

Replacement

1. Remove the related parts.

- Windshield
- Rear window
- Sunvisor
- Ceiling lights
- Headliner
- Moonroof frame (For some types)

2. Pull out and straighten the damaged area to approximately the original shape.

NOTE: Check the inner front pillar and the inner center pillar for position and damage.

Cut the roof panel and pull out the pillars if necessary.

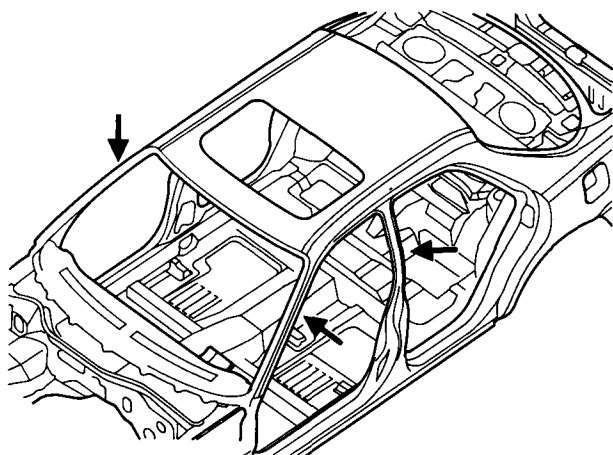
- Pull out the damaged area with the frame straightener before removing the roof panel.
- Attach the car to the frame straightener by tightening the underbody clamps located at the horizontal pinch welds.

3. Keep the body level.

NOTE: Refer to the 95-96 Acura 2.5TL & 96 Acura 3.2TL Service Manuals for safety stand location points.

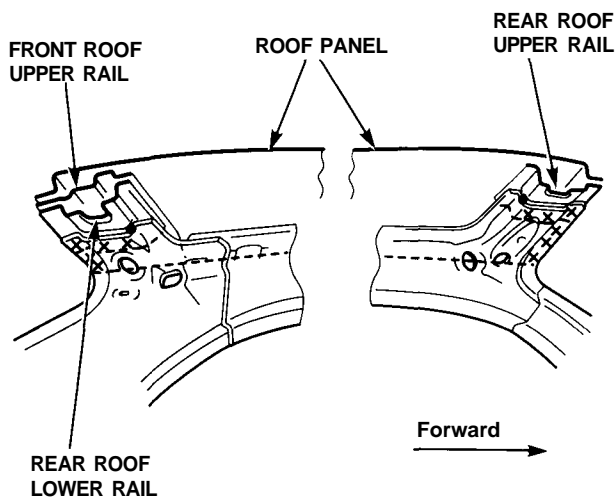
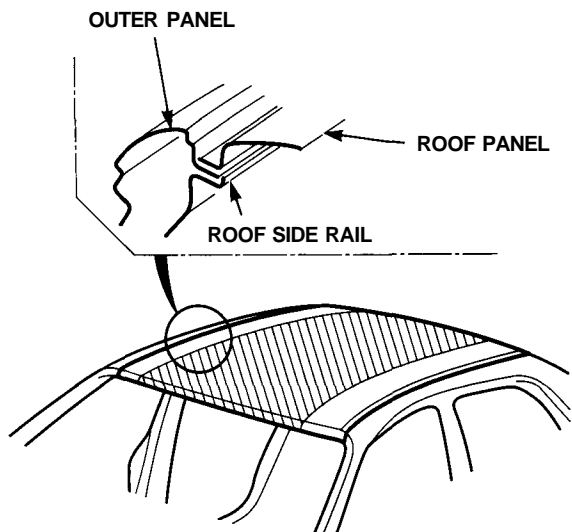
Jack-up the body at the front and back. Place safety stands at the four designated places of the side sills.

NOTE: Make sure that the right and left pillars are parallel with the windshield surface. Check the door for proper opening and closing.



4. Cut off the shaded areas of the roof panel.

- Cut the roof rail weld flange with a handsaw at the four corners.
- Using a chisel, pry off the roof panel along the bold lines as shown.
- Center punch around the spot weld imprints of the roof gutter welded flange.
- Drill holes using the spot cutter.
- Using a chisel, pry off the welded flange.



- Weld the holed areas with a MIG or gas welder.

⚠ WARNING

To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

(cont'd)

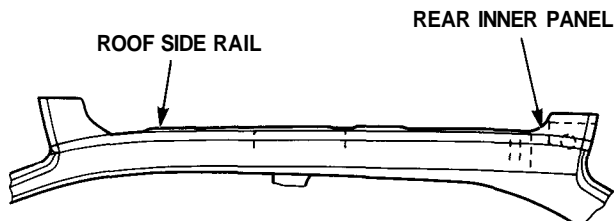
Roof Panel

Replacement (cont'd)

- Level and finish burrs on the welded flanges with a disc sander.

⚠ WARNING To prevent eye injury, wear goggles or safety glasses whenever sanding, cutting or grinding.

- Even out the roof side rail welded flange with a hammer and dolly for a close fit with the roof panel welded flange.



5. Apply paint to the underside of the new roof panel.
 - See Paint Repair section.

- ⚠ WARNING**
- Ventilate when spraying paint. Most paint contains substances that are harmful if inhaled or swallowed. Read the paint label before opening the paint container.
 - Avoid contact with skin. Wear an approved respirator, gloves, eye protection and appropriate clothing when painting.
 - Paint is flammable. Store it in a safe place, and keep it away from sparks, flames or cigarettes.

