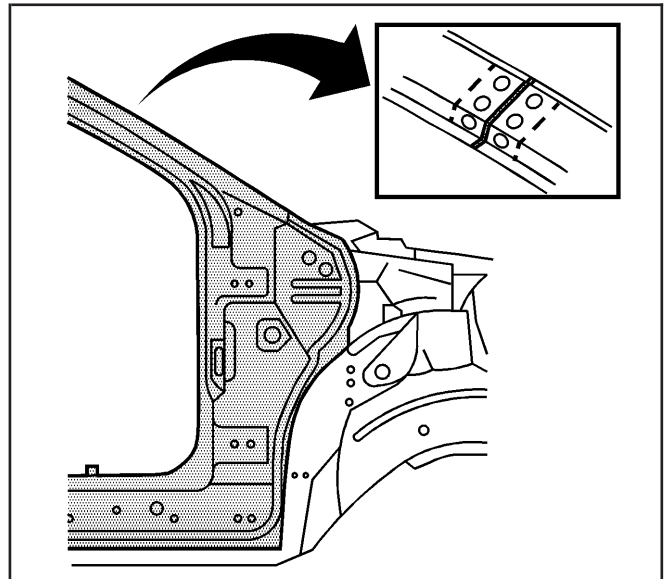
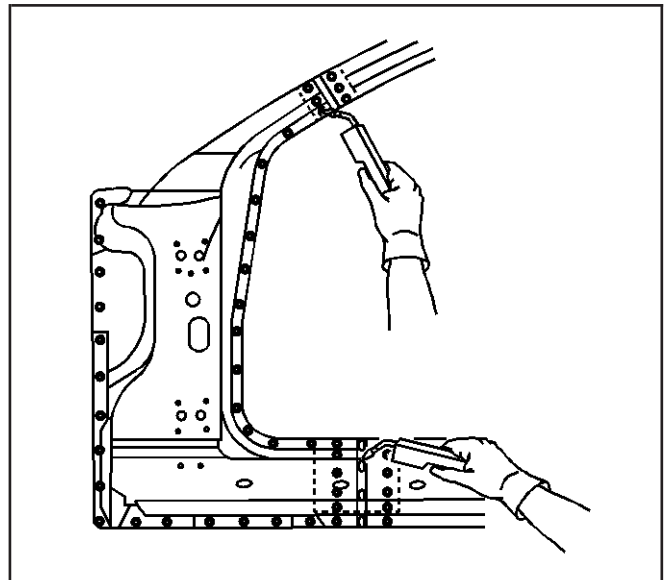


8. Prepare all mating surfaces as necessary.
9. Apply 3M Weld-Thru Coating P/N 05916 or equivalent to all mating surfaces.
10. Fit the backing plates halfway into the sectioning joints, 25 mm (1 in) at the windshield pillar and 50 mm (2 in) at the rocker panel areas. Clamp the plates in place, and plug weld to the section joint
11. Position the outer front pillar to the vehicle using 3-dimensional measuring equipment. Clamp the pillar in place.
12. Plug weld accordingly.



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13. Plug weld accordingly.
14. Stitch weld the butt weld locations.
15. To create a solid weld with minimum heat distortion, make a 25 mm (1 in) stitch weld along the seam with gaps of 25 mm (1 in). Go back and complete the stitch weld.
16. Clean and prepare all of the welded surfaces.
17. Apply the sealers and anti-corrosion materials to the repair area, as necessary.
18. Paint the repaired area.
19. Install all of the related panels and components.
20. Connect the negative battery cable.
21. Enable the SIR system.



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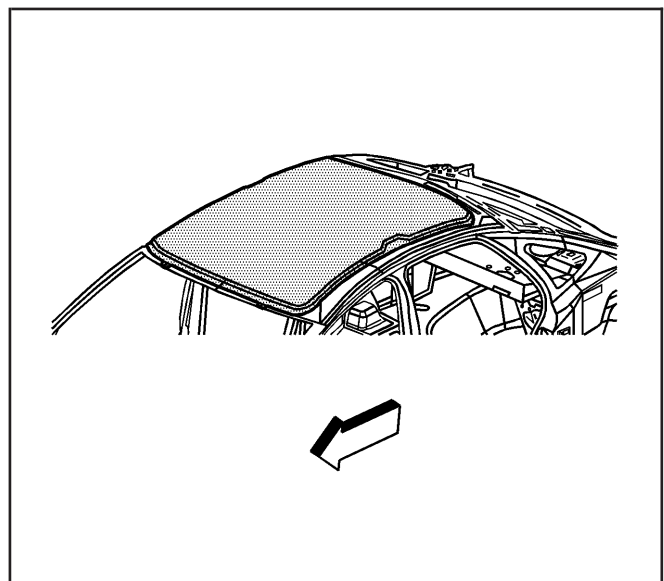
Roof Panel Replacement - Outer

Removal Procedure

Caution: To avoid personal injury when exposed to welding flashes or to galvanized (Zinc Oxide) metal toxic fumes while grinding/cutting on any type of metal or sheet molded compound, you must work in a properly ventilated area, wearing an approved respirator, eye protection, earplugs, welding gloves, and protective clothing.

