



Program Bulletin



CUSTOMER SATISFACTION PROGRAM

SUBJECT: PAINTED ROOF ADHESIVE SEPARATION

**MODELS: 2005-2006 CHEVROLET CORVETTE
WITH PAINTED ROOF**

**STEPS 3 AND 23 IN THE SERVICE PROCEDURE HAVE BEEN REVISED. PLEASE REVIEW
THE REVISED PROCEDURE IMMEDIATELY.
DISCARD ALL COPIES OF BULLETIN 05112 ISSUED FEBRUARY 2006.**

THIS PROGRAM IS IN EFFECT UNTIL MARCH 31, 2007.

CONDITION

On **certain** 2005-2006 Chevrolet Corvette vehicles, the painted roof panel may separate from its frame in some areas if it is exposed to stresses along with high temperature and humidity. The occupants of the vehicle may notice one or more of these symptoms: a snapping noise when driving over bumps, wind noise, poor roof panel fit, roof panel movement/bounce when a door or hatch is closed, or a water leak in the headliner.

CORRECTION

Dealers are to apply adhesive foam to ensure proper adhesion, or in a small number of vehicles, replace the roof panel.

VEHICLES INVOLVED

Involved are **certain** 2005-2006 Chevrolet Corvette vehicles with a painted roof, and built within these VIN breakpoints:

YEAR	DIVISION	MODEL	FROM	THROUGH
2005	Chevrolet	Corvette	55100002	55135053
2006	Chevrolet	Corvette	65100001	65100046

IMPORTANT: Dealers should confirm vehicle eligibility through **GMVIS** (GM Vehicle Inquiry System) prior to beginning program repairs. [Not all vehicles within the above breakpoints may be involved.]

For US and Canada: For GM dealers, Canadian Saab, and Canadian Saturn retailers with involved vehicles, a Campaign Initiation Detail Report (CIDR) containing the complete vehicle identification number, customer name and address data has been prepared and will be loaded to the GM DealerWorld (US) Recall Information, GMinfoNet (Canada) Recall Reports. For US Saturn retailers only, the involved vehicles are provided in a Facility VIN List file sent to you at your current email address. Dealers/retailers will not have a report available if they have no involved vehicles currently assigned.

For Export: For dealers with involved vehicles, a Campaign Initiation Detail Report containing the complete vehicle identification number, customer name and address data has been prepared, and is being furnished to involved dealers. Dealers will not receive a report with the bulletin if they have no involved vehicles currently assigned.

The Campaign Initiation Detail Report may contain customer names and addresses obtained from Motor Vehicle Registration Records. The use of such motor vehicle registration data for any purpose other than follow-up necessary to complete this program is a violation of law in several states/provinces/countries. Accordingly, you are urged to limit the use of this report to the follow-up necessary to complete this program.

PARTS INFORMATION

Parts required to complete this program are to be obtained from General Motors Service Parts Operations (GMSPO). Please refer to your "involved vehicles listing" before ordering parts. Normal orders should be placed on a DRO = Daily Replenishment Order. In an emergency situation, parts should be ordered on a CSO = Customer Special Order.

Part Number	Description	Quantity/Vehicle
88861400	Adhesive Kit-Foam	2

SPECIAL TOOL

Beginning the week of February 13, 2006, each dealer will be shipped a Two-Part Adhesive Applicator Gun, BO-48206, for use in this recall. This tool is being furnished at no charge. Additional tools, if required, may be purchased by contacting SPX Kent-Moore at 1-800-468-6657.

