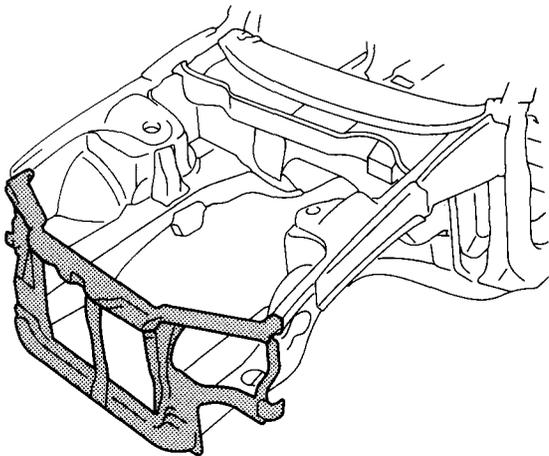


## Replacement

### 1. Remove the related parts.

- Front bumper
- Hood
- Right and left headlights
- Right and left front fenders
- Radiator, condenser
- Hood latch



### 2. Roughly pull out and straighten the damaged area.

- Check the damage to the front wheelhouse and front side frame before removing the front bulkhead. Use the frame straightener to roughly pull out and repair the damaged bulkhead before removing the bulkhead.

NOTE: Check the fit of the door, taking care not to pull the damaged area out more than necessary.

- Use the horizontal pinch weld clamps and attach the car to the frame straightener at the clamping points securely.

### 3. Keep the body level.

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

NOTE: Refer to the Acura 2.5TL/Acura 3.2TL Service Manuals for safety stand location points.

### 4. Cut and pry off the front bulkhead.

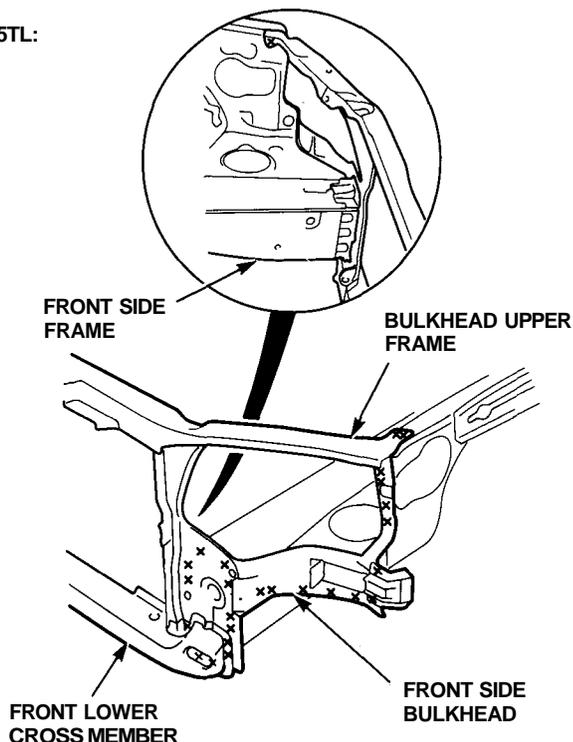
- Center punch around the spot weld imprints.
- Use the special spot cutter to drill holes at the spot weld nuggets on the front wheelhouse and front side frame.

NOTE: When drilling holes be careful not to drill down to the front wheelhouse or front side frame themselves.

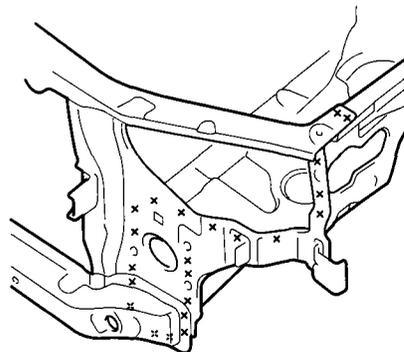
- Cut off the bulkhead with an air chisel, leaving the welding flanges intact.
- Level and finish the burrs from the pried off spot welds with a disc sander.

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

### 2.5TL:



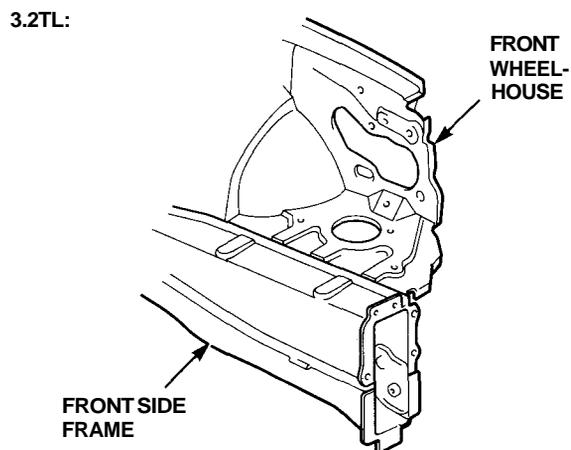
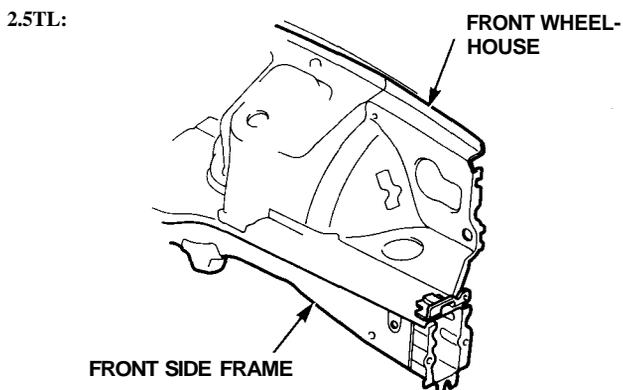
### 3.2TL:



(cont'd)

# Front Bulkhead Replacement (cont'd)

5. Mold the damaged related parts.
- Use a hammer and dolly to mold the damaged areas of the front wheelhouse front and side frame.
  - Even out the welding flanges with a hammer and dolly.
  - Fill all drilled holes by MIG or gas welding.



