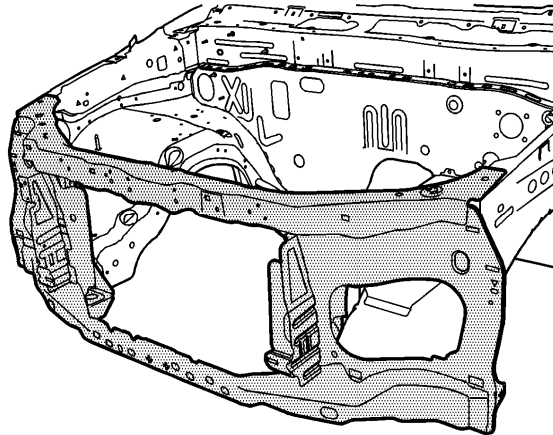


# Radiator Support Replacement

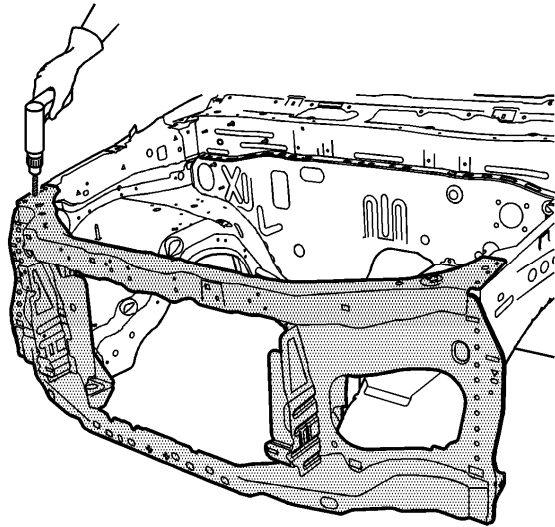
## Removal Procedure

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

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

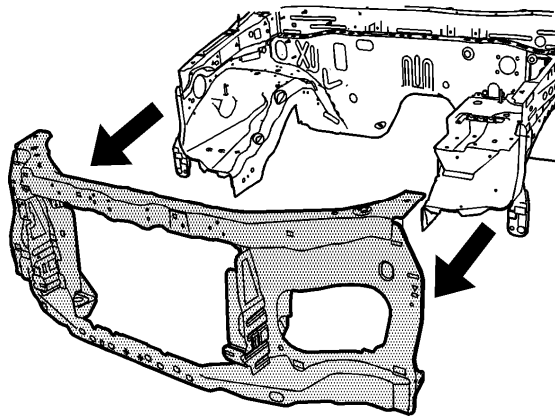


3. Remove all related panels and components.
4. Restore as much of the damage as possible to factory specifications. Refer to [Dimensions - Body](#).
5. Note the location and remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.



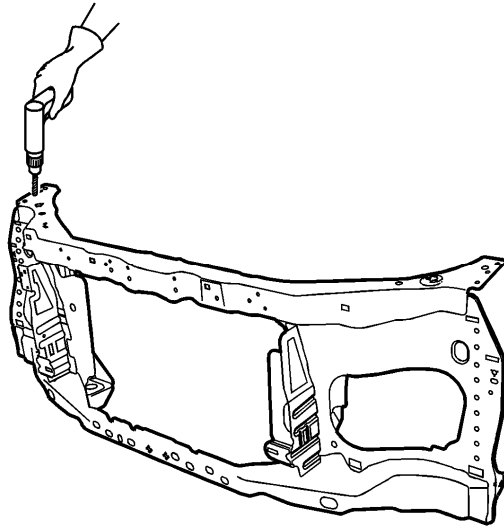
**Important:** Do not damage any inner panels or reinforcements.

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



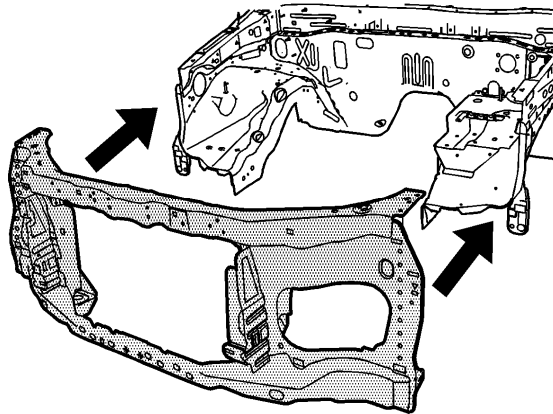
7. Remove the damaged radiator support .

## [Installation Procedure](#)



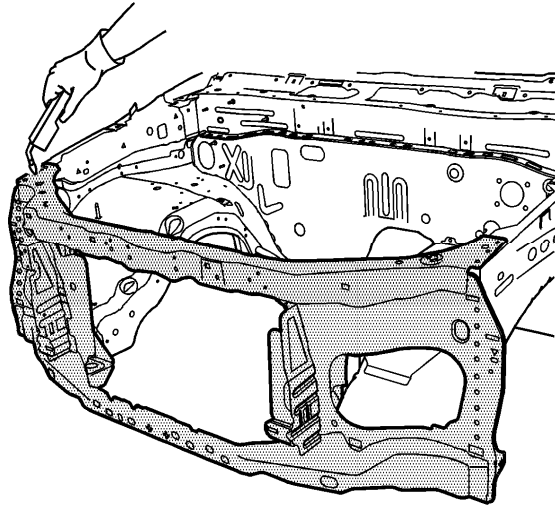
**Important:** If the location of the original plug weld holes can not be determined, or if structural weld-thru adhesive is present, space the plug weld holes every 40 mm (1½ in) apart.

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

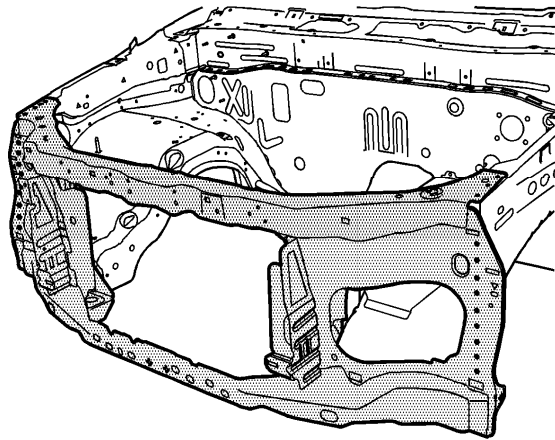


**Important:** You may need to lift the body to install the radiator support.

4. Position the radiator support. Refer to [Frame Cushion or Insulator Replacement](#).



5. Plug weld accordingly.



6. Clean and prepare all welded surfaces.
7. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint and Coatings.
8. Paint and repair the area. Refer to [Basecoat/Clearcoat Paint Systems](#) in Paint and Coatings.
9. Install all related panels and components.
10. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#) in Engine Electrical.

11. Enable the SIR system. Refer to [SIR Disabling and Enabling](#) in SIR.