SERVICE PROCEDURE

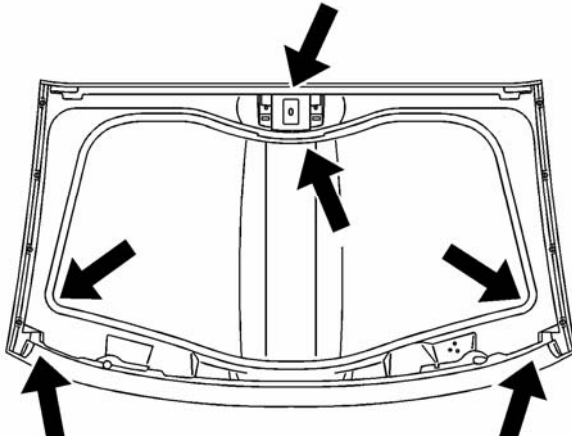
Tools Required

- BO-48206 Two-Part Applicator Gun

1. Remove the roof panel from the vehicle.

Caution: Be sure to protect the painted surface of the panel from damage.

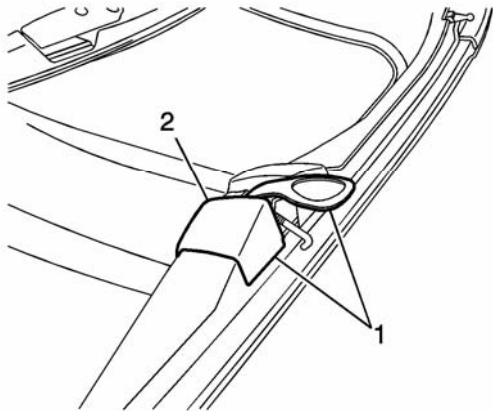
2. With the painted surface down, support the roof panel horizontally on a glass stand, bench, or other suitable area.
3. Lift the edge of the headliner in the areas indicated for inspection in the next step.



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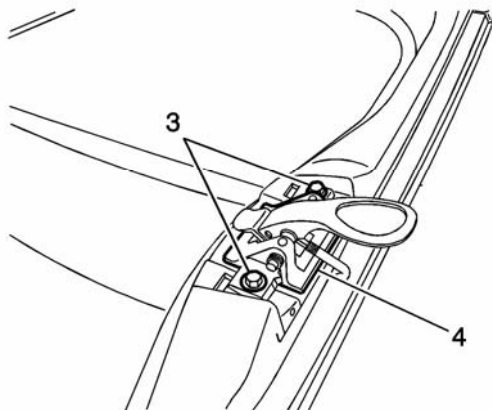
4. Inspect for proper adhesion by inserting a feeler gage between the panel and the frame. Particular attention should be paid to the areas around the rear latch and the front corners.
 - If the feeler gage does not identify any area without proper adhesion, proceed to the next step.
 - If the feeler gage does identify an area without proper adhesion, replace the roof panel (do not continue with this procedure). The following SI procedures may be used:

Description	SI Document #
Headliner Replacement - Roof Lift Off Panel	1508849
Roof Lift Off Panel Rear Latch Replacement	1582986
Roof Lift Off Panel Front Latch Handle Replacement	1582355
Roof Lift Off Panel Molding Replacement	656617
Roof Lift Off Panel Rear Locator Pin Replacement	656610
Roof Lift Off Panel Adjustment	815143



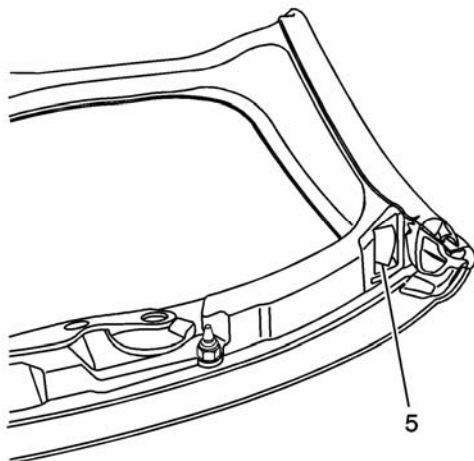
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- 5. Remove the rear latch trim screws (1) and the trim (2).



