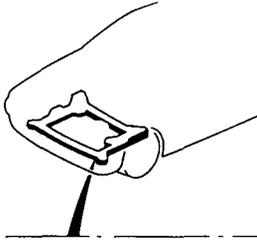


Front Side Frame

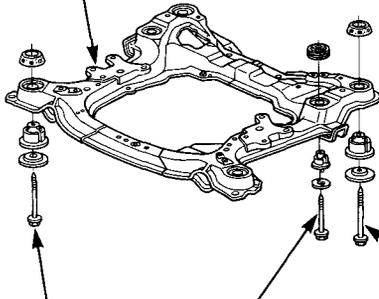
Replacement

1. Remove the related parts.
 - Front suspension related parts
 - Brake hoses and pipes
 - Engine compartment electrical components
 - Fittings in passenger compartment, etc.
 - Steering gearbox.
2. Remove the sub-frame.



2.5TL:

FRONT SUB-FRAME

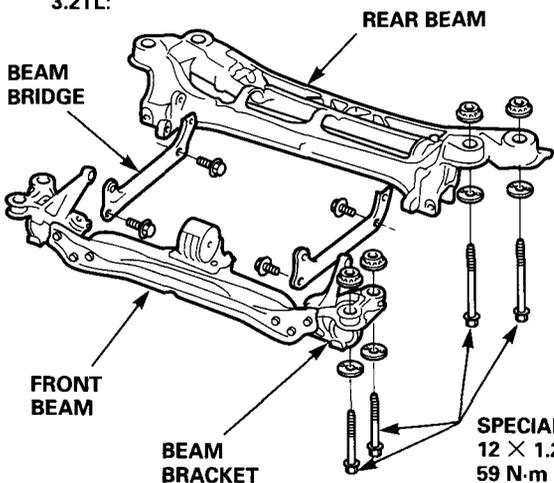


SPECIAL BOLT
14 × 1.5 mm
95 N·m (9.7 kgf·m,
70 lbf·ft)
Replace.

SPECIAL BOLT
12 × 1.25 mm
64 N·m (6.5 kgf·m,
47 lbf·ft)
Replace.

SPECIAL BOLT
14 × 1.5 mm
95 N·m (9.7 kgf·m,
70 lbf·ft)
Replace.

3.2TL:



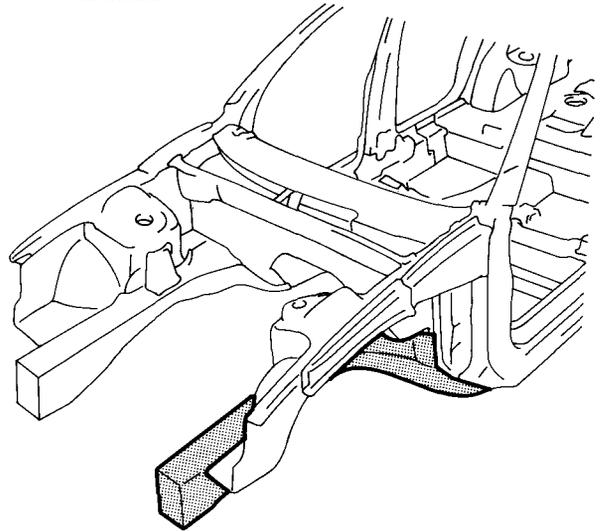
SPECIAL BOLT
12 × 1.25 mm
59 N·m (6.0 kgf·m,
43 lbf·ft)
Replace.

NOTE: With the front bulkhead removed.

3. Roughly pull out and straighten the damaged area.
 - Attach the car to the frame straightener by tightening the underbody clamps located at the horizontal pinch welds.

NOTE: Refer to the 95-96 Acura 2.5TL & 96 Acura 3.2TL Service Manuals for safety stand location points.

- Before cutting off the damaged sections, pull them out so that they are restored to the original shape.
- Cutting off the front side frame before roughly pulling out the damage makes repair of the related front floor, lower dashboard, and other related parts difficult.



