

Rear Floor

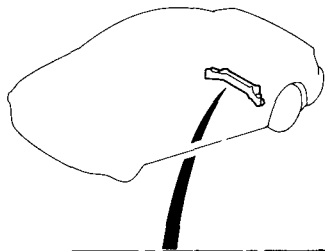
Replacement

1. Remove the related parts.

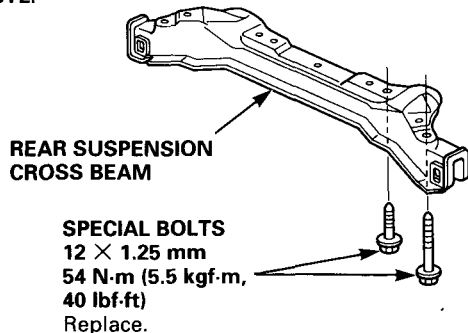
- Rear seat
- Trim and other luggage compartment fittings
- Left and right rear suspension assembly
- Parking brake parts
- Muffler
- Wire harness
- Other parts as necessary
- Fuel tank and fuel pipes

⚠ 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.

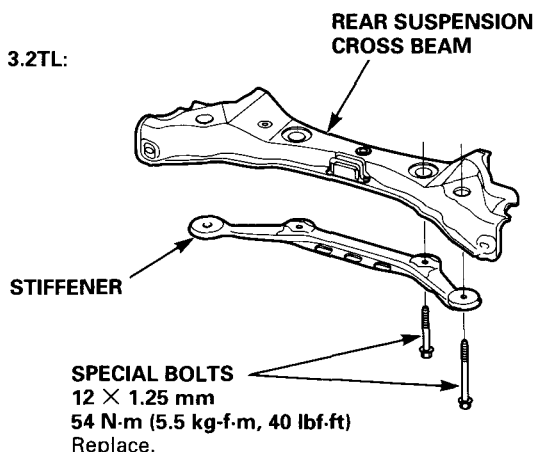
2. Remove the rear suspension cross beam.



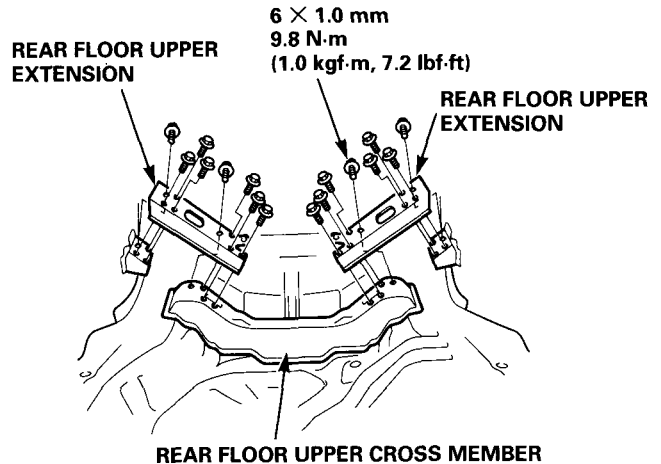
2.5TL:



3.2TL:



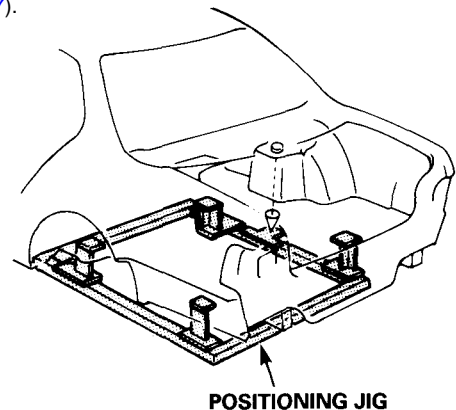
3. Remove the rear floor upper extensions.



4. Pull out and straighten the damaged area.

- Check whether the damage extended to the rear floor cross member, rear wheelhouse and the passenger compartment, and pull out the damaged parts using the frame corrector.
- Impact damage to the rear floor spreads to related parts such as the rear frame, rear floor cross member and rear wheelhouse.
- Therefore, pull out the damaged areas with the frame straightener and measure in reference to body dimensional drawing.