Caution: Refer to SIR Caution on page 1-1 in General Information.

1. Disable the SIR system.



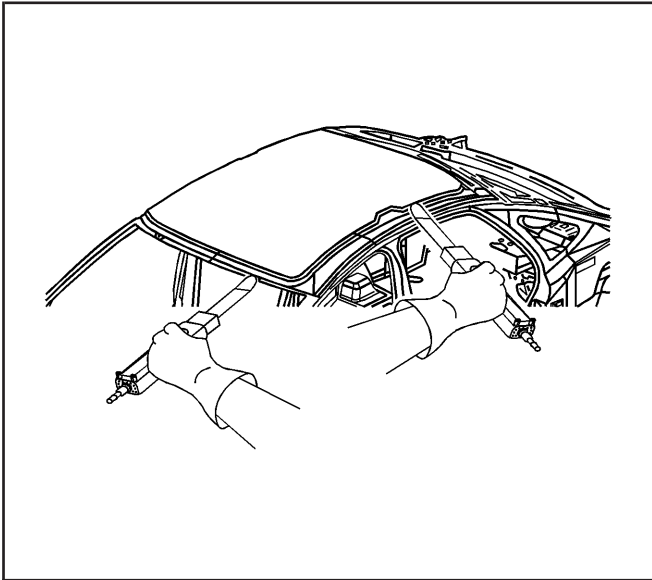
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Caution: Before servicing any electrical component, the ignition key must be in the OFF or LOCK position and all electrical loads must be OFF, unless instructed otherwise in these procedures. If a tool or equipment could easily come in contact with a live exposed electrical terminal, also disconnect the negative battery cable. Failure to follow these precautions may cause personal injury and/or damage to the vehicle or its components.

2. Disconnect the negative battery cable.
3. Take note of the gap sizes along the perimeter of the roof panel to the headers, the glass, and the doors.
4. Remove all related panels and components.
5. Repair as much of the damaged area as possible. Refer to *Dimensions - Body* on page 3-7.
6. Note the location and remove the sealers and anti-corrosion materials from the repair area, as necessary.
7. Remove the 4 nuts that retain the front and rear of the roof panel to the front and rear header panels.

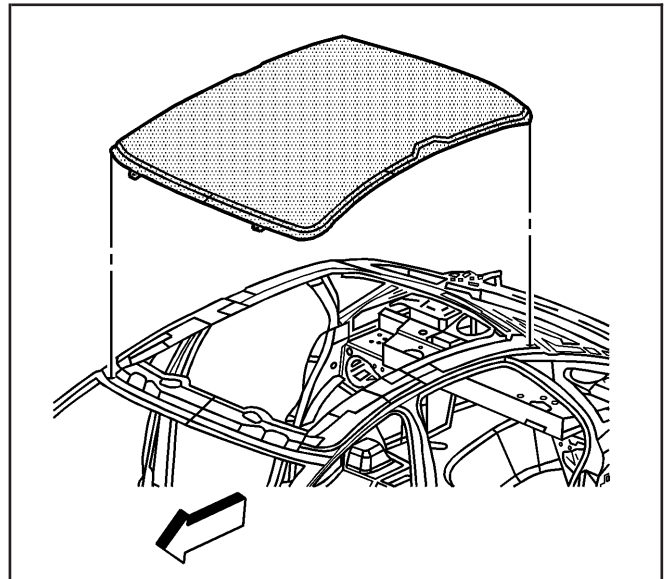
Important: Do not damage any inner panels or reinforcements.

8. Locate and cut the urethane adhesive holding the roof panel to the vehicle. Note the location of the adhesive for installation of the roof panel.



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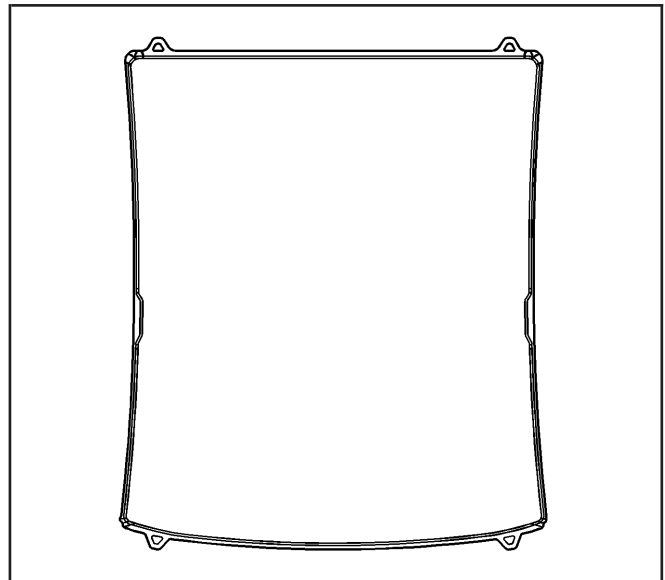
9. Remove the damaged roof panel.



