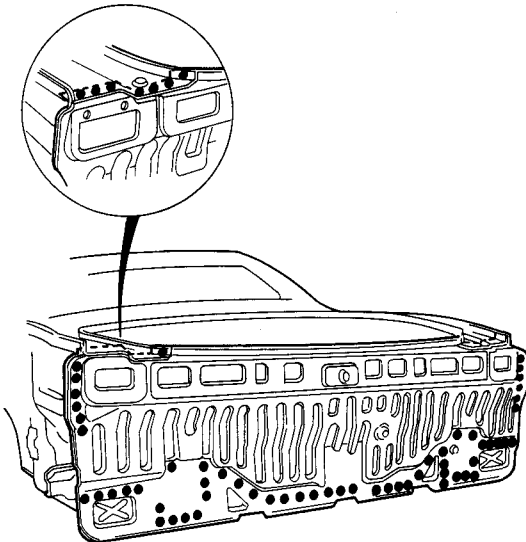
⚠ WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

- Open and close the trunk lid to check for proper installation.
- Position the rear panel in its correct position with the rear bumper and rear fenders installed.

8. 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 welding, plug welding, and fillet welding.
- Check the welding sections for cracks (see page 2-29).



9. 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.

⚠ 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.

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

- Apply sealer to the rear side outer joint and around the taillight areas of the rear panel.
- Apply sealer to the rear panel and rear floor joint.

11. Apply the paint.

See Paint Repair section.

⚠ WARNING

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- 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.

12. Apply anti-rust agent (see [section 7](#)).

13. Install the related parts.

Install in the reverse order in which they were removed.

14. Inspect, check, and clean.

- Adjust the clearance with the trunk lid, then adjust the level differences and fit. Check operation.
- Test for leaks in the trunk compartment.
- Clean the trunk floor.