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



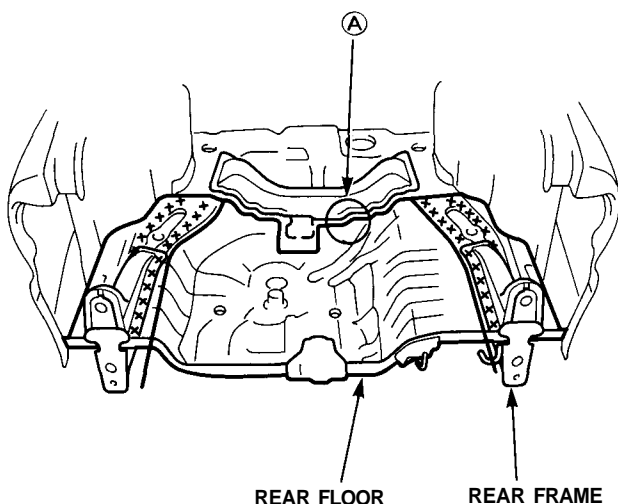
5. Peel off the undercoat.

Heat the undercoat at the weld areas of the lower rear floor with a gas torch and peel off the undercoat with a metal spatula.

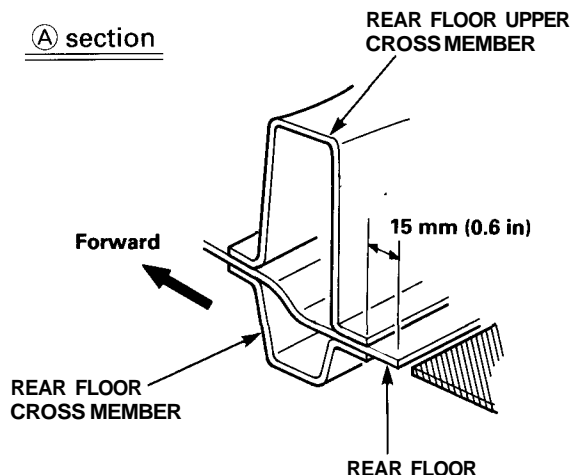
CAUTION: Be careful not to burn the fittings inside the trunk compartment while heating.

6. Cut and pry off the rear panel (see page 4-45).

7. Cut and pry off the rear floor.
 - Cut off the rear floor with a gas cutter or air chisel. Level the spot welded flanges of the rear side frame and rear floor cross member, as shown by the bold line in the figure below.



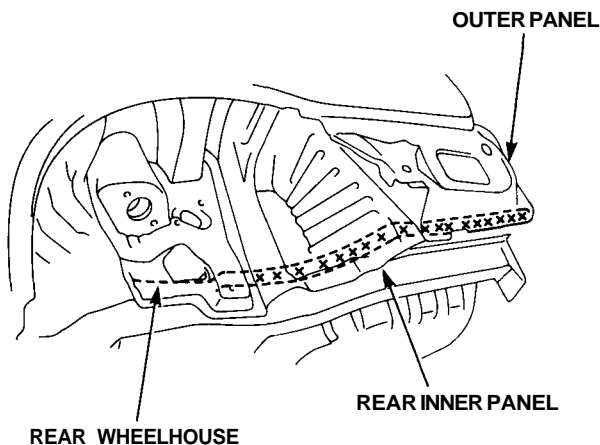
NOTE: Cut the rear floor 15 mm (0.6 in) from the welded flange of the rear floor upper cross member.



- Center punch around the spot weld imprints on the remaining welded flanges. Do the same with the rear wheelhouse and the side of the rear end inner panel.
- Drill holes with a spot cutter.

NOTE: When drilling holes, be careful not to drill down to the rear frame.

- Pry off the flanges using a chisel.



8. Mold the related parts.
 - Remove the burrs from the spot weld or MIG weld using a sander.

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

- Fill any holes made in the spot welded areas of the flange by MIG or gas welding.

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

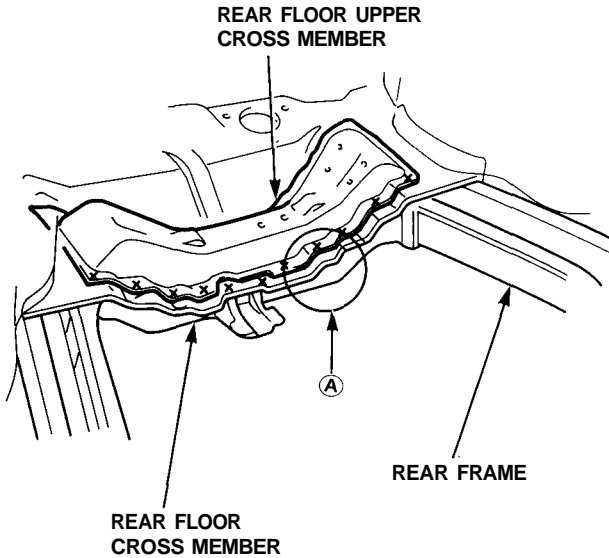
(cont'd)

Rear Floor

Replacement (cont'd)

- Smooth the welding flanges of the rear frame with a hammer and dolly.

