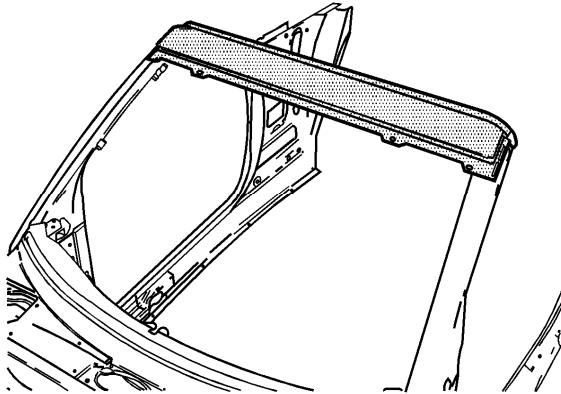


# Roof Front Header Inner Panel Replacement

## Removal Procedure

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

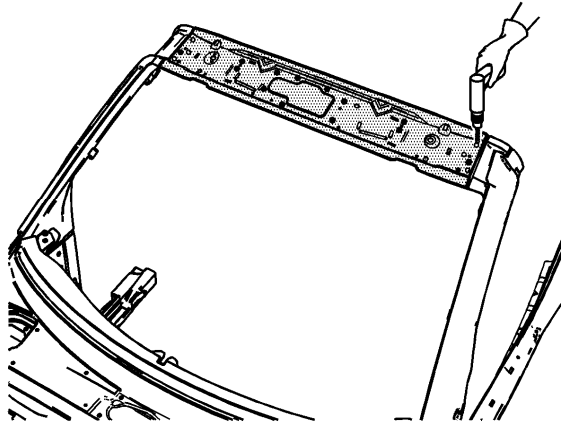
1. Disable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.



3. Remove all related panels and components including the outer header panel. Refer to [Windshield Frame Header Front Panel Replacement](#) .
4. Repair as much of the damage as possible to factory specifications. Refer to Windshield Opening in [Dimensions - Body](#) .

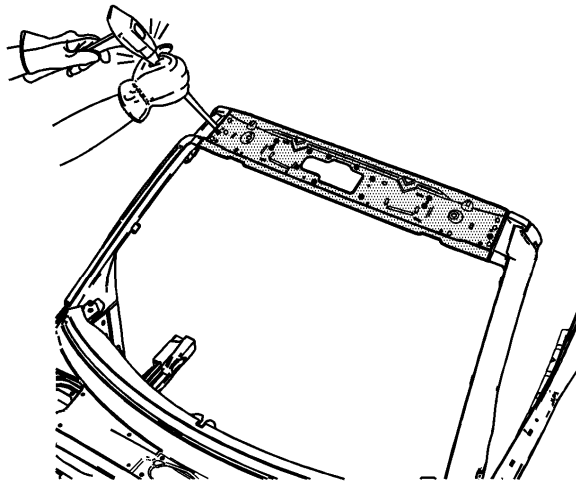
**Caution:** Refer to [Foam Sound Deadeners Caution](#) in Cautions and Notices.

5. Note the location and remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.

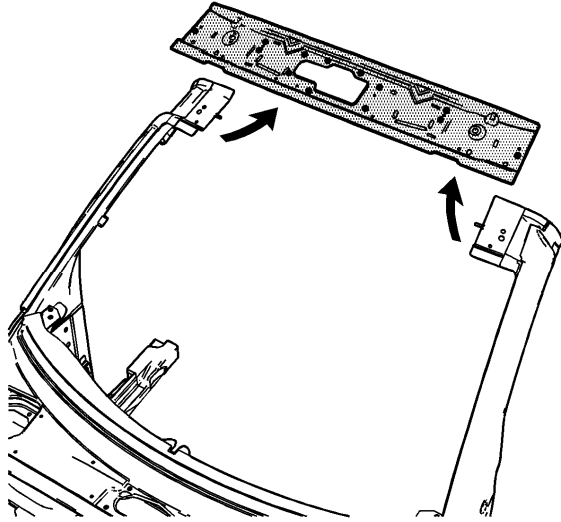


**Important:** Do NOT damage any inner panels or reinforcements.

6. Locate and drill out all factory welds. Note the number and location of the welds for installation of the front header inner panel.

