

Roof Outer Replacement

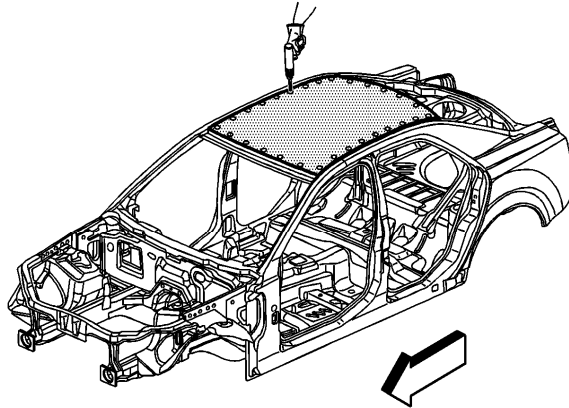
Removal Procedure

Caution: Refer to [Approved Equipment for Collision Repair Caution](#) in Cautions and Notices.

The roof panel is attached to the steel roof structure with beads of adhesive on the sides and spot-welds on the side rail, 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. Factory roof panel is attached with spot welds on the side rails, the service part will use adhesive only on both side rails.

Important: Use care when cutting to protect adjacent panels. Cut inboard of the roof structure.

1. Disable the SIR system. Refer to [SIR Disabling and Enabling](#) .
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) .
3. Remove all related panels and components.
4. Visually inspect the damage. Repair as much of the damage as possible.
5. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .
6. Locate and mark all factory welds.

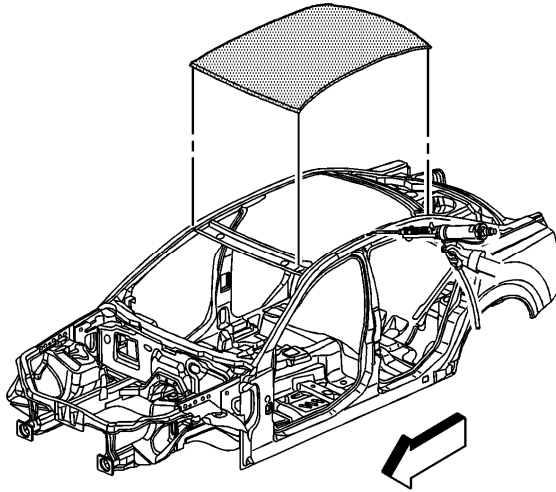


7. Drill all factory welds. Note the number and location of welds for installation of the service assembly.
8. Cut the adhesive with an appropriate tool after removing the panel.
9. Remove the remaining portion of the original panel.

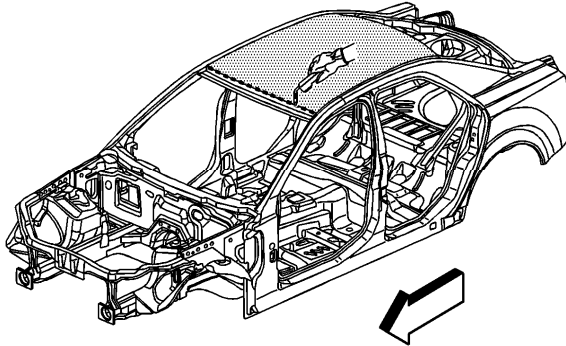
Installation Procedure

1. Clean and prepare the attaching surfaces for welding.
2. Drill 8 mm (5/16 in) 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 front and rear flanges every 40 mm (1 1/2 in).

3. Position the service panel.



4. Install the panel using one-part windshield urethane to side flanges.
5. Inspect the fit.



6. Plug weld accordingly.
7. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .
8. Paint the repaired area. Refer to [Basecoat/Clearcoat Paint Systems](#) .
9. Install all related panels and components.
10. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) .
11. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) .