

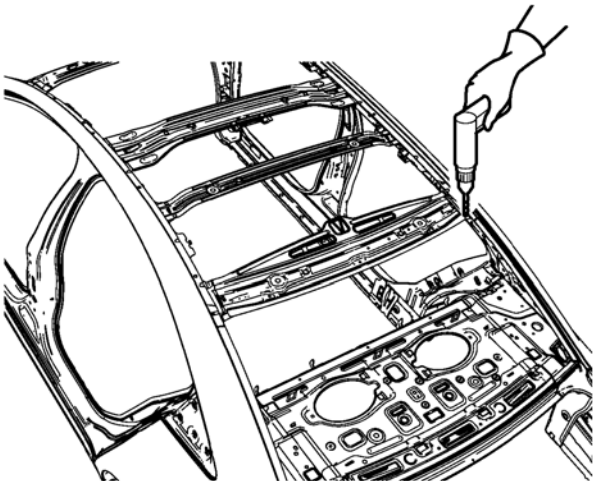
Roof Rear Header Panel Replacement (MAG-Welding)

Note: According to different corrosion warranties, only the regional mandatory joining methods are allowed.

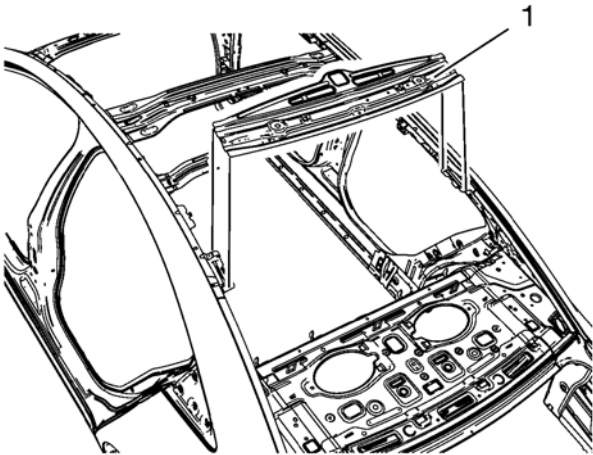
Removal Procedure

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

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. Visually inspect the damage. Repair as much of the damage as possible.
5. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#).
6. Locate and mark all factory welds.

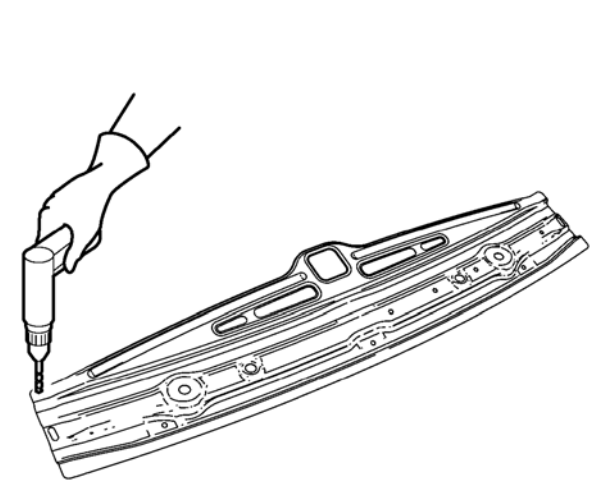


7. Drill all factory welds. Note the number and location of welds for installation of the service assembly.



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

Installation Procedure



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