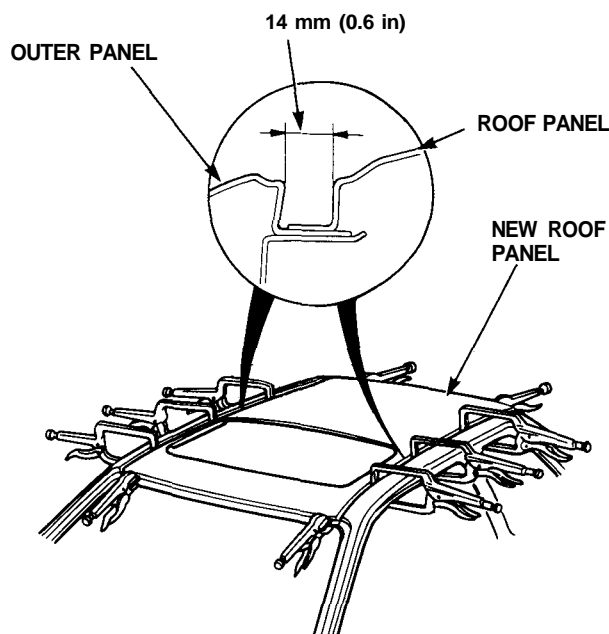
6. Set the new roof panel.
 - Sand off the undercoat from both sides of the flange sections to be spot welded to expose the steel plate.

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- Clamp the roof panel with vice-grips.

NOTE:

- Check that the flange surfaces fit closely. Be careful not to twist or deform the roof panel.
- Check the width of the groove for the roof moldings on both sides.
- Apply the spot sealer to the welding surface when spot welding.



- Check the body dimension (see [section 6](#)).

7. Tack weld the new roof panel.

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- Spot weld the clamped sections to temporarily install the roof panel.
- Set the windshield and rear window, and check the roof panel for proper installation.
- Install the roof molding and check the width of the groove.

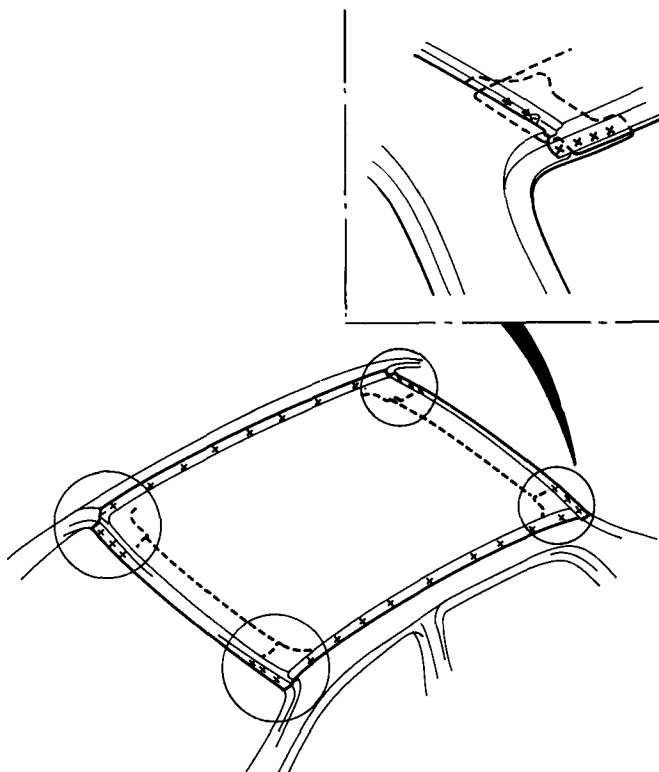
8. Perform the main welding.

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- Spot weld the roof rails at the front and rear.
- Spot weld the roof arch.
- Make 20% to 30% more spot welds than there were holes drilled.

- Smooth the spot weld areas under the windshield and rear window with a hammer and dolly.

NOTE: After welding the pillars, grind and finish the welded areas flat and blend them into the roof panel.

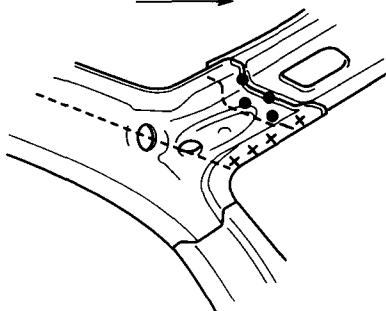


- Weld the roof rail from the inside by MIG welding as shown.

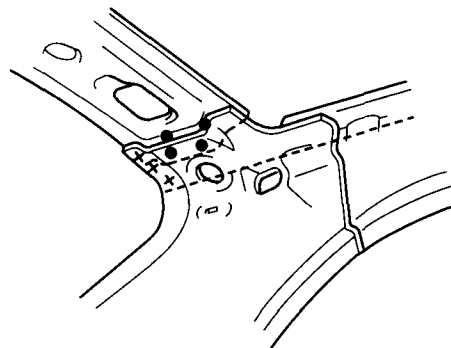
⚠ WARNING To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.

<Front>

Forward

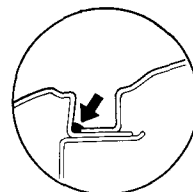


<Rear>



9. Apply and level the sealer to the welded areas.

10. Apply the paint.
See Paint Repair section.



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11. Apply an anti-rust agent to the inside of the roof side rail.

12. Install the related parts.
Install in the reverse order of removal.

13. Check and clean.
 - Check the windshield and rear window for water leaks.
 - Make sure the moonroof operates smoothly.
 - Clean the passenger compartment thoroughly.