

## Rear Window Frame Header Panel Replacement - Rear

### Removal Procedure

**Caution:** Refer to *Approved Equipment for Collision Repair Caution* on page 1-1.

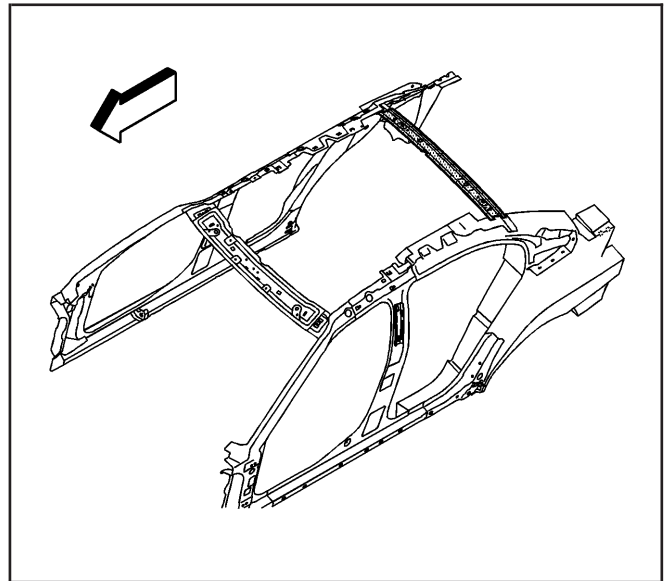
1. Disable the SIR system. Refer to *SIR Disabling and Enabling Zones* on page 1-129.

**Caution:** Refer to *Battery Disconnect Caution* on page 1-1.

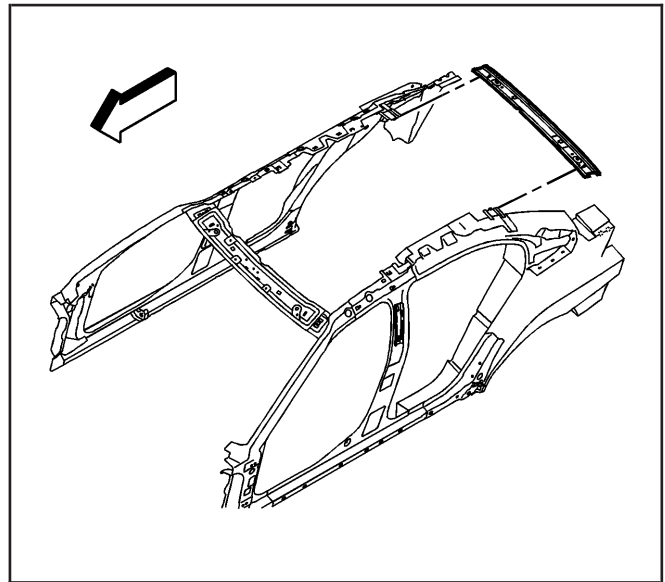
2. Disconnect the negative battery cable.
3. Remove all related panels and components.
4. Repair as much of the damaged area as possible. Refer to *Dimensions - Body (Sedan)* on page 1-2.
5. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to *Anti-Corrosion Treatment and Repair*.

**Important:** Note the number and location of the factory welds for installation of the rear window frame header panel.

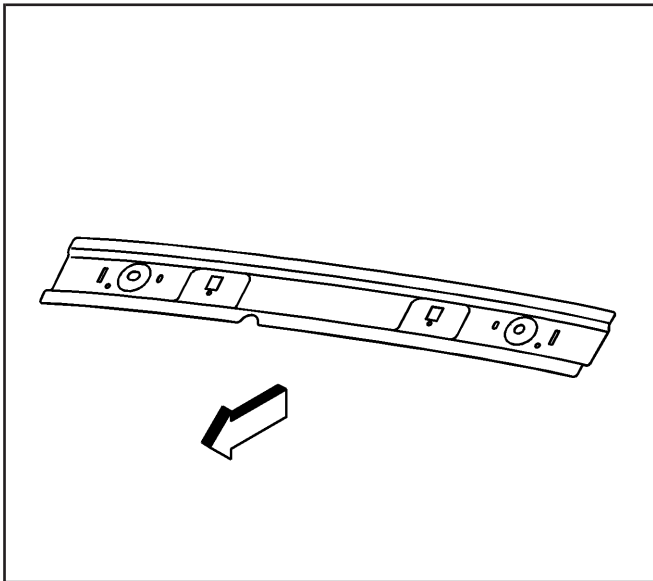
6. Locate and drill out all the necessary factory welds.
7. Remove the rear window frame header panel.



