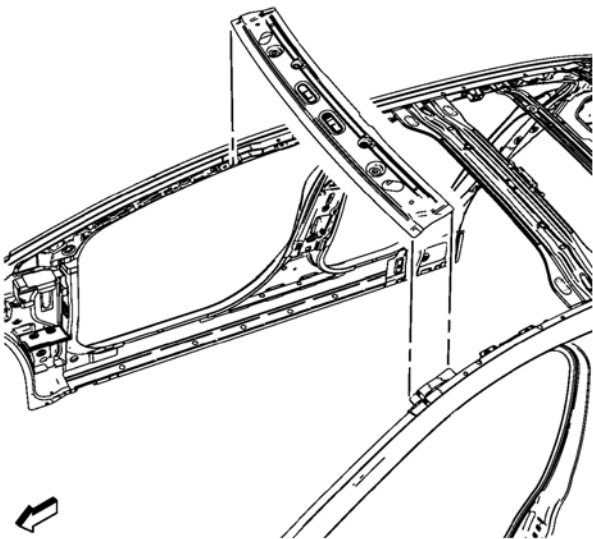
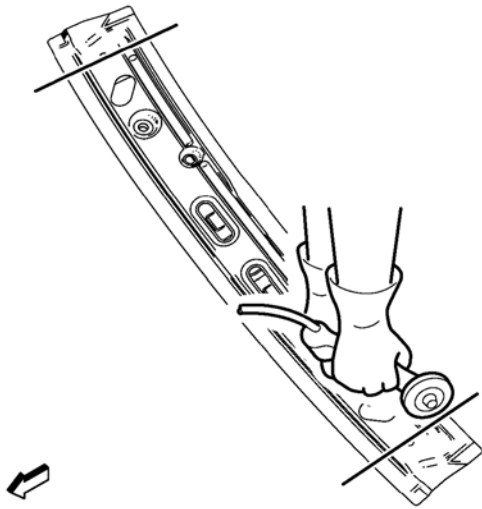


11. Cut the panel where sectioning is to be performed.



12. Remove the damaged roof front header panel.

Installation Procedure



1. Cut the roof front header panel in corresponding locations to fit the remaining original panel. The sectioning joint should be trimmed to allow a gap of one-and-one-half-times the metal thickness at the sectioning joint.
2. Create a 50 mm (2 in) backing plate from the unused portion of the service part.
3. Drill 8 mm (5/16 in) along the sectioning cut on the remaining original part. Locate these holes 13 mm (1/2 in) from the edge of part and spaced 40 mm (1 1/2 in) apart.
4. Prepare all mating surfaces as necessary.
5. Fit the backing plates halfway into the sectioning joints, clamp in place and plug weld to the vehicle.
6. Align roof front header panel.