

2004 ACCESSORIES & EQUIPMENT

Frame & Underbody - C/K SUV

SPECIFICATIONS

FASTENER TIGHTENING SPECIFICATIONS

Fastener Tightening Specifications

Application	Specification	
	Metric	English
Assist Step Body Mounting Bolts	90 N.m	66 lb ft
Assist Step Bracket Bolt	25 N.m	18 lb ft
Assist Step Bracket Nuts	9 N.m	80 lb in
Assist Step Spacer Nuts	29 N.m	21 lb ft
Body Mounting Bolt	85 N.m	63 lb ft
Bottom Fender Bolt	25 N.m	18 lb ft
Engine Protection Shield to Frame Rail Bolts	20 N.m	15 lb ft
Frame Crossmember Bolt/Nut	180 N.m	133 lb ft
Front Lamp Harness Ground Bolt	6 N.m	53 lb in
Inner Side Rocker Panel Bolts (Lower)	10 N.m	89 lb in
Inner Side Rocker Panel Bolts (Upper)	29 N.m	21 lb ft
Intermediate Cable Nut	4 N.m	30 lb in
Master Cylinder Mounting Nuts	36 N.m	27 lb ft
Tow Hook to Frame Rail Bolts	85 N.m	63 lb ft
Trailer Hitch to Frame Bolts	125 N.m	92 lb ft
Transmission Mount to Support Bolts	40 N.m	30 lb ft
Transmission Support to Frame Bolts	95 N.m	70 lb ft

REPAIR INSTRUCTIONS

TRANSMISSION SUPPORT REPLACEMENT

Removal Procedure

1. Raise the vehicle. Refer to **Lifting and Jacking the Vehicle** in General Information.
2. Support the transmission with a transmission jack.
3. Remove the nut retaining the transmission mount to the transmission support.
4. Raise the rear of the transmission.

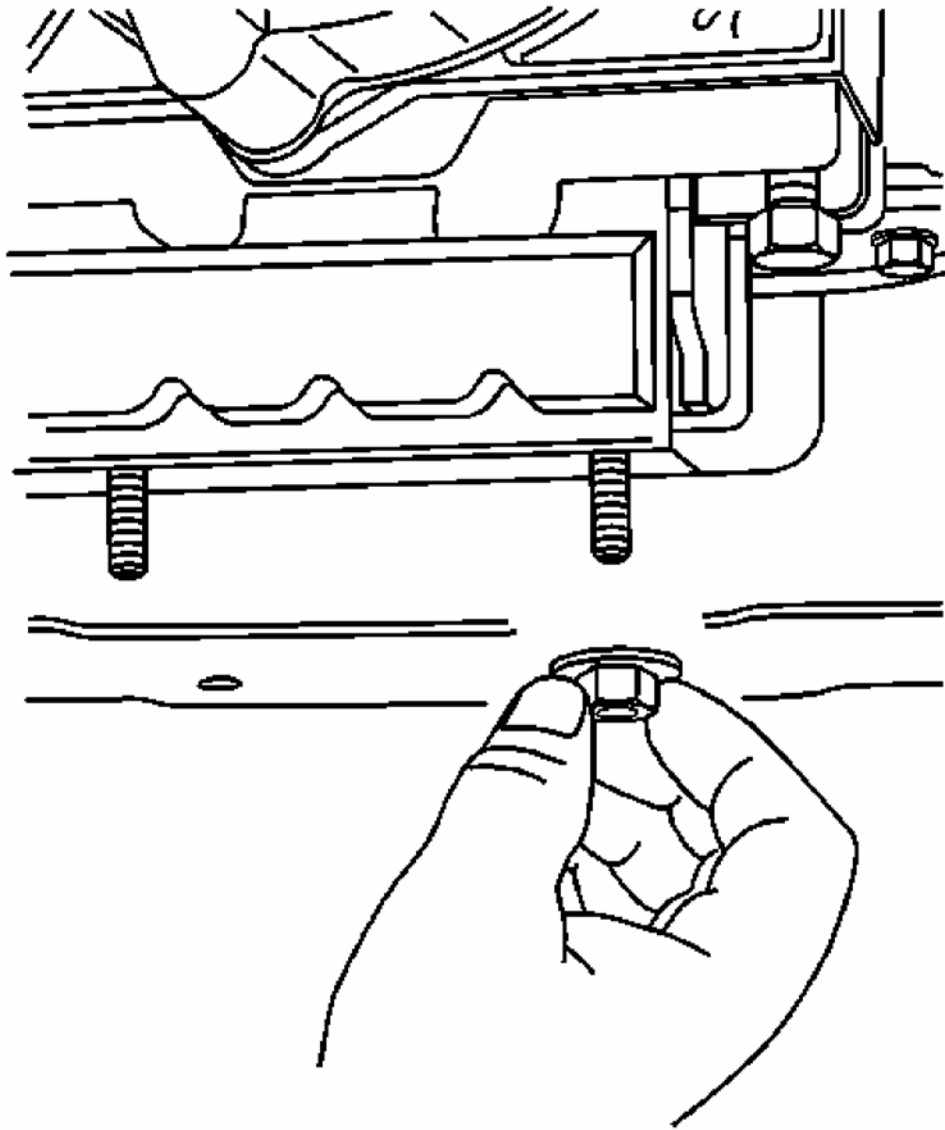


Fig. 1: Identifying Transmission Mount Nuts
Courtesy of GENERAL MOTORS CORP.

5. Remove the bolts and the nuts retaining the transmission support to the frame. (15 series)

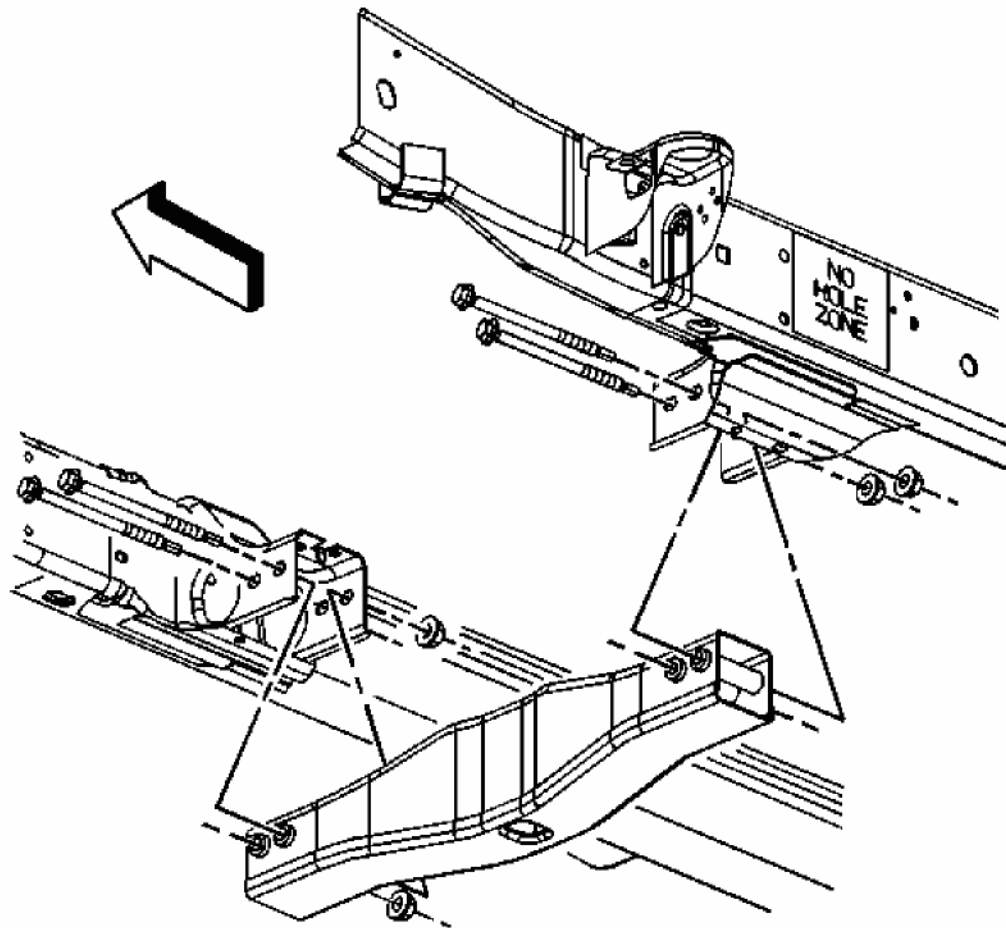


Fig. 2: View Of Transmission Crossmember
Courtesy of GENERAL MOTORS CORP.

6. Remove the bolts and the nuts retaining the transmission support to the frame. (25/35 series)

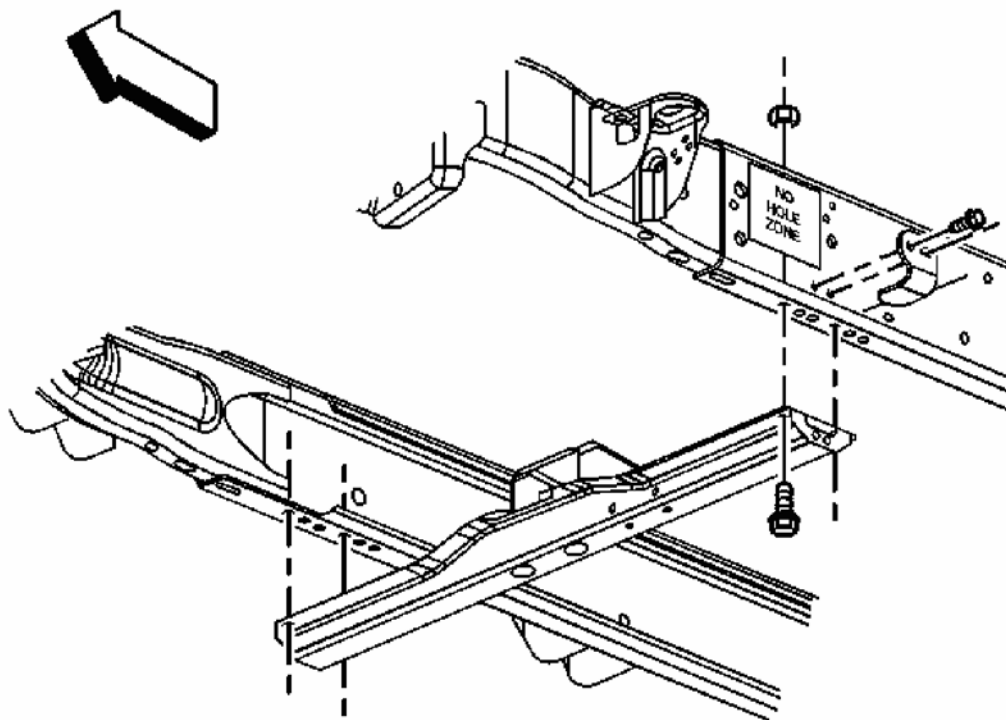


Fig. 3: Identifying Crossmember & Bolts
Courtesy of GENERAL MOTORS CORP.

7. Remove the transmission support from the frame.

Installation Procedure

1. Install the transmission support to the frame. (15 series)

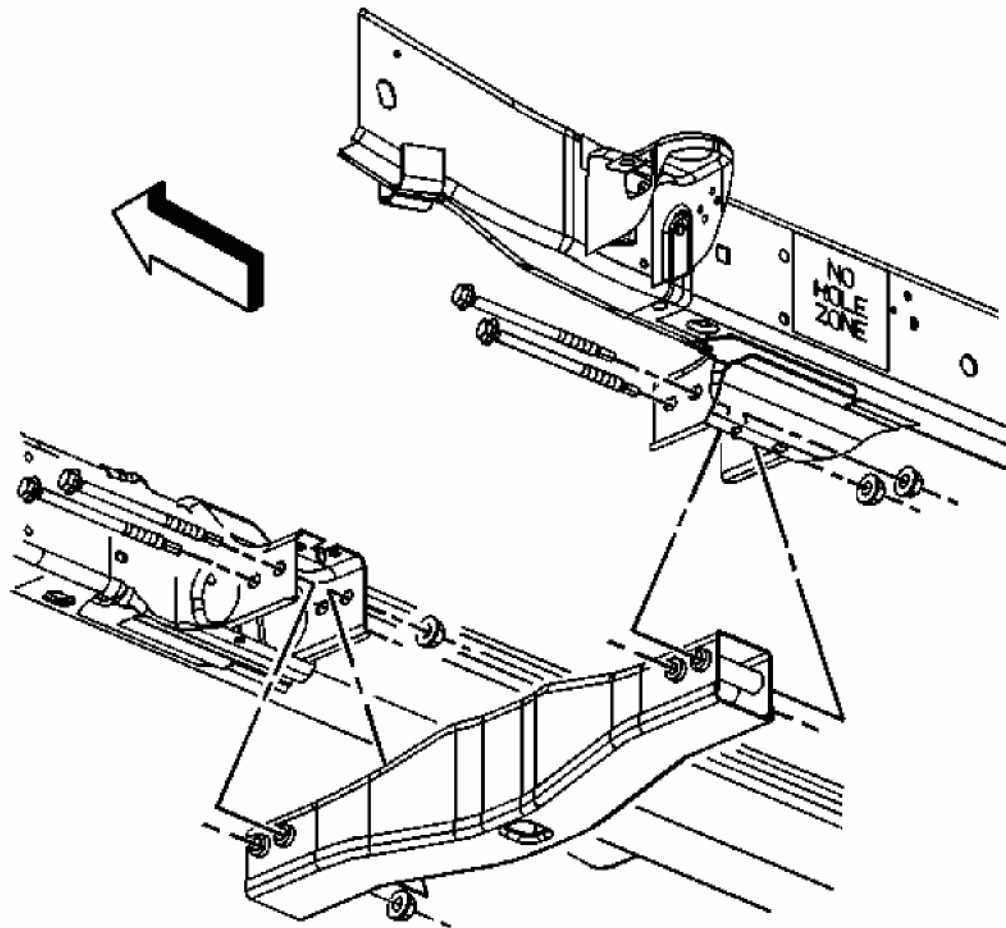


Fig. 4: View Of Transmission Crossmember
Courtesy of GENERAL MOTORS CORP.

2. Install the transmission support to the frame. (25/35 series)

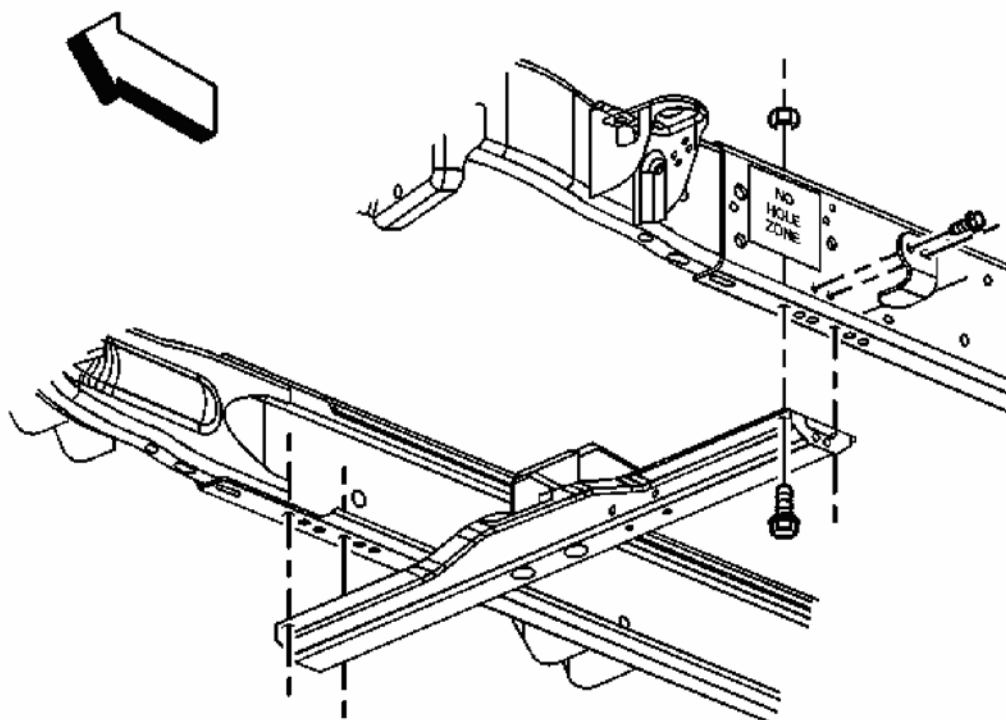


Fig. 5: Identifying Crossmember & Bolts
Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to Fastener Notice in Cautions and Notices.

3. Install the bolts and the nuts in order to retain the transmission support to the frame.

Tighten: Tighten the nuts to 95 N.m (70 lb ft).

4. Lower the rear of the transmission.
5. Install the transmission mount to the transmission support.
6. Install the nuts in order to retain the transmission mount to the transmission support.

Tighten: Tighten the nuts to 40 N.m (30 lb ft).

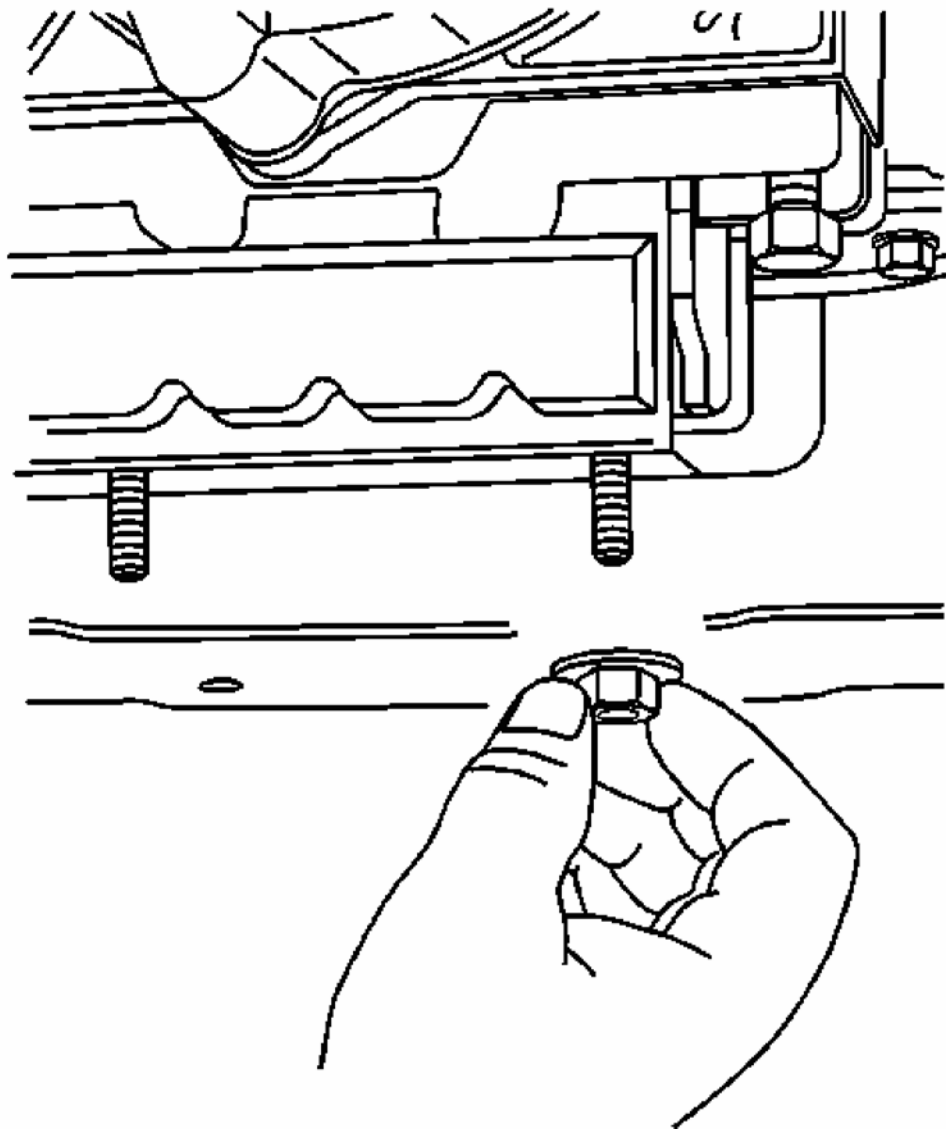


Fig. 6: Identifying Transmission Mount Nuts
Courtesy of GENERAL MOTORS CORP.

7. Remove the transmission jack.
8. Lower the vehicle.

CROSSMEMBER REPLACEMENT - FRONT ENGINE (2WD)

Removal Procedure

1. Raise the vehicle. Refer to Lifting and Jacking the Vehicle in General Information.
2. Remove the engine crossmember bolts.

