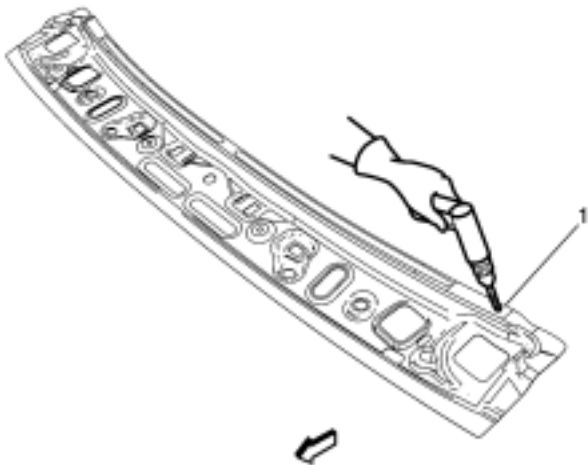
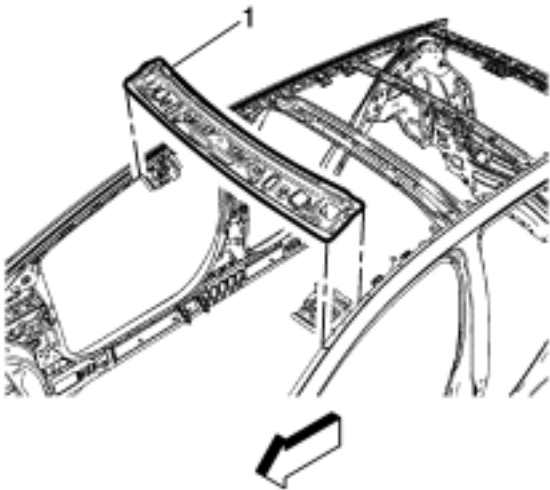


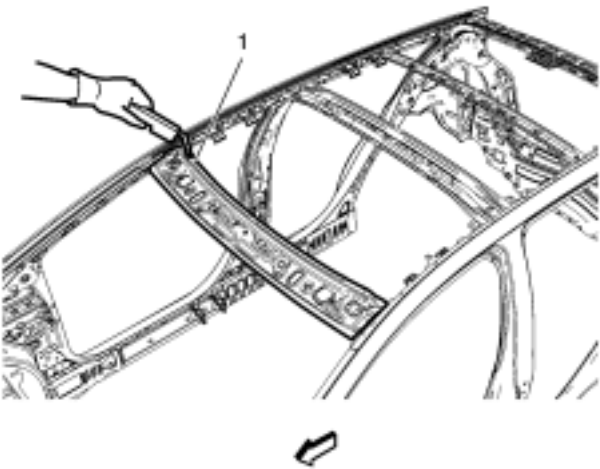
Installation Procedure



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



- 3. Position the roof front header (1) panel on the vehicle.
- 4. Verify the fit of the panel.
- 5. Clamp the roof front header panel into position.



- 6. Plug weld accordingly (1).
- 7. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) .
- 8. Paint the repaired area. Refer to [Basecoat/Clearcoat Paint Systems](#) .
- 9. Install all related panels and components.
- 10. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) .
- 11. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) .