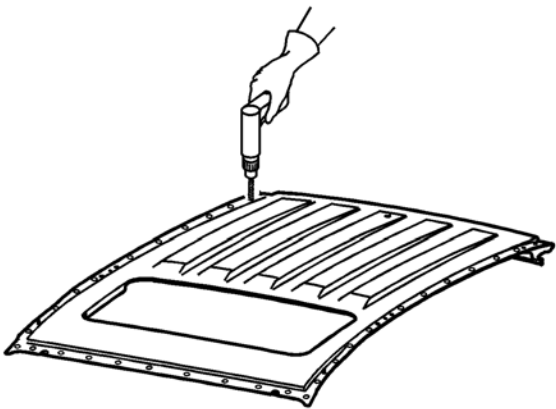


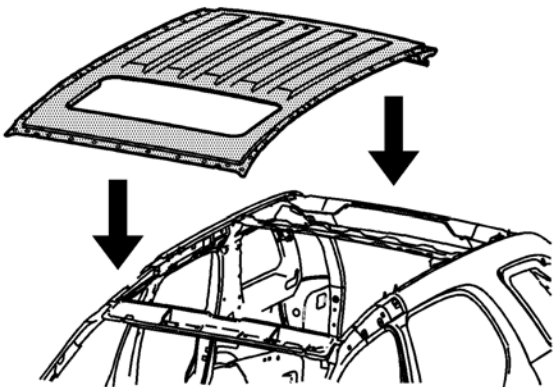
Installation Procedure



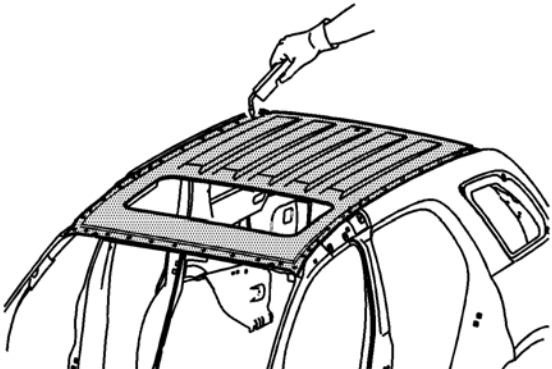
1. Drill 8-mm (5/16-in) plug weld holes as necessary in locations noted from the original panel.

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 every 40 mm (1½ in) apart.

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



4. With the aid of an assistant, position the roof panel to the body.



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