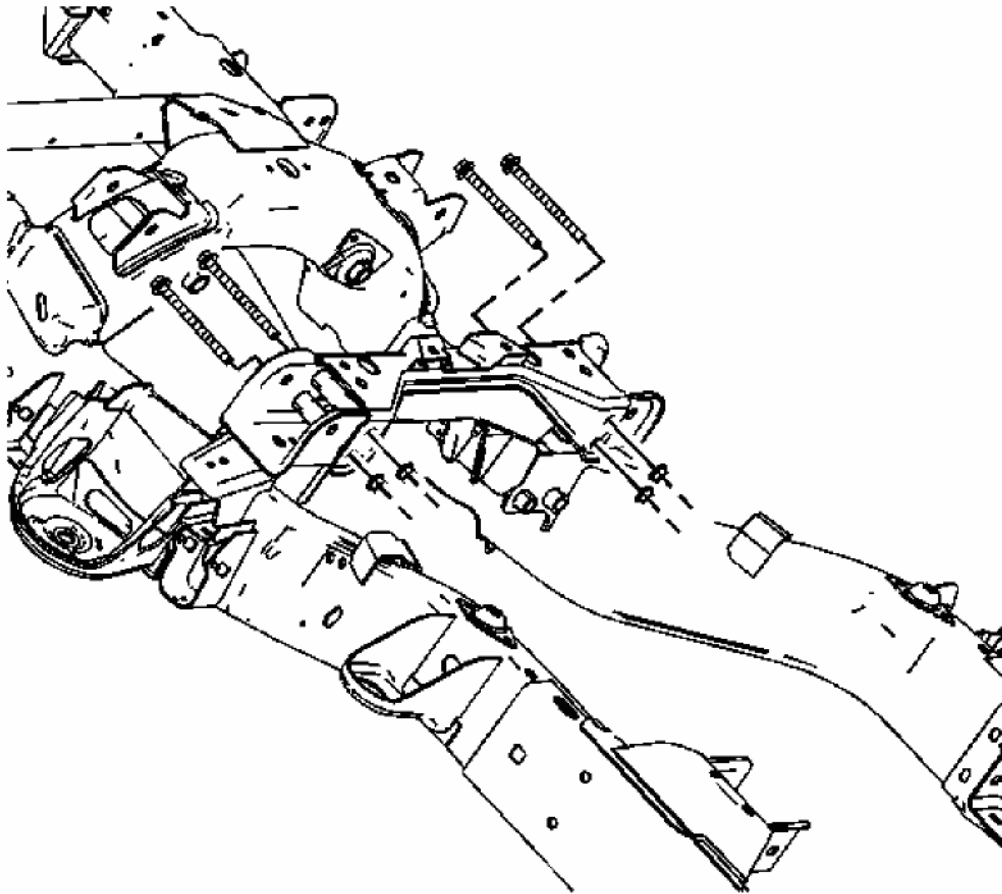


Fig. 7: Removing Front Engine Crossmember Bolts (2WD)
Courtesy of GENERAL MOTORS CORP.

3. Remove the engine crossmember.

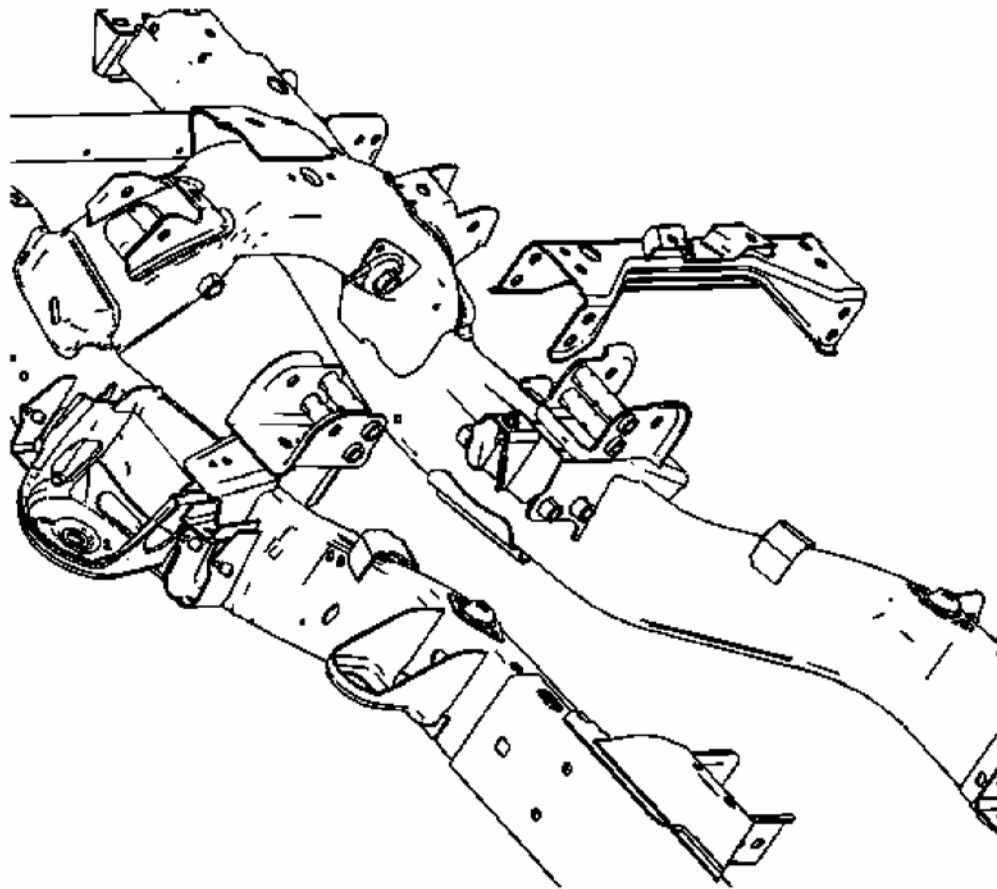


Fig. 8: Removing Front Engine Crossmember (2WD)
Courtesy of GENERAL MOTORS CORP.

Installation Procedure

1. Install the engine crossmember.

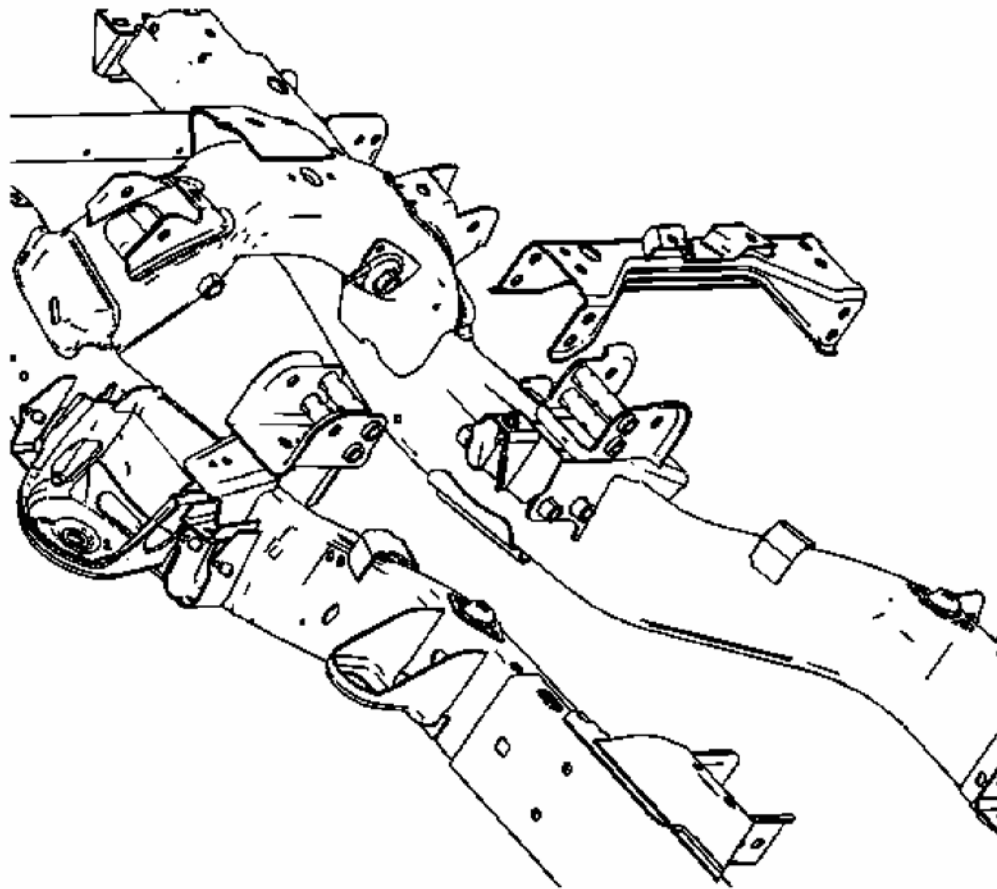


Fig. 9: Installing Front Engine Crossmember (2WD)
Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to Fastener Notice in Cautions and Notices.

2. Install the engine crossmember bolts.

Tighten: Tighten the engine crossmember bolts to 120 N.m (88 lb ft).

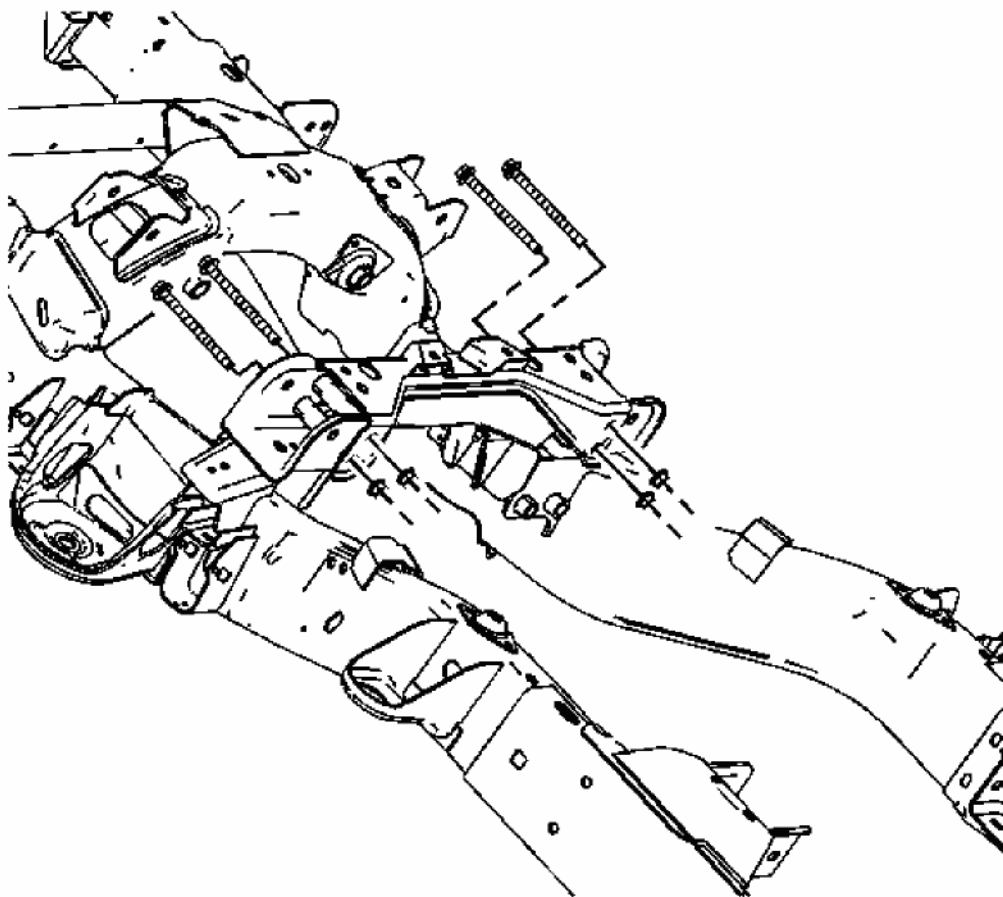


Fig. 10: Installing Front Engine Crossmember Bolts (2WD)
Courtesy of GENERAL MOTORS CORP.

3. Lower the vehicle.

CROSSMEMBER REPLACEMENT - FRONT ENGINE (4WD)

Removal Procedure

1. Raise and support the vehicle. Refer to **Lifting and Jacking the Vehicle** in General Information.
2. Remove the differential carrier shield. Refer to **Shield Replacement** in Front Drive Axle.
3. Remove the bolts retaining the crossmember to the frame.

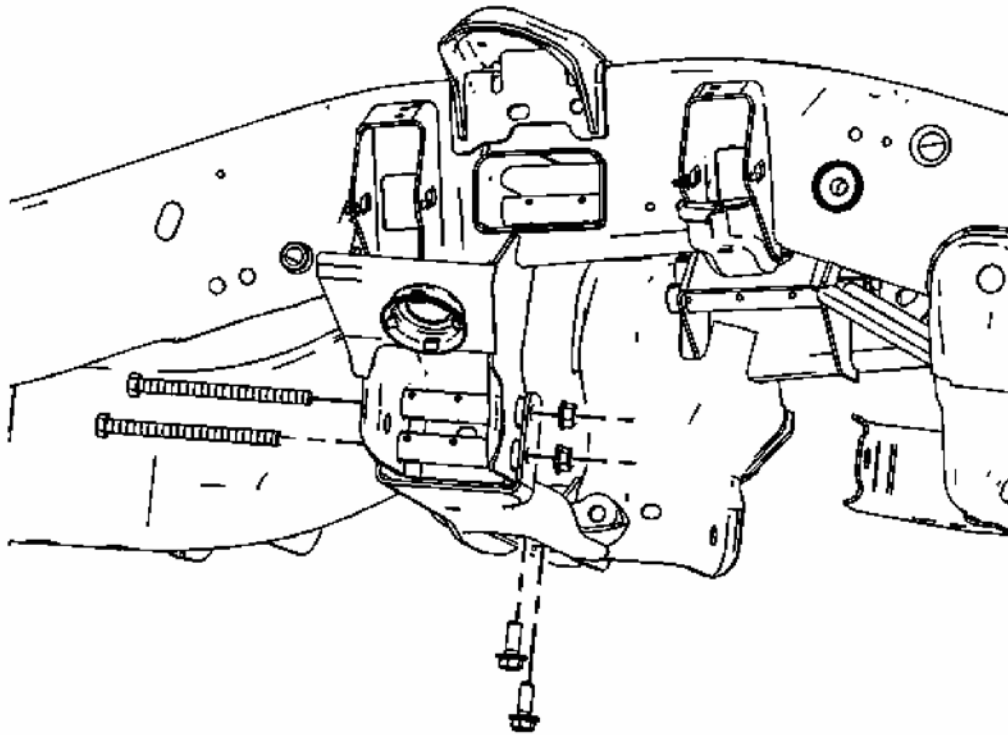


Fig. 11: Removing Front Engine Crossmember Bolts (4WD)
Courtesy of GENERAL MOTORS CORP.

4. Remove the crossmember from the vehicle.

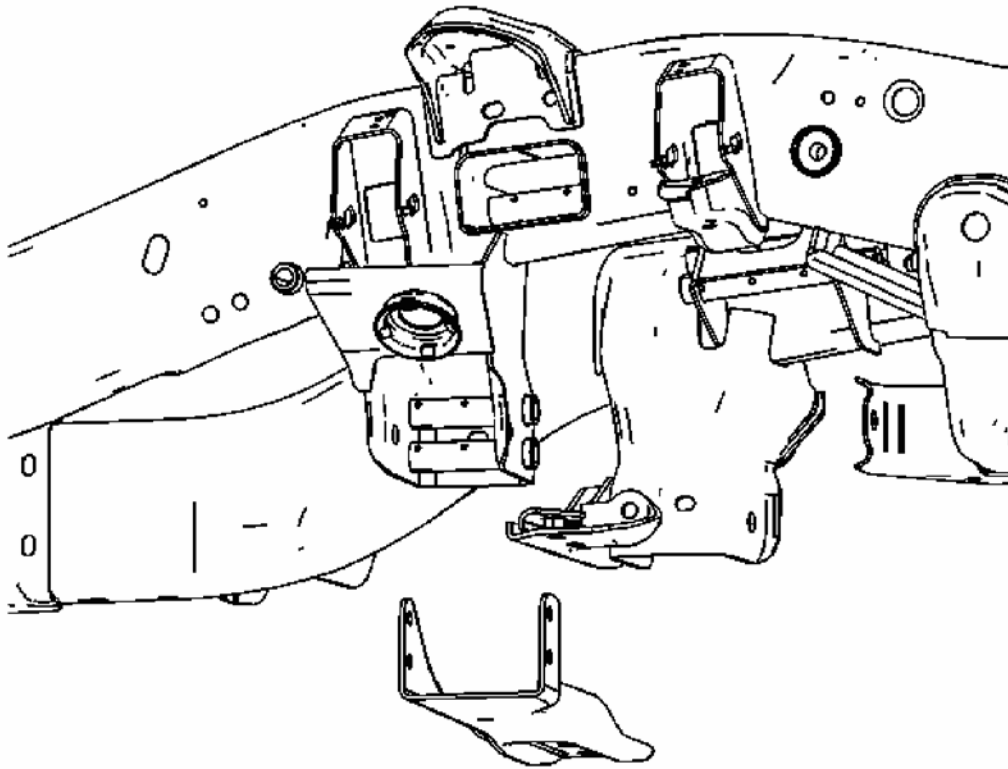


Fig. 12: Removing Front Engine Crossmember (4WD)
Courtesy of GENERAL MOTORS CORP.

Installation Procedure

1. Install the crossmember to the vehicle.

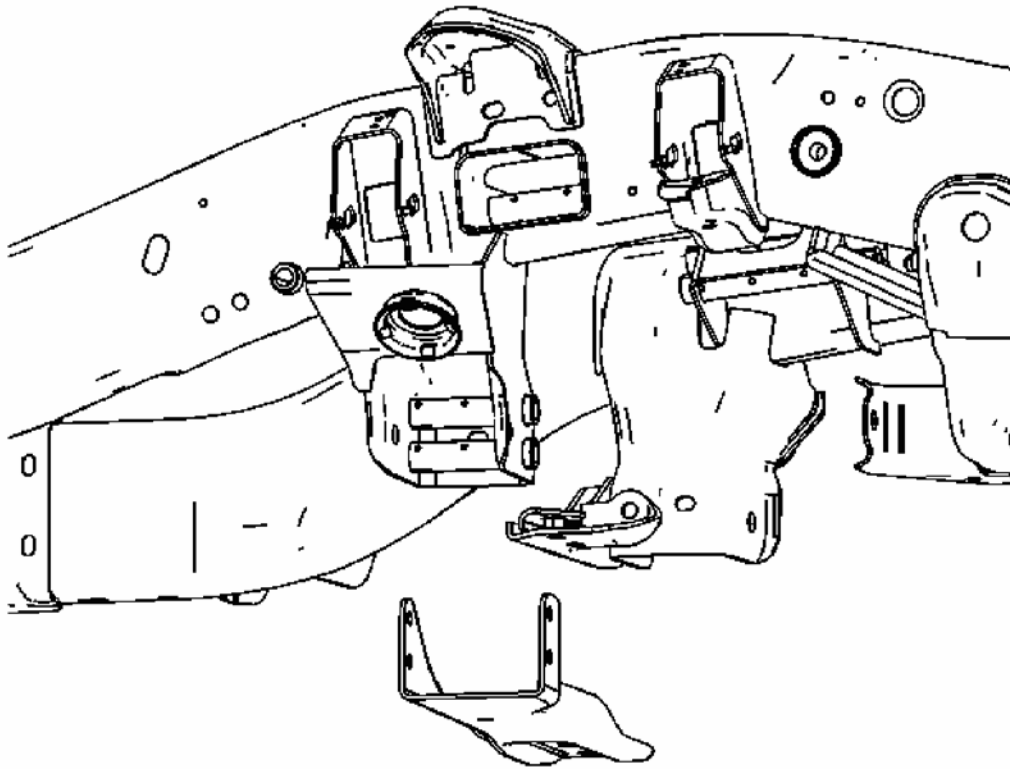


Fig. 13: Installing Front Engine Crossmember (4WD)
Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to Fastener Notice in Cautions and Notices.

2. Install the bolts retaining the crossmember to the frame.

Tighten: Tighten the crossmember retaining bolts to 120 N.m (88 lb ft).

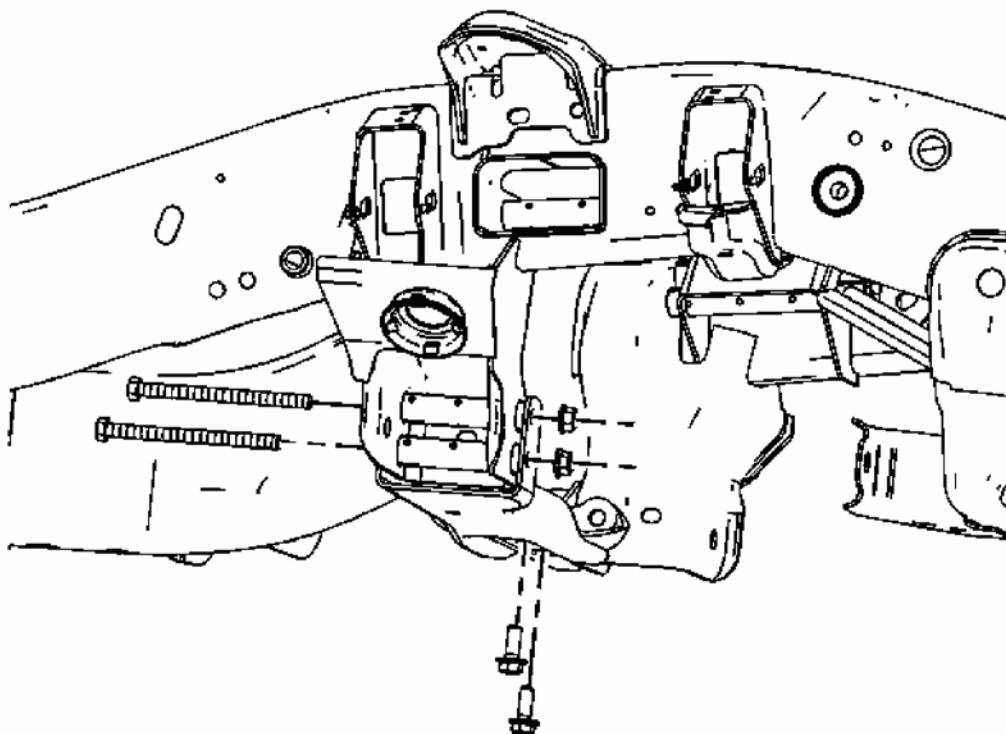


Fig. 14: Installing Front Engine Crossmember Bolts (4WD)
Courtesy of GENERAL MOTORS CORP.

3. Install the differential carrier shield. Refer to **Shield Replacement** in Front Drive Axle.
4. Lower the vehicle.

FRAME BRACE REPLACEMENT

Removal Procedure

1. Raise the vehicle. Refer to **Lifting and Jacking the Vehicle** in General Information.
2. Remove the bolts retaining the frame brace to the frame.
3. Remove the frame brace from the vehicle.

