

## BILL OF MATERIALS

### RADIATOR SUPPORT ASSEMBLY

1 x LOWER SUPPORT  
2 x VERTICAL SUPPORTS  
1 x ARCHED UPPER CROSS BAR  
2 x 5/16" x 2" BOLTS  
2 x 7/16"-14 NUTS

### TOOLS REQUIRED (NOT INCLUDED)

TAPE MEASURE  
SQUARE  
CLAMPS  
MIG WELDER  
CUTOFF WHEEL  
GRINDER  
21/64" DRILL BIT  
29/64" DRILL BIT  
DRILL

### RECOMMENDATIONS

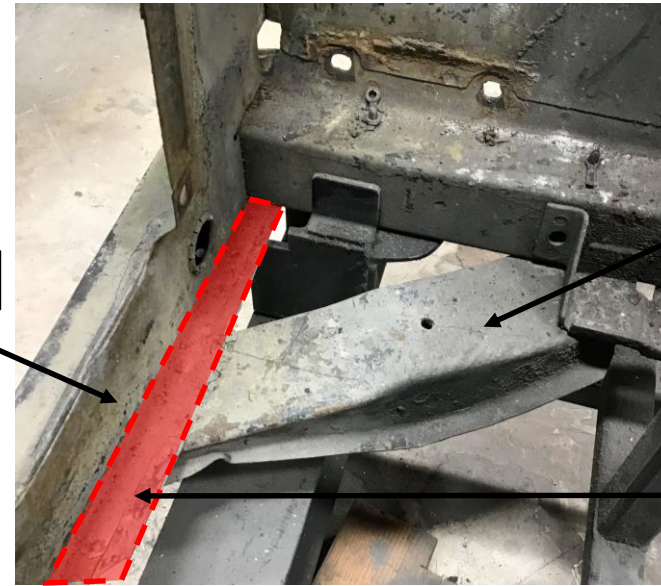
A SPOT WELD DRILL BIT MAY BE HELPFUL WHEN REMOVING CORNER BRACES.

# RADIATOR SUPPORT INSTRUCTIONS

**STEP 1** – REMOVE CORNER SUPPORTS, REMOVE CROSSMEMBER FLANGE, WELD CROSSMEMBER BACK TOGETHER FLUSH WITH BACK WALL.

**TOOLS**

- CUT OFF WHEEL
- MIG WELDER
- GRINDER
- TAPE MEASURE
- SQUARE



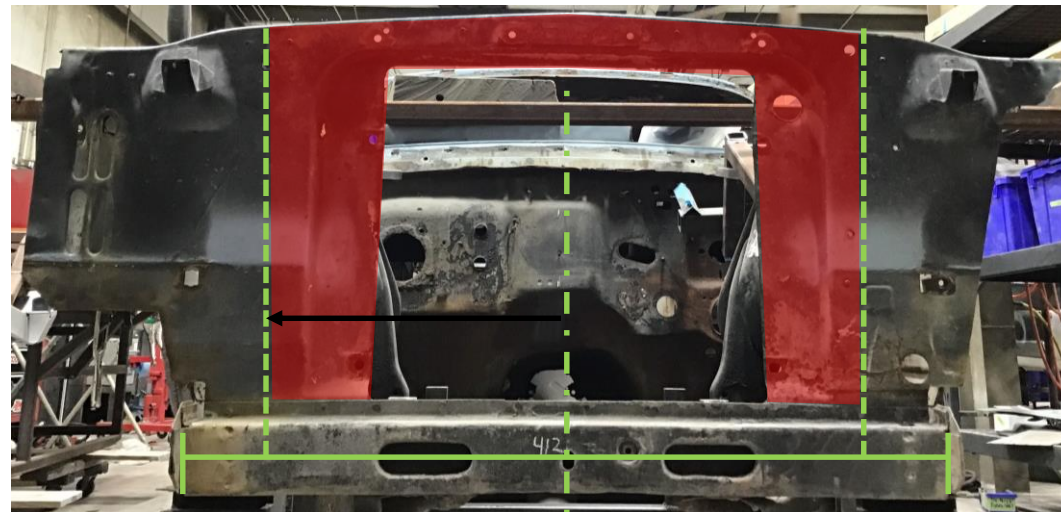
BACK WALL

REMOVE LEFT AND RIGHT CORNER BRACES

CUT LOWER FLANGE OFF CROSSMEMBER. MIG WELD REMAINING SURFACES BACK TOGETHER FLUSH WITH BACK WALL.

**STEP 2** – MEASURE WIDTH OF CROSSMEMBER AND FIND/MARK CENTER. MARK 14" FROM CENTER ON BOTH SIDES AND DRAW A VERTICAL LINE UP THE FRONT APRON. CUT AND REMOVE CENTER SECTION OF FRONT APRON.

**NOTE** – IN LATER STEPS THE VERTICAL CUTS WILL BE FURTHER TRIMMED BACK TO BE FLUSH WITH THE VERTICAL SUPPORT BARS PROVIDED IN THE KIT. FINAL CUTS WILL PROVIDE A TOTAL OPENING WIDTH OF 30".



