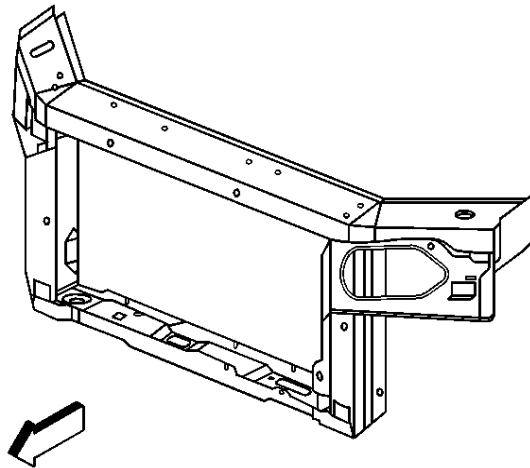


Radiator Support Replacement

Removal Procedure

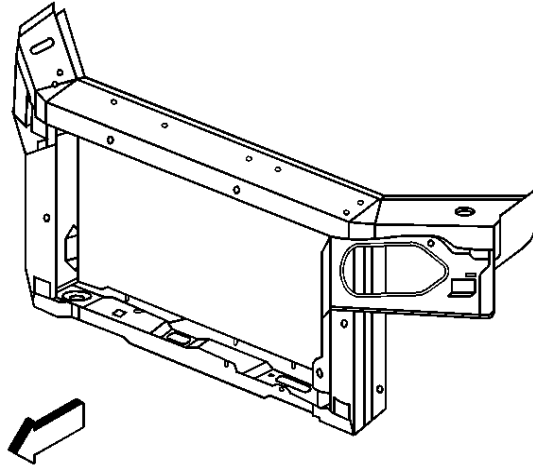
Caution

Refer to [Approved Equipment for Collision Repair Caution](#) in Cautions and Notices.



1. Remove all related panels and components.
2. Visually inspect and restore as much of the damage as possible to factory specifications.
3. Locate, mark, and drill out all factory welds. Note the number and location of welds for installation of the service assembly.
4. Remove the damaged radiator support assembly.

Installation Procedure



1. Prepare the mating surfaces as necessary. Inspect for proper fit of the service part.
2. Check for proper fit of the service assembly.
3. Drill 8 mm (5/16 in) plug weld holes as necessary in the locations noted from the original assembly.
4. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#).
5. Position the service assembly using 3-dimensional measuring equipment.
6. Plug weld accordingly with frequent measurements to ensure proper fit and alignment.
7. Clean and prepare all welded surfaces.
8. Prime with 2-part catalyzed primer.
9. Apply sealers and anti-corrosion materials as necessary.

Important

Prior to refinishing, refer to GM 4901MD-99 Refinish Manual for recommended products. Do not combine paint systems. Refer to paint manufacturer's recommendations.

10. Install all related panels and components.