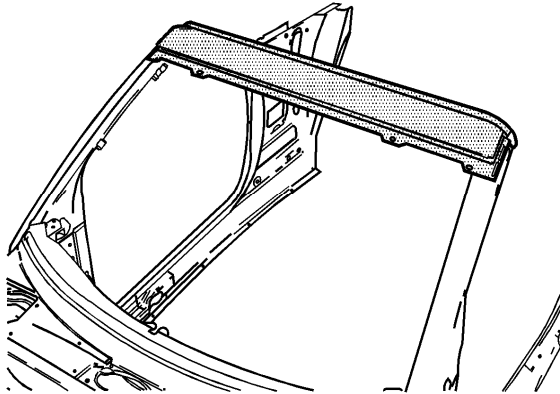


Windshield Frame Header Front Panel Replacement

Removal Procedure

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

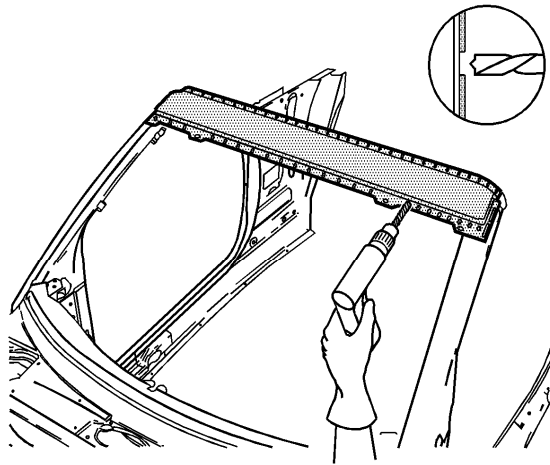
1. Disable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.



3. Remove all related panels and components.
4. Repair as much of the damage as possible to factory specifications. Refer to Windshield Opening in [Dimensions - Body](#) .

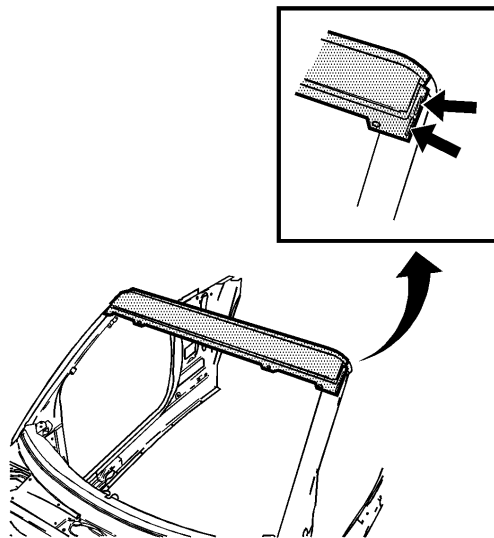
Caution: Refer to [Foam Sound Deadeners Caution](#) in Cautions and Notices.

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.

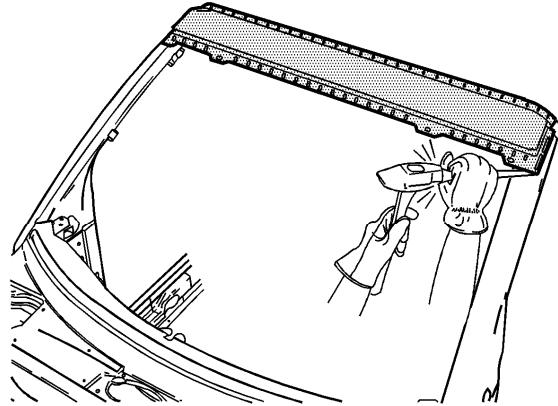


Important: Do not damage any inner panels or reinforcements.

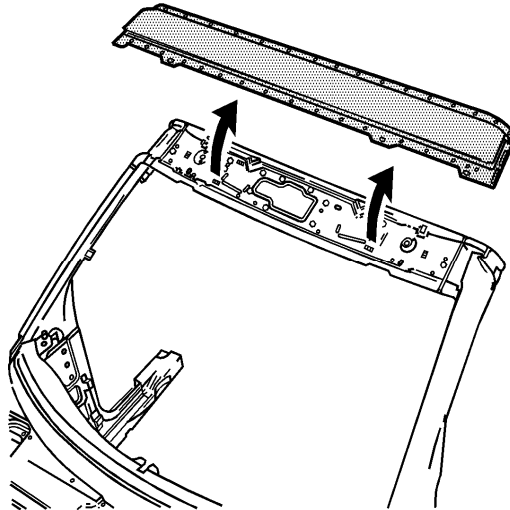
6. Locate and drill out all factory welds. Note the number and location of welds for installation of the header panel.