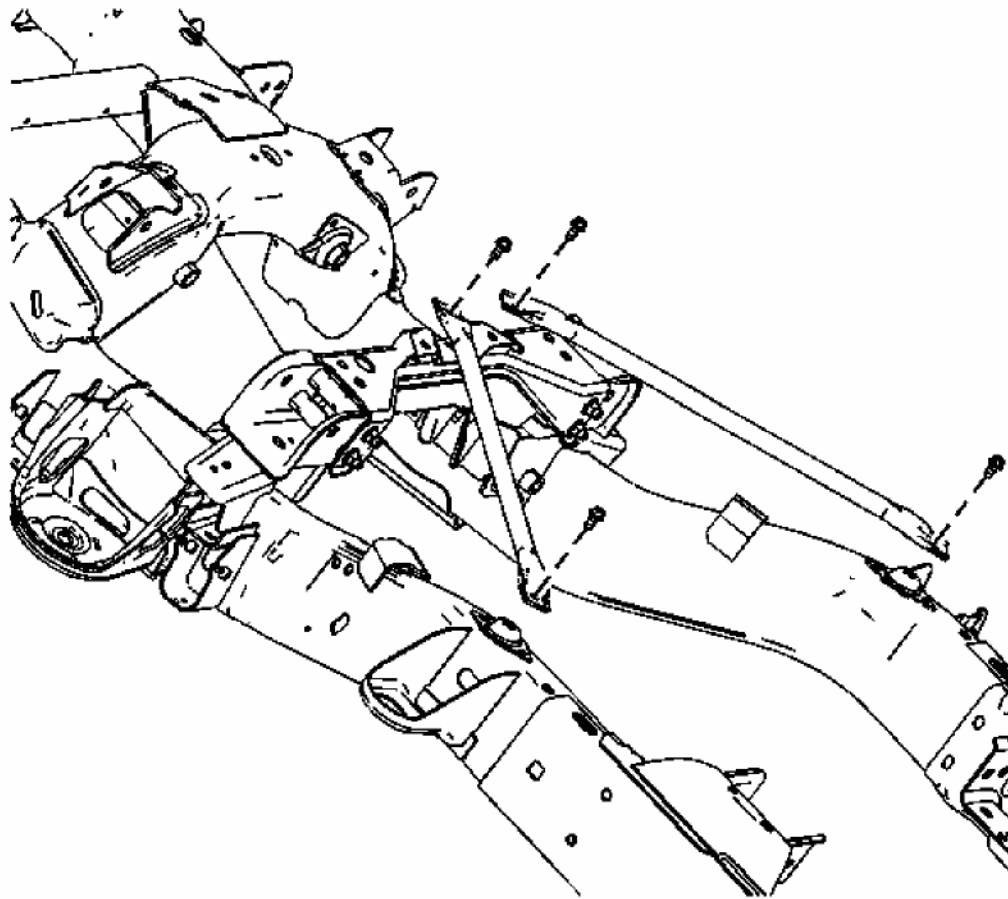


Fig. 15: Removing Frame Brace
Courtesy of GENERAL MOTORS CORP.

Installation Procedure

1. Install the frame brace to the vehicle.

NOTE: Refer to Fastener Notice in Cautions and Notices.

2. Install the bolts retaining the frame brace to the frame.

Tighten: Tighten the frame brace retaining bolts to 50 N.m (37 lb ft).

3. Lower the vehicle.

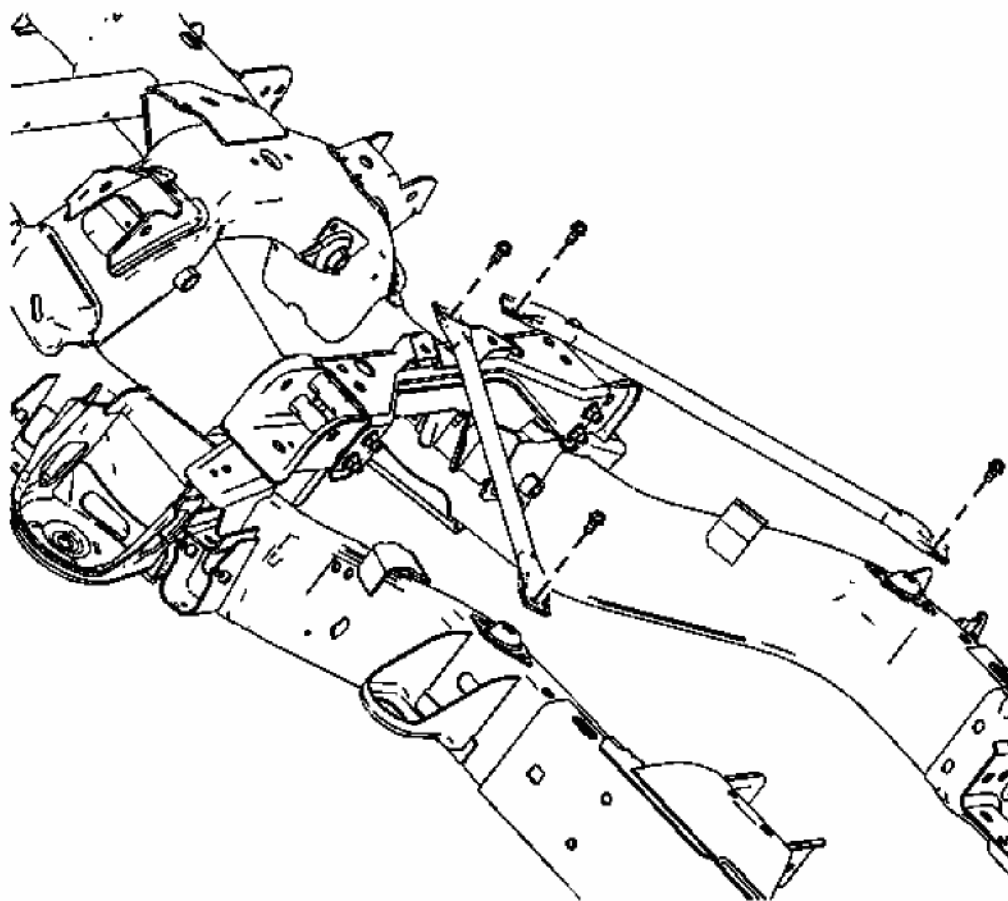


Fig. 16: Installing Frame Brace
Courtesy of GENERAL MOTORS CORP.

FRAME CUSHION OR INSULATOR REPLACEMENT

Removal Procedure

Support the frame with the hoist when you change the body mounts. If only one mount is changed loosen and lower the entire side on which the mount in question is being replaced.

1. Raise the vehicle on a hoist. Refer to **Lifting and Jacking the Vehicle** in General Information.
2. Using jack stands or the equivalent to support the body where the mounts will be replaced.
3. Remove the body mount bolt, retainer, and lower cushion at the radiator support.

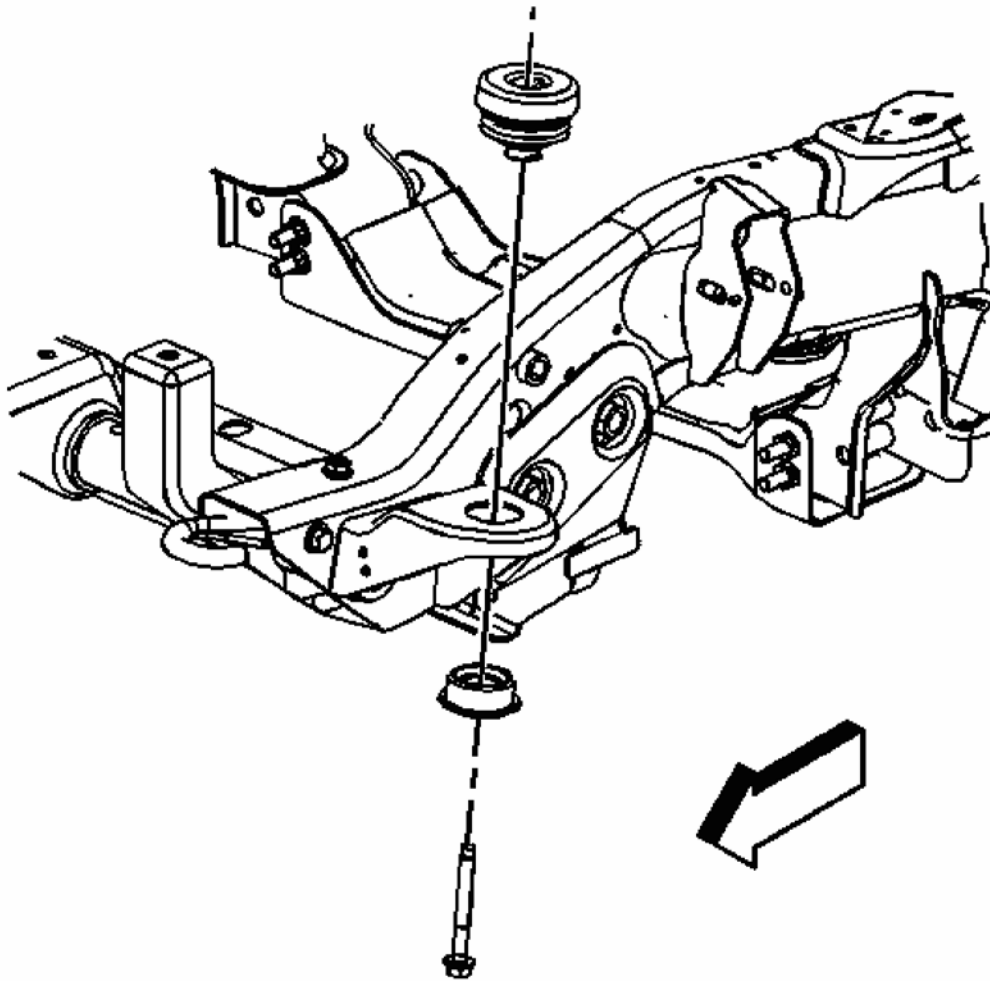


Fig. 17: Removing Body Mount Bolt, Retainer & Lower Cushion At Radiator Support

Courtesy of GENERAL MOTORS CORP.

4. Remove the body mount bolt, retainers, and lower cushions at the front mount location.

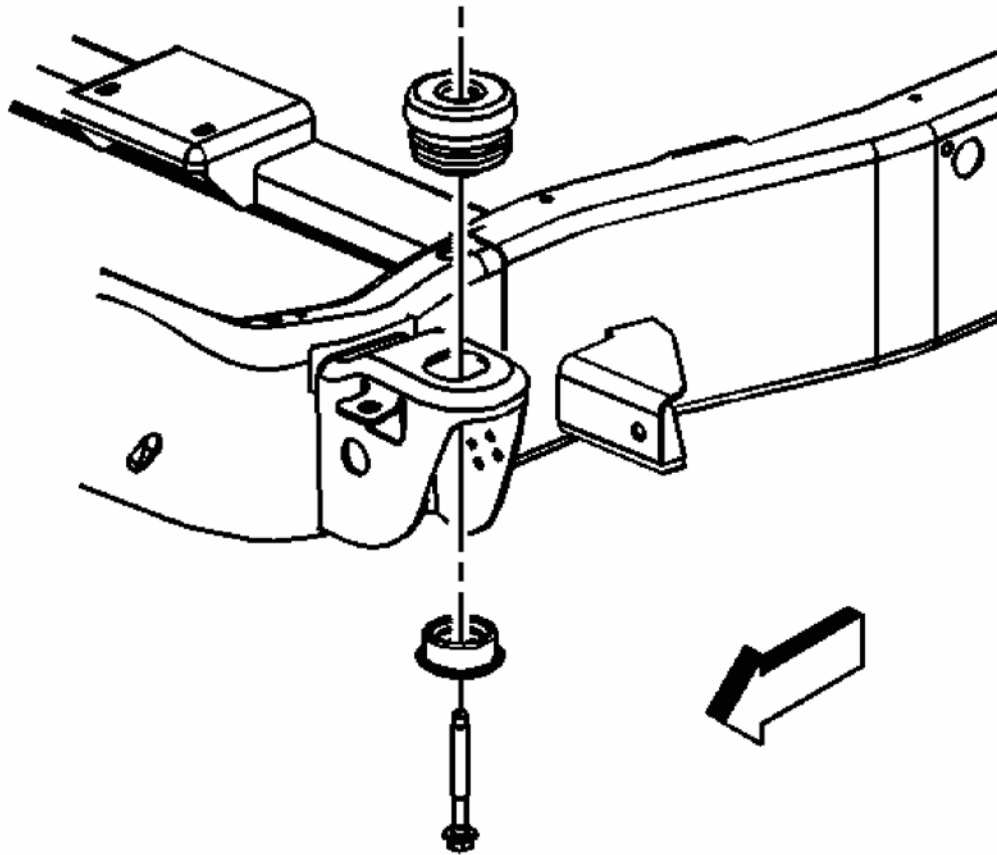


Fig. 18: Removing Body Mount Bolt, Retainers & Lower Cushions At Front Mount

Courtesy of GENERAL MOTORS CORP.

5. Remove the body mount bolt, retainers, and lower cushions at the other mount locations.

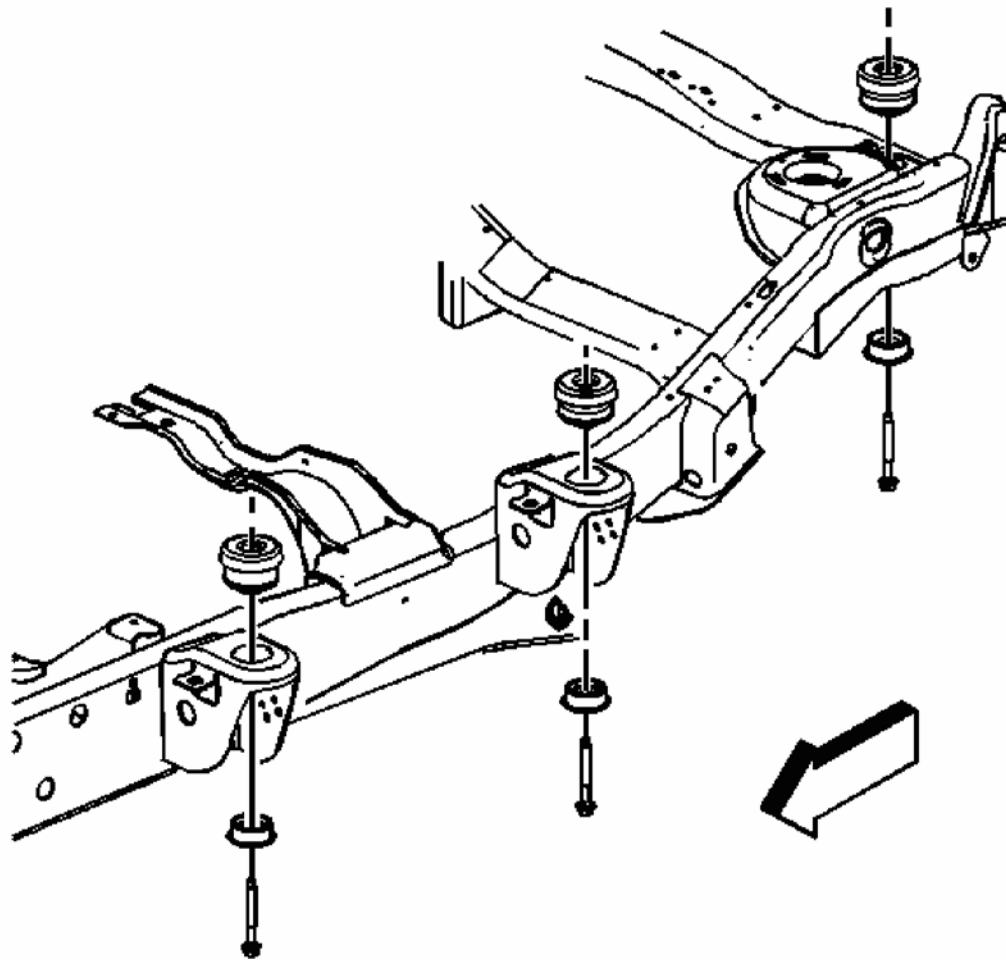


Fig. 19: Removing Body Mount Bolt, Retainers & Lower Cushions At Other Mounts

Courtesy of GENERAL MOTORS CORP.

6. Remove the body mount bolt, retainers, and lower cushion at the rear most mount.

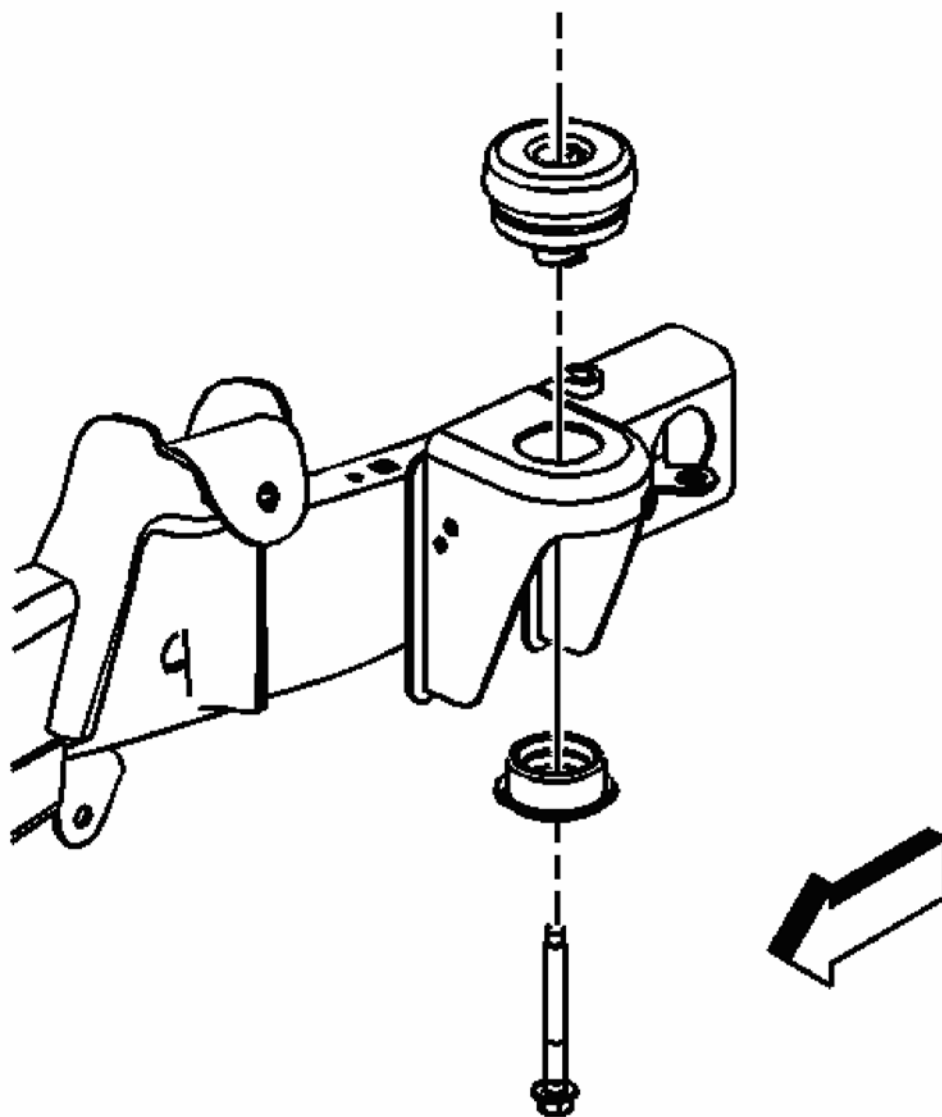


Fig. 20: Removing Body Mount Bolt, Retainers & Lower Cushion At Rear Most Mount

Courtesy of GENERAL MOTORS CORP.

7. Disconnect or remove any wiring harness or component that may interfere with the lowering of the frame.
8. Lower the hoist in order to leave the body supported by the jack stands.
9. Remove the upper cushions and the shims from the vehicle.

1. Install the upper cushions and the shims to the vehicle.
2. Raise the hoist to allow the body mount bolts to be installed.
3. Connect or install any wiring harness or component that was removed to allow for the lowering of the frame.
4. Install the body mount bolt, retainer, and lower cushion at the rear most mount.

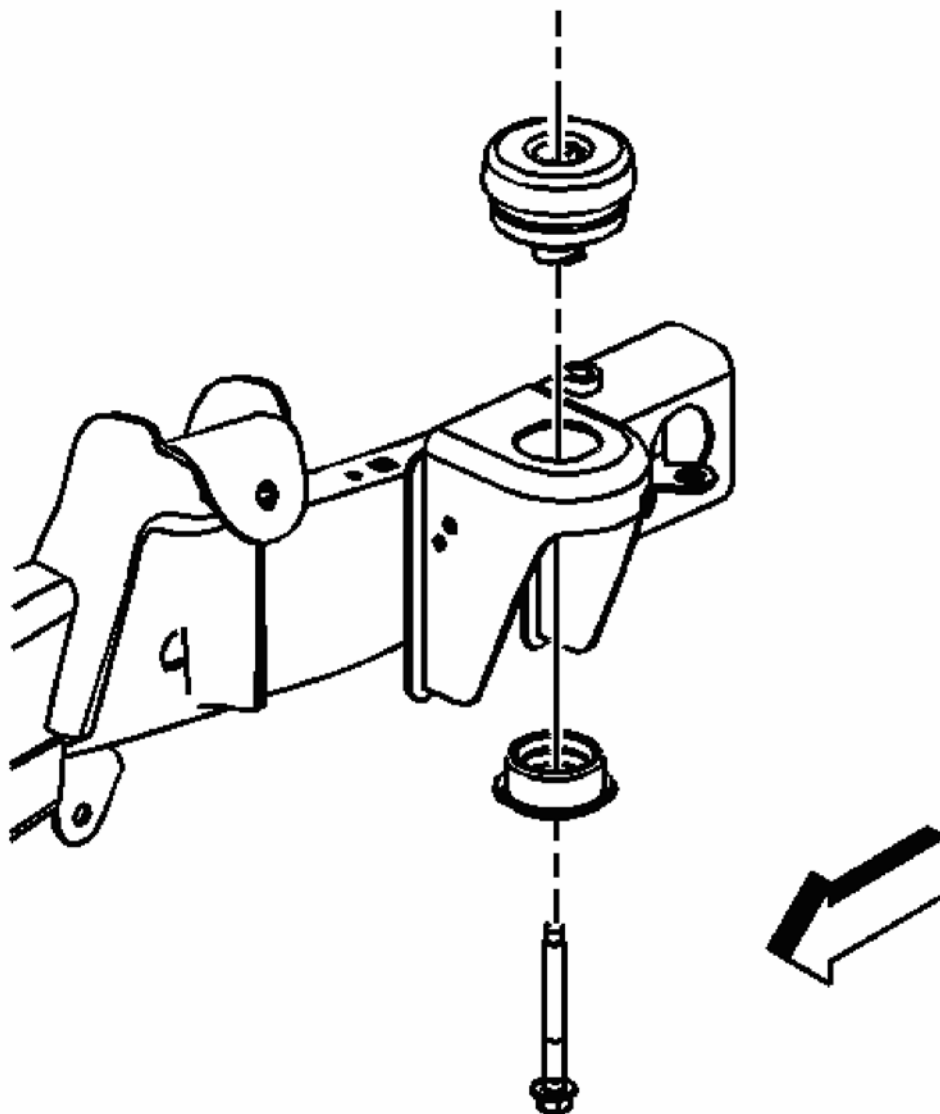


Fig. 21: Installing Body Mount Bolt, Retainer & Lower Cushion At Rear Most Mount

Courtesy of GENERAL MOTORS CORP.

