

8. Roof Panel

The roof panel is attached to the steel roof structure with beads of adhesive on the sides, and spot welds on the windshield and back glass flanges. Replacement of the roof panel can be performed using conventional procedures, however, the windshield and back glass must be removed (figure 8-1).

— Notice —

*Use care when cutting to protect adjacent panels.
Make sure to cut inboard of the roof structure.*

Remove or Disconnect

1. Remove all related panels and components.
2. Visually inspect and restore as much of the damage as possible to the factory specifications.
3. Remove all sealers, sound deadeners, and anti-corrosion materials as necessary.
4. Locate, mark, and drill out all factory welds. Note the number and location of welds for installation of the service assembly.

— Notice —

There are three welds along each side of the roof panel that must be drilled for roof removal.

5. Cut the original roof panel along the sides leaving approximately 75mm (3 inches) remaining attached.
6. After removing the panel, cut the adhesive with an appropriate tool and remove the remaining portion of the original panel.

Install or Connect

1. Clean and prepare the attaching surfaces for welding.
2. Drill 8mm ($\frac{5}{16}$ inch) holes for plug welding along the windshield and back glass edges of the service panel as noted from the original panel. Drill the holes for plug welding along the sides every 40mm (1½ inches). NOTE: Adhesive is not required for service panel installation.
3. Position the service panel, check the fit, then plug weld accordingly.

— Important —

*Refer to Service Bulletin #43-10-48
for more detailed information.*

4. Prime with two-part catalyzed primer. Do not combine paint systems. Refer to paint manufacturer's recommendations.
5. Install all related panels and components.

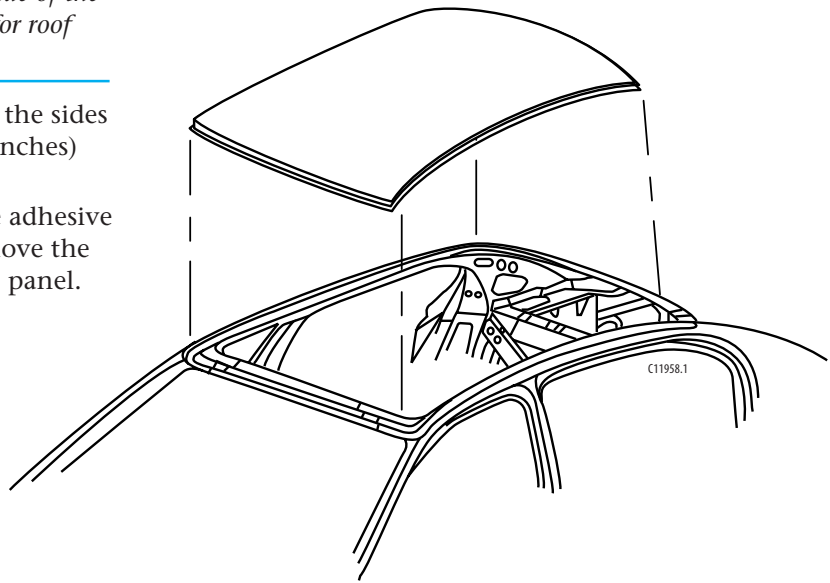


Figure 8-1:
Roof Panel Service