

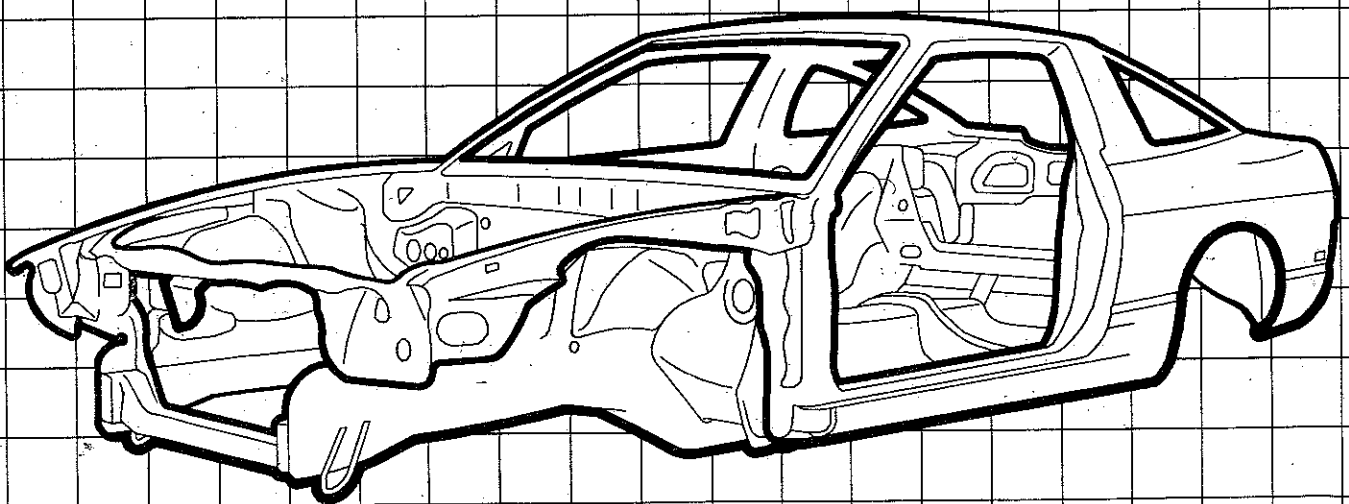


# NISSAN

# MODEL **S13** SERIES

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# BODY REPAIR MANUAL



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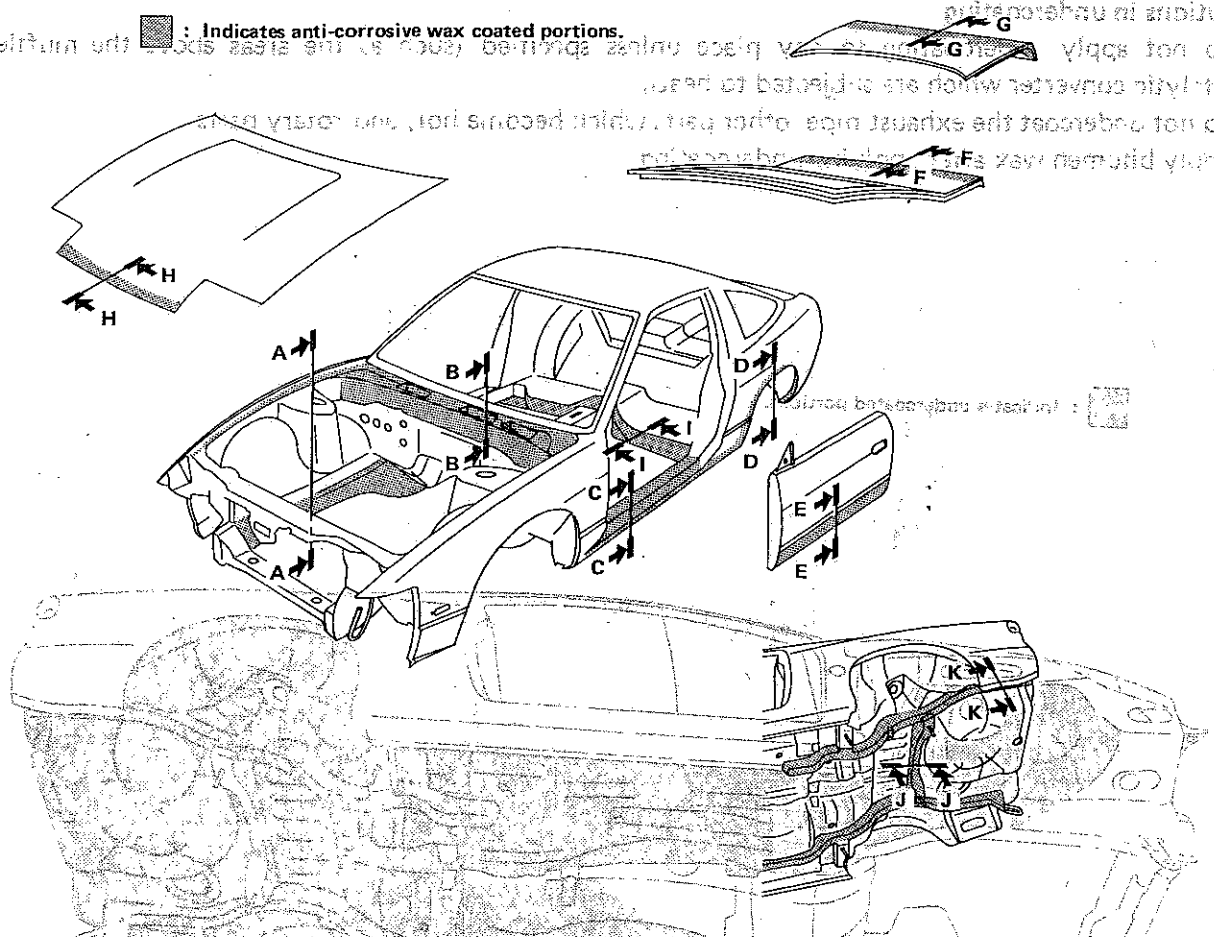
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# CORROSION PROTECTION