5. Install the body mount bolt, retainers, and lower cushions at the other mount locations.

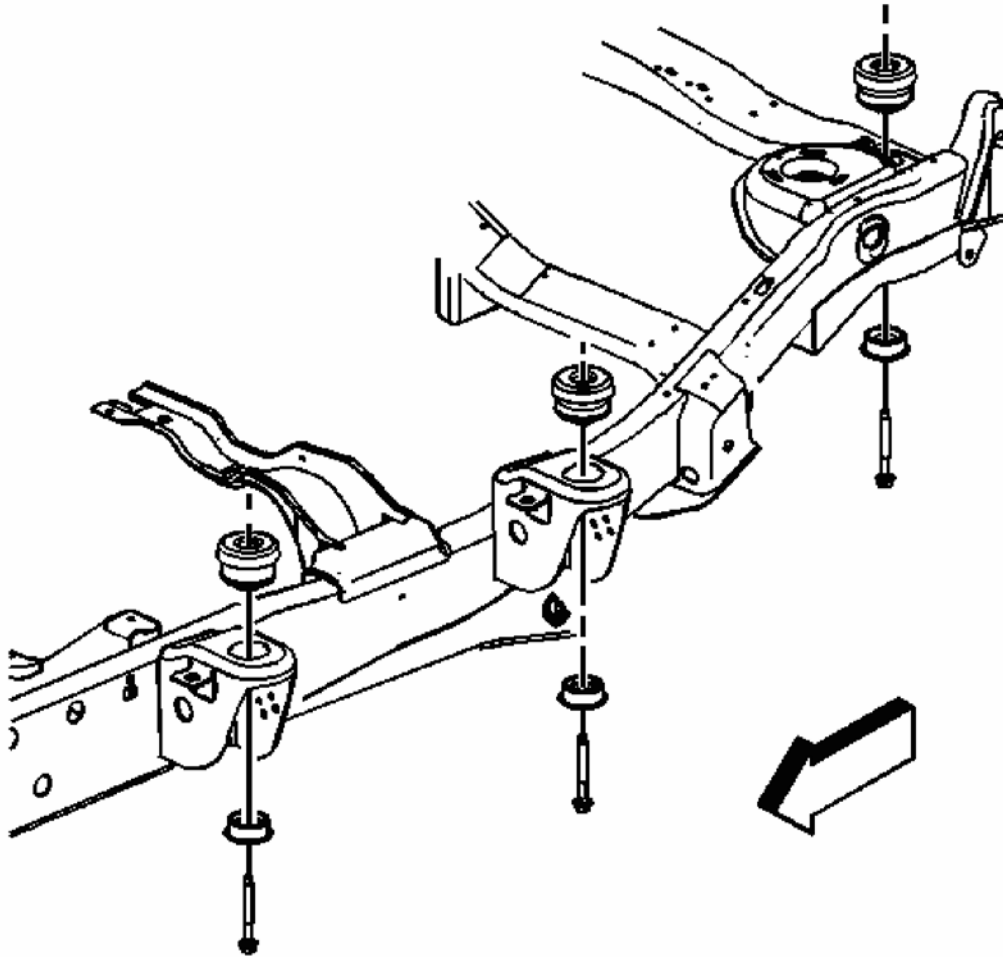


Fig. 22: Installing Body Mount Bolt, Retainers & Lower Cushions At Other Mounts

Courtesy of GENERAL MOTORS CORP.

6. Install the body mount bolt, retainers, and lower cushions at the front mount location.

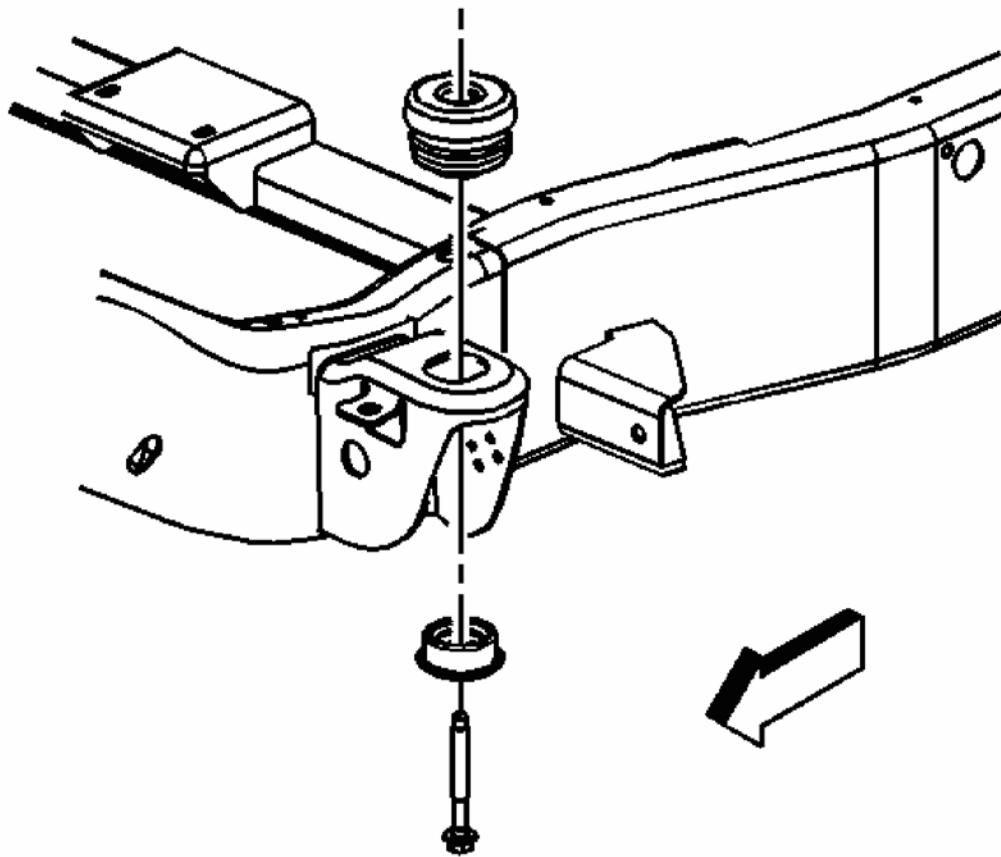


Fig. 23: Installing Body Mount Bolt, Retainers & Lower Cushions At Front Mount

Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to Fastener Notice in Cautions and Notices.

7. Install the body mount bolt, retainer, and lower cushion at the radiator support.

Tighten: Tighten the bolts to 85 N.m (63 lb ft).

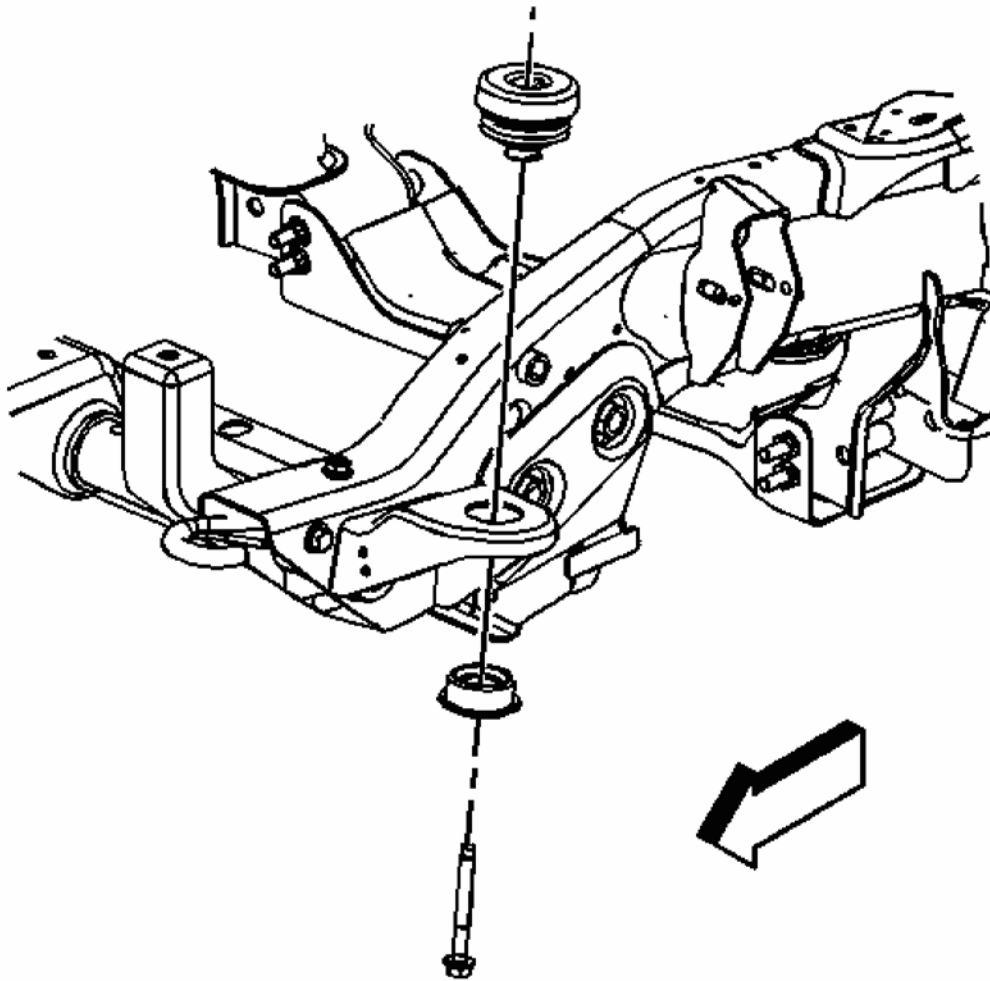


Fig. 24: Installing Body Mount Bolt, Retainer & Lower Cushion At Radiator Support

Courtesy of GENERAL MOTORS CORP.

8. Remove the jack stands.
9. Lower the vehicle.

TRAILER HITCH REPLACEMENT

Removal Procedure

1. Disconnect the trailer wiring harness.

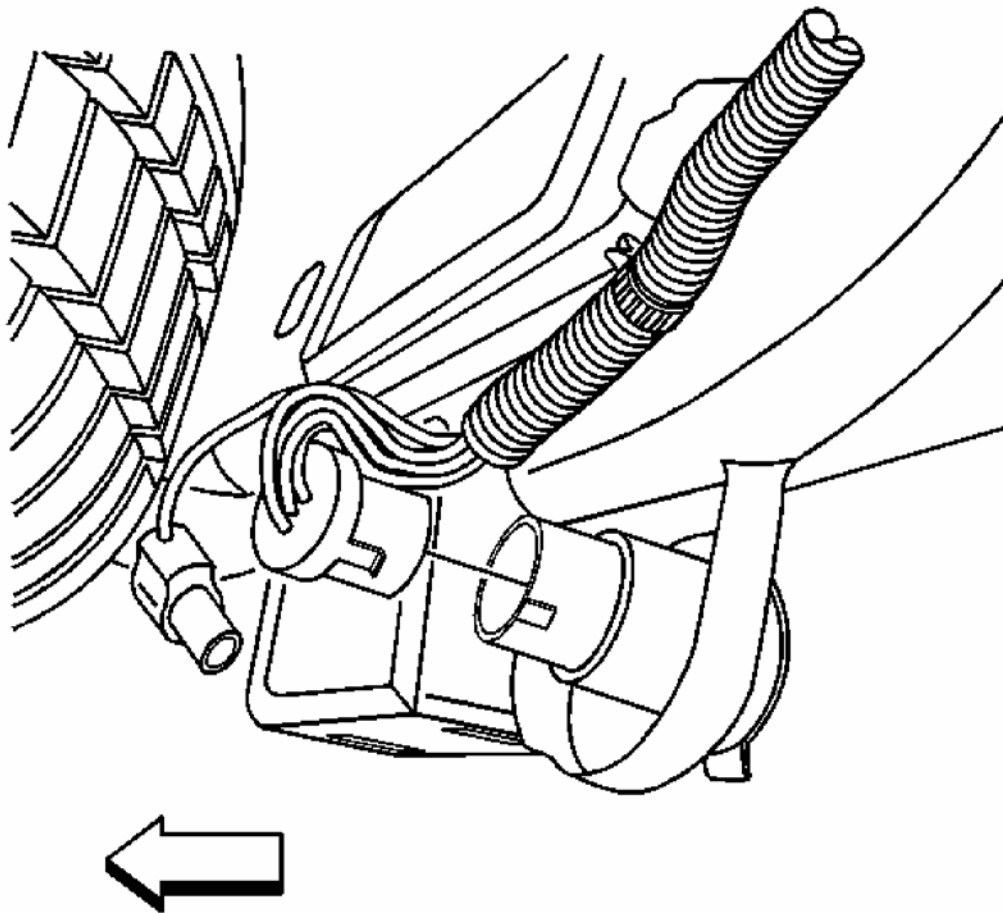


Fig. 25: Disconnecting Trailer Wiring Harness
Courtesy of GENERAL MOTORS CORP.

2. Remove the hitch platform bolts from the frame rails and the rear bumper.
3. Remove the hitch platform from the vehicle.

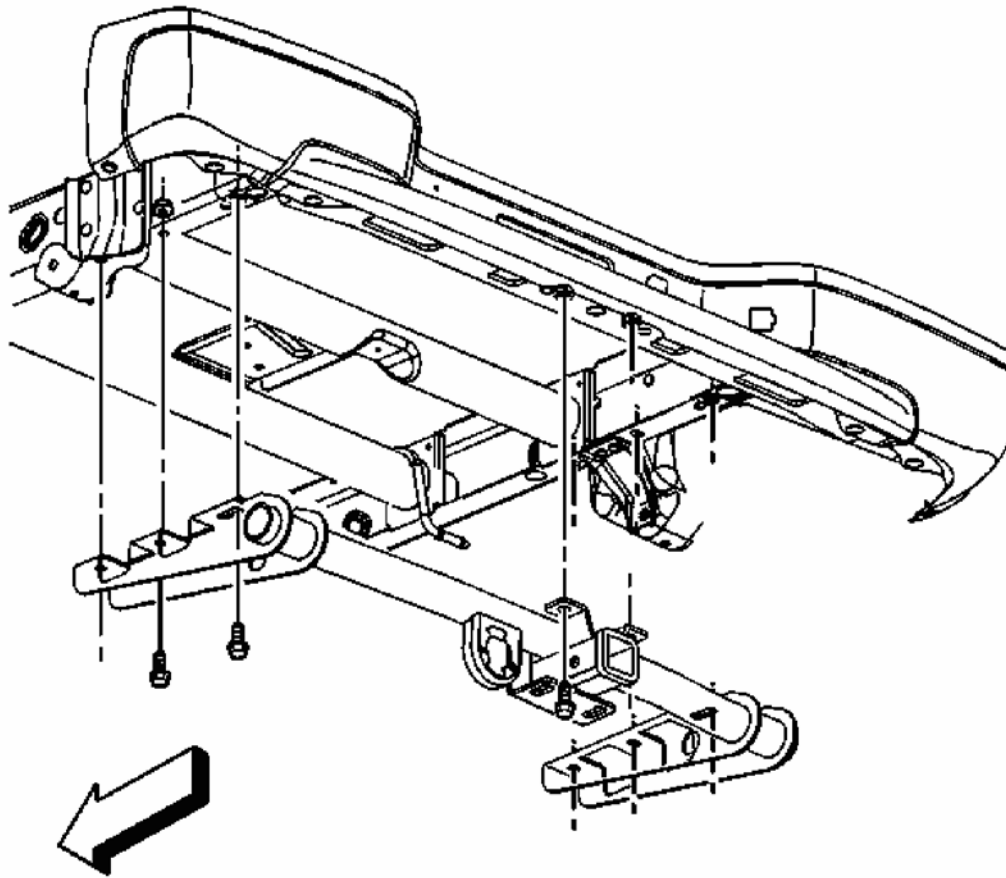


Fig. 26: Removing Hitch Platform
Courtesy of GENERAL MOTORS CORP.

Installation Procedure

1. Position the hitch platform to the vehicle.

NOTE: Refer to Fastener Notice in Cautions and Notices.

2. Install the platform hitch bolts to the frame rails and the rear bumper.

Tighten: Tighten the bolts to 125 N.m (92 lb ft).

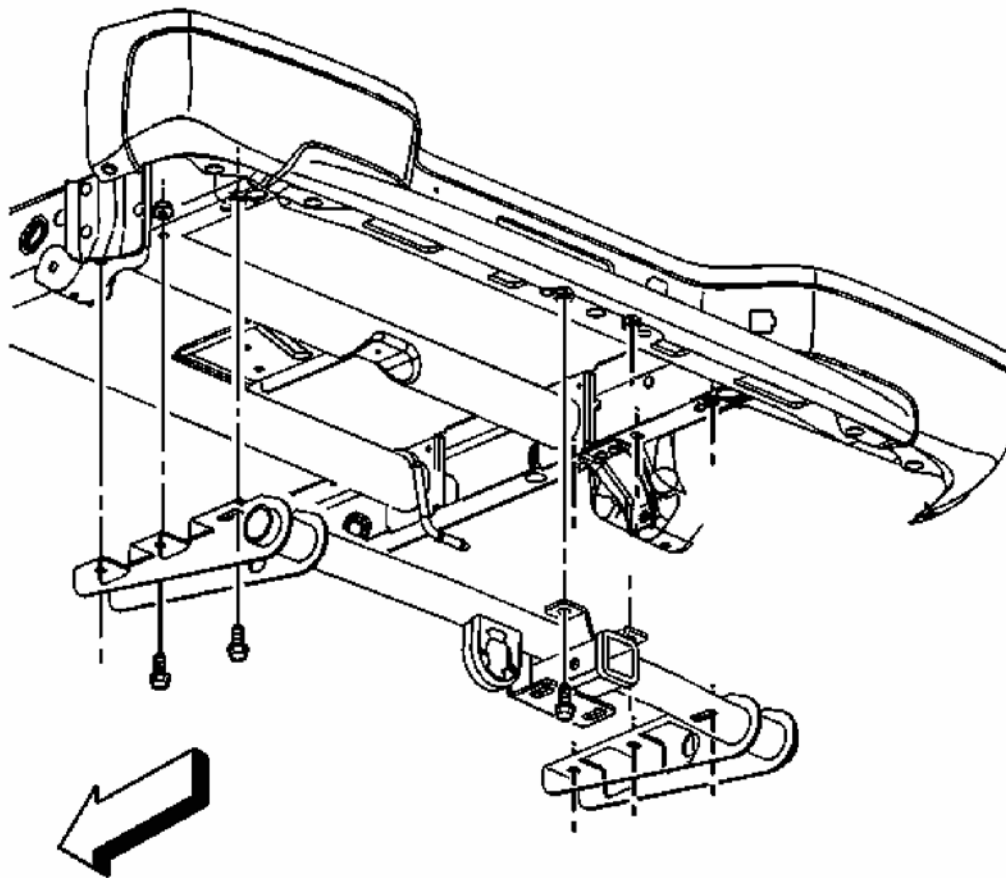


Fig. 27: Installing Hitch Platform
Courtesy of GENERAL MOTORS CORP.