4. 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 the undercoat with a metal spatula.

CAUTION: Be careful not to burn the fittings inside the passenger compartment when heating.

5. Remove the front side frame.
NOTE: It's not necessary to separate the front wheelhouse from the front side frame if the wheelhouse/damper housing is to be replaced also.

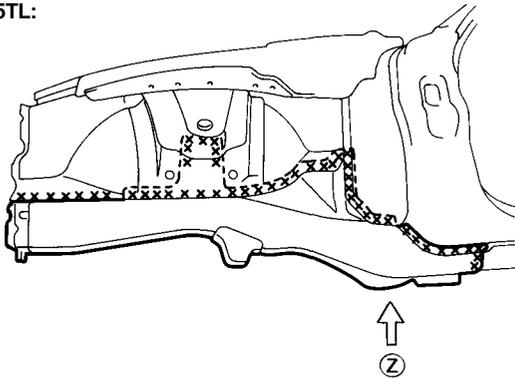
- Center punch around the spot weld imprints on the wheelhouse, damper housing, lower dashboard, front floor and floor frame.
- Using a spot cutter, drill holes in the spot welded areas.
- Peel off the welding flange using the chisel.

- Remove the burrs from the drilled sections with a disc sander.

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

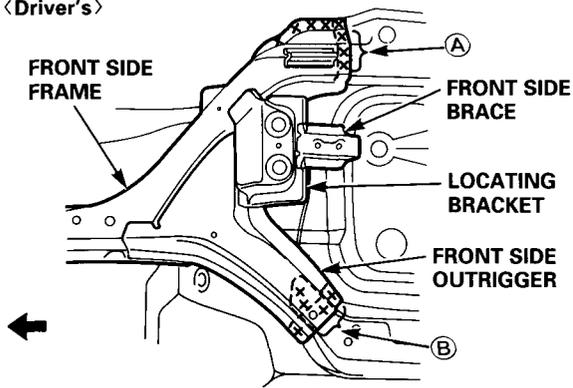
NOTE: When drilling holes (A) and (B) be careful not to drill down to the inside sill.

2.5TL:

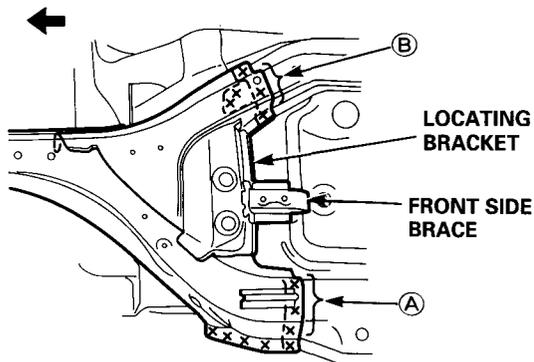


VIEW Z

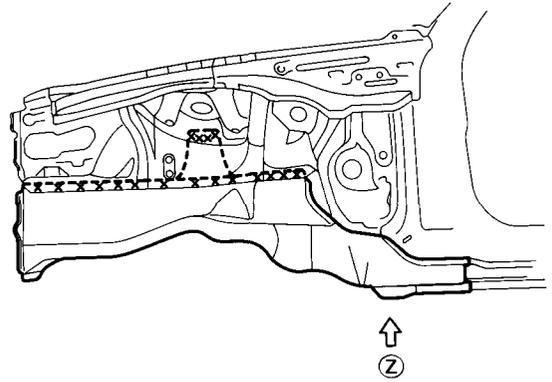
<Driver's>



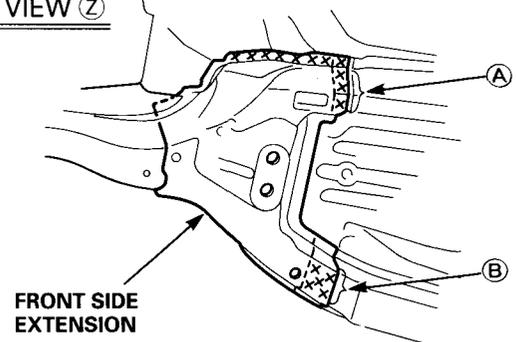
<Passenger's>



3.2TL:



