

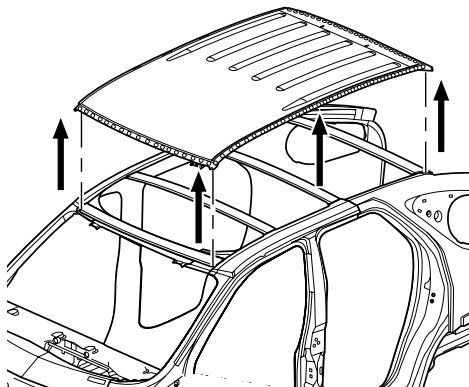
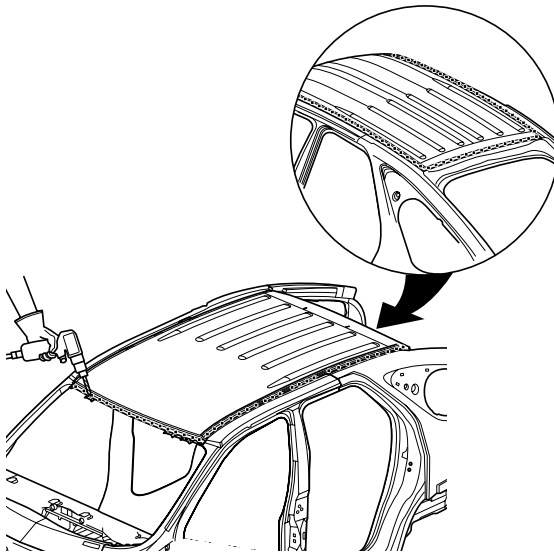
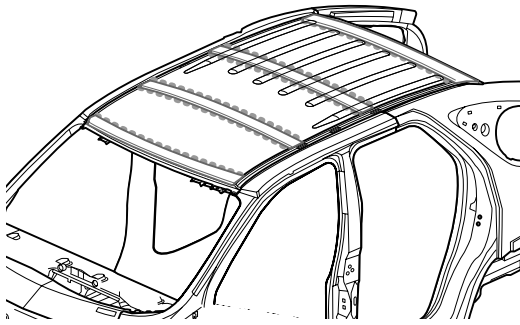
# Roof Outer Replacement

## Removal Procedure

1. Remove all related panels and components.
2. Restore as much of the damage as possible to factory specifications.
3. Note the location and remove the following as necessary:
  - Sealers
  - Sound deadeners
  - Anti-corrosion materials

**IMPORTANT:** Do not damage any inner panels or reinforcements.

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



5. Remove the damaged roof panel.

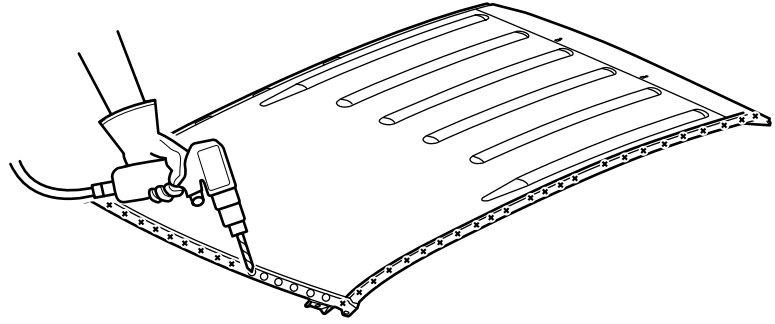
# Roof Outer Replacement

## Installation Procedure

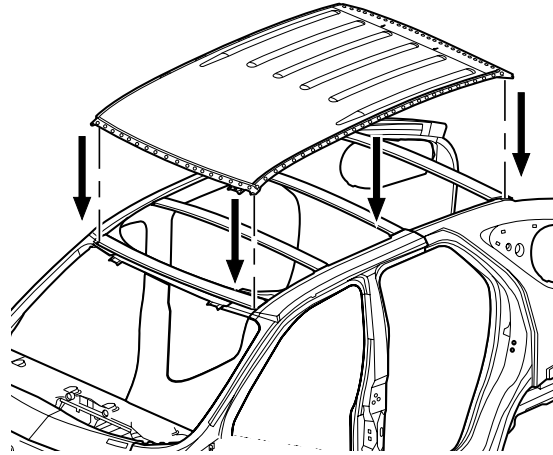
1. Drill 8 mm (5/16 in.) plug weld holes as necessary in locations noted from the original panel.

*IMPORTANT: In any area damaged beyond recognition, space plug weld holes every 40 mm (1-1/2 in.) apart.*

2. Prepare all attachment surfaces as necessary.
3. Apply weld-thru primer to all bare-metal surfaces.



4. Position the roof panel.



5. Plug weld accordingly.
6. Clean and prepare all welded surfaces.

*IMPORTANT: Prior to refinishing, refer to publication GM4901M-D-00 GM Approved Refinish Materials for recommended products. Do not combine paint systems. Refer to paint manufacturer's recommendations.*

7. Apply the following as necessary:
  - An anti-corrosion primer
  - Sound deadeners
  - Sealers
8. Refinish as necessary.
9. Install all related panels and components.