7. Using a grinder or an equivalent tool, remove the MIG welds on each end of the header.

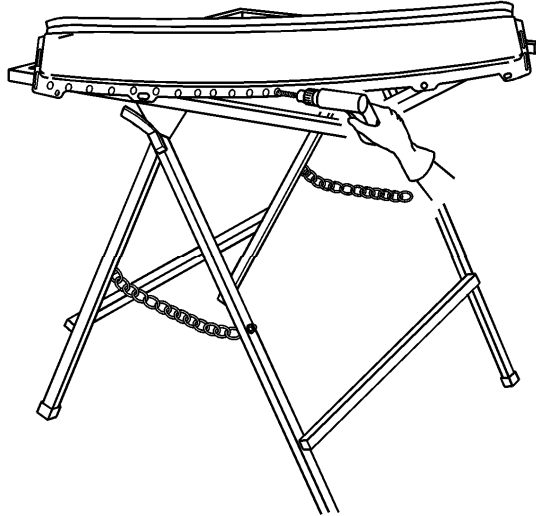


8. Verify the existence of structural weld-through adhesive. Refer to [Structure Adhesive - Identification](#) . If necessary use a chisel to separate the outer header panel from the inner header panel.

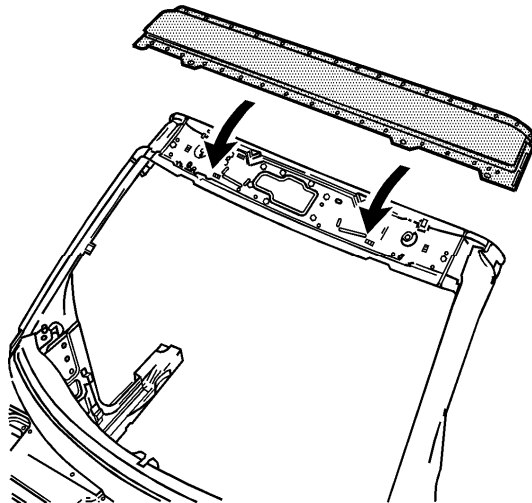


9. Remove the damaged header panel.

Installation Procedure

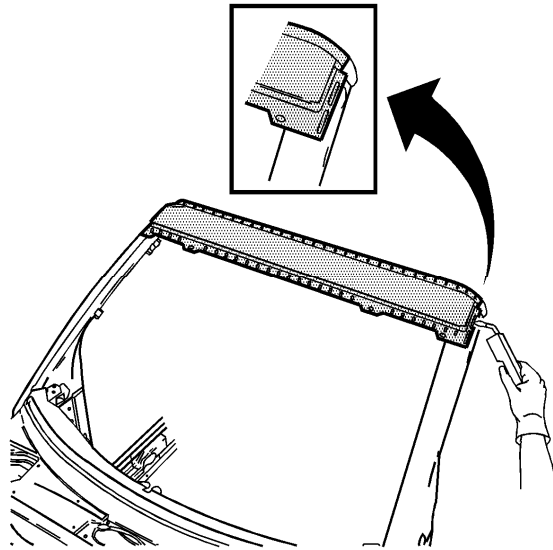


1. Drill 8 mm (5/16 in) plug weld holes in the service part as necessary at the locations noted from the original header panel.
2. Replace the structural adhesive with an additional plug weld between the existing plug welds, where necessary.
3. Prepare all mating surfaces as necessary.
4. Apply GM-approved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

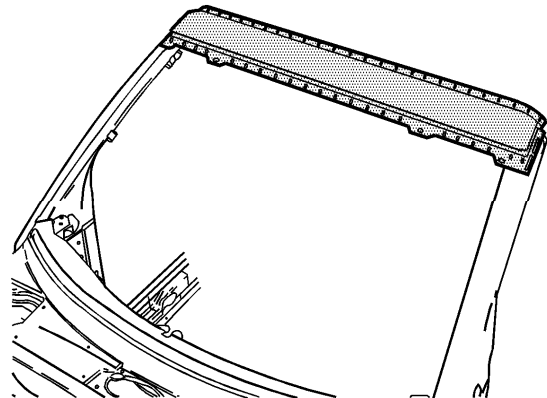


5. Position the header panel. Refer to Windshield Opening in [Dimensions - Body](#) .

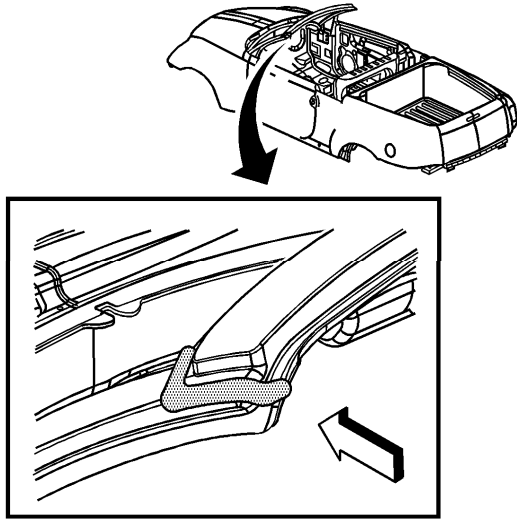
6. Plug weld accordingly.



7. Continuous weld 2 slots in each side of the outer header panel.



8. Clean and prepare all welded surfaces.



9. Apply the sealers and 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 system. Refer to [SIR Disabling and Enabling](#) in SIR.