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Installation Procedure

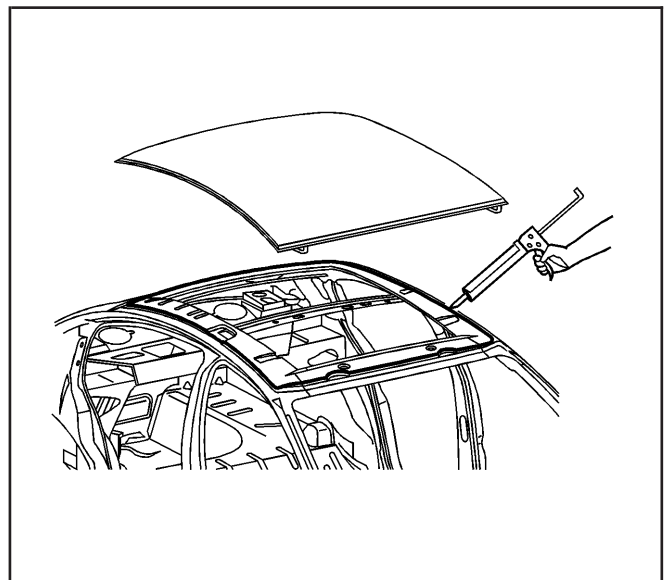
1. Prepare all mating surfaces as necessary.
2. Apply 3M Weld-Thru Coating P/N 05916 or equivalent to all mating surfaces.



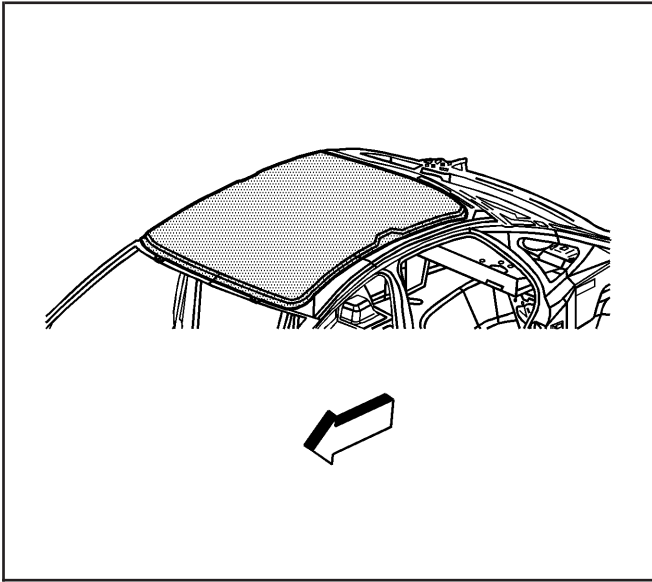
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Important: Place the urethane adhesive on the outboard side of the roof panel stud hole locations.

3. Place a 10 mm (3/8 in) diameter bead of urethane adhesive GM P/N 12346392 on the perimeter of the vehicle roof attachment points.



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4. Position the roof panel on the vehicle.
5. Verify the fit of the roof panel to the front edge of the front header panel and to the rear edge of the rear header panel.
6. Verify the fit of the roof panel at the gap along the top of the door frame to the roof panel. Adjust the panel if necessary.

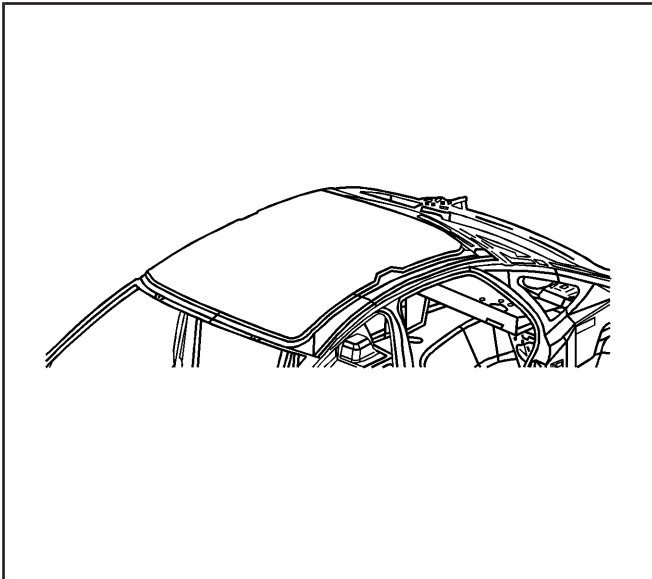
Notice: Use the correct fastener in the correct location. Replacement fasteners must be the correct part number for that application. Fasteners requiring replacement or fasteners requiring the use of thread locking compound or sealant are identified in the service procedure. Do not use paints, lubricants, or corrosion inhibitors on fasteners or fastener joint surfaces unless specified. These coatings affect fastener torque and joint clamping force and may damage the fastener. Use the correct tightening sequence and specifications when installing fasteners in order to avoid damage to parts and systems.

7. Install the 4 nuts at the front and rear header panels.

Tighten

Tighten the nuts to 8–12 N·m (3.1–4.7 lb in).

8. Apply the sealers and anti-corrosion materials to the repair area, as necessary.
9. Paint the repair area.
10. Install all related panels and components.
11. Connect the negative battery cable.
12. Enable the SIR system.



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