VIEW Z

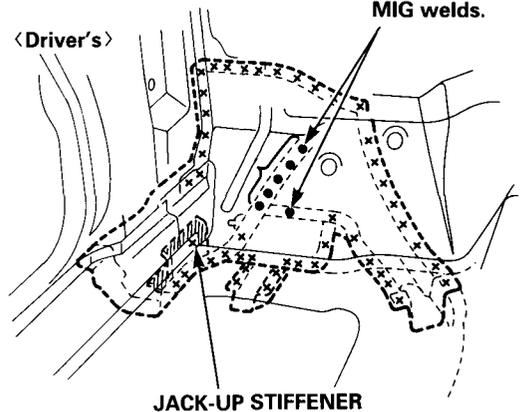


- Center punch around the spot weld imprints on the front side frame and front side outrigger from inside the passenger compartment.
- Drill holes in the spot welded area with a 5 mm (0.2 in) drill.

NOTE: Drill holes completely through the parts since the replacement front side frame, front side outrigger and jack-up stiffener will be welded by MIG welding.

- Remove the MIG welds of the front side frame and lower dashboard with a disc sander.

2.5TL:

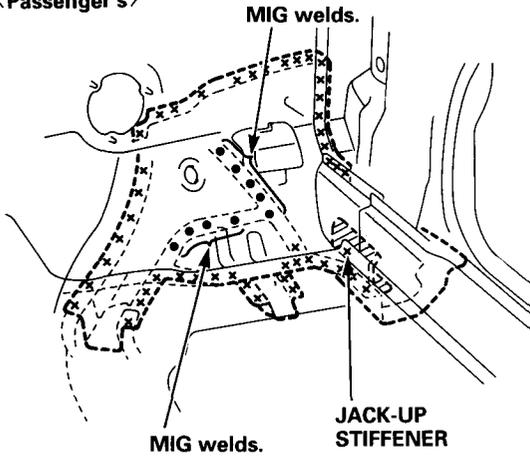


(cont'd)

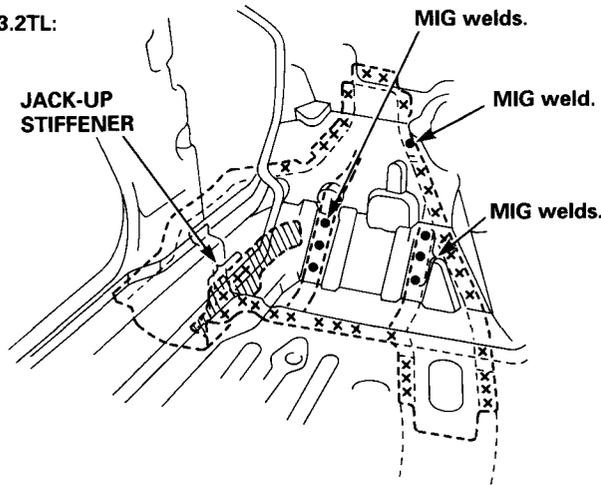
Front Side Frame

Replacement (cont'd)

<Passenger's>

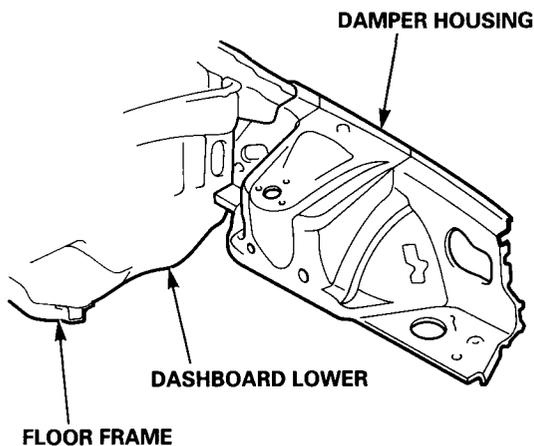


3.2TL:



6. Mold the related parts.

- Reshape the front wheelhouse and damper housing lower dashboard-to-front floor joint using a hammer and dolly.
- Fill all drilled holes by MIG or gas welding.



