

Roof Outer Panel Replacement

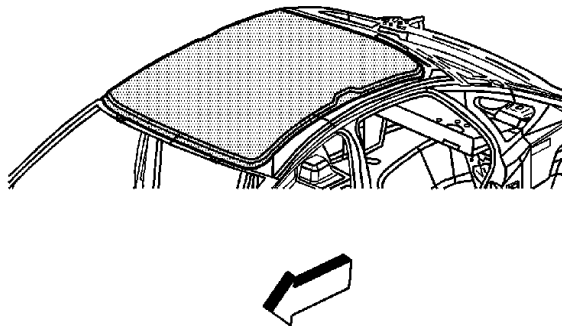
Removal Procedure

Important: Deformation of the roof panel is highly noticeable in terms of the vehicle's outer appearance. Before replacing the roof, make sure that the body is horizontal.

Before welding the roof panel, adjust the frame door opening flanges so that they contact the roof panel. Pay particular attention to twists and parallelism.

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

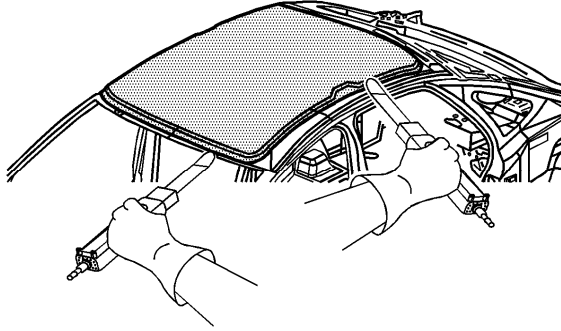
1. Disable the SIR system. Refer to [SIR Disabling and Enabling](#) .
2. Disconnect the negative battery cable.
3. Take note of the gap sizes along the perimeter of the roof panel to the headers, the glass, and the doors.



4. Remove all related panels and components.
5. Repair as much of the damaged area as possible. Refer to [Dimensions - Body](#) .
6. Note the location and remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .

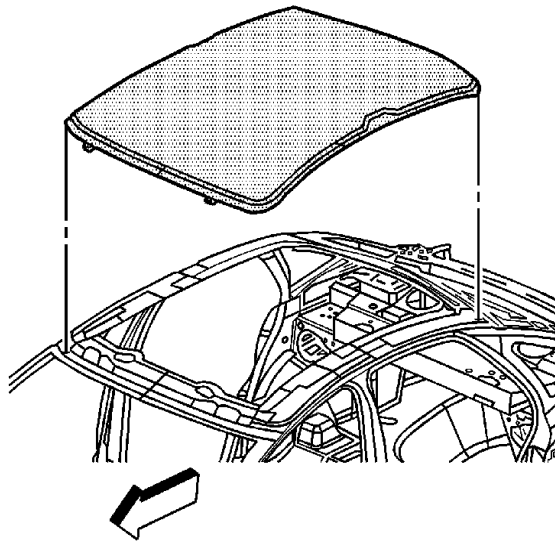
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7. Remove the 4 nuts that retain the front and rear of the roof panel to the front and rear header panels.



Important: Do not damage any inner panels or reinforcements.

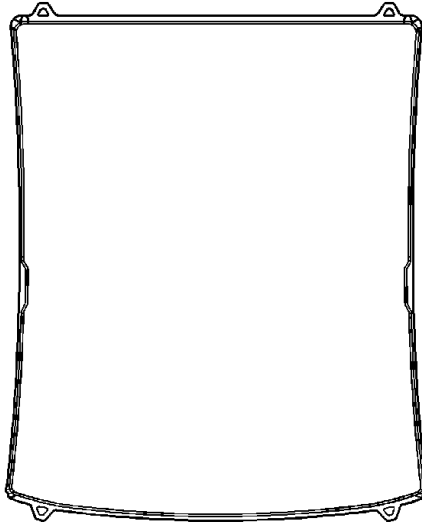
8. Locate and cut the urethane adhesive holding the roof panel to the vehicle. Note the location of the adhesive for installation of the roof panel.



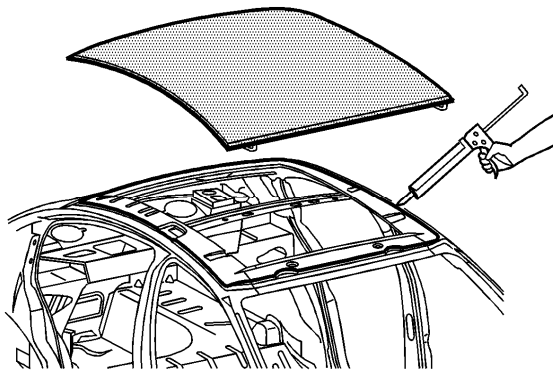
9. Remove the damaged roof panel.

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Installation Procedure



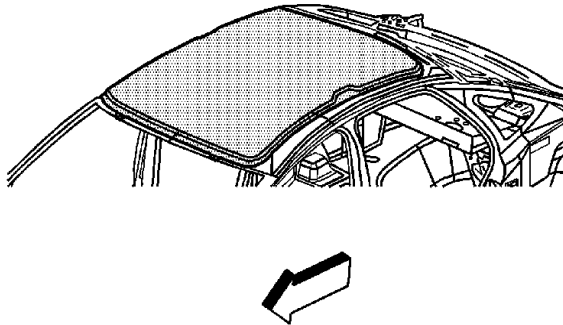
1. Prepare all mating surfaces as necessary.
2. Use pinchweld primer #2 from the glass kit GM P/N 12346392. Shake the pinchweld primer for at least 1 minute.
3. Apply the black #2 primer with a new applicator dauber to the primer locations noted from the original panels.
4. Allow the black #2 primer to dry for approximately 10 minutes.



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Important: Place the urethane adhesive on the outboard side of the roof panel stud hole locations.

5. Place a 10 mm (3/8 in) diameter bead of urethane adhesive GM P/N 12346392 on the perimeter of the vehicle roof attachment points.



6. Position the roof panel on the vehicle.
7. Verify the fit of the roof panel to the front edge of the front header panel and to the rear edge of the rear header panel.
8. Verify the fit of the roof panel at the gap along the top of the door frame to the roof panel. Adjust the panel if necessary.

Notice: Refer to [Fastener Notice](#) in Cautions and Notices.

9. Install the 4 nuts at the front and rear header panels.

Tighten

Tighten the nuts to 8-12 N·m (3.1-4.7 lb in).

10. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .
11. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#) .
12. Install all related panels and components.
13. Connect the negative battery cable.
14. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) .