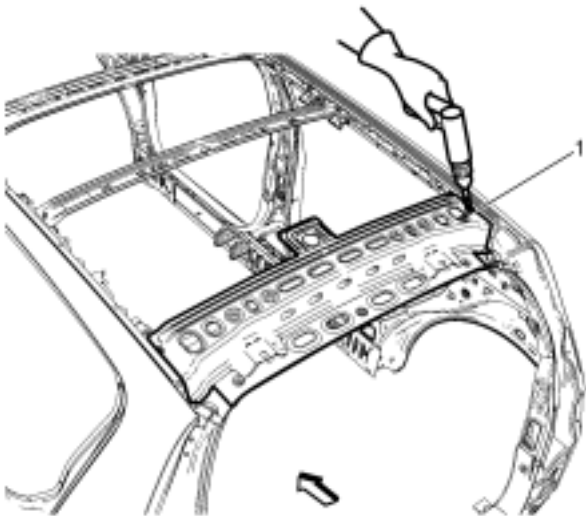


Roof Rear Header Panel Replacement (5HB)

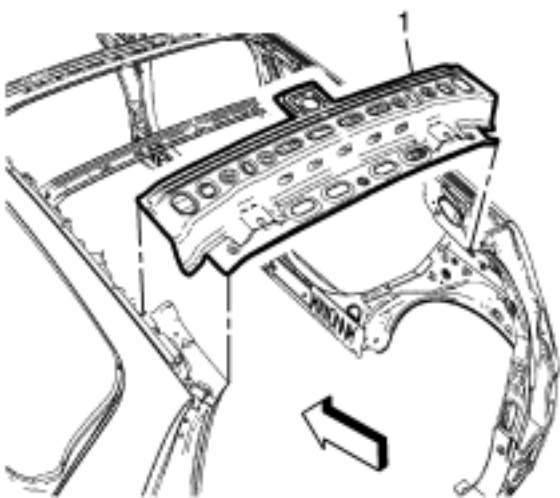
Removal Procedure

Warning: Refer to [Approved Equipment for Collision Repair Warning](#) .

1. Disable the SIR system. Refer to [SIR Disabling and Enabling](#) .
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) .
3. Remove all related panels and components.
4. Repair as much of the damage as possible to factory specifications. Refer to [Dimensions - Body](#) .
5. Remove the sealers and anti-corrosion materials from the repair area. Refer to [Anti-Corrosion Treatment and Repair](#) .
6. Locate and mark all factory welds.



7. Drill all factory welds (1). Note the number and location of welds for installation of the service assembly.



8. Remove the damaged rear header panel (1).

Installation Procedure



1. Drill **8mm (5/16 in)** holes for plug welding along the edges of the service panel (1) as noted from the original panel.
2. Clean and prepare the attaching surfaces for welding.