7. Set the new front side frame.

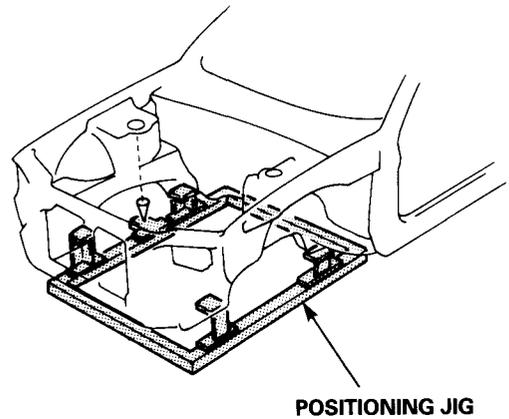
- Remove the undercoat from the both sides of the welding section, and expose the steel plate using a disc sander.

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

NOTE: Apply the spot sealer to the welding surface when spot welding.

- Tighten the front side frame against the front floor and side sill using vise-grips or pliers.
- Place a jack under the front side frame end and support it, and measure the positions for temporary attachment.

NOTE: Use of a positioning jig is recommended (see page 1-7).



- Clamp the front bulkhead and front wheelhouse/damper housing with squill vises and vise-grips.
- Measure the front compartment diagonally.
- Spot weld several points in the clamped sections, and temporarily attach the front side frame.

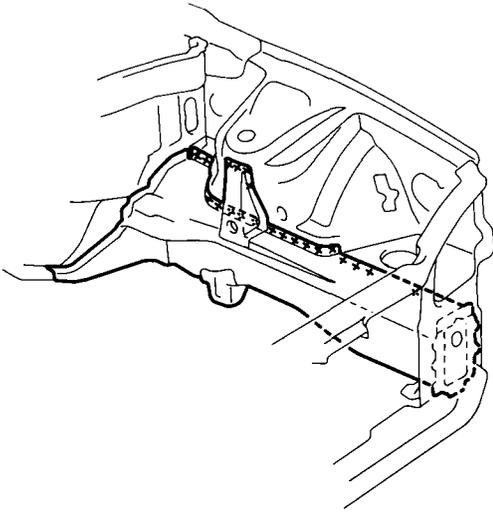
⚠ WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

- Check the body dimensions (see section 6).

8. Perform the main welding.
- Make 20% to 30% more spot welds than there were holes drilled.
 - Weld as much as possible with the jig still mounted.

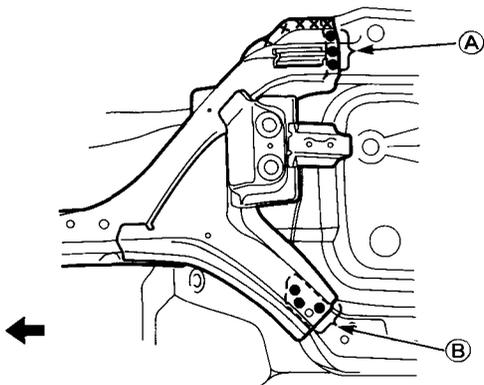
⚠ WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

- Weld the front side frame, wheelhouse, damper housing and bulkhead.

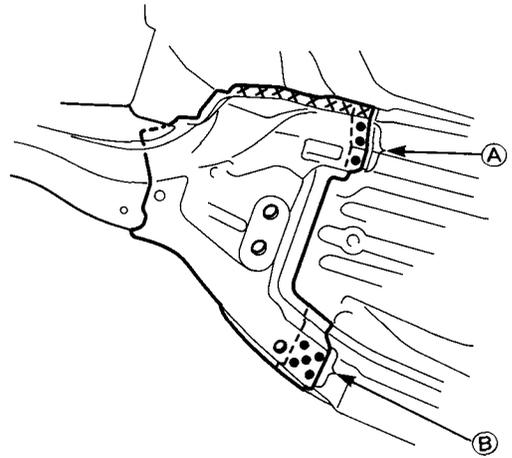


- (A) and (B), make 5 mm (0.2 in) holes in the MIG weld holes with the outrigger, and plug weld the inside sill with a MIG welder.