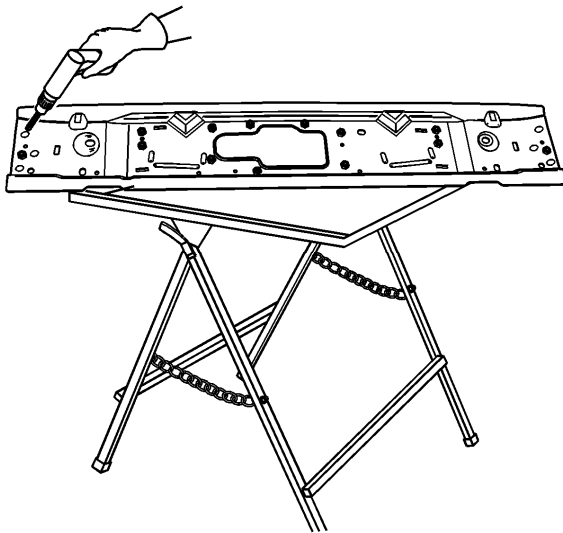


7. Verify the existence of structural weld-through adhesive. Refer to [Structure Adhesive - Identification](#) . If necessary use a chisel to separate the damaged panel from the upper A-pillars.



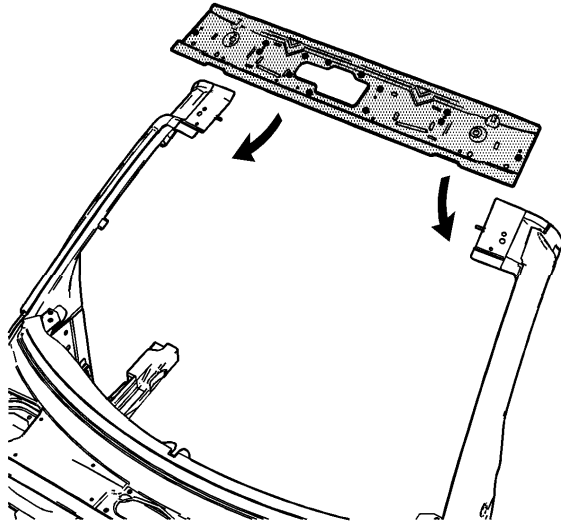
8. Remove the damaged header inner panel.

### Installation Procedure

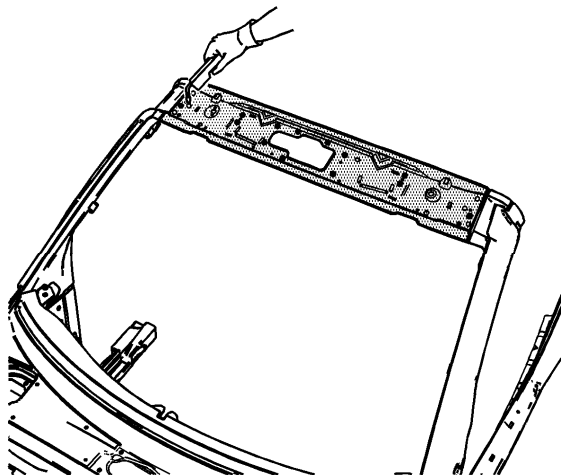


**Important:** If the location of the original plug welds cannot be determined, or where structural weld-through adhesive was present, space the plug weld holes every 40 mm (1½ in) apart.

1. Drill 8 mm (5/16 in) plug weld holes in the service part as necessary in the locations noted from the original panel.
2. Replace the structural adhesive with an additional plug weld between existing plug welds where necessary.
3. Prepare all mating surfaces as necessary.
4. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#) .



5. Position the front header inner panel. Refer to Windshield Opening in [Dimensions - Body](#) .



6. Plug weld accordingly.

7. Install the windshield frame header panel. Refer to [Windshield Frame Header Front Panel Replacement](#) .
8. Clean and prepare all welded surfaces.
9. Apply the sealers and the anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.
10. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#) in Paint and Coatings.
11. Install all related panels and components.
12. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.
13. Enable the SIR. Refer to [SIR Disabling and Enabling](#) in SIR.