3. Connect the trailer wiring harness.

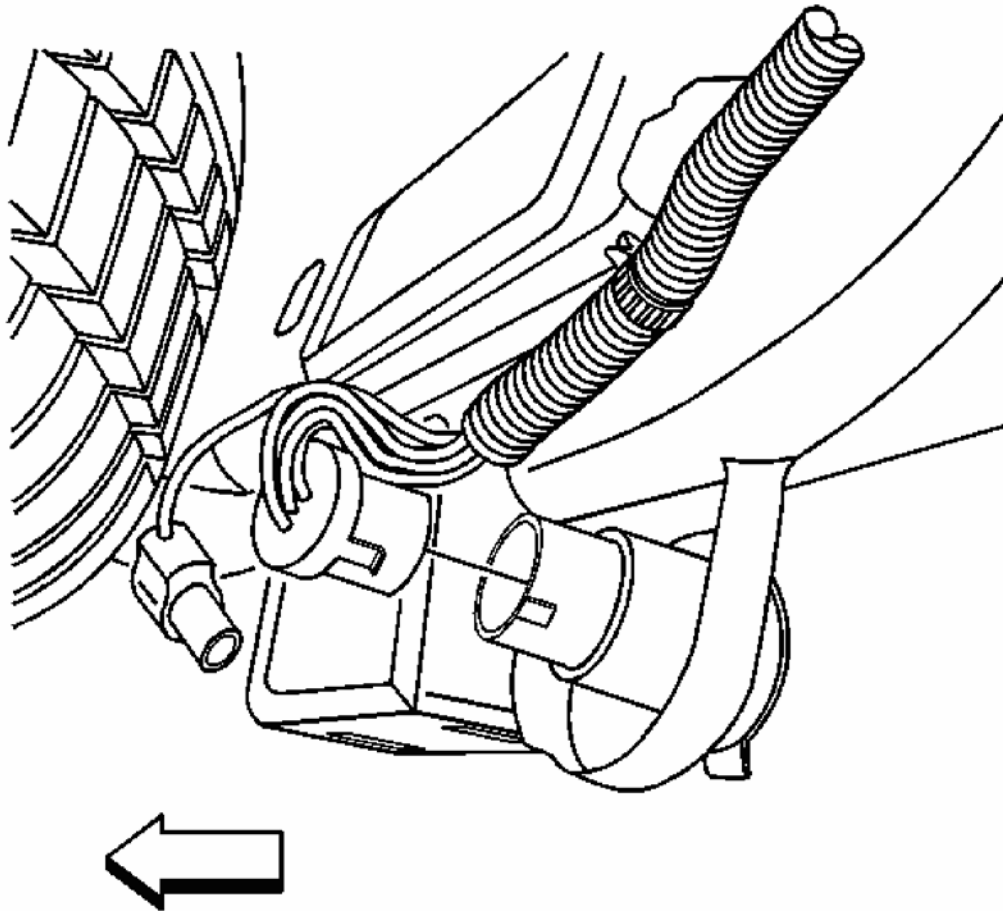


Fig. 28: Connecting Trailer Wiring Harness
Courtesy of GENERAL MOTORS CORP.

TOW HOOK REPLACEMENT (15 SERIES)

Removal Procedure

1. Remove the front bumper. Refer to **Bumper Replacement - Front (Old Style)**
2. Remove the tow hook bolts from the frame rail.
3. Remove the tow hook from the vehicle.

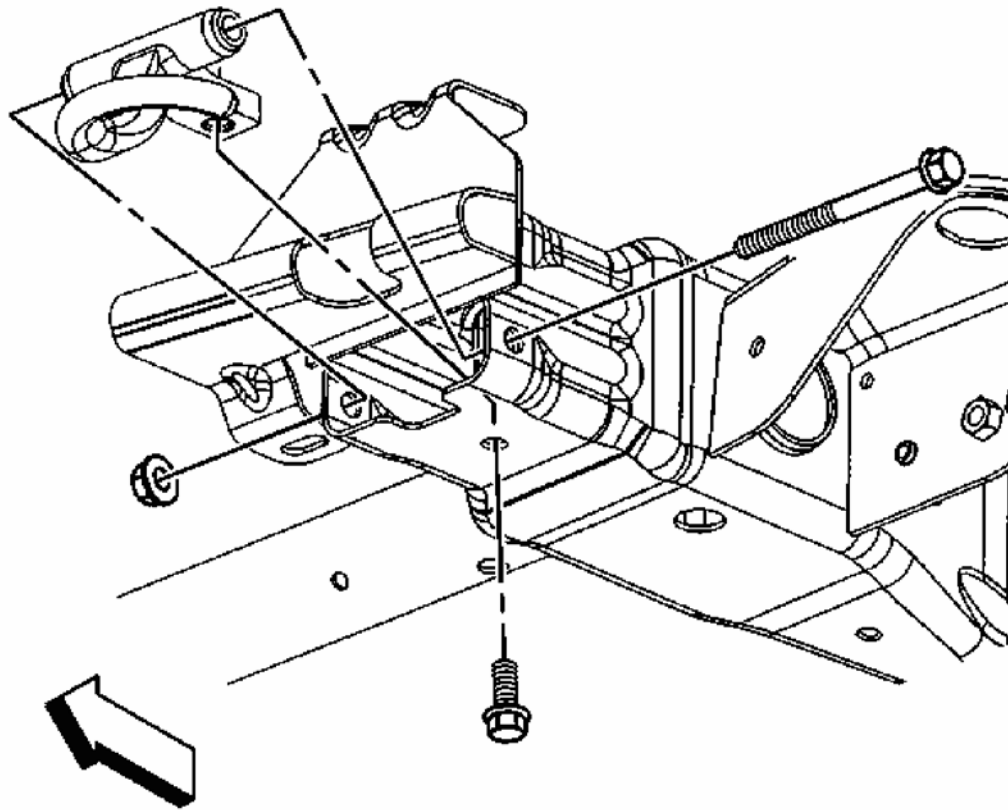


Fig. 29: Removing Tow Hook (15 Series)
Courtesy of GENERAL MOTORS CORP.

Installation Procedure

1. Install the tow hook to the frame rail.

NOTE: Refer to Fastener Notice in Cautions and Notices.

2. Install the bolts to the tow hook through the frame rail.

Tighten: Tighten the bolts to 85 N.m (63 lb ft).

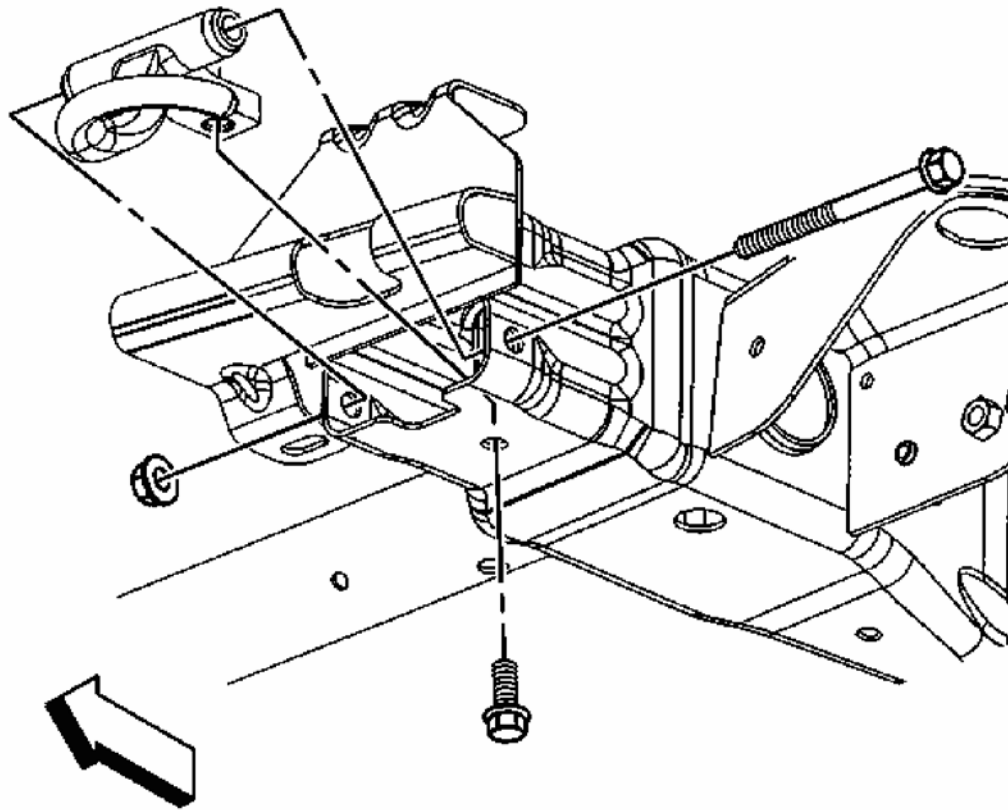


Fig. 30: Installing Tow Hook (15 Series)
Courtesy of GENERAL MOTORS CORP.

3. Install the front bumper. Refer to **Bumper Replacement - Front (Old Style)** .

TOW HOOK REPLACEMENT (25/35 SERIES)

Removal Procedure

1. Remove the tow hook bolts from the frame rail.
2. Remove the tow hook from the vehicle.

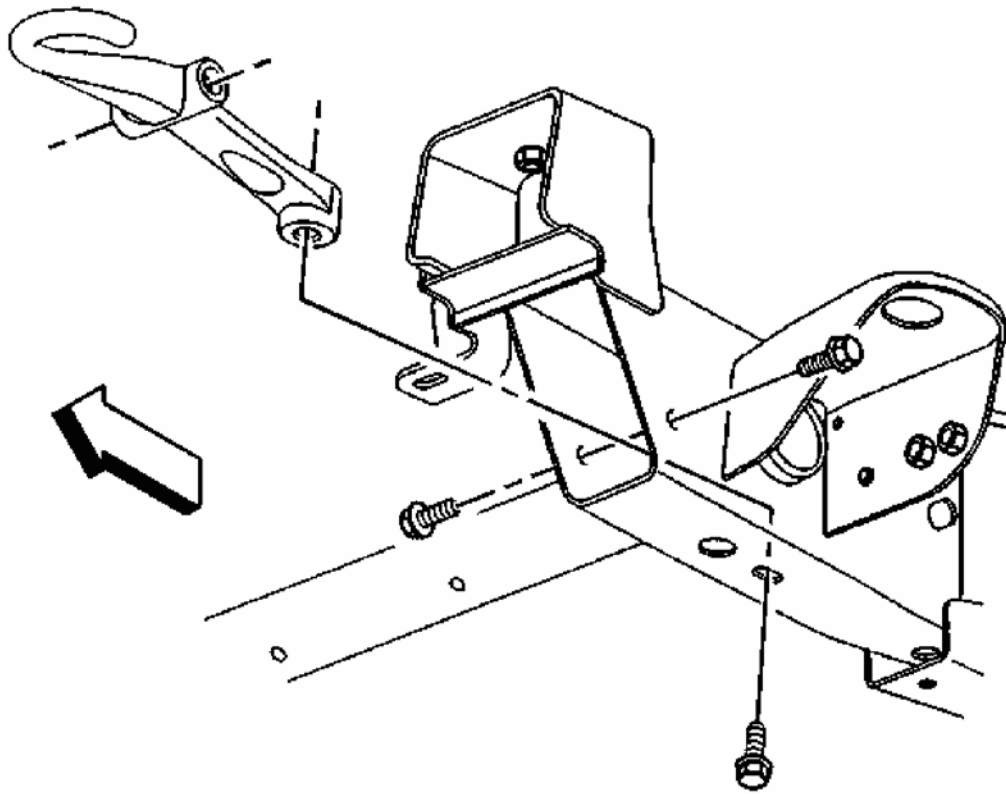


Fig. 31: Removing Tow Hook (25/35 Series)
Courtesy of GENERAL MOTORS CORP.

Installation Procedure

1. Install the tow hook to the frame rail.

NOTE: Refer to Fastener Notice in Cautions and Notices.

2. Install the bolts to the tow hook through the frame rail.

Tighten: Tighten the bolts to 85 N.m (63 lb ft).

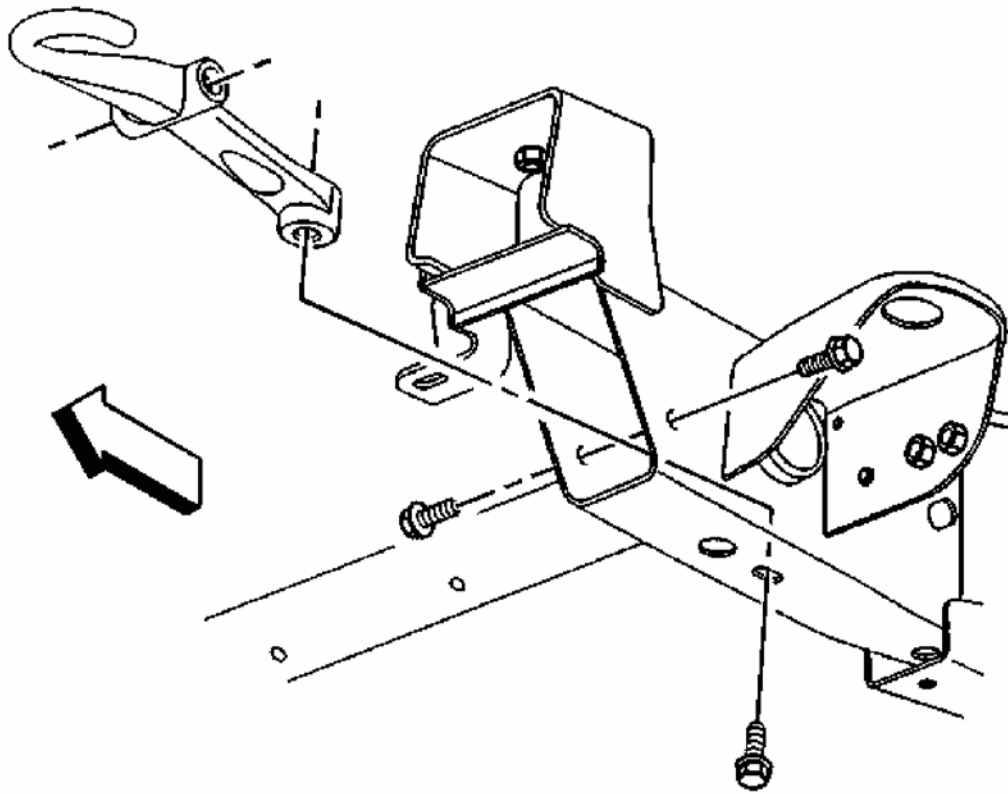


Fig. 32: Installing Tow Hook (25/35 Series)
Courtesy of GENERAL MOTORS CORP.

ASSIST STEP REPLACEMENT (DENALI/ESCALADE)

Removal Procedure

1. Remove the push-in retainer from the assist step front cover.
2. Remove the cover from the vehicle.

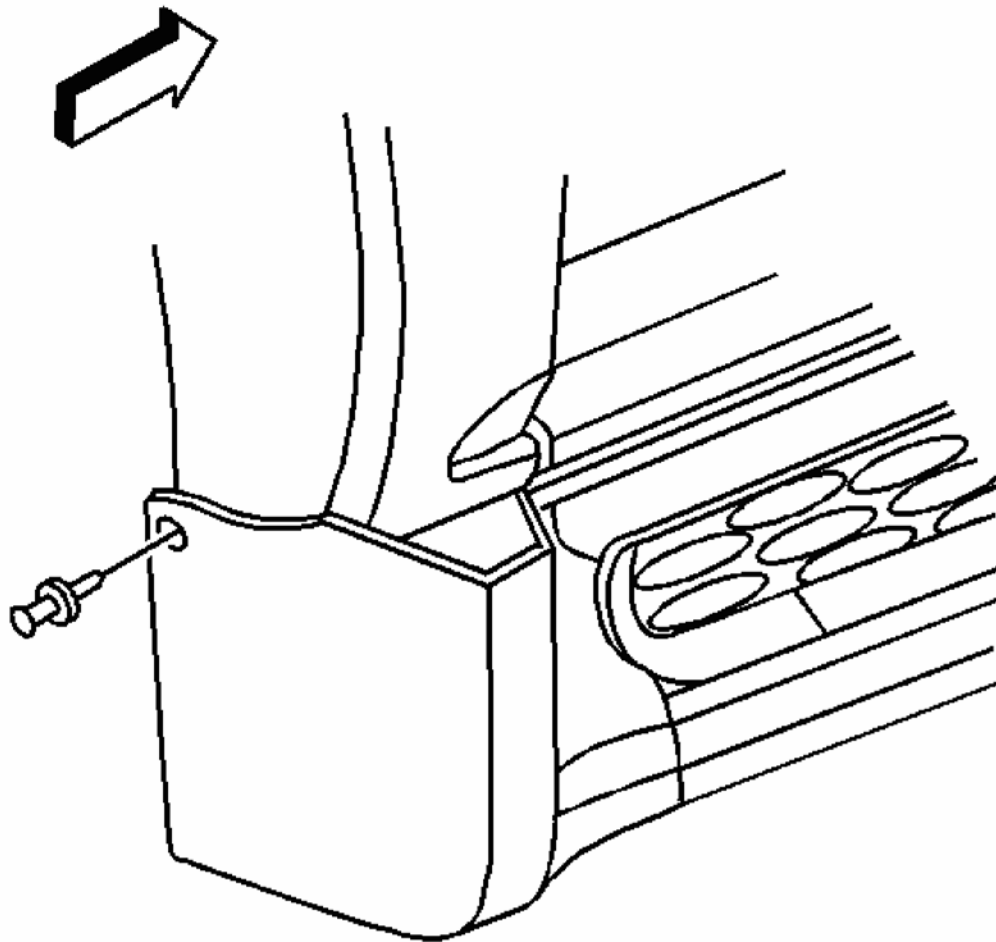


Fig. 33: Removing Push-In Retainer From Assist Step Front Cover (Denali/Escalade)

Courtesy of GENERAL MOTORS CORP.

3. Remove the retainer clip from the assist step rear cover.
4. Remove the cover from the vehicle.

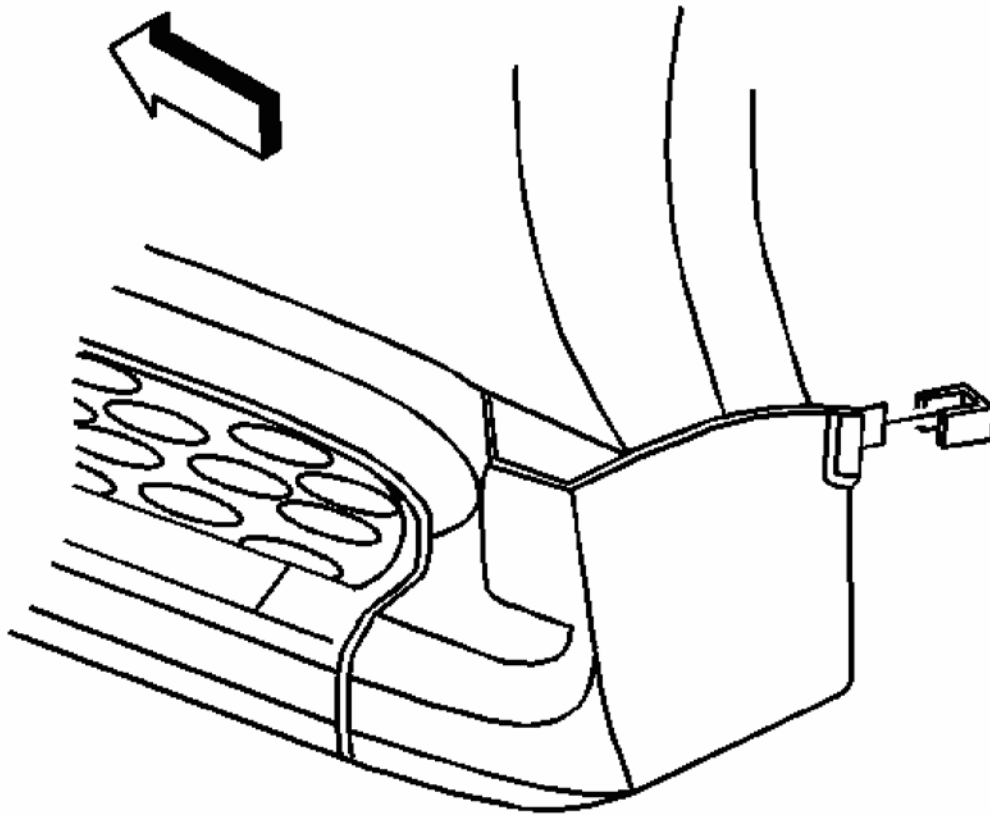


Fig. 34: Removing Retainer Clip From Assist Step Rear Cover (Denali/Escalade)
Courtesy of GENERAL MOTORS CORP.

5. Remove the bottom fender bolt (2) and the washer (1) from the vehicle.

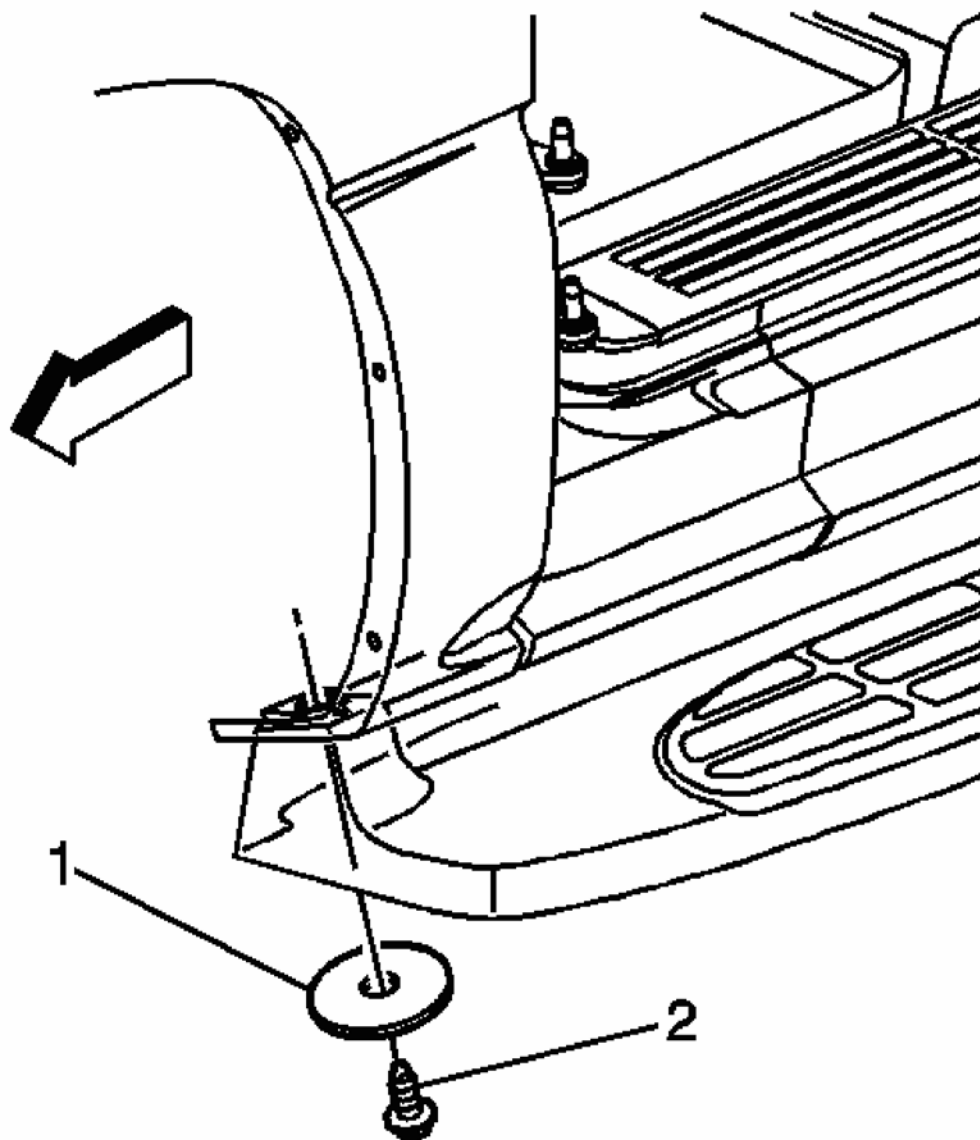


Fig. 35: Removing Bottom Fender Bolt & Washer (Denali/Escalade)
Courtesy of GENERAL MOTORS CORP.