6. Set the new front bulkhead.
- Grind both sides of the welding section of the bulkhead with a sander to remove the undercoat and expose the steel plate.

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

- Clamp both the right and left sides with the vise-grips as shown.

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

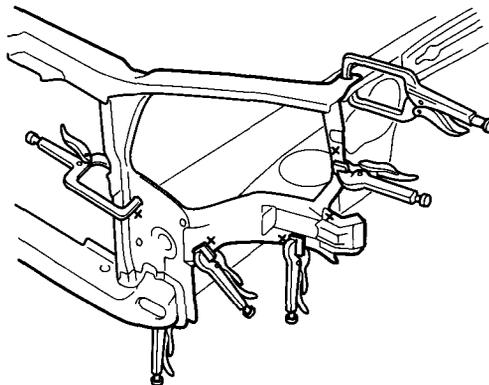
- Check the front bulkhead position using the body dimensional drawings (see [section 6](#)).

7. Tack weld the new front bulkhead.

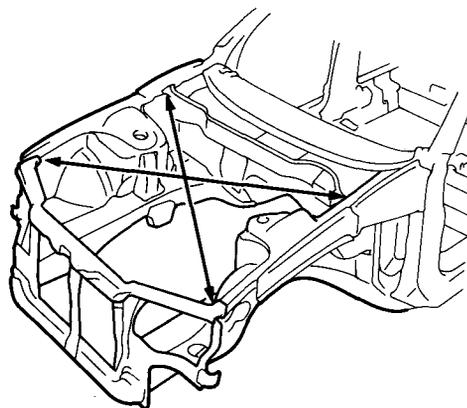
**⚠ WARNING** To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

Spot weld the clamped sections.

NOTE: Make sure that the right and left bulkheads are in line with each other.



8. Measure the front compartment diagonally. Measure the front compartment diagonally with a tracking gauge or convex tool as shown to check it for twisting or bending.



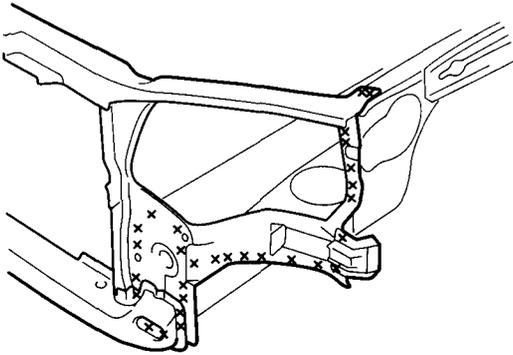
9. Temporarily assemble the hood, headlight and front fender, then check the clearances and level differences.

10. Perform the main welding.

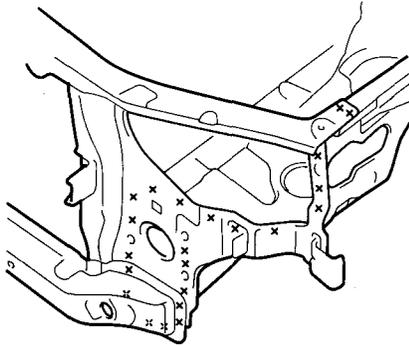
- Spot weld the bulkhead as shown.
- Make 20% to 30% more spot welds than there were holes drilled.

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

2.5TL:



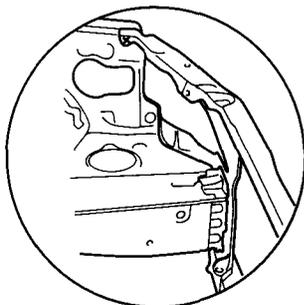
3.2TL:



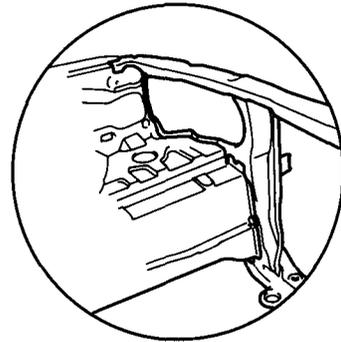
11. Finish the welds.

Use a hammer and dolly to even out the front wheel-house and front side frame flanges for a close fit with the surface of the front bulkhead.

2.5TL:



3.2TL:



12. Apply the undercoat (see [section 7](#)).

13. Attach the front fender.

Lower the body.

NOTE: Tighten the wheel nuts to the specified torque.  
Torque: 108 N-m (11.0 kgf-m, 79.6 lbf-ft)

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. Install the related parts.

Inspect, check, and make adjustments.

- Adjust the headlight aim.
- Check that the electrical components light up and operate properly.
- Replenish radiator coolant and inspect for leaks.