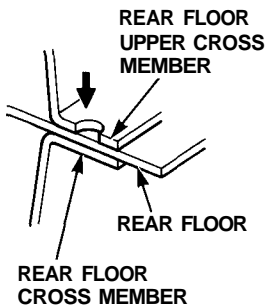
NOTE: Check that the rear frame is parallel at the right and left.



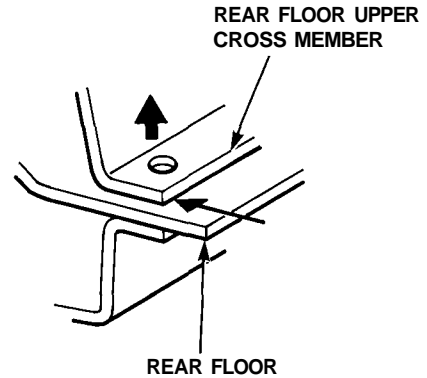
- Center punch the spot weld imprints on the rear floor upper cross member welded flange.
- Drill holes with a spot cutter at the areas joined to the rear floor upper cross member and rear floor.

NOTE: When drilling holes be careful not to drill down to the rear floor.

A area



- Pry off the welded flange sections using a chisel.



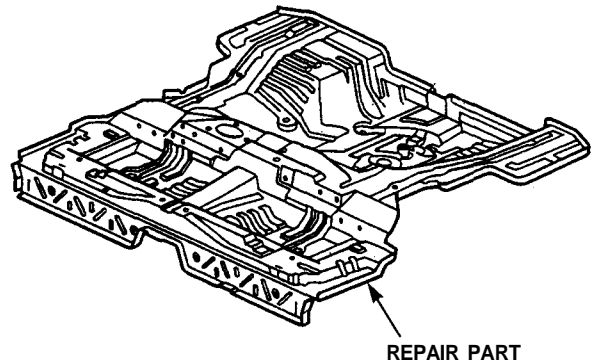
9. Keep the body level.
Jack-up the body at the front and back. Place safety stands at the four designated places of the side sill.
10. Set the repair part.
 - Cut the new rear floor to align it with the body.

NOTE: Cut the new part so it overlaps the body side floor by approximately 40 mm (1.6 in).

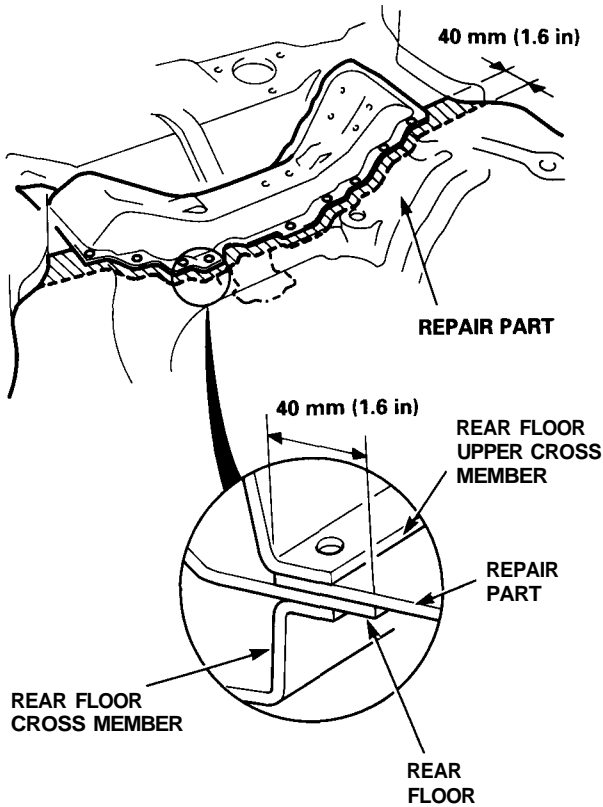
- Remove the undercoat from both sides of the areas to be welded with a sander to expose the steel plate.

WARNING

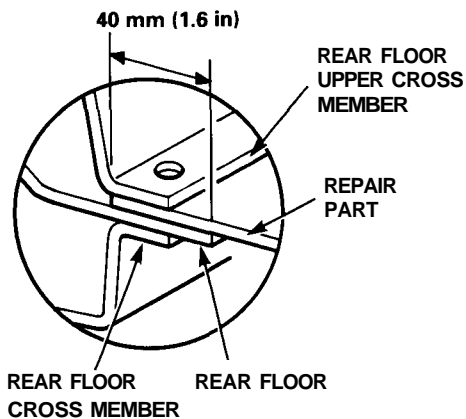
To prevent eye injury, wear goggles or safety glasses whenever sanding, cutting or grinding.