6. With the aid of an assistant, remove the bolts (1, 5) and the nuts (2, 3) from the assist step brackets.
7. Remove the assist step from the vehicle.
8. Remove the heater and A/C tubes retaining nuts from the studs, if equipped. Refer to **Heater Pipe Replacement - Auxiliary** in Heating, Ventilation, and Air Conditioning.

9. Remove the assist step bolts (6) from the brackets.
10. Remove the brackets (4) from the vehicle.

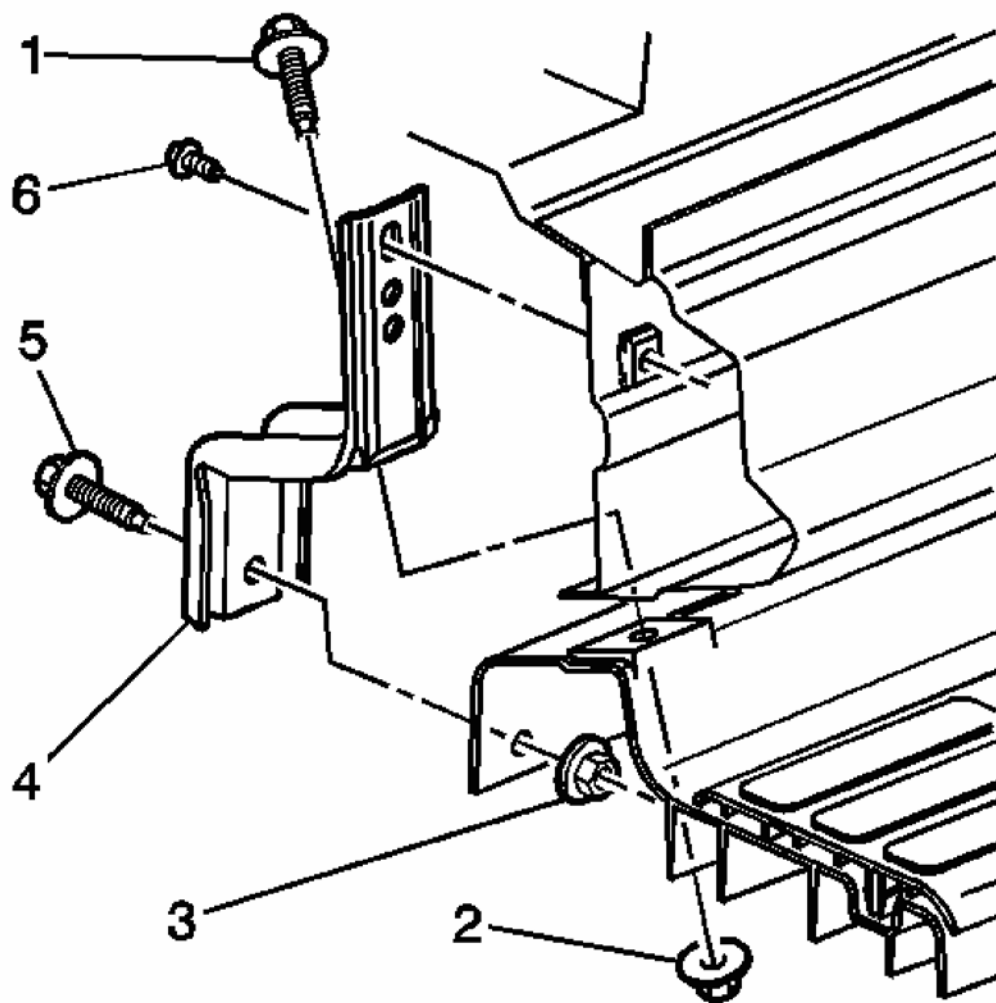


Fig. 36: Removing Assist Step Brackets (Denali/Escalade)
Courtesy of GENERAL MOTORS CORP.

Installation Procedure

IMPORTANT: Use the Threadlocker, GM P/N 12345382 (Canadian P/N 10953489), to all bolt threads prior to assembly.

1. Install the assist step brackets to the vehicle (4).
2. Install the bolts (6) to the brackets and ensure that the brackets are seated securely to the

inner rocker panel.

3. Install the heater and A/C tubes retaining nuts to the studs, if equipped. Refer to **Heater Pipe Replacement - Auxiliary** in Heating, Ventilation, and Air Conditioning.
4. With the aid of an assistant, install the assist step to the vehicle.
5. Install the bolts (1, 5) and the nuts (2, 3) to the assist step bracket, and leave the nuts loose.

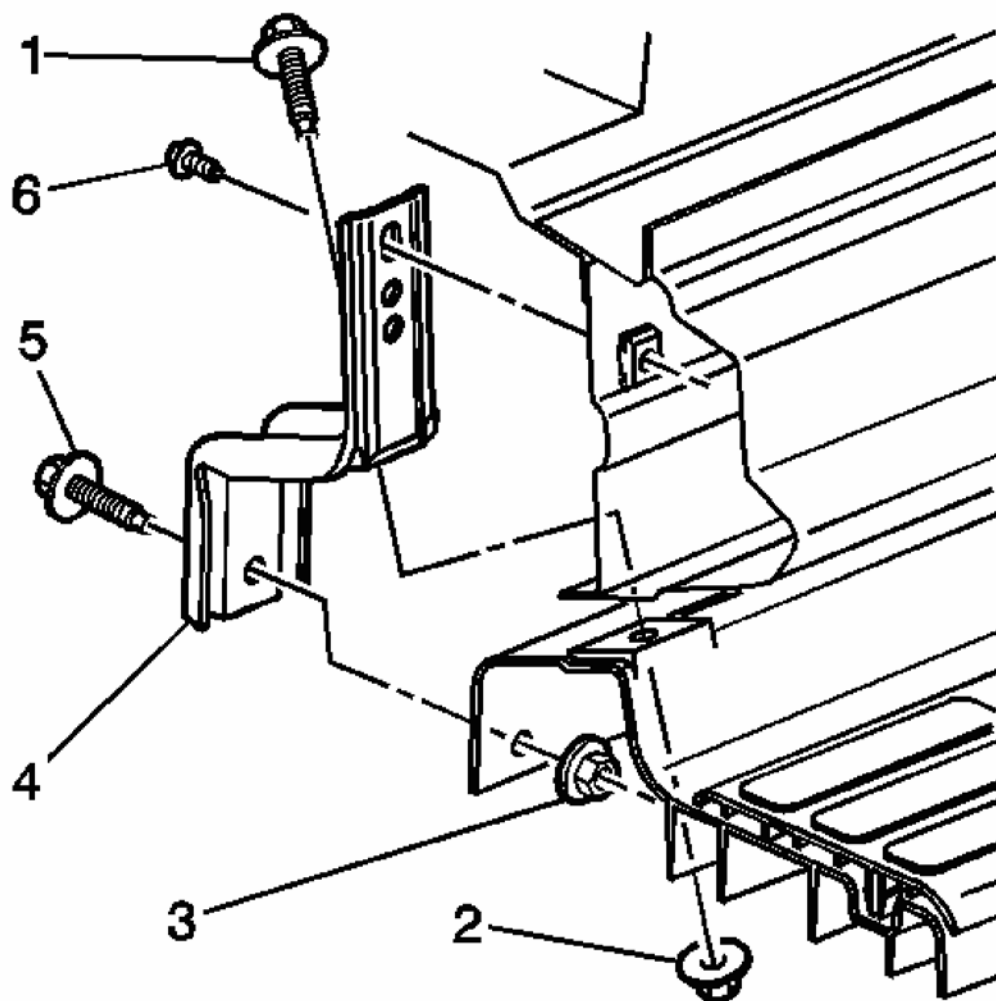


Fig. 37: Installing Assist Step Brackets (Denali/Escalade)
Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to Fastener Notice in Cautions and Notices.

6. Install the bottom fender bolt (2) and the washer (1) to the vehicle.

Tighten: Tighten the bottom fender bolt (2) to 25 N.m (18 lb ft).

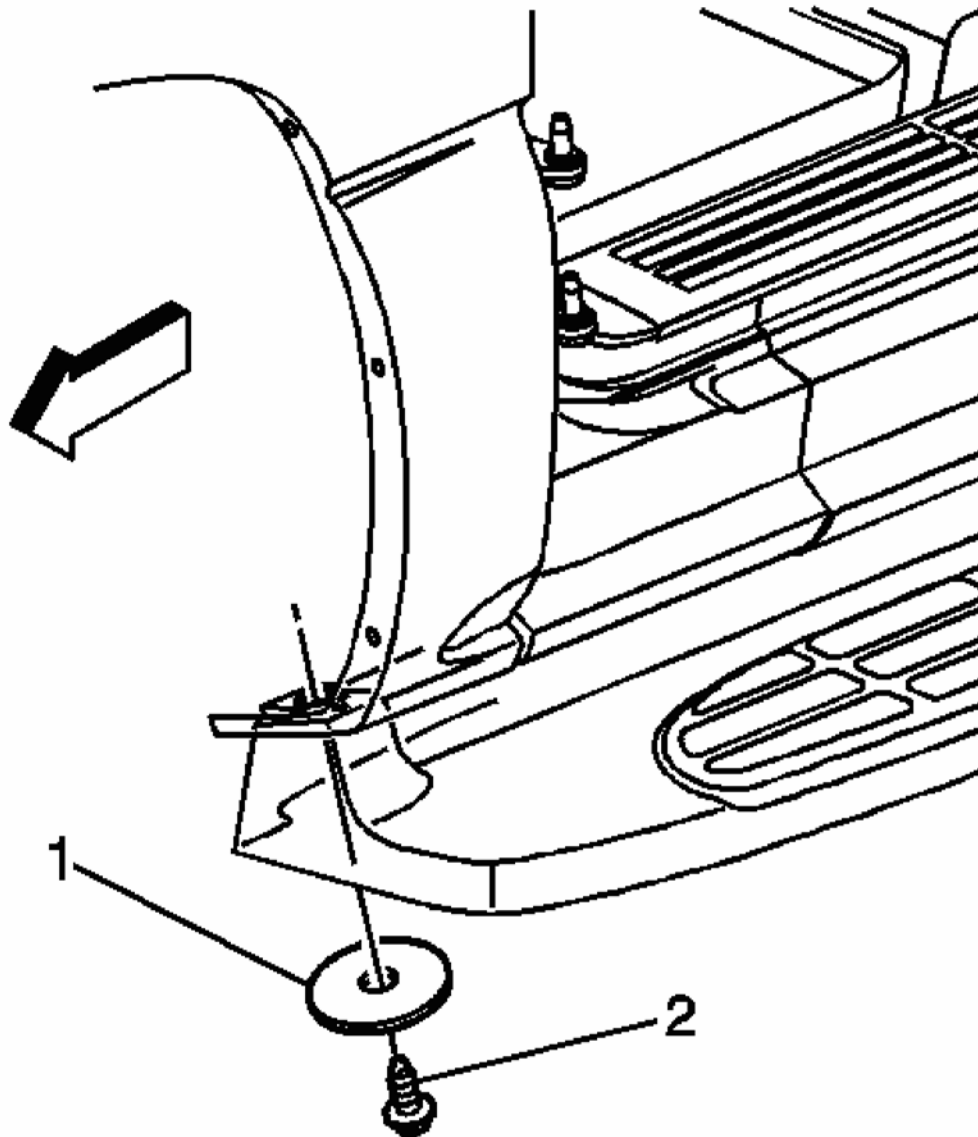


Fig. 38: Installing Bottom Fender Bolt & Washer (Denali/Escalade)
Courtesy of GENERAL MOTORS CORP.

7. Tighten the assist step fasteners in the following sequence:

Tighten:

1. Tighten the bracket bolt (6) to 25 N.m (18 lb ft).
2. Tighten the assist step bracket nut (2) to 9 N.m (80 lb in).
3. Tighten the assist step to the bracket nut (3) to 9 N.m (80 lb in).

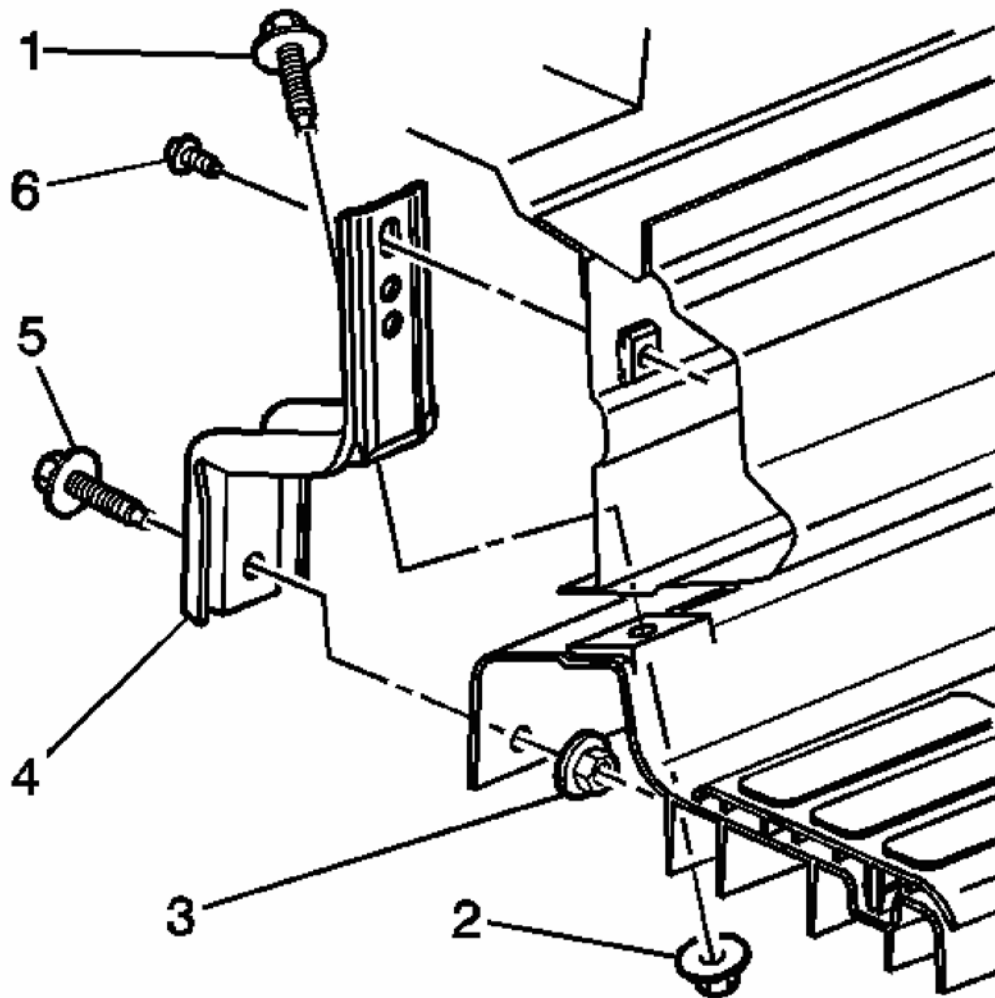


Fig. 39: Tightening Assist Step Fasteners (Denali/Escalade)
Courtesy of GENERAL MOTORS CORP.

8. Install the assist step rear cover to the vehicle.
9. Install the clip retainer.

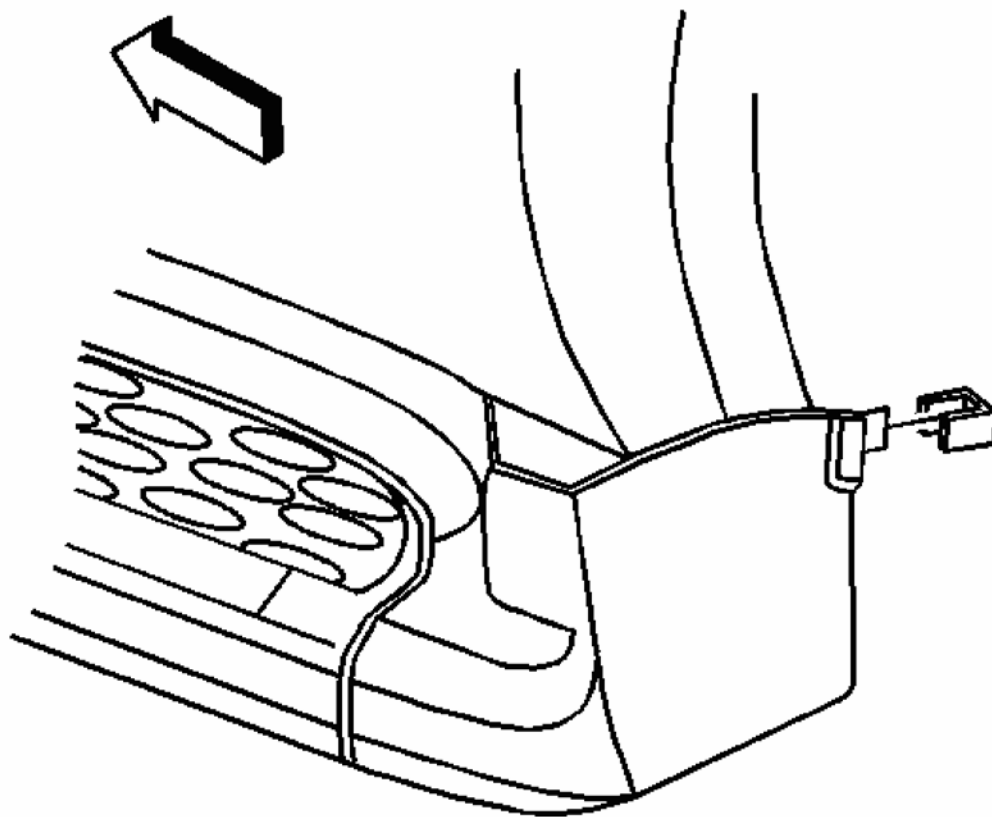


Fig. 40: Installing Assist Step Rear Cover Clip Retainer (Denali/Escalade)
Courtesy of GENERAL MOTORS CORP.

10. Install the assist step front cover to the vehicle.
11. Install the push-in retainer.

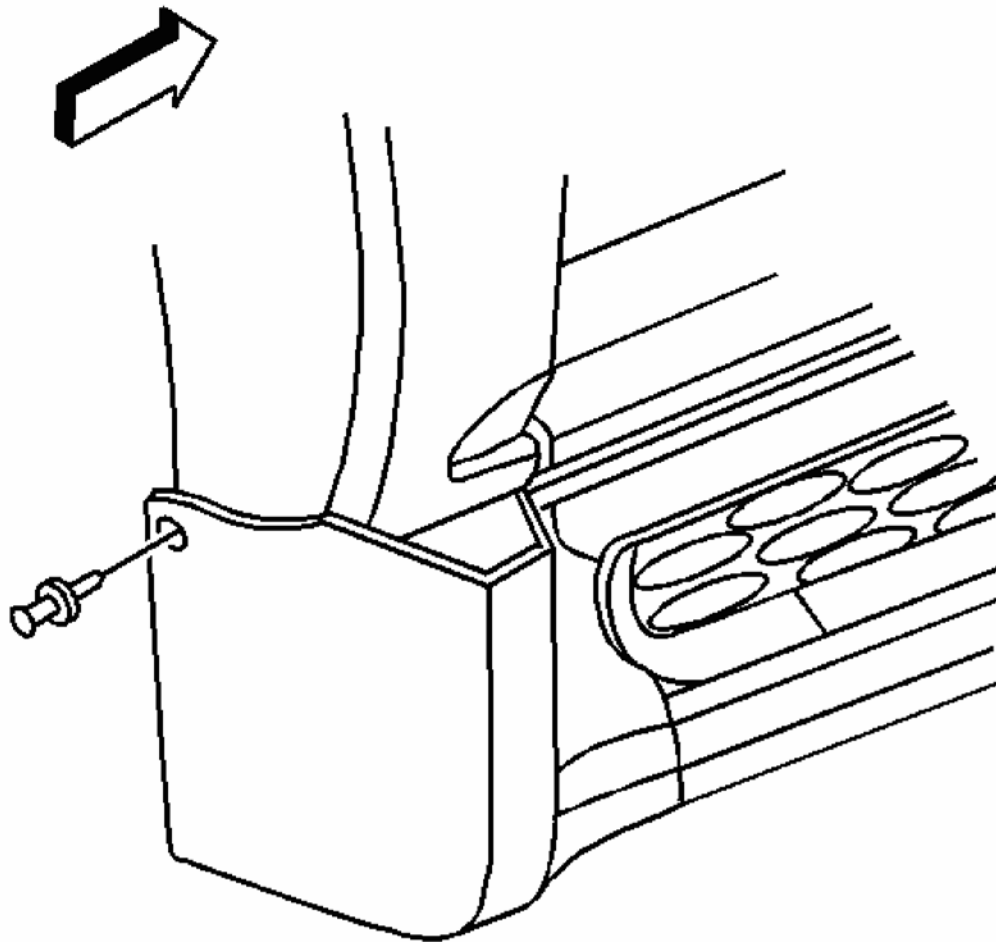


Fig. 41: Installing Assist Step Front Cover Push-In Retainer (Denali/Escalade)
Courtesy of GENERAL MOTORS CORP.