## ANTI-CORROSIVE WAX

In order to improve corrosion resistance, anti-corrosive wax is applied inside the body sill and inside other closed sections. Accordingly, when replacing these parts, be sure to apply anti-corrosive wax to the appropriate areas of the new parts. Select an excellent anti-corrosive wax which will penetrate after application and has a long shelf life.

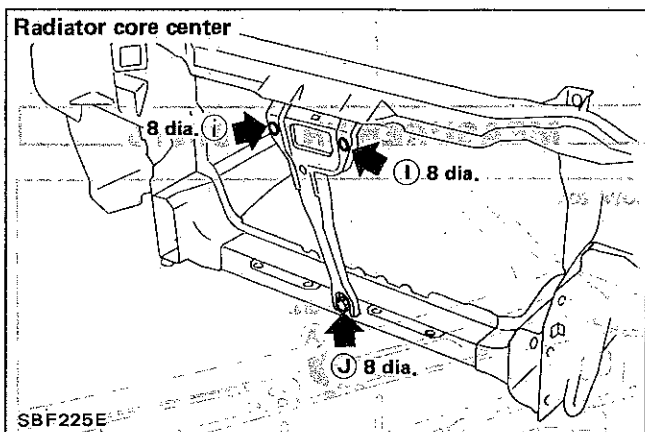
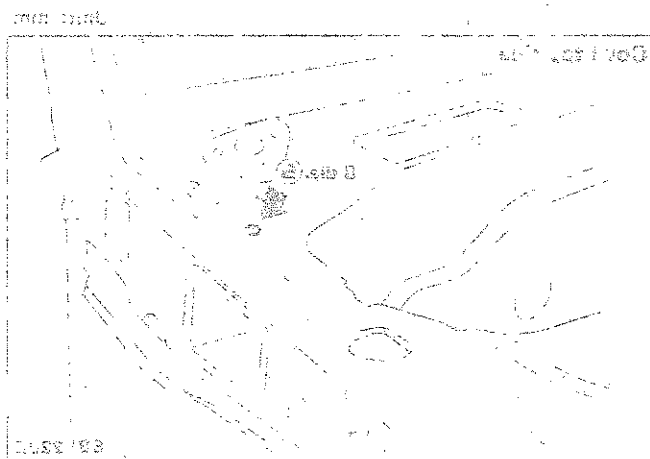
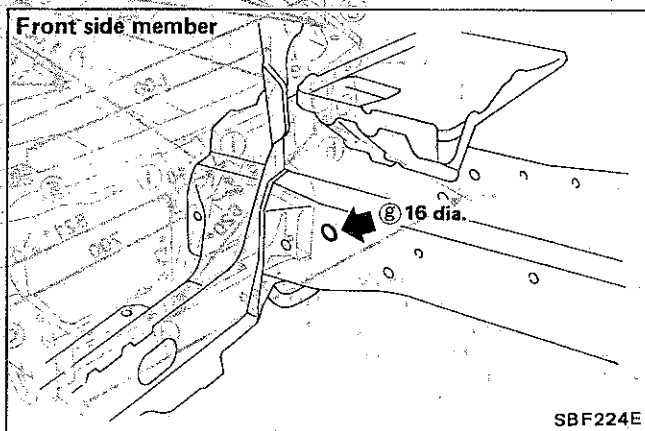
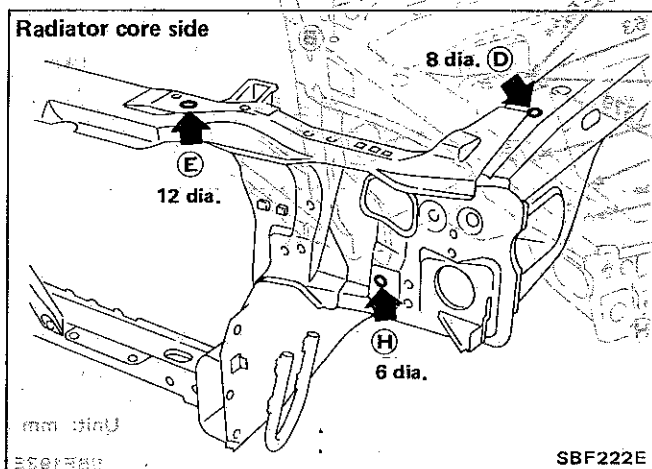
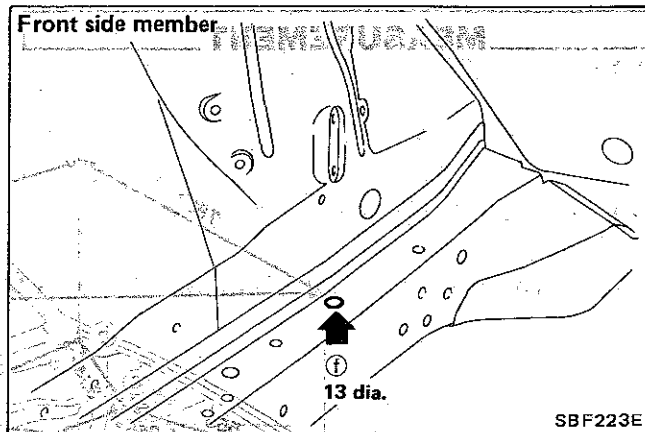
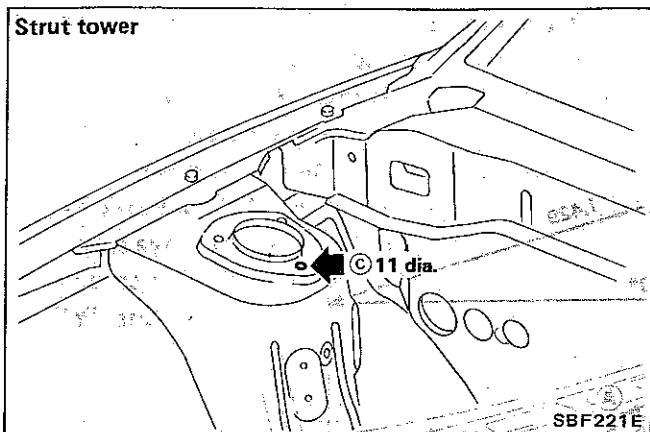
: Indicates anti-corrosive wax coated portions.