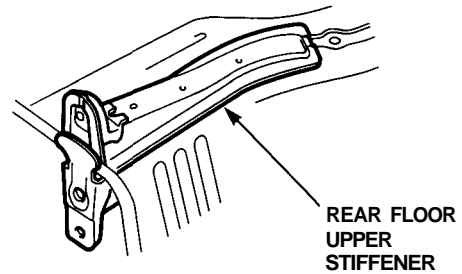
- Insert the repair part between the rear floor and rear floor upper cross member.
- Check that the weld flange surfaces fit closely.



- Check the position of the rear floor and rear frames using the body dimensional drawings (see [section 6](#)) and the positioning jig.



11. Set the rear floor upper stiffener, and check the rear panel position.



12. Perform the main welding.

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

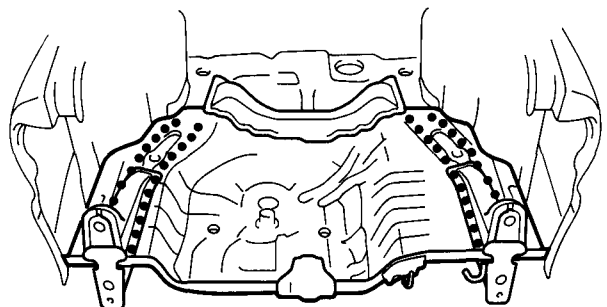
Spot welding:

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

- Recheck the position of the rear frames and rear floor, then weld the repair part and rear frames.
- Make 20% to 30% more spot welds than there were holes drilled.

MIG welding:

- Drill the holes for welding the repair part.
- Check the rear frame position and weld the repair part to the rear frames.

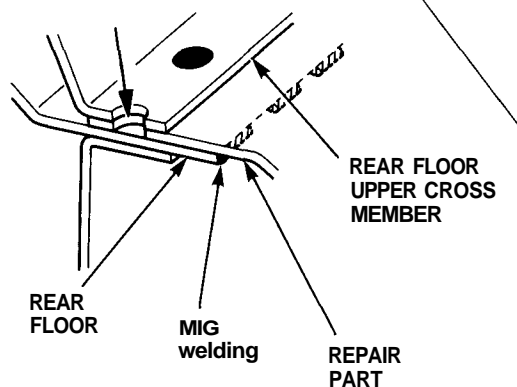
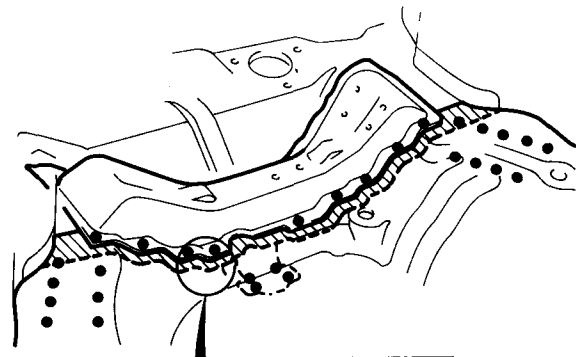


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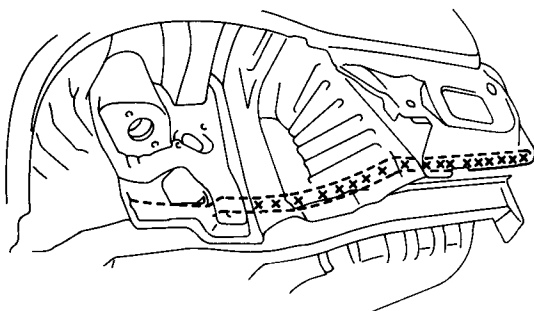
Rear Floor

Replacement (cont'd)

- Make 5 mm (0.2 in) hole in the MIG weld hole with the repair part.
- Weld the rear floor, repair part and rear floor upper cross member.



- Weld the rear wheelhouse and outer panel.



- Weld the rear panel and install the rear floor upper extension.

13. Finish the welded area.

Even out the welded area with a hammer and dolly, and fit the flange surfaces closely together.

14. Apply the sealer.

Apply sealer at the overlapped area of the rear floor, and the welded surfaces of the rear wheelhouse and rear end inner panel. Seal gaps completely (see [section 5](#)).

15. 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.

16. Apply the undercoat.

Apply anti-rust agent to the inside of the jack-up stiffener and jointed areas of the rear floor (see [section 7](#)).

17- Weld the rear panel and install the related parts.

Install in the reverse order in which they were removed.

18. Inspect and clean.

- Measure the rear wheel alignment.
- Clean the inside of the trunk compartment.