ASSIST STEP REPLACEMENT (ESCALADE)

Removal Procedure

1. Remove the push-in retainer from the assist step front cover.
2. Remove the cover from the vehicle.

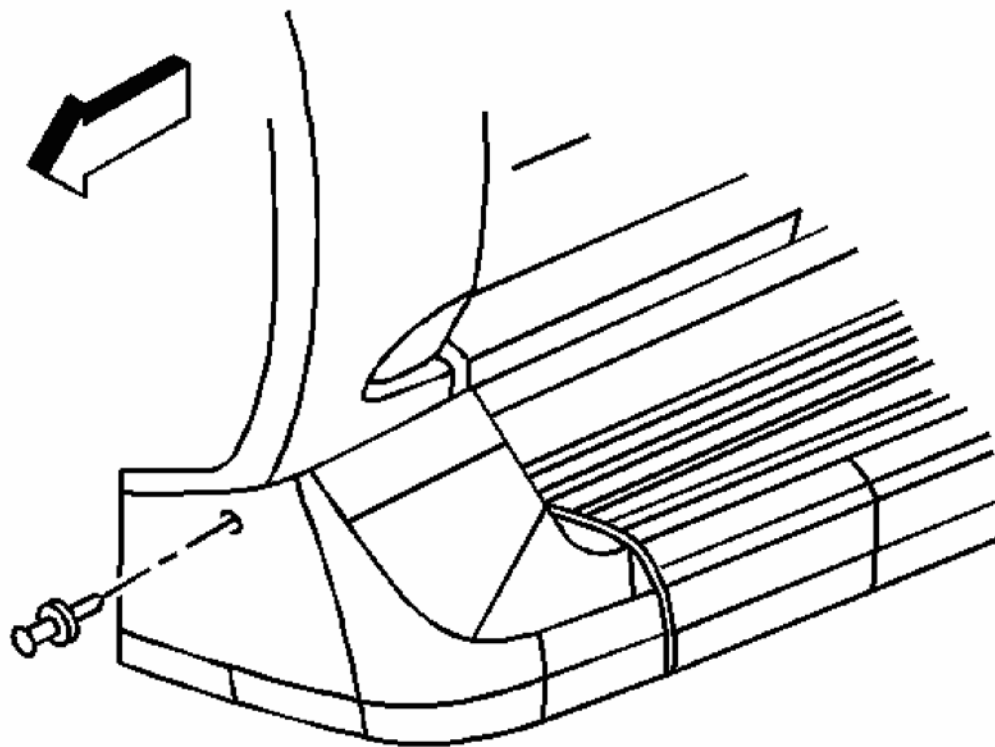


Fig. 42: Removing Push-In Retainer From Assist Step Front Cover (Escalade)
Courtesy of GENERAL MOTORS CORP.

3. Remove the push-in retainer from the assist step rear cover.
4. Remove the cover from the vehicle.

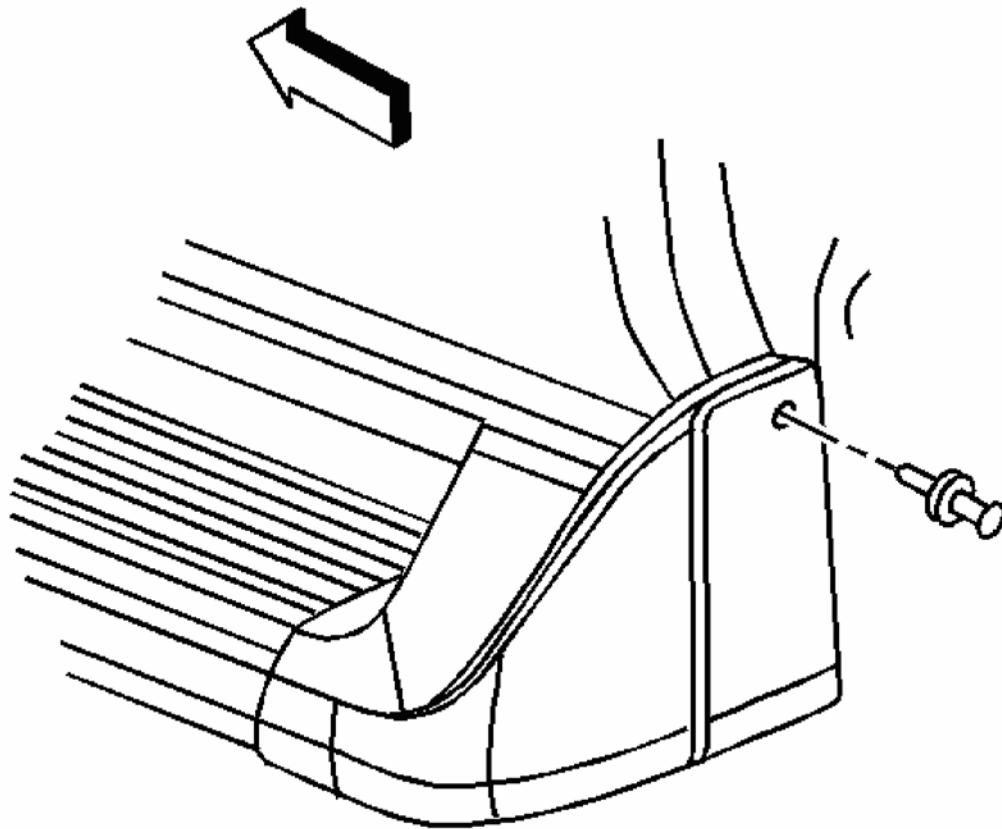


Fig. 43: Removing Push-In Retainer From Assist Step Rear Cover (Escalade)
Courtesy of GENERAL MOTORS CORP.

5. Remove the bottom fender bolt (2) from the vehicle.

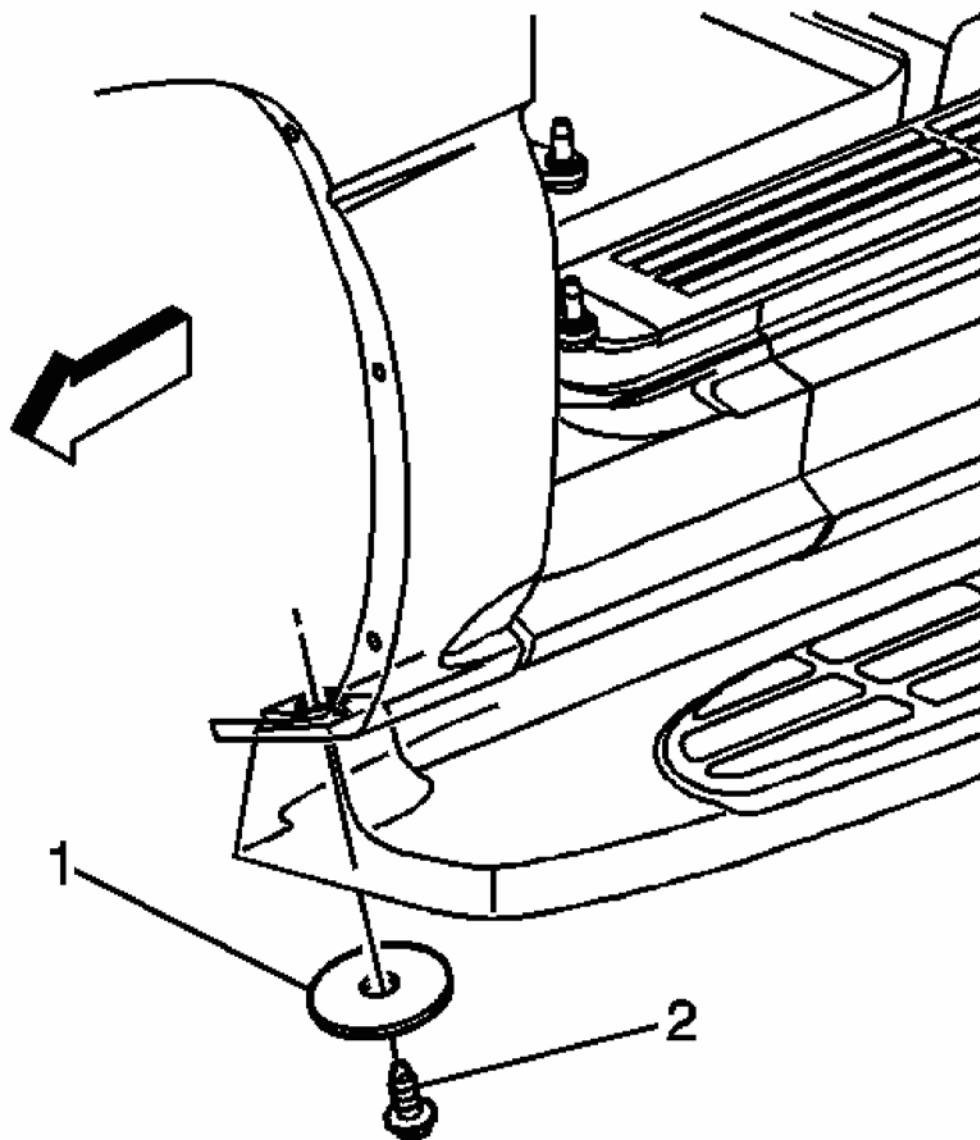


Fig. 44: Removing Bottom Fender Bolt (Escalade)
Courtesy of GENERAL MOTORS CORP.

6. With an assistant, remove the bolts (3,1) from the assist step brackets.
7. Remove the assist step from the vehicle.
8. Remove the heater and A/C tubes retaining nuts from the studs, if equipped. Refer to **Heater Pipe Replacement - Auxiliary** in Heating, Ventilation, and Air Conditioning.
9. Remove the assist step bolts (6) from the brackets.

10. Remove the brackets from the vehicle.

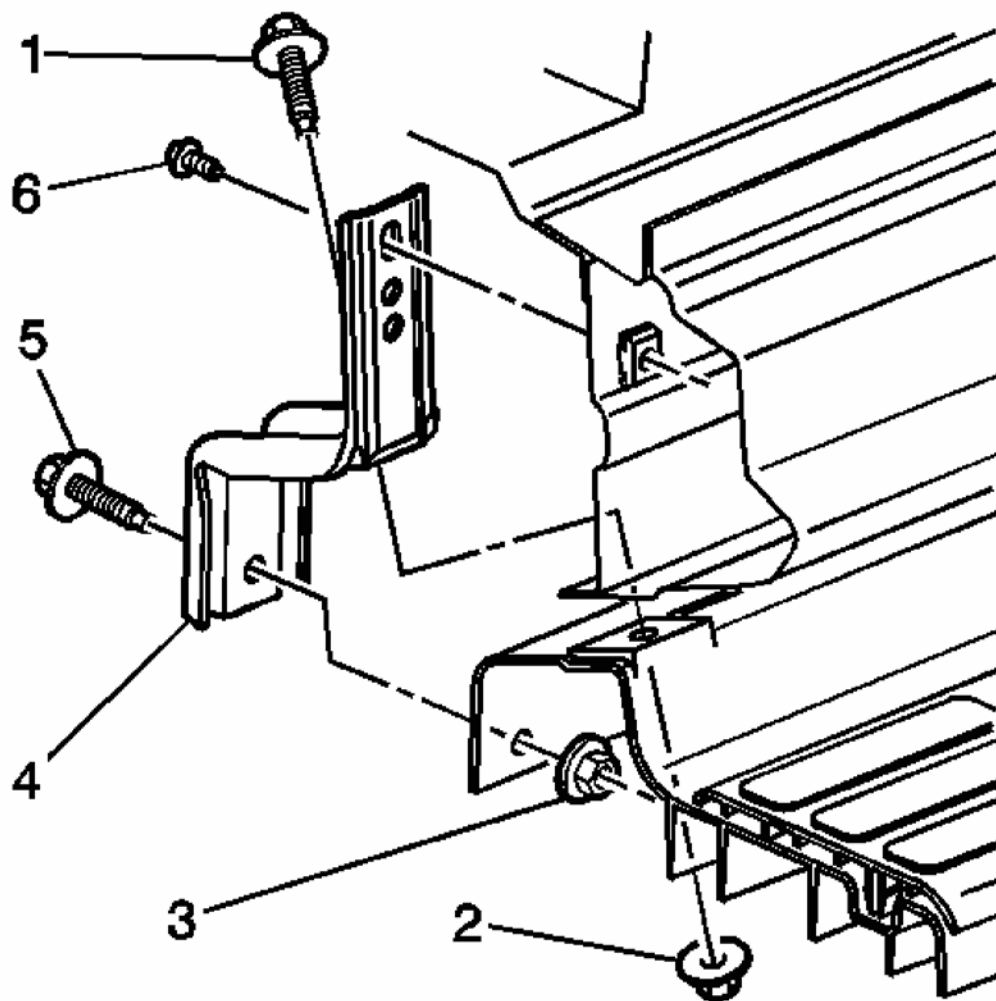


Fig. 45: Removing Assist Step Brackets (Escalade)
Courtesy of GENERAL MOTORS CORP.

Installation Procedure

IMPORTANT: Use the thread locker GM P/N 12345382 to all bolt threads prior to assembly.

1. Install the assist step brackets to the vehicle.
2. Install the bolts (6) to the brackets and ensure that the brackets are seated securely to the inner rocker panel.

3. Install the heater and A/C tubes retaining nuts to the studs, if equipped. Refer to **Heater Pipe Replacement - Auxiliary** in Heating, Ventilation, and Air Conditioning.
4. With an assistant, install the assist step to the vehicle.
5. Install the bolts (3,1) to the assist step bracket, and leave the bolts loose.

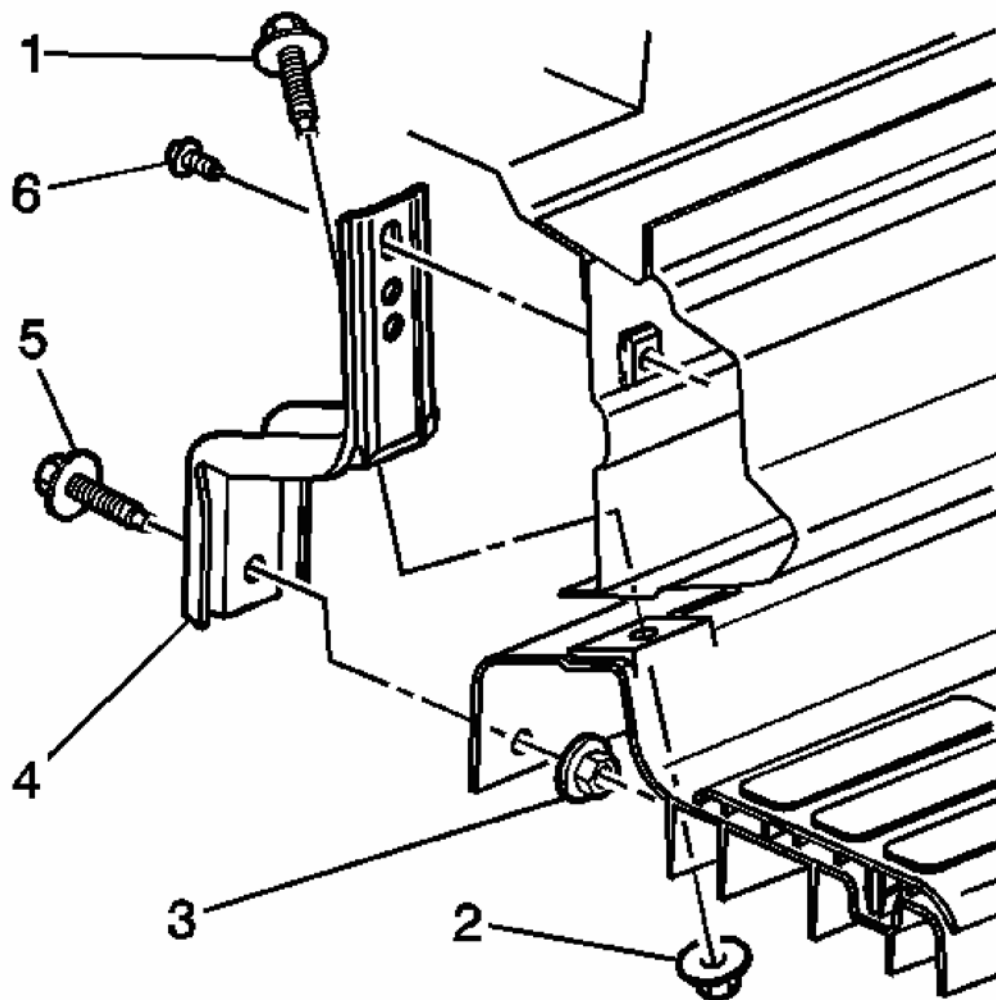


Fig. 46: Installing Assist Step Brackets (Escalade)
Courtesy of GENERAL MOTORS CORP.

6. Install the bottom fender bolt (2) and the washer to the vehicle.

NOTE: Refer to **Fastener Notice** in Cautions and Notices.

7. Tighten the assist step fasteners in the following sequence:

Tighten:

1. Tighten the front fender bolt to 25 N.m (18 lb ft).
2. Tighten the bracket bolt to 25 N.m (18 lb ft).
3. Tighten the assist step bracket bolt (2) to 9 N.m (80 lb in).
4. Tighten the assist step to the bracket bolt to 9 N.m (80 lb in).

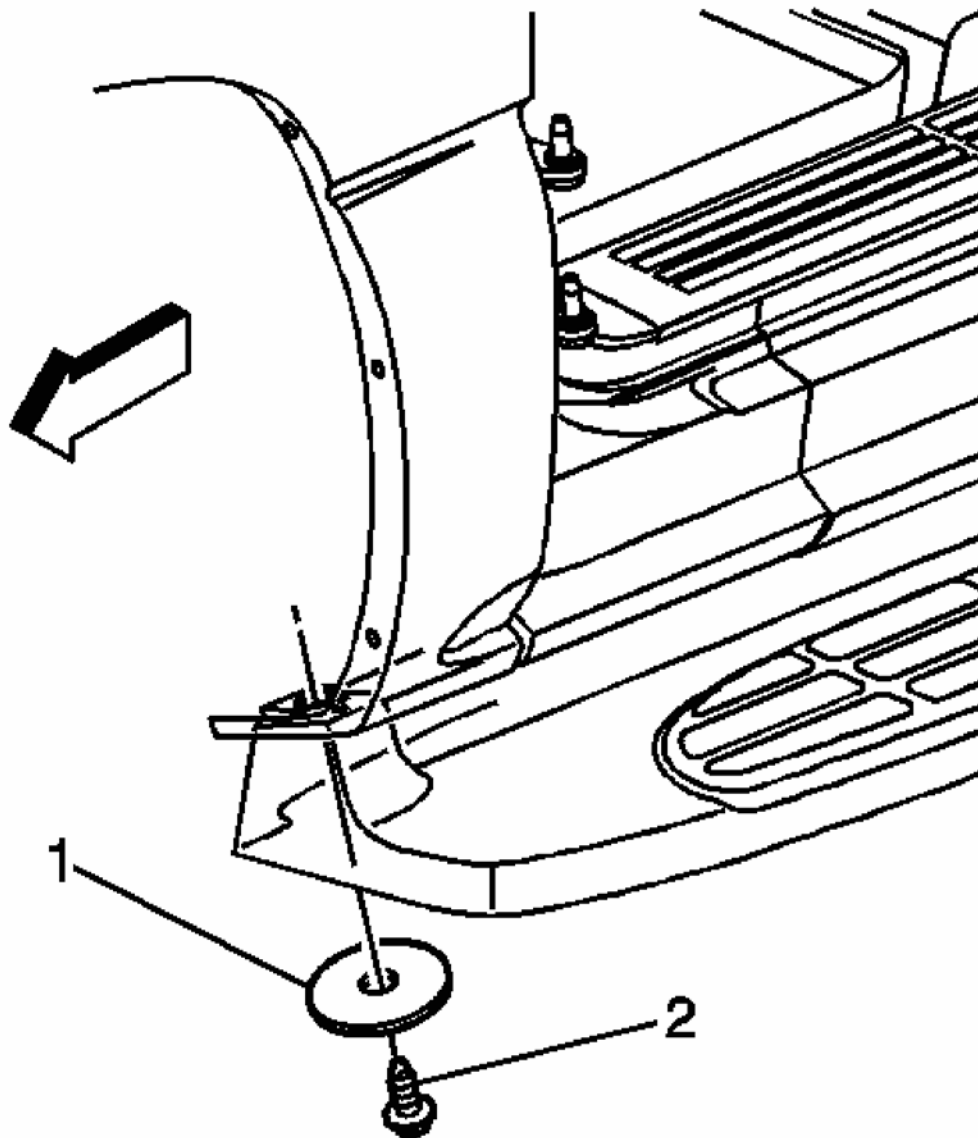


Fig. 47: Installing Bottom Fender Bolt (Escalade)
Courtesy of GENERAL MOTORS CORP.

