

Replacement

1. Remove the related parts:

- Hood
- Front fender
- Front door
- Windshield
- Front side trim
- Door opening trim
- Side cowl lining
- Dashboard
- Front pillar trim
- Wire harness, etc.
- Steering column
- Steering hanger pipe

NOTE: Make sure that the right and left pillars are parallel with the windshield surface. Check the door for proper opening and closing.

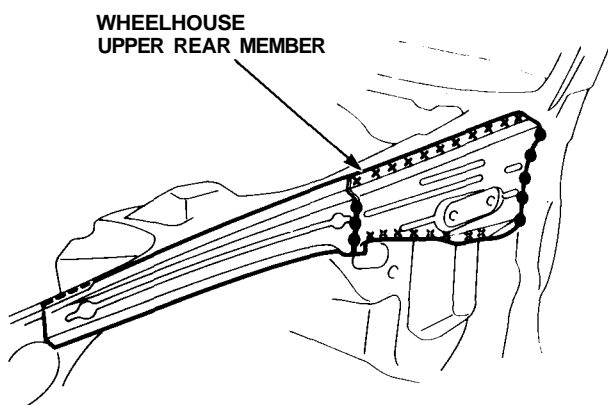
2. Pull out and straighten the damaged area.

- Pull out the damaged area with the frame straightener before cutting off the front pillar extension and front pillar.

NOTE: Pull out until the pillar is lined up with the surface of the windshield.

- With the pillar pulled out, pull out and straighten the related lower dashboard and floor section.
- After pulling, check the inner pillar position using the body dimensional drawings (see [section 6](#)).

3. Remove the wheelhouse upper rear member.



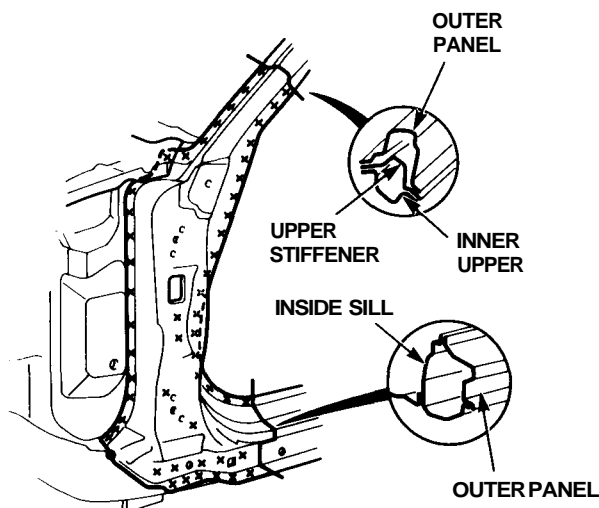
4. Cut off the front pillar.

- Cut off the front pillar along the bold line shown in the figure to the right with a gas cutter.
- Use a handsaw to cut the windshield and side sill areas.

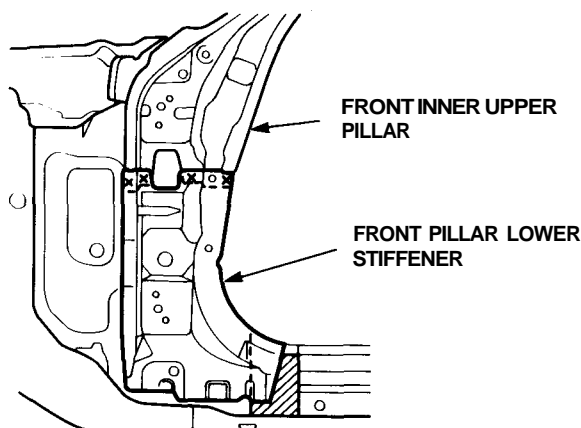
NOTE: Be careful not to cut the inner section.

- Center punch around the spot weld imprints.
- Drill holes using a spot cutter.
- Chisel off the weld flanges.
- Finish the burrs at the drilled areas with a disc sander.

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



- Repair the front pillar lower stiffener if necessary.



(cont'd)

Front Pillar (Outer Panel)

Replacement(cont'd)

5. Mold the related parts.

Fill any holes by MIG or gas welding, and even out with a hammer and dolly.