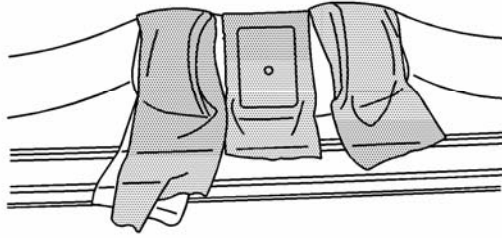
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- 6. Remove the rear latch attaching bolts (3) and the rear latch assembly (4).
- 7. Install the rear latch attaching bolts (3) to the frame.

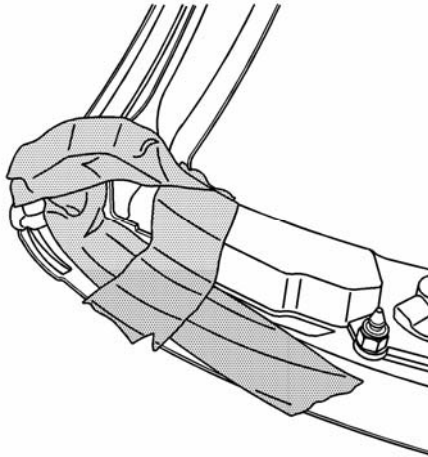


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- 8. Remove the front corner brackets (5)



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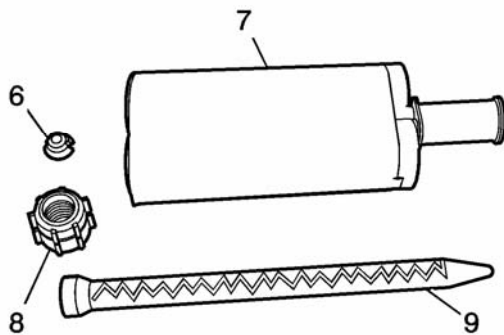


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9. Tape off the rear latch and the front bracket areas.

Important: Be sure to cover the area completely using tape with strong adhesion. It is difficult to clean the foam off of visible surfaces.

10. Using a pen or small knife, cut holes in the tape to inject foam.

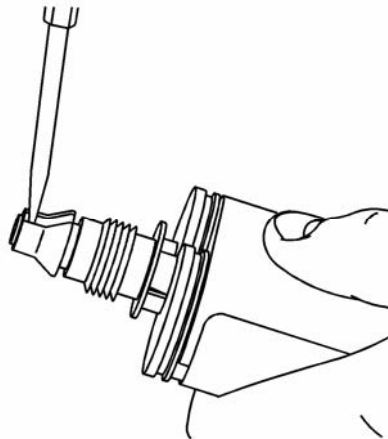


- 6 Reducer
- 7 Two-Part Foam Cartridge
- 8 Nut
- 9 Mixer Nozzle

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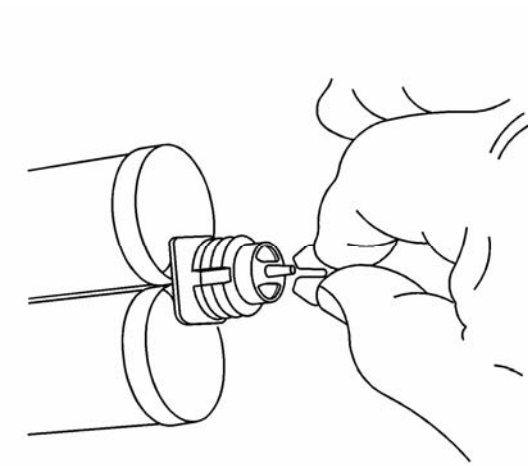
Important: This is a two-part foam product that expands and sets very quickly. Once the mixing begins, the foam will be set in approximately 15 seconds. It is recommended that technicians wear disposable gloves while working with foam.