Section A-A	Section C-C	Section E-E	Section G-G	Section I-I	Section K-K
 Front fender Hoodedge reinforcement Front side member	 Inner sill Outer sill	 Inner door Outer door	 Outer trunk lid Inner trunk lid	 Rear floor Front floor	 Rear floor rear Rear floor side Rear side member Rear fender
Section B-B	Section D-D	Section F-F	Section H-H	Section J-J	
 Air box Lower dash	 Outer rear wheelhouse Rear fender	 Fastback model Outer trunk lid Inner trunk lid	 Outer hood Inner hood	 Rear floor rear Center crossmember	

# BODY ALIGNMENT

## ENGINE COMPARTMENT



## HANDLING PRECAUTIONS FOR PLASTICS

# HANDLING PRECAUTIONS FOR PLASTICS

Abbreviation	Material name	Heat resisting temperature °C (°F)	Resistance to gasoline and solvents	Other cautions
PE	Polyethylene	80 (176)	Gasoline and most solvents are harmless.	Flammable
PVC	Polyvinyl chloride	90 (194)	Gasoline and most solvents are harmless if applied for a very short time (wipe up quickly).	Poison gas is emitted when burned.
PP	Polypropylene	90 (194)	Gasoline and most solvents are harmless.	Flammable
ABS	Acrylonitrile butadiene styrene resin	90 (194)	Avoid gasoline and solvents.	Avoid brake fluid.
AES	Acrylonitrile ethylene styrene	90 (194)	Avoid gasoline and solvents.	Avoid brake fluid.
PMMA	Polymethyl methacrylate	90 (194)	Avoid gasoline and solvents.	Avoid brake fluid.
PUR	Polyurethane	90 (194)	Gasoline and most solvents are harmless.	Avoid brake fluid.
AAS	Acrylonitrile acrylic rubber styrene	95 (203)	Avoid gasoline and solvents.	Avoid brake fluid.
PPO	Polyphenylene oxide	110 (230)	Avoid gasoline and solvents.	
POM	Polyacetal	120 (248)	Gasoline and solvents are harmless.	Avoid battery acid.
PC	Polycarbonate	120 (248)	Avoid gasoline and solvents.	
PA	Polyamide (Nylon)	150 (302)	Gasoline and most solvents are harmless.	Avoid immersing in water.
FRP	Fiber reinforced plastics	170 (338)	Gasoline and most solvents are harmless.	
PPC	Polypropylene composite	115 (239)	Gasoline and most solvents are harmless.	Flammable
PBT	Polybutylene terephthalate	140 (284)	Gasoline and most solvents are harmless.	
TPR	Thermoplastic rubber	80 (176)	Avoid gasoline and solvents.	
TPE	Thermoplastic elastomer	80 (176)	Avoid gasoline and solvents.	