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

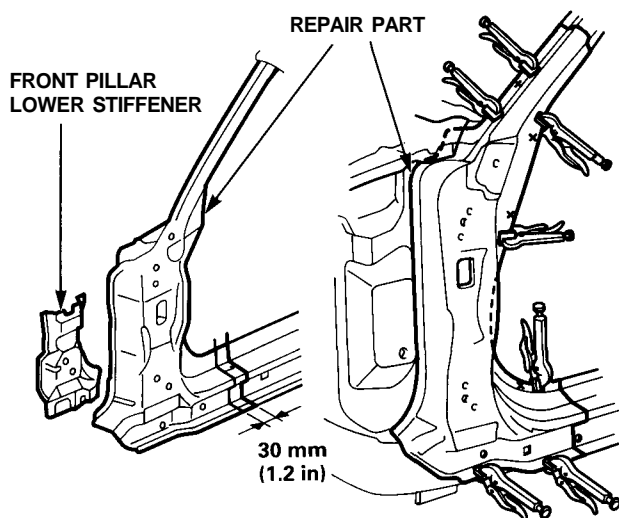
6. Set the repair part
 - Align the repair part with the top cut section, then cut it with a handsaw.

NOTE: Cut the side sill joint with a handsaw leaving an overlap of 30 mm (1.2 in).

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

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

- Clamp with vise-grips as shown.
- Check the body dimensions (see [section 6](#)).



7. Tack welds the clamped sections.

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8. Temporarily mount the door and front fender.

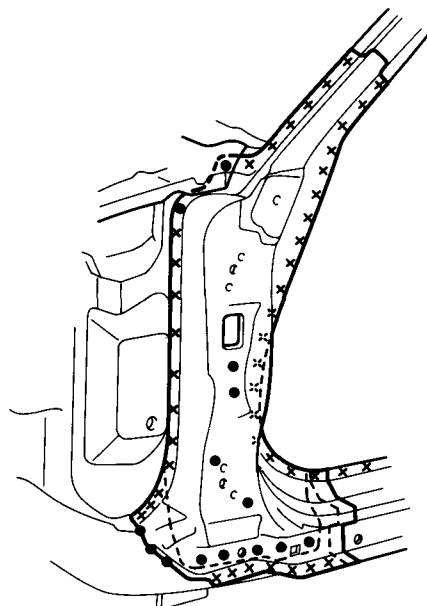
- Remove the vise-grips, then mount the door.
- Check the clearance and level differences of the door and fender.

9. Perform main welding.

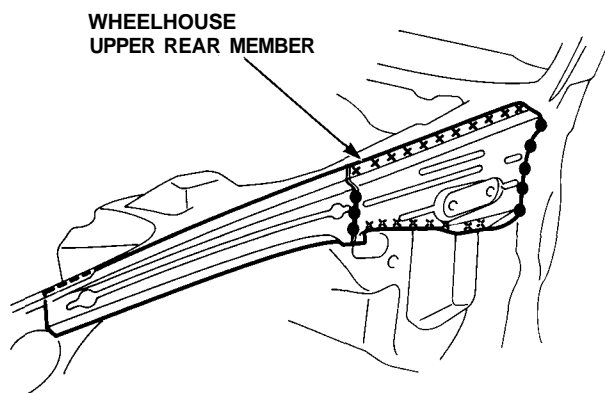
- Weld the front pillar and side sill outer joints with a MIG welder.
- Make 20% to 30% more spot welds than there were holes drilled.

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- Make 5 mm (0.2 in) holes in the MIG weld holes with the repair part, and weld the lower stiffener extension, lower stiffener and dashboard upper side member with a MIG welder.



- Weld the wheelhouse upper rear member.



10. Finish the welding areas.

- Finish grind the finishing allowance with a disc sander until it is smooth.

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- Smooth the flanged section of the door opening with a hammer and dolly.

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

12. 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.

13. Apply anti-rust agent to the inside of the front pillar, wheelhouse upper member and side sill (see [section 7](#)).

14. Install the related parts.

- Install in the reverse order of removal.
- Check the door for proper installation and level difference from the fenders.

15. Clean and check.

- After installing the dashboard, check the lights and gauges for proper operation.
- Clean the passenger compartment and check for water leaks.