11. Prepare one cartridge.



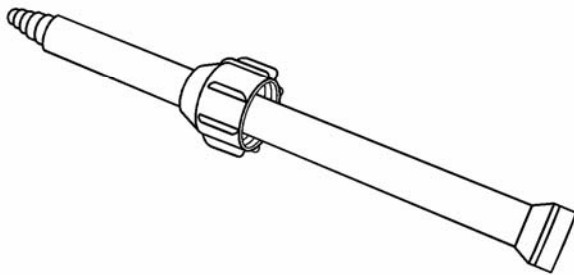
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11.1 Remove the top plug. Insert a screwdriver into the end and rock it back and forth.



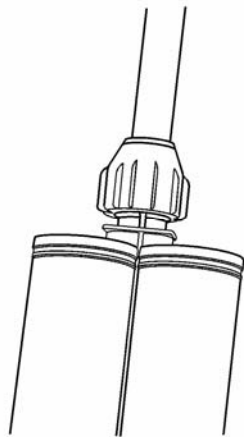
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11.2 Install a reducer into the cartridge.



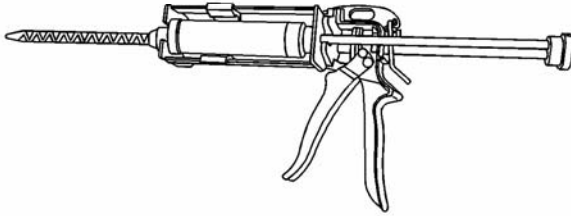
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11.3 Insert a mixer nozzle through a nut.



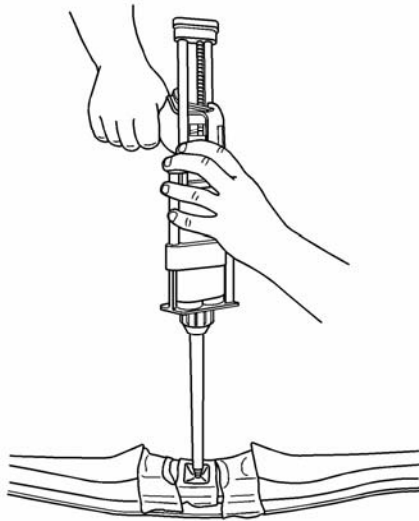
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11.4 Install the nozzle onto the cartridge.



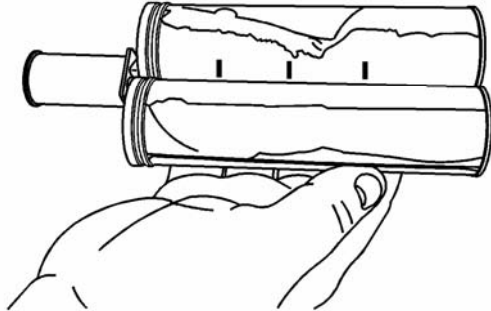
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- 11.5 Install the cartridge nozzle assembly to the BO-48206 applicator gun.
- 11.6 Prepare a piece of tape to cover the hole after the foam is injected.



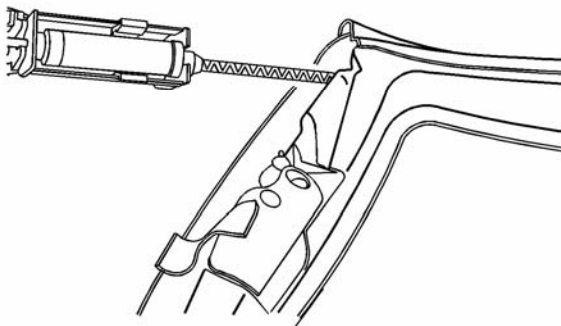
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12. Inject the entire cartridge of foam into the rear latch area of the panel.
13. Tape over the hole to keep the foam from coming out.
14. Prepare a second cartridge.