CENTER

# RADIATOR SUPPORT INSTRUCTIONS

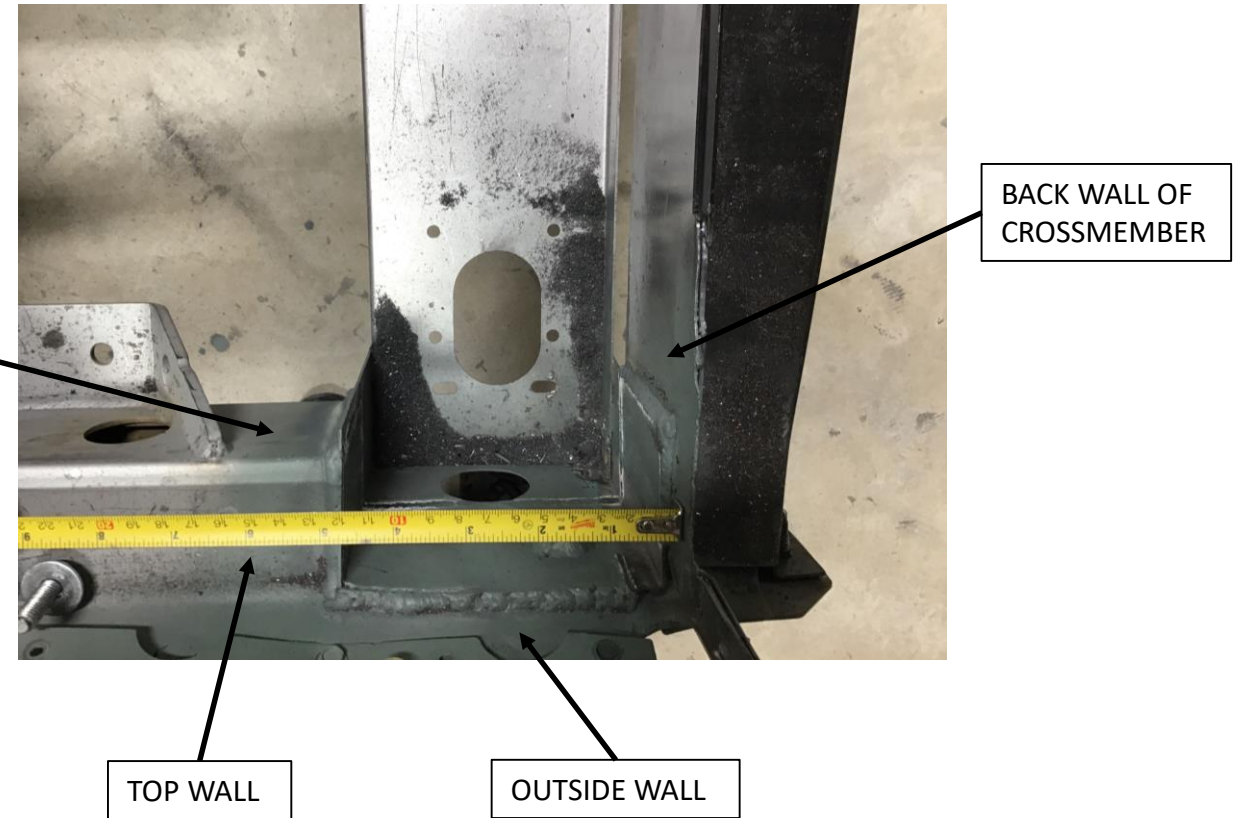
**STEP 3** – NOTCH FRAME RAILS 4.75" DEEP MEASURING FROM BACK WALL OF CROSSMEMBER. REMOVE TOP WALL, INSIDE WALL, AND BOTTOM WALL. KEEP OUTSIDE WALL OF FRAME RAIL INTACT.

**STEP 4** – INSERT RADIATOR SUPPORT STRUCTURE BETWEEN FRAME RAILS. SET TO A DEPTH OF 2.125" FROM LOWER OUTSIDE FRAME RAIL FLANGE TO BOTTOM OF LOWER RADIATOR SUPPORT TRAY. CLAMP IN PLACE AND CHECK ARCHED CROSS BAR FOR FLUSH FITMENT WITH REMAINING FRONT APRONT TOP FLANGES.

**STEP 5** – DRILL  $21/64$ " HOLES THROUGH TOP APRON FLANGES (1 PLACE PER SIDE) TO MATCH THE BOLT HOLES RUNNING THROUGH THE ARCHED TOP BEAM. BOLT APRON FLANGE, TOP BEAM, AND SIDE BARS TOGETHER USING PROVIDED  $5/16$ "x2" BOLTS. SIDE BARS ARE ALREADY TAPPED WITH THREADS FOR THIS HARDWARE.

## TOOLS

- CUT OFF WHEEL
- MIG WELDER
- GRINDER
- CLAMPS
- $21/64$ " DRILL BIT
- DRILL



# RADIATOR SUPPORT INSTRUCTIONS

**STEP 6** – PERIMETER WELD LOWER SUPPORT TO FRAME RAILS (INSIDE AND OUTSIDE SURFACES). WELD SIDE BARS TO FRONT APRON AND CUT APRON FLUSH WITH VERTICAL BARS. DISTANCE BETWEEN UPRIGHT BARS SHOULD MEASURE 30”.



- TOOLS**  
 CUT OFF WHEEL  
 MIG WELDER  
 GRINDER  
 CLAMPS

# RADIATOR SUPPORT INSTRUCTIONS

**STEP 7** – DRILL 29/64” HOLE THROUGH NEW RADIATOR SUPPORT TO MATCH FRONT BUMPER BEAM HOLE IN OUTSIDE FRAME RAIL SURFACE. CENTER NUT AND BOLT ASSEMBLY IN HOLE AND WELD NUT FROM INSIDE. TEST FIT BUMPER BEAM BRACKET TO ENSURE PROPER ALIGNMENT BEFORE WELDING NUT.



DRILL AND WELD NUT FOR BUMPER BEAM BOLT.

WELD BUMPER BEAM NUT FROM INSIDE AFTER ALIGNING WITH BOLT.

## **TOOLS**

- CUT OFF WHEEL
- MIG WELDER
- GRINDER
- 29/64” DRILL BIT
- DRILL

## COMPLETE ASSEMBLY

