

## Replacement

### 1. Remove the related parts.

- Driver's and passenger's seat
- Carpet
- Hand brake assembly

NOTE: With a side sill removed (one side).

**⚠ WARNING** Do not smoke while working near the fuel system. Keep open flame away from the fuel system. If necessary, remove the fuel tank and/or lines before welding nearby. Drain fuel into an approved container.

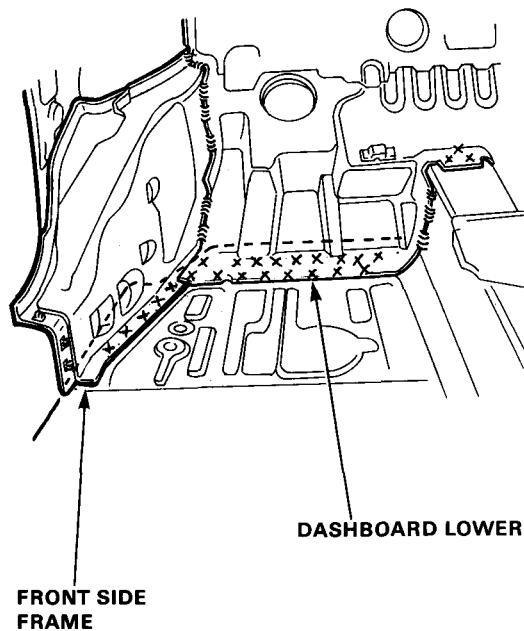
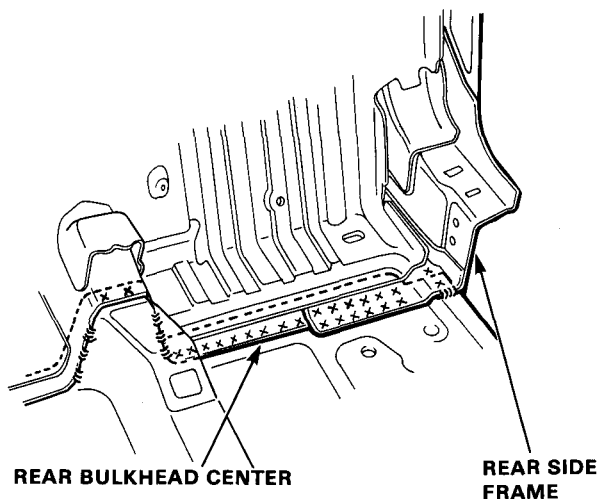
### 2. Remove the front floor.

- Strike a punch in the center of the spot welds to the dashboard lower and rear bulkhead center.
- Drill the spot welds using a 10 mm (3/8") spot cutter.
- Grind the MIG/fillet welds using a rotary cutter.

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

- Remove the spot welds and fillet welds using a chisel.
- Do not drill through the side sill.
- Smooth the welding sections of the dashboard lower and rear bulkhead with a hammer and dolly.

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



### 3. Set the new front floor.

- Drill the 8 mm (5/16") plug weld holes in the welding flange of the new front floor.
- Remove the undercoat from the welding section of the front floor and expose the aluminum alloy base using a disc sander.

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- Heat the undercoat at the bottom of the body using a gas torch, and remove it thoroughly with a knife.
- Remove the paint film from the welding section of the body using a disc sander and clean oil contaminations with a shop towel soaked with a wax and grease remover.
- Before setting the new front floor, clean the welding sections of the front floor and body using a stainless steel wire brush.

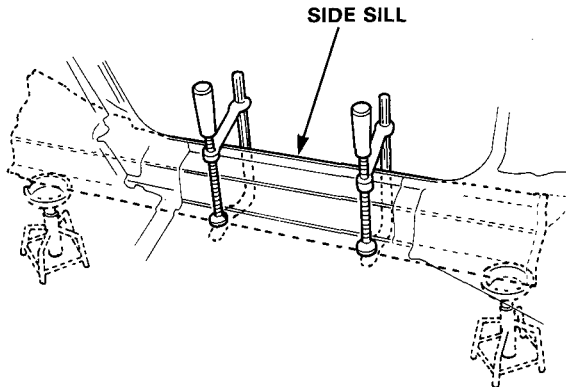
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# Front Floor

## Replacement (cont'd)

- Clamp the new front floor, side sill, dashboard lower, and rear bulkhead center with screw clamps.
- Weld the clamped sections for temporary installation.

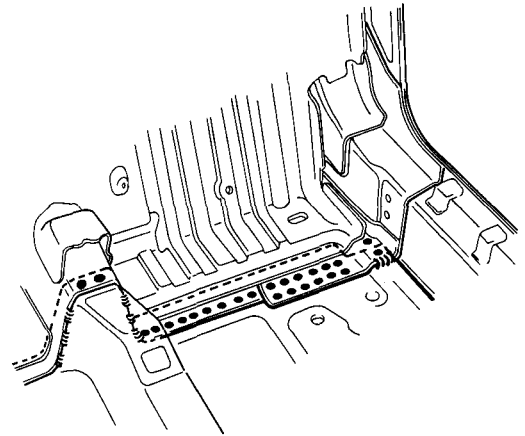
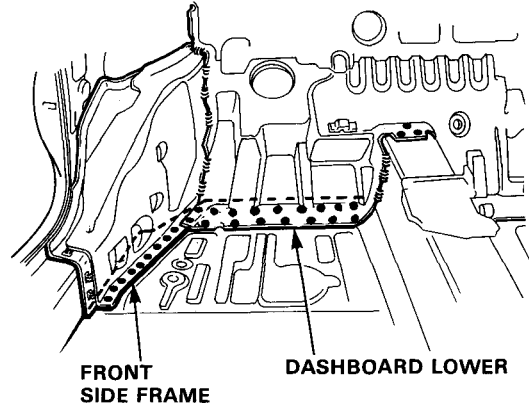
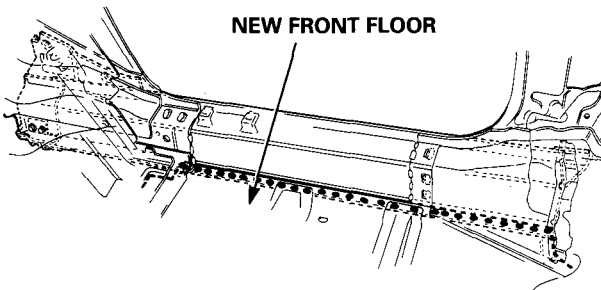
**⚠ WARNING** To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.



4. 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 or fillet welding.
- Check the welding sections for cracks (see page 2-29).



5. Finish the welding area.

- Roughly grind the welds using 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.

6. Apply the sealer (see [section 7](#)).  
Apply sealer to the mating surface with the front floor.

7. 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.
8. Apply the undercoat (see [section 5](#)).  
Undercoat the front floor, etc. and apply anti-rust agent to the inside of the welding section of the front side sill, side frame and dashboard lower.
  9. Install the related parts .
  10. Check and clean.
    - Check the seats for movement.
    - Perform the brake test.
    - Clean the passenger compartment.