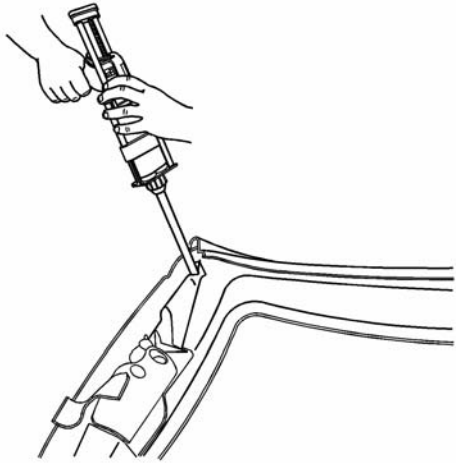
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- 14.1 Remove a portion of the label.
 - 14.2 Measure the length of the tubes containing the foam product. Divide the length and mark the cartridge into four equal parts.
 - 14.3 Remove the top plug.
 - 14.4 Install a reducer into the cartridge.
 - 14.5 Insert a mixer nozzle through a nut.
 - 14.6 Install the nozzle onto the cartridge.
 - 14.7 Install the cartridge nozzle assembly to the BO-48206 applicator gun.
 - 14.8 Prepare a piece of tape to cover the hole in each front corner after the foam is injected.
15. The following steps must be performed within approximately 15 seconds from start to finish.



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- 15.1 While watching the cartridge, inject one quarter of the foam in one front corner, pointing front to back.



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- 15.2 In the same corner, turn the applicator and inject one quarter of the foam, pointing the applicator from side to side.
- 15.3 Tape the hole closed.
- 15.4 Repeat for the other front corner.
16. Wait 60 seconds for the foam to set.
17. Remove all of the tape.
18. Look for any areas where the foam may have leaked out between the frame and the composite panel. In the rare event that a leak is found, the roof panel must be replaced, otherwise continue the procedure.
19. Install the front corner brackets. A sharp knife or small screwdriver may be needed to remove just enough foam to install the brackets.
20. Remove the latch bolts.
21. Install the latch and bolts. A sharp knife or small screwdriver may be needed to remove just enough foam to install the latch and latch trim cover.
22. Install the rear latch trim cover and screws.
23. Smooth the headliner back into position.
24. Install the top to the vehicle.

COURTESY TRANSPORTATION

The General Motors Courtesy Transportation program is intended to minimize customer inconvenience when a vehicle requires a repair that is covered by the New Vehicle Limited Warranty. The availability of courtesy transportation to customers whose vehicles are within the warranty coverage period and involved in a product program is very important in maintaining customer satisfaction. Dealers are to ensure that these customers understand that shuttle service or some other form of courtesy transportation is available and will be provided at no charge. Dealers should refer to the General Motors Service Policies and Procedures Manual for Courtesy Transportation guidelines.

CLAIM INFORMATION

Submit a Product Claim with the information indicated below:

REPAIR PERFORMED	PART COUNT	PART NO.	PARTS ALLOW	CC-FC	LABOR OP	LABOR HOURS	NET ITEM
Inspect & Inject Foam Adhesive	2	---	*	MA-96	V1442	0.4	**
Inspect & Replace Roof Panel (inc. injection of foam adhesive, if req'd)	3	---	*	MA-96	V1443	1.8	***
Courtesy Transportation for vehicles within the New Vehicle Limited Warranty (US & Canadian GM Dealers)	N/A	N/A	N/A	MA-96	****	N/A	*****

- * The "Parts Allowance" should be the sum total of the current GMSPO Dealer net price plus applicable Mark-Up or Landed Cost Mark-Up (for Export) for the foam adhesive kits, and if required, roof panel needed to complete the repair.
- ** The amount identified in the "Net Item" column should represent the actual sum total of the current GMSPO Dealer net price plus applicable Mark-Up or Landed Cost Mark-Up (for Export) for the tape if needed to perform the required repairs, not to exceed \$0.50 USD, \$0.58 CAD.
- *** The amount identified in the "Net Item" column should represent the actual sum total of the current GMSPO Dealer net price plus applicable Mark-Up or Landed Cost Mark-Up (for Export) for the tape, if needed to perform the required repairs, not to exceed \$0.50 USD, \$0.58 CAD, plus paint allowance (GI).
- **** Submit courtesy transportation using normal labor operations for courtesy transportation as indicated in the GM Service Policies and Procedures Manual for vehicles within the New Vehicle Limited Warranty.
- ***** The amount identified in the "Net Item" column should represent the actual dollar amount for courtesy transportation.

