

Roof Panel

Notice: The headliner, windshield, and backglass must be removed prior to the removal of the roof assembly. Protect the interior of the vehicle by covering it or removing it, and use care when working near adjacent panels, glass, weatherstrips and moldings. It is recommended the seats be removed to avoid damage due to the overhead welding required to service the roof assembly (Fig. 4.25).

Important: On vehicles equipped with a sunroof, take care not to damage the drain tubes. The drain tubes are located between the inner and outer body components.

— REMOVE OR DISCONNECT —

- 1 Remove all related panels and components necessary to access the welds attaching the roof assembly to the vehicle.
- 2 Restore as much of the damage as possible to factory specifications.

- 3 Remove sealers 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 panel.
- 5 Locate the factory weld joint at the sail panel (Fig. 4.26). Apply heat and wire brush to remove silicone-bronze material from area. Separate the roof panel from the quarter sail panel.
- 6 Remove the damaged roof panel assembly.

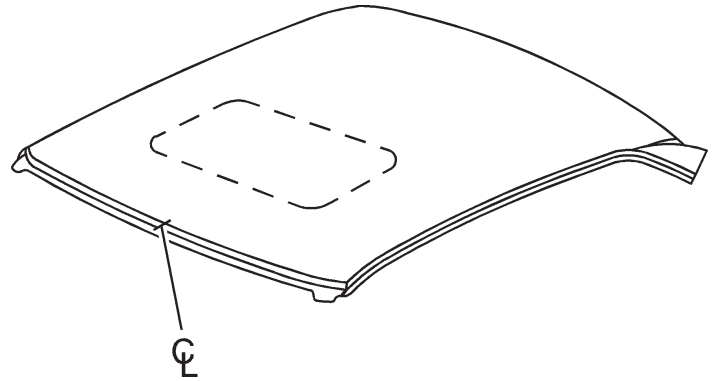


Fig. 4.25 — Die Mark Indicates Center Line in Roof

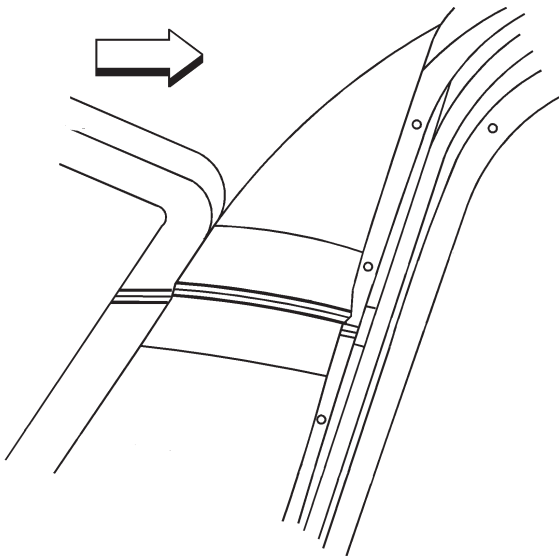


Fig. 4.26 — Factory Weld

Roof Panel

— INSTALL OR CONNECT —

- 1 Drill 8mm (5/16 inch) holes for plug welding at the sail panel over-lap joint, and around the perimeter of the panel as noted from the original roof panel.
- 2 Clean and prepare the mating surfaces as necessary.
- 3 Position the roof panel on the vehicle. Check fit and alignment (Fig. 4.27).
- 4 When the service assembly is correctly positioned, plug weld accordingly. Stitch weld the roof panel at the sail panel seam.
- 5 Clean and prepare all bare metal surfaces. Apply as necessary:
 - sealers and anti-corrosion materials
 - sound deadeners
 - two-part catalyzed primer
 - top-coat

Important: Do not combine paint systems. Refer to paint manufacturer's recommendations.
- 6 Apply GM Goodwrench structural bonding epoxy (part #12345726) or equivalent, to the roof panel stiffener and position according to original roof panel.
- 7 Install the panels and components previously removed for access.

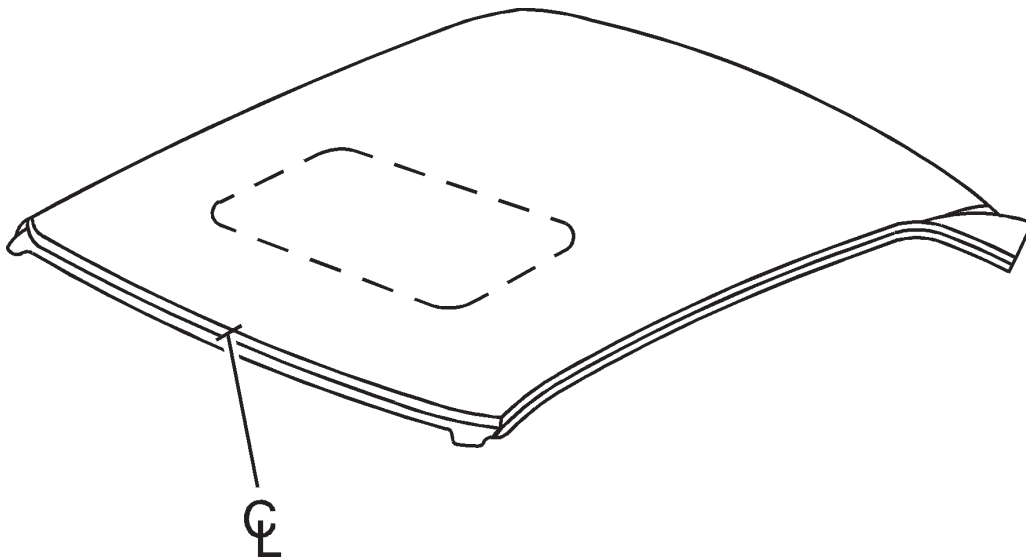


Fig. 4.27 — Die Mark Indicates Center of Roof