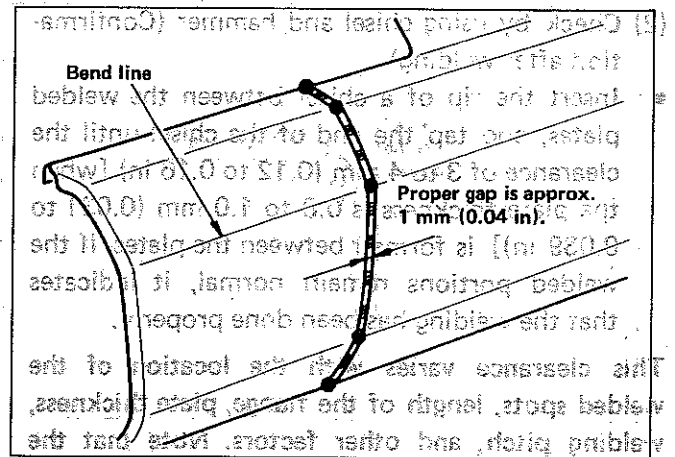
1. When repairing and painting a portion of the body adjacent to plastic parts, consider their characteristics (influence of heat and solvent) and remove them if necessary or take suitable measures to protect them.
2. Plastic parts should be repaired and painted using methods suiting the materials.

## PRECAUTIONS

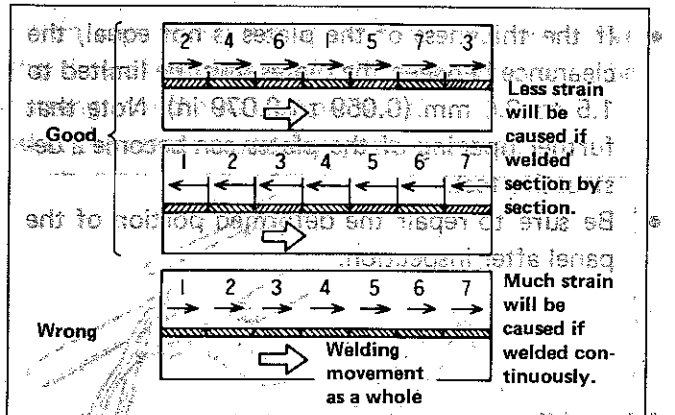
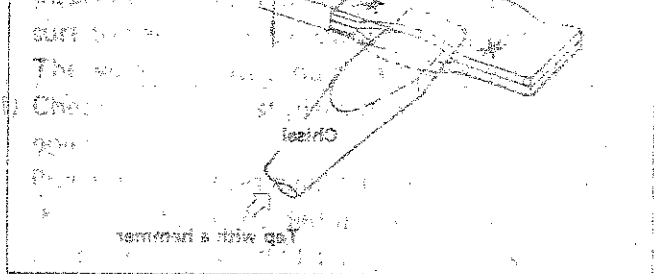
### PRECAUTIONS IN OPERATION

**(2) Butt welding**

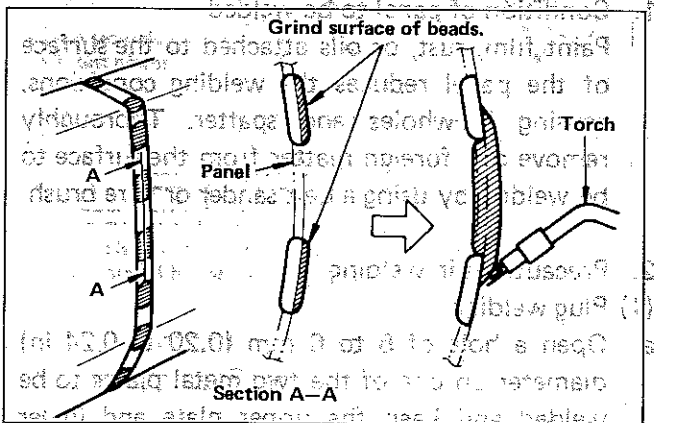
- a. Before performing this welding, tack-weld two pieces of the metals to be welded to prevent generation of strains and to align two metal surfaces. Tack two metal pieces by placing point welds and then fill in the spaces by placing short welding beads.



- b. Long weld line is apt to cause strain. Use the method shown at the left to reduce strain.

