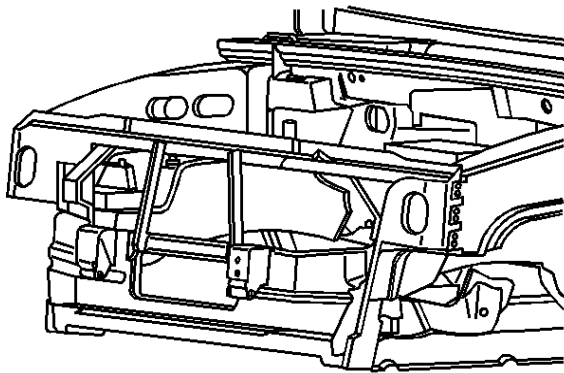


# Radiator Lower Support Replacement

## Removal Procedure

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

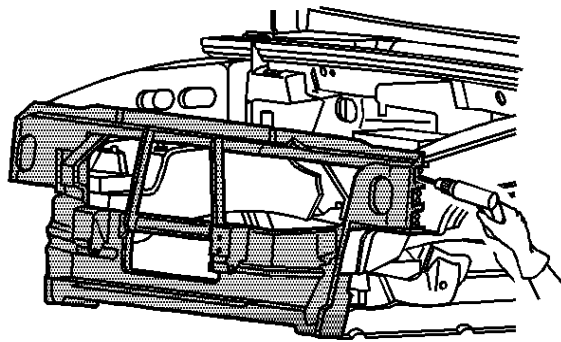
1. Disable the SIR system. Refer to [SIR Disabling and Enabling](#).
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#).



3. Remove all related panels and components.
4. Restore as much of the damage as possible to factory specifications. Refer to [Dimensions - Body](#).

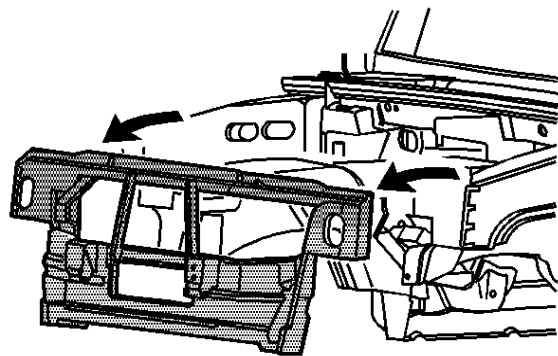
**Caution:** Refer to [Foam Sound Deadeners Caution](#) in the Preface section.

5. Note the location and remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#).



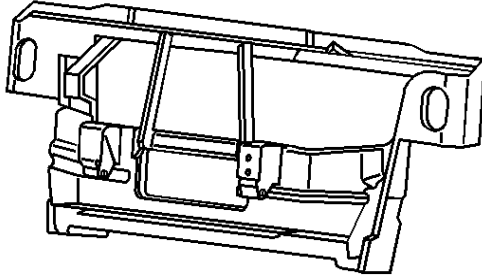
**Important:** Do not damage any inner panels or reinforcements.

6. Locate and drill out all factory welds. Note the number and location of the welds for installation of the radiator support.



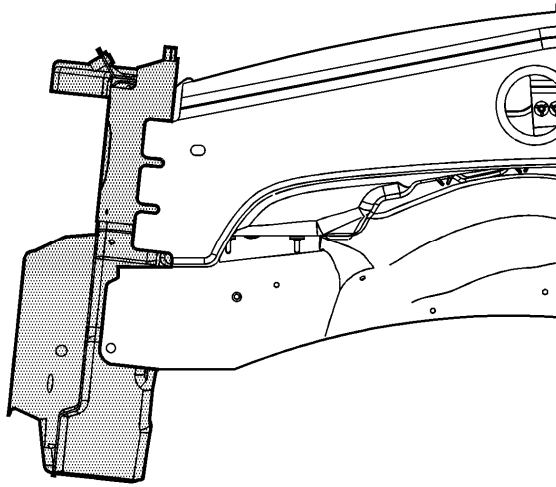
7. Remove the damaged radiator support.

## Installation Procedure



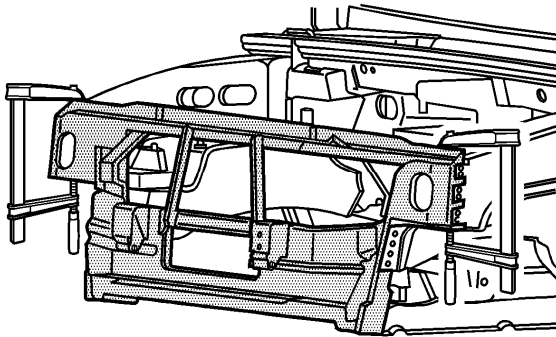
**Important:** In any area damaged beyond recognition, or if structural weld thru adhesive is present, space the plug weld holes 40 mm (1½ in) apart.

1. Drill 8 mm (5/16 in) plug weld holes in the service part as necessary in the locations noted from the original panel.
2. Prepare all attachment surfaces as necessary.
3. Apply GM-approved weld thru coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#).

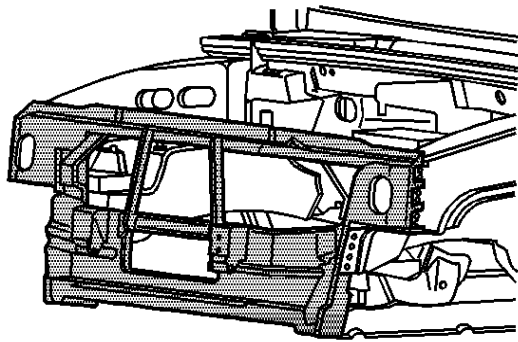


**Important:** Installing the radiator lower support to the body mount, the radiator will seat about 1 inch above the fender.

4. Position the radiator support.
5. Install radiator to the frame body mount and tighten fastener to 85 N·m.



6. To locate the radiator lower support in the correct location use a clamp or equivalent tool. (1)



7. Plug weld accordingly.
  8. Remove clamps.
  9. Clean and prepare all welded surfaces.
  10. Apply the sealers and anti-corrosion materials to the repair area, as necessary.  
Refer to [Anti-Corrosion Treatment and Repair](#).
  11. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#).
  12. Install all related panels and components.
  13. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#).
  14. Enable the SIR system. Refer to [SIR Disabling and Enabling](#).
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