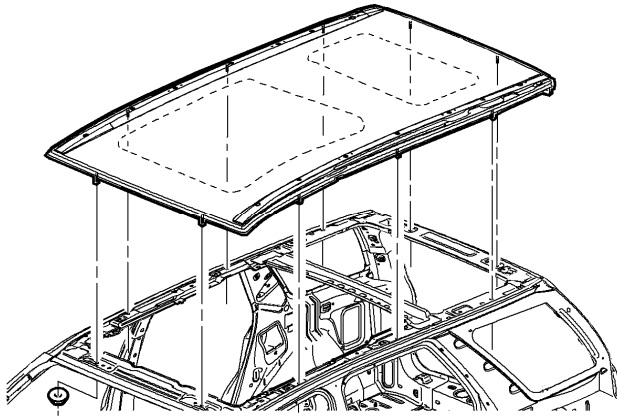


# Roof Outer Panel Replacement

## Removal Procedure

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

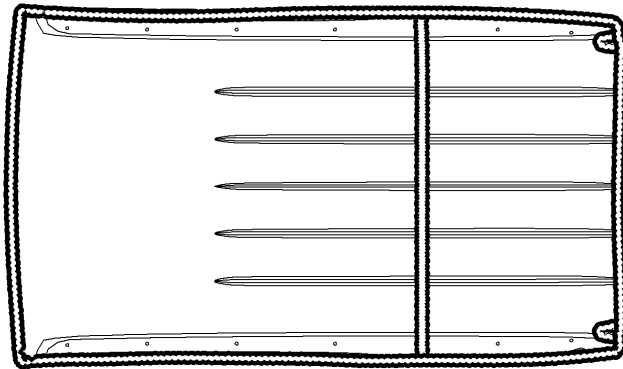


1. Disable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.
2. Remove the headliner. Refer to [Headlining Trim Panel Replacement](#) in Interior Trim.
3. Remove the sunroof. Refer to [Sunroof Module Assembly Replacement](#) in Roof.
4. Remove the windshield. Refer to [Windshield Replacement](#) in Stationary Windows.
5. Remove the lift gate. Refer to [Liftgate Replacement](#) in Body Rear End.
6. Remove the luggage carrier. Refer to [Luggage Carrier Replacement](#) in Roof.
7. Repair as much of the damage as possible to factory specifications. Refer to [Dimensions - Body](#) .
8. 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.

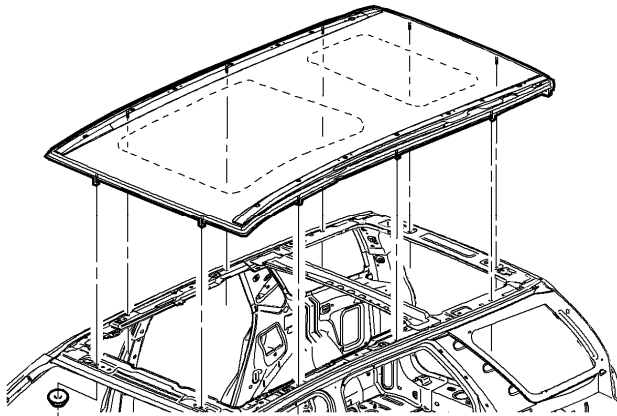
9. Cut openings in roof panel as shown.
10. Remove the nuts that attach the roof.
11. Cut the adhesive around the roof panel and bows.
12. Remove the damaged roof panel.

## Installation Procedure



1. Using a razor knife, remove the loose urethane and trim high spots in the remaining urethane to provide for an even application of new urethane.
2. Use a lint free cloth and Varnish Makers and Painters (VMP) naphtha or a 50/50 mixture by volume of isopropyl alcohol and water to remove the adhesive.
3. Install the lift gate. Refer to [Liftgate Replacement](#) in Body Rear End.
4. Prepare all mating surfaces as necessary.
5. Apply a 8 mm (0.31 in) minimum bead urethane adhesive GM P/N 12345633 or equivalent to the roof panel. Urethane bead must cover the entire flange in order to ensure proper seal.

**Important:** Do NOT pull the panels apart after joined together. Slide the panels against each other to realign the panels.



6. Position the roof panel onto the spaceframe.

**Notice:** Refer to [Fastener Notice](#) in Cautions and Notices.

7. Install the roof nuts.

**Tighten**

Tighten the nuts to 10 N·m (89 lb in).

8. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.
9. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#) in Paint and Coatings.
10. Install the luggage carrier. Refer to [Luggage Carrier Replacement](#) in Roof.
11. Install the windshield. Refer to [Windshield Replacement](#) in Stationary Windows.
12. Install the sunroof, if equipped. Refer to [Sunroof Module Assembly Replacement](#) in Roof.
13. Install the headliner. Refer to [Headlining Trim Panel Replacement](#) in Interior Trim.
14. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.