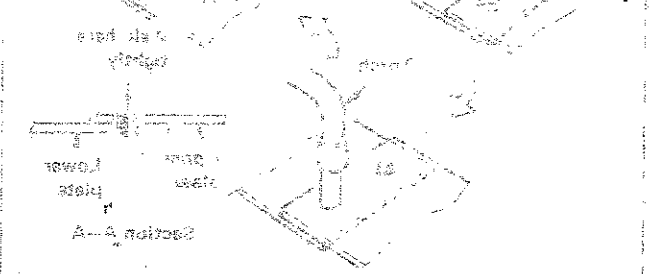


- c. To fill the spaces between intermittently placed beads, first grind the beads along the surface of the panel using a sander, then fill metal into the space. If weld metal is placed without grinding the surface of the beads, blowholes may be produced.



**3. Inspection of welded portion**

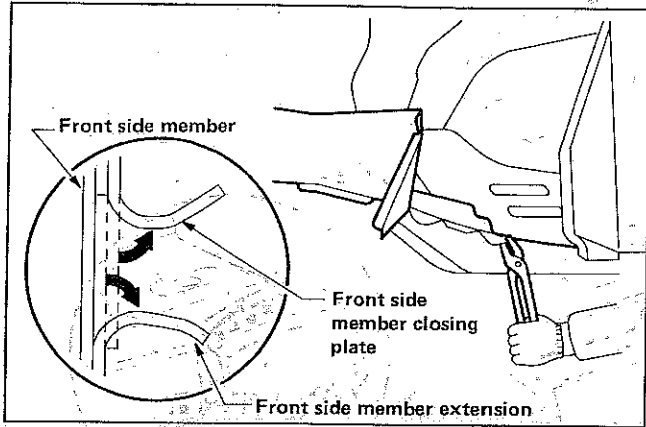
Refer to the inspection method described for spot welding.



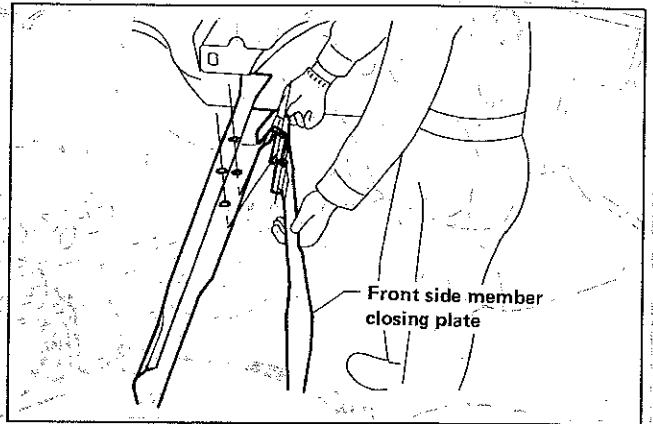
# REPLACEMENT OPERATIONS

## FRONT SIDE MEMBER

- Bend panels as shown in figure to facilitate removal.

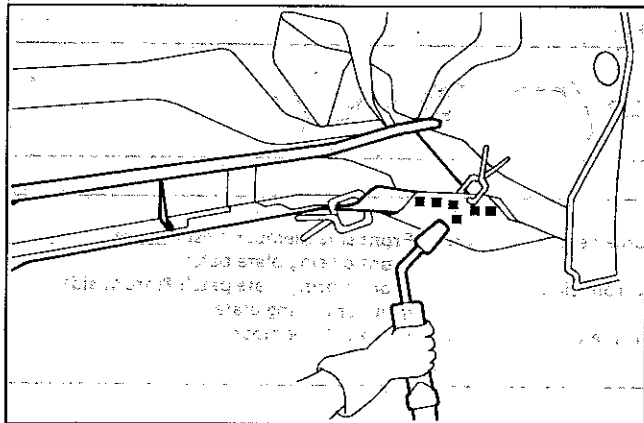


- Align front suspension member hole, when installing front side member closing plate.

