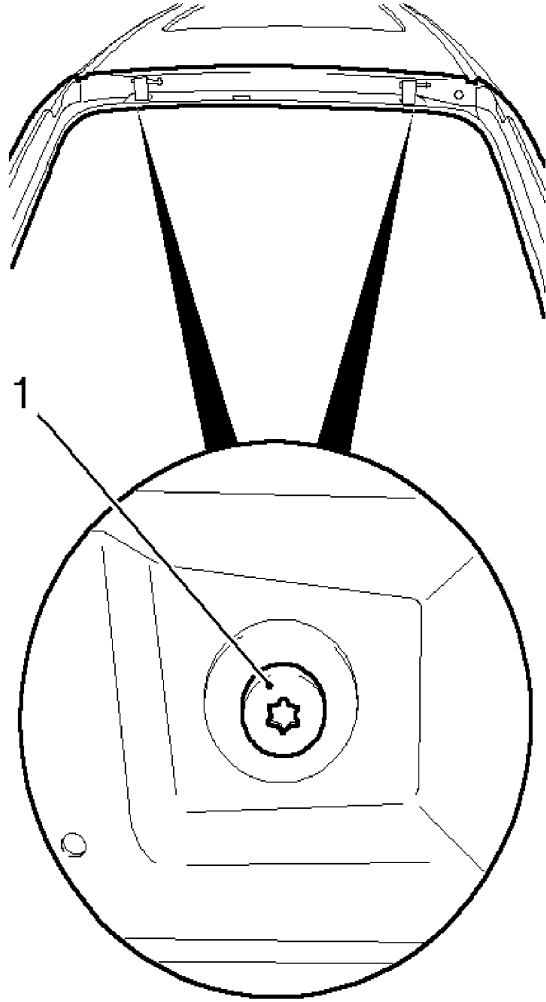
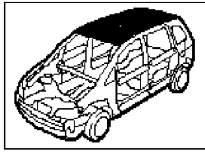


Roof Outer Panel Replacement

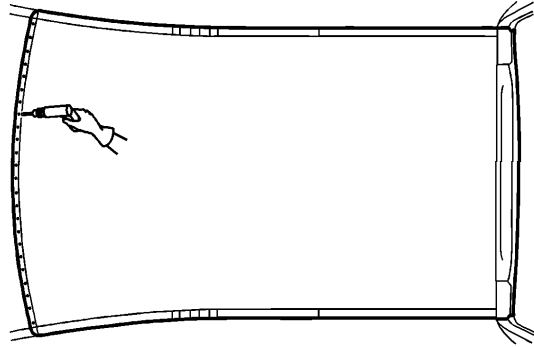
Removal Procedure

Caution: Refer to [Approved Equipment for Collision Repair Caution](#) in the Preface section.

1. Disable the SIR system.
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 to factory specifications. Refer to [Dimensions - Body](#) .
6. Note the location and remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .
7. Remove the windshield.
8. Remove the liftgate.



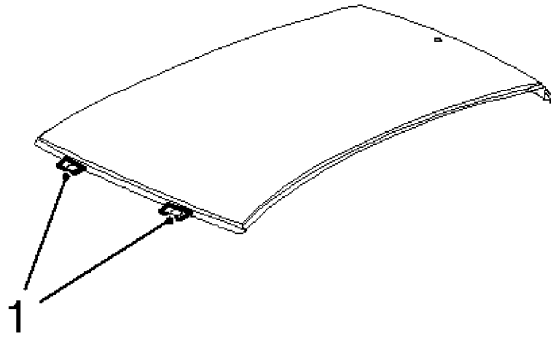
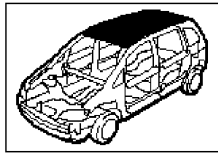
9. Remove the liftgate hinge bolts (1).



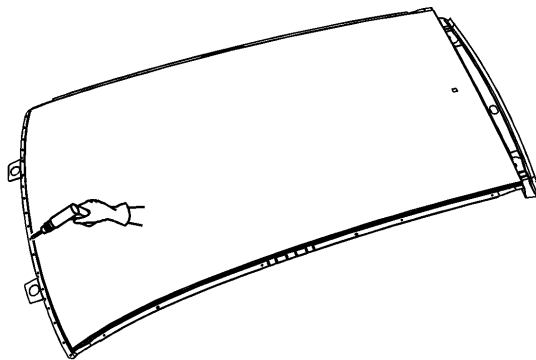
Important: Do not damage any inner panels or reinforcements. Drill through the roof panel only.

10. Locate and drill out all factory welds. Note the number and locations of the welds for installation of the roof panel.
11. With the aid of an assistant, remove the damaged roof panel.

Installation Procedure



1. Cut off the transport lugs on the new part.

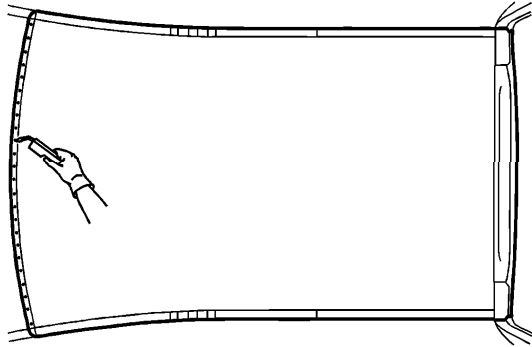


2. Drill 8 mm (5/16 in) plug weld holes as necessary in locations noted from the original panel.

Important: If the location of the original plug weld holes can not be determined, or if structural weld-thru adhesive is present, space the plug weld holes 40 mm (1 1/2 in) apart.

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. Apply Fusor super flexible anti-flutter foam fast set, Fusor P/N 121/124, or equivalent, with the bead placed as shown.
6. With the aid of an assistant, position the roof panel on the vehicle.



7. Plug weld accordingly.
 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](#) .
 10. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#) .
 11. Install the liftgate. Refer to [Liftgate Replacement](#) .
 12. Install the windshield. Refer to [Windshield Replacement](#) .
 13. Install all related panels and components.
 14. Connect the negative battery cable.
 15. Enable the SIR system.
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