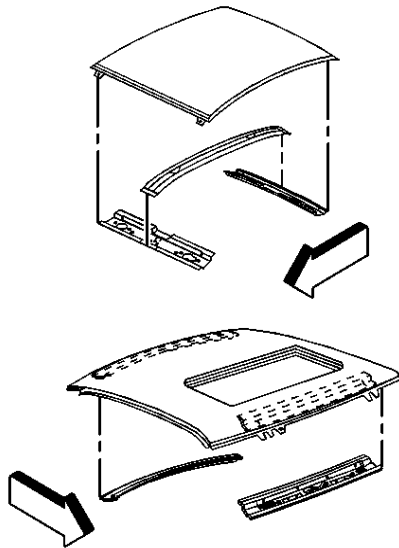


Roof Outer Replacement

Removal Procedure

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

Important: The roof panel is serviced as a complete assembly, including the outer panel and the inner reinforcements. The roof panel is attached by a number of welds which must be drilled to remove the outer panel and inner reinforcements for servicing.

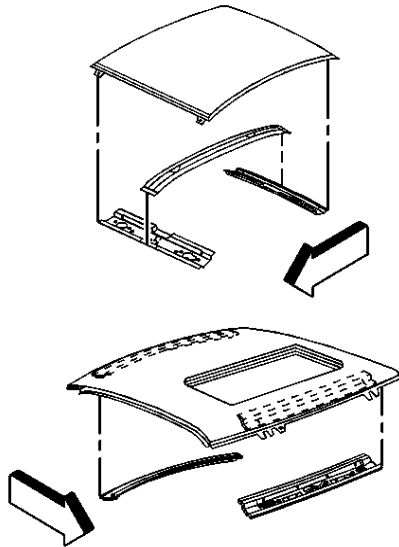


1. Remove all related panels and components necessary to access the welds attaching the roof assembly to the vehicle.
2. Visually inspect and restore as much of the damage as possible.
3. Remove sealers and anti-corrosion materials as necessary.
4. Locate, mark, and drill out all factory welds. Note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

Important: A second person may be needed to safely remove the roof assembly and prevent damage to the vehicle.

5. Remove the damaged roof panel assembly.

Installation Procedure



1. Clean and prepare the mating surfaces as necessary.
2. Position the roof panel on the vehicle.
3. Check fit and alignment.
4. Correctly position the service assembly and plug weld accordingly.
5. Clean and prepare all welded surfaces.
6. Prime with 2-part catalyzed primer.
7. Apply sealers and anti-corrosion materials as necessary.

Important: Prior to refinishing, refer to GM 4901MD-99 Refinish Manual for recommended products. Do not combine paint systems. Refer to paint manufacturer's recommendations.

8. Install all related panels and components.
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