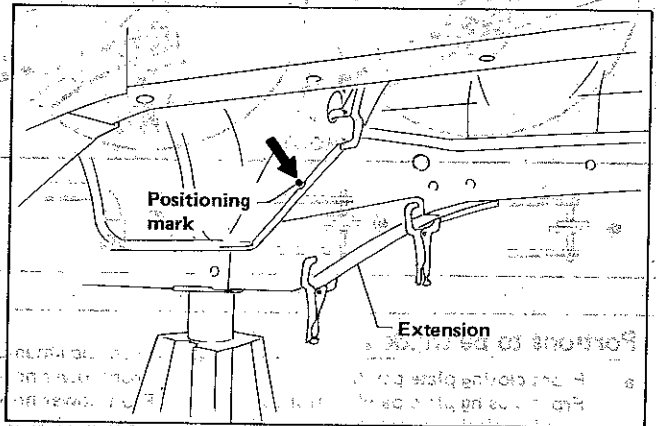


### INSTALLATION NOTES

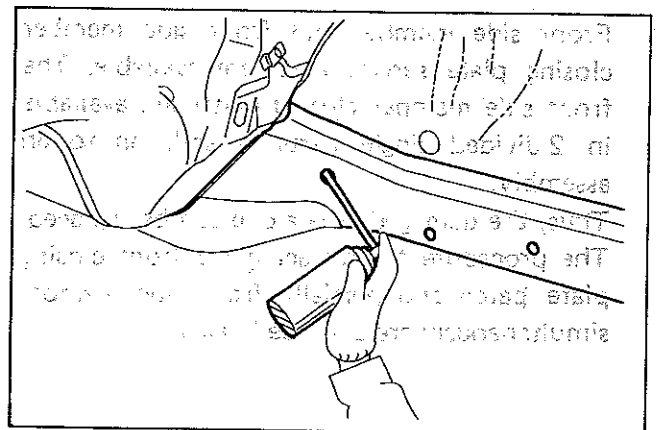
- Install front side member, correct bent front side member extension, then weld front side member and front side member extension.



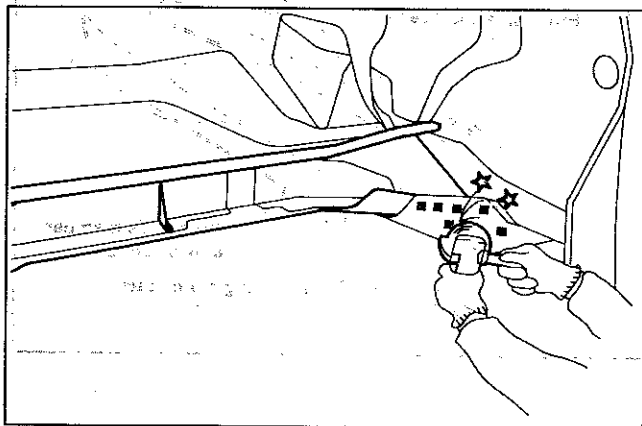
- Align service part with lower dash panel positioning mark when installing.



- Apply anti-corrosive agent to inside of front side member.



- Grind welded portions.

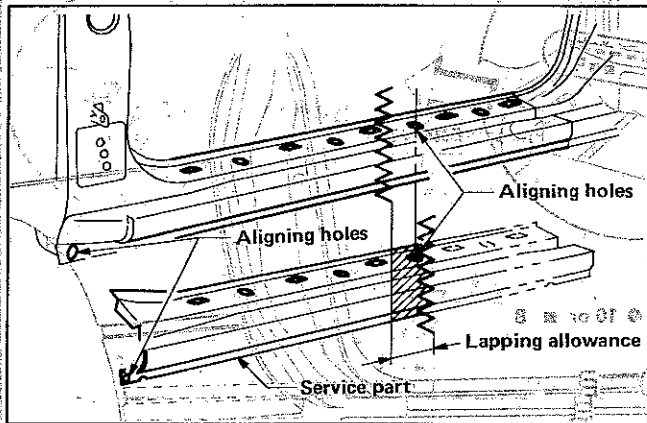


## REPLACEMENT OPERATIONS

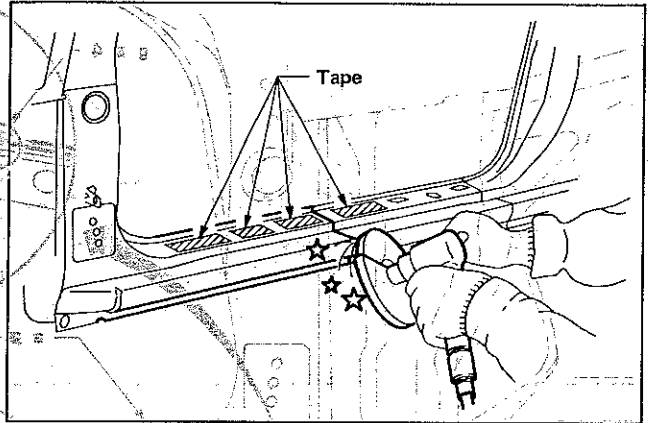
### OUTER SILL (Partial Replacement)

#### INSTALLATION NOTES

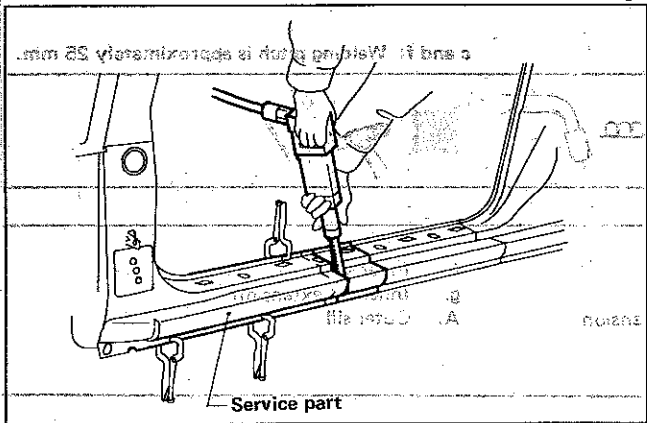
- Cut off service part, leaving its hole in same position as that of vehicle body for positioning.



