

Rear Floor Cross Member

Replacement

1. See Rear Floor Replacement for removal of related parts.
2. Peel off the undercoat.
Heat the undercoat at the weld areas of the rear floor and rear frame 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 when heating.

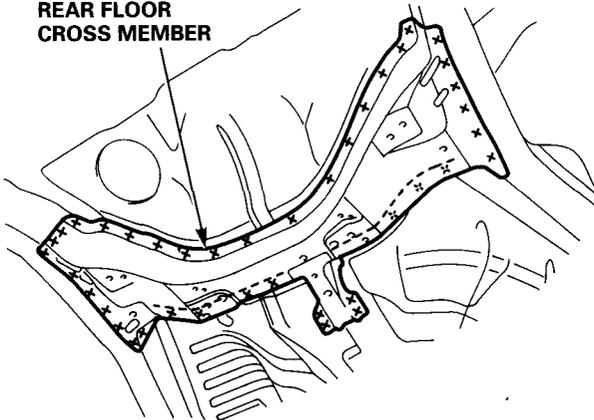
3. Remove the rear floor cross member.

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

- Center punch around the spot weld imprints on the rear floor cross member from under the rear floor.
- Drill holes with a spot cutter at the area joined to the rear floor cross member and rear floor.

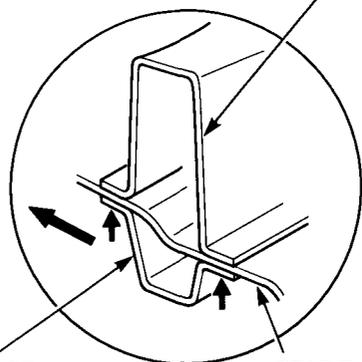
NOTE: When drilling holes be careful not to drill down to the rear floor upper cross member.

REAR FLOOR CROSS MEMBER



REAR FLOOR UPPER CROSS MEMBER

REAR FLOOR CROSS MEMBER

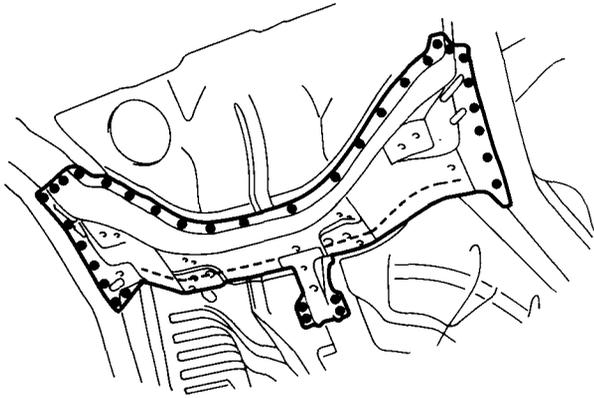


REAR FLOOR

- Center punch around the spot weld imprints on the rear frame.
 - Drill holes with a spot cutter.
 - Be careful not to let them penetrate through to the rear frame.
 - Pry off the part with a chisel.
4. Set the new rear floor cross member.
 - Sand off undercoat from both sides of the areas to be welded to expose the steel plate.
▲ WARNING To prevent eye injury, wear goggles or safety glasses whenever sanding, cutting or grinding.
 - Make 5 mm (0.2 in) holes in the MIG weld holes with the new rear floor cross member.
 - Set the new rear floor cross member in the original position properly and place a jack under the rear floor cross member for support.
 - Refer to the set position body dimensional drawings (see [section 6](#)) for proper positioning of the rear floor cross member.
 - Temporarily weld the mating surfaces with the rear frame.

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

 - Check the rear floor cross member in its correct position with the fuel tank installed.
 5. Perform the main welding.
▲ WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.
- MIG weld the rear floor cross member from under the rear floor.



6. Finish the welding area.
Roughly grind the welds in the trunk compartment with a disc grinder. Be sure to leave the finishing allowance.

NOTE: Take care not to grind excessively.

7. Apply the sealer (see [section 5](#)).
8. 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.**

9. Apply the undercoat (see [section 7](#)).
10. Install the related parts.
Install in the reverse order of removal.
11. Check and clean.
 - Check the rear wheel alignment.
 - Clean the trunk compartment.