CUSTOMER NOTIFICATION – For US and Canada

General Motors will notify customers of this program on their vehicle (see copy of customer letter included with this bulletin).

CUSTOMER NOTIFICATION – For Export

Letters will be sent to known owners of record located within areas covered by the US National Traffic and Motor Vehicle Safety Act. For owners outside these areas, dealers should notify customers using the attached sample letter.

DEALER PROGRAM RESPONSIBILITY - All

All unsold new vehicles in dealers' possession and subject to this program must be held and inspected/repaired per the service procedure of this program bulletin before customers take possession of these vehicles.

Dealers are to service all vehicles subject to this program at no charge to customers, regardless of mileage, age of vehicle, or ownership, through March 31, 2007.

Customers who have recently purchased vehicles sold from your vehicle inventory, and for which there is no customer information indicated on the dealer listing, are to be contacted by the dealer. Arrangements are to be made to make the required correction according to the instructions contained in this bulletin. A copy of the customer letter is provided in this bulletin for your use in contacting customers. Program follow-up cards should not be used for this purpose, since the customer may not as yet have received the notification letter.

In summary, whenever a vehicle subject to this program enters your vehicle inventory, or is in your dealership for service prior to March 31, 2007, you must take the steps necessary to be sure the program correction has been made before selling or releasing the vehicle.



February 2006

Dear General Motors Customer:

This notice is sent to inform you that Chevrolet is conducting a customer satisfaction program that affects certain 2005 and 2006 model year vehicles that are equipped with a painted roof.

We have learned that the painted roof panel may separate from its frame in some areas if it is exposed to stresses along with high temperature and humidity. The occupants of the vehicle may notice one or more of these symptoms: a snapping noise when driving over bumps, wind noise, poor roof panel fit, roof panel movement/bounce when a door or hatch is closed, or a water leak in the headliner.

What We Will Do: To prevent this condition from occurring, your Chevrolet dealer will inspect the roof panel for proper adhesion, and if necessary, inject adhesive foam to seal the panel. In some cases, the roof panel may require replacement. This service will be performed for you at **no charge until March 31, 2007.**

What You Should Do: To limit any possible inconvenience, we recommend that you contact your dealer as soon as possible to schedule an appointment for this repair. By scheduling an appointment, your dealer can ensure that the necessary parts will be available on your scheduled appointment date.

Customer Reply Form: The enclosed customer reply form identifies your vehicle. Presentation of this form to your dealer will assist in making the necessary correction in the shortest possible time. If you no longer own this vehicle, please let us know by completing the form and mailing it back to us.

If you have any questions or need any assistance, just contact your dealer or the appropriate Customer Assistance Center at the number listed below. The Customer Assistance Center's hours of operation are from 8:00 AM to 11:00 PM, EST, Monday through Friday.

Division	Number	Text Telephones (TTY)
Chevrolet	1-800-630-2438	1-800-833-2438
Guam	1-671-648-8650	
Puerto Rico – English	1-800-496-9992	
Puerto Rico – Español	1-800-496-9993	
Virgin Islands	1-800-496-9994	

Courtesy Transportation: If your vehicle is within the New Vehicle Limited Warranty your dealer may provide you with shuttle service or some other form of courtesy transportation while your vehicle is at the dealership for this repair. Please refer to your Owner's Manual and your dealer for details on Courtesy Transportation.

We sincerely regret any inconvenience or concern that this situation may cause you. We want you to know that we will do our best, throughout your ownership experience, to ensure that your Chevrolet Corvette provides you many miles of enjoyable driving.

General Motors Corporation

Enclosure
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