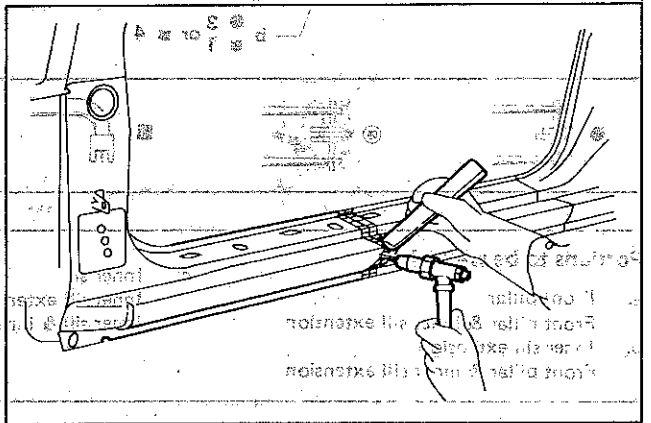
- When dressing butt weld part, cover up holes in upper part of outer sill with tape to prevent chips from entering.



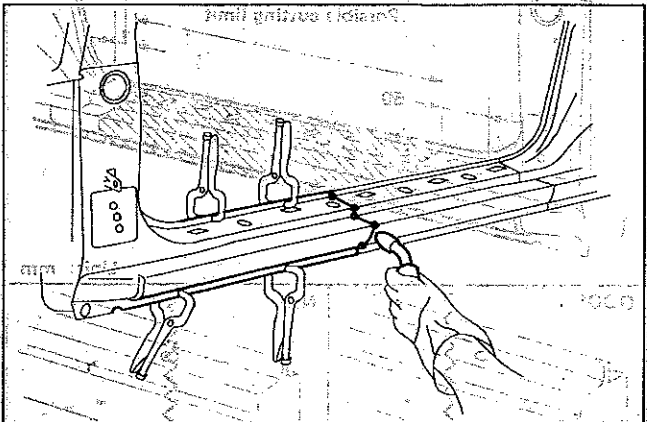
- Place service part, align its hole with that of vehicle body, and perform overlap cutting.



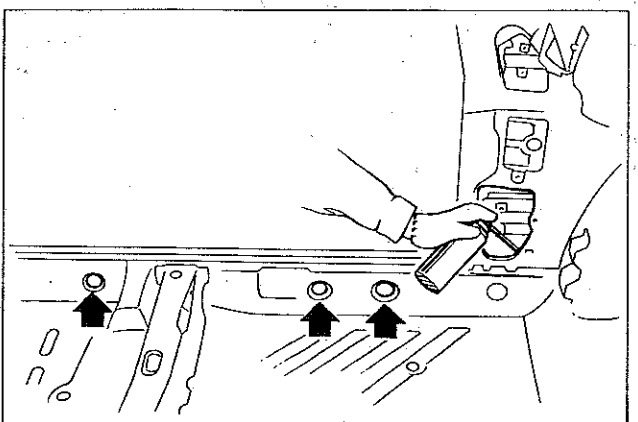
- If butt welded part at portion (A) is not smooth enough after sanding, finish by soldering.



- When welding, temporarily weld each press line first to prevent movement.