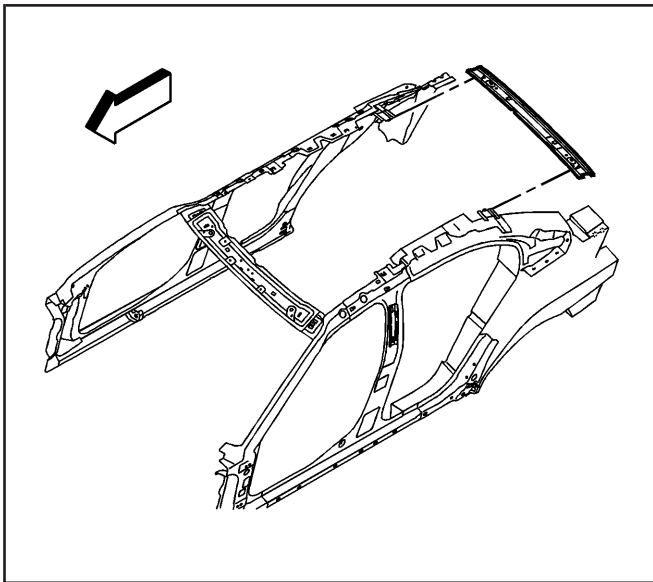
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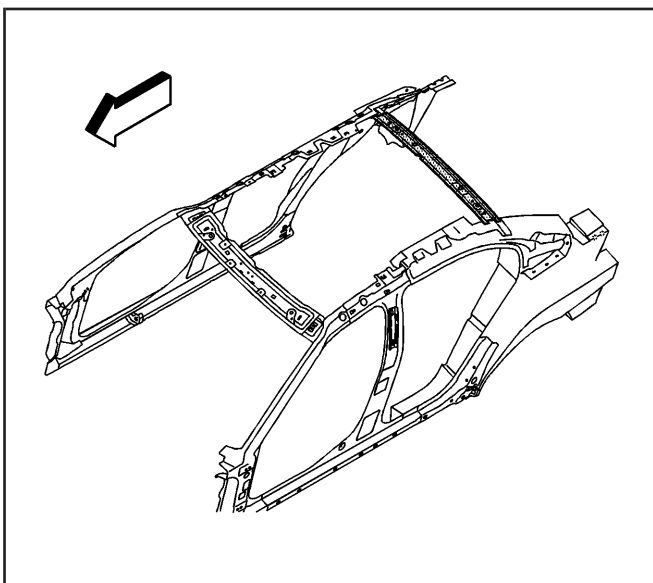
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## Installation Procedure

**Important:** If the location of the original plug weld holes can not be determined, 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. Prepare all mating surfaces as necessary.
3. Apply 3M® Weld-Thru coating P/N 05916 or equivalent to all mating surfaces.

4. Position the rear window frame header panel to the vehicle using 3-dimensional measuring equipment. Clamp the rear header panel in place.

5. Plug weld accordingly.
6. Clean and prepare all of the welded surfaces.
7. Install all of the related panels and components.
8. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to *Anti-Corrosion Treatment and Repair*.
9. Paint the repaired area. Refer to *Basecoat/Clearcoat Paint Systems*.

**Caution:** Refer to **Battery Disconnect Caution** on page 1-1.

10. Connect the negative battery cable.
11. Enable the SIR system. Refer to *SIR Disabling and Enabling Zones* on page 1-129.