2.5TL:



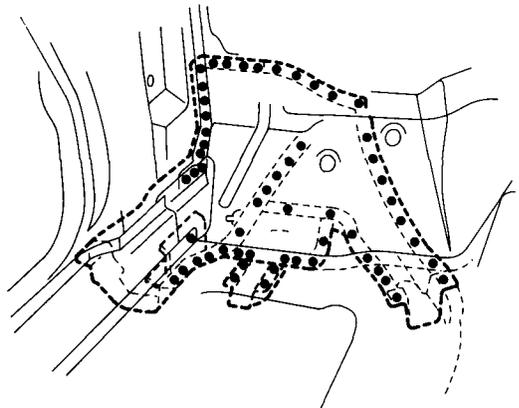
3.2TL:



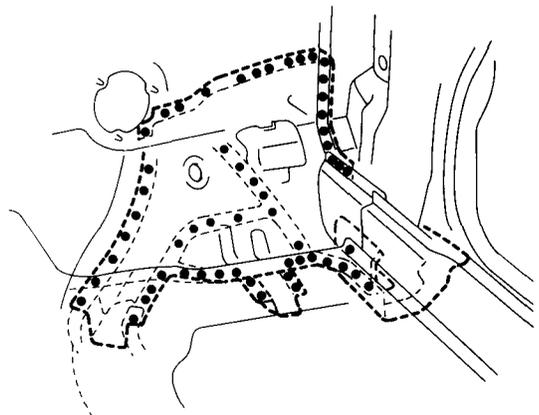
- From the passenger compartment side, plug weld the holed areas of the lower dashboard and front floor with a MIG welder.

2.5TL:

<Driver's>



<Passenger's>

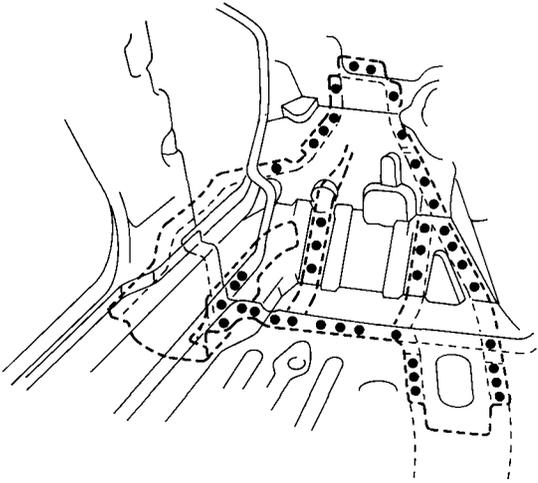


(cont'd)

Front Side Frame

Replacement (cont'd)

3.2TL:



9. Finish the welds.

Use a hammer and dolly to even out the damper housing, wheelhouse, lower dashboard, front bulkhead and side sill flanges for a close fit with the surface of the front side frame.

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

Apply sealer to the mating surfaces of the lower dashboard, etc.

11. 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 the paint container.
- **Avoid contact with skin.** Wear an approved respirator, gloves, eye protection and appropriate clothing when painting.
- **Paint is flammable.** Store it in a safe place, and keep it away from sparks, flames or cigarettes.

12. Apply the undercoat.

Undercoat the front floor, and apply anti-rust agent to the inside of the welding section of the side sill, front side frame, etc (see [section 7](#)).

13. Install the related parts.

Install in the reverse order in which they were removed.

14. Inspect, check and adjust.

- Measure the front wheel alignment.
- Inspect the brake system.
- Adjust the headlight aim.