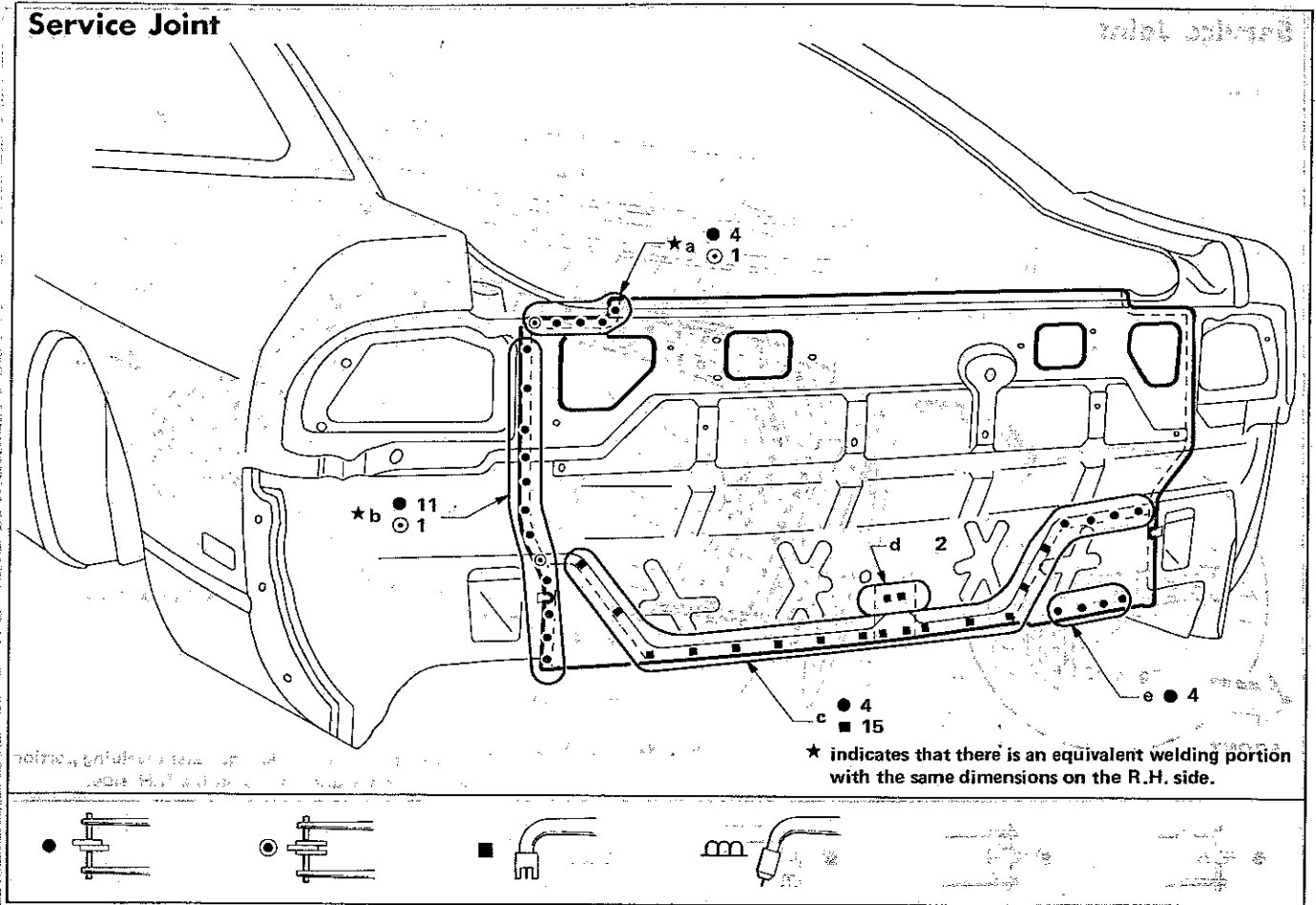
- Be sure to treat inside of outer sill with an anti-corrosive agent.



# REPLACEMENT OPERATIONS

## REAR PANEL

FAST BACK



**Portions to be welded**

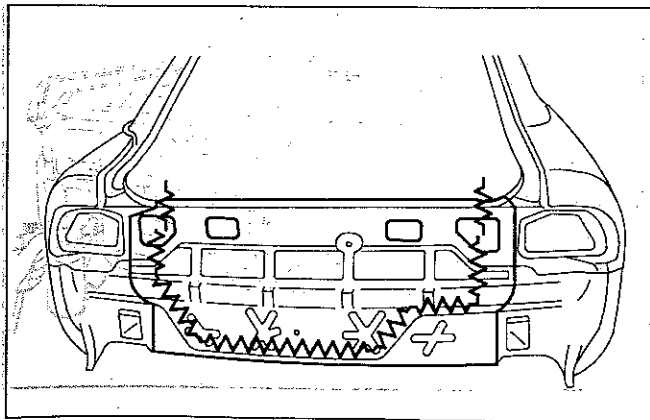
a. Rear fender corner  
Rear fender corner & rear combination lamp base

b. Rear combination lamp base  
Rear combination lamp base & rear floor rear  
c. Rear floor rear  
Rear floor rear & fuel tank bracket

d. Fuel tank bracket  
e. Rear floor rear reinforcement

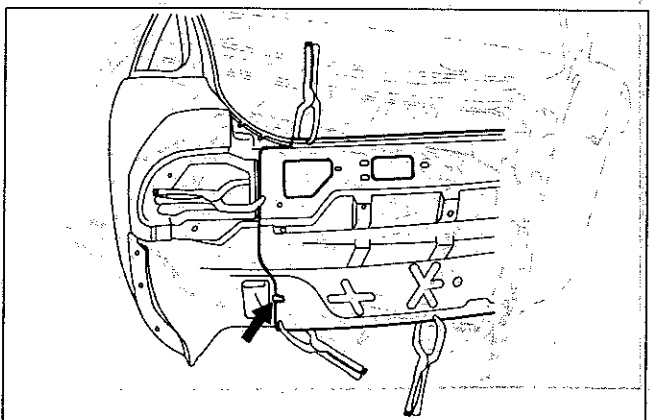
**REMOVAL NOTE**

- Cut off damaged portion so that welded part can be easily spot cut later.



**INSTALLATION NOTE**

- When installing service part, align locating holes.



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