8. Install the assist step rear cover to the vehicle.
9. Install the push-in retainer.

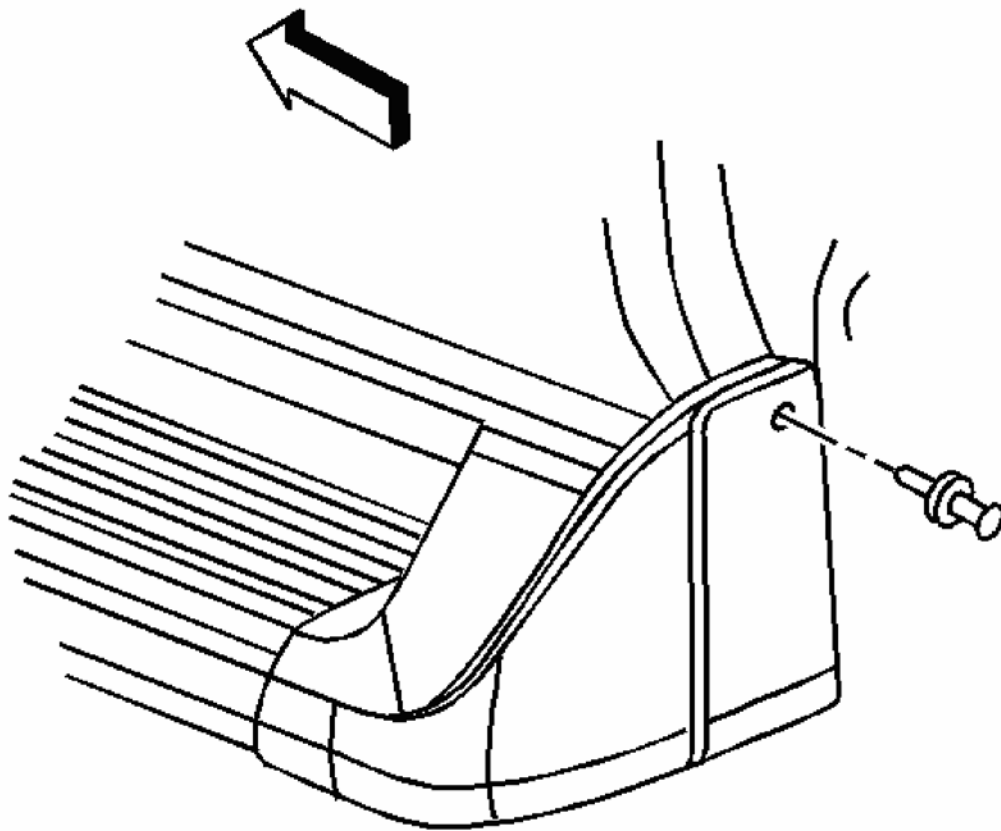


Fig. 48: Installing Assist Step Rear Cover Push-In Retainer (Escalade)
Courtesy of GENERAL MOTORS CORP.

10. Install the assist step front cover to the vehicle.
11. Install the push-in retainer.

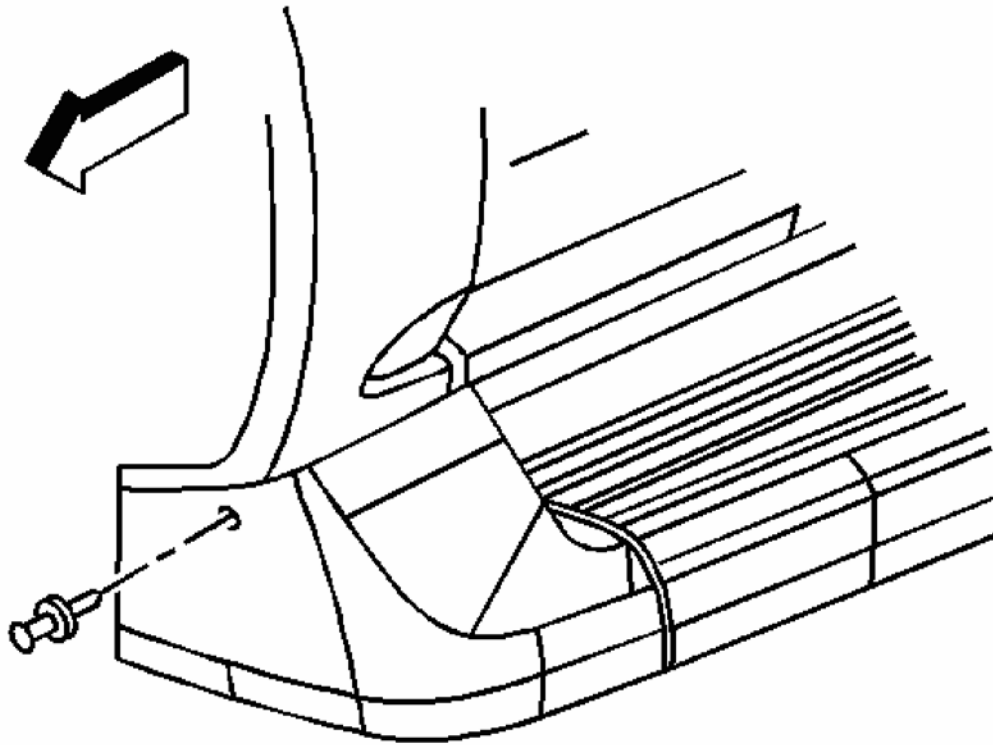


Fig. 49: Installing Assist Step Front Cover Push-In Retainer (Escalade)
Courtesy of GENERAL MOTORS CORP.

ASSIST STEP REPLACEMENT (Z-71)

Removal Procedure

1. With the aid of a helper, remove the retaining nuts and the spacers (1) from the bottom side of the assist step, and remove the assist step from the vehicle.

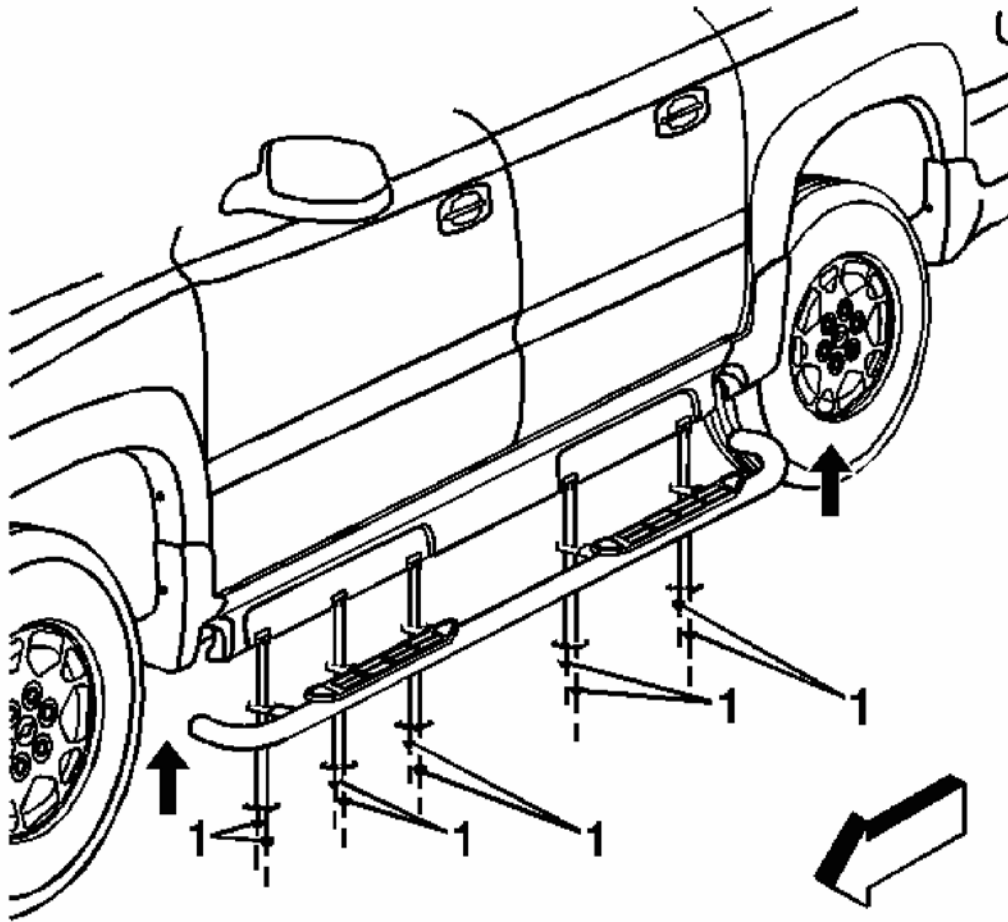


Fig. 50: Removing Retaining Nuts & Spacers From Assist Step (Z-71)
Courtesy of GENERAL MOTORS CORP.

2. Remove the rocker panel molding. Refer to **Molding Replacement - Rocker Panel (Z-71)** or **Molding Replacement - Rocker Panel (Utility)** in Exterior Trim.
3. Drill out the rivets (1) from the assist step brackets.

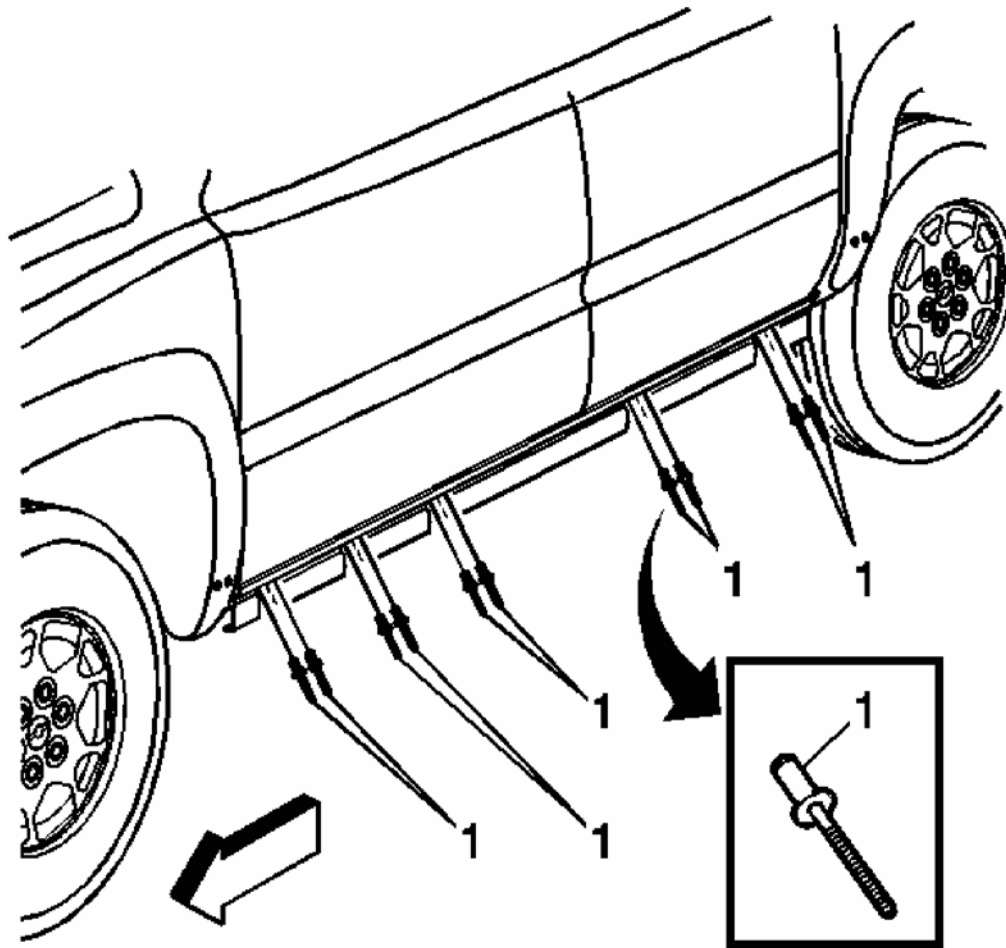


Fig. 51: Drilling Out Rivets From Assist Step Brackets (Z-71)
Courtesy of GENERAL MOTORS CORP.

4. Remove the 5 stud plates (1) from the 5 assist step brackets (2).

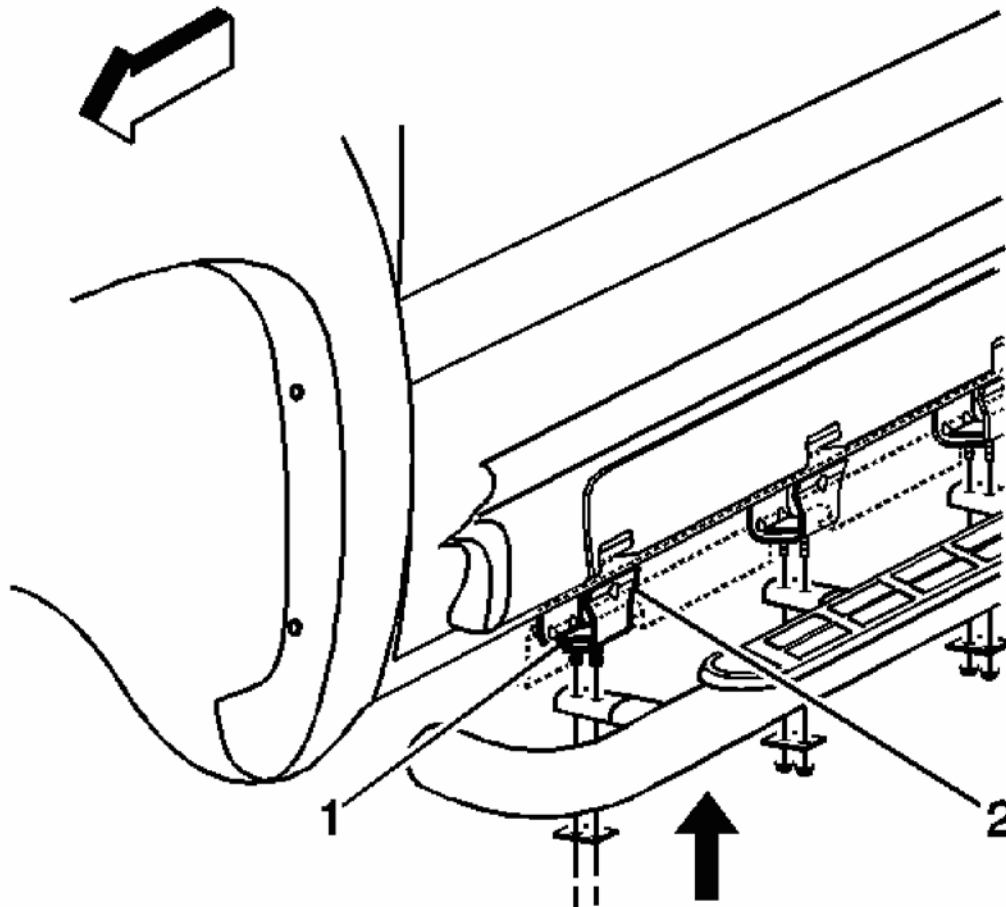


Fig. 52: Removing Stud Plates From Assist Step Brackets (Z-71)
Courtesy of GENERAL MOTORS CORP.

5. Remove the 5 retaining bolts (1) from the inner side of the rocker panel.
6. Remove the 5 retaining bolts (2) from the inner side of the rocker panel.
7. Remove the assist step brackets (5) from the vehicle.
8. Drill out the rivets (3) for the rocker panel molding bracket (4).
9. Remove the bracket (4) from the vehicle.

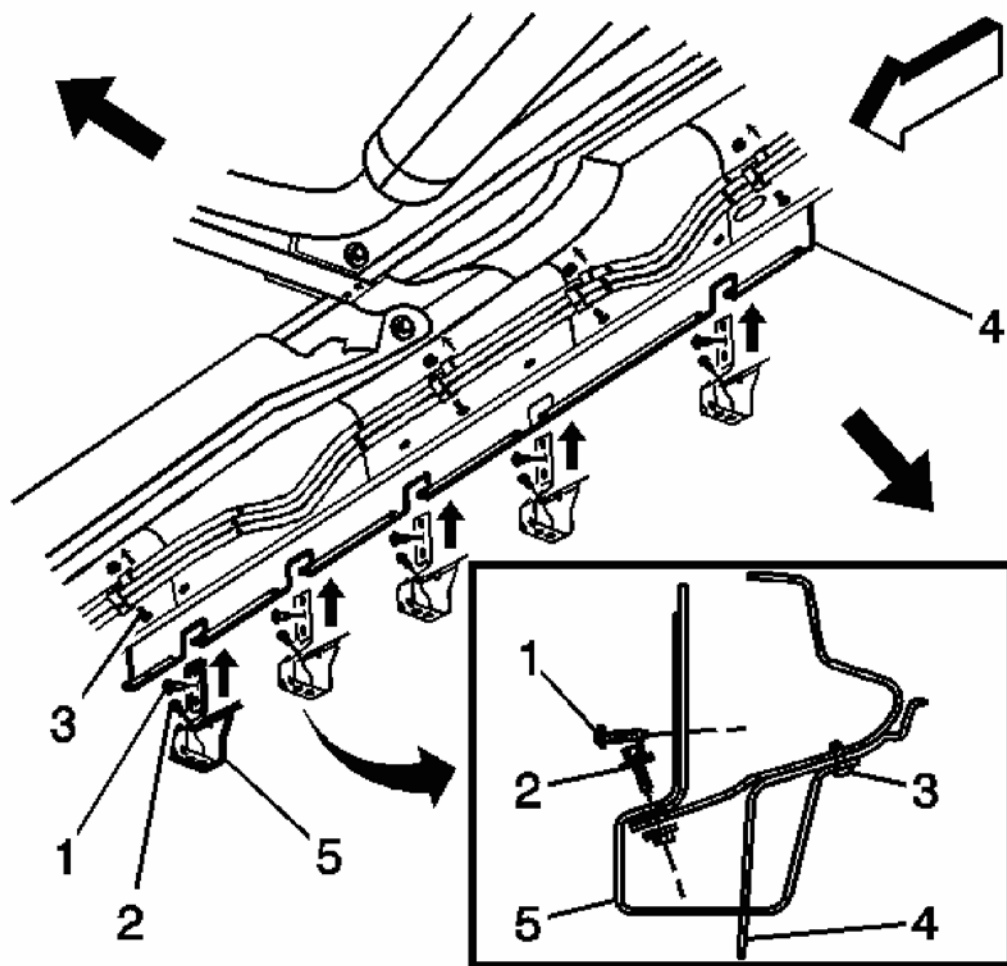


Fig. 53: Removing Assist Step Brackets & Rocker Panel Molding Bracket (Z-71)
Courtesy of GENERAL MOTORS CORP.

Installation Procedure

1. Install the rocker panel molding bracket (4) to the vehicle.
2. Install the rivets (3) that secure the rocker panel molding bracket (4) to the vehicle.
3. Install the assist step brackets (5) to the vehicle.

NOTE: Refer to Fastener Notice in Cautions and Notices.

4. Install the 5 retaining bolts (1) to the inner side of the rocker panel.

Tighten: Tighten the bolts (1) to 29 N.m (21 lb ft).

5. Install the 5 retaining bolts (2) to the inner side of the rocker panel.

Tighten: Tighten the bolts (1) to 10 N.m (89 lb in).

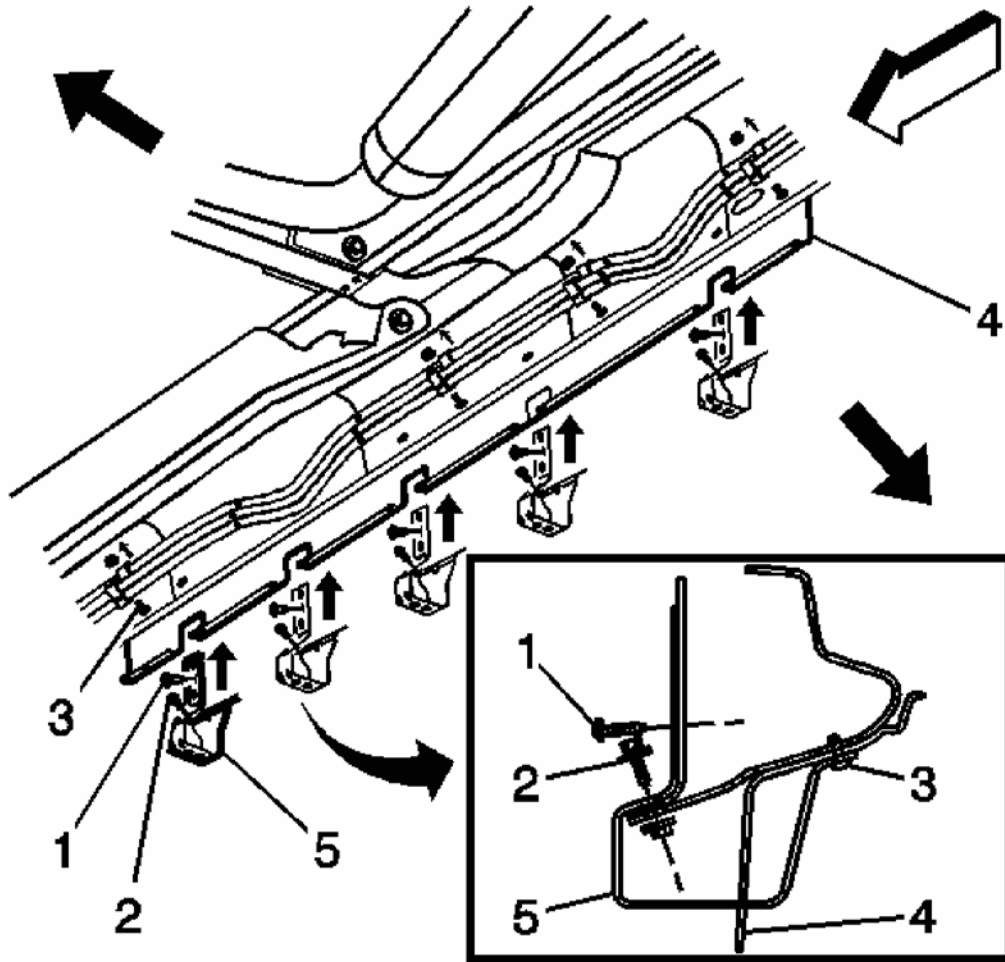


Fig. 54: Installing Rocker Panel Molding Bracket & Assist Step Brackets (Z-71)
Courtesy of GENERAL MOTORS CORP.

6. Install the 5 stud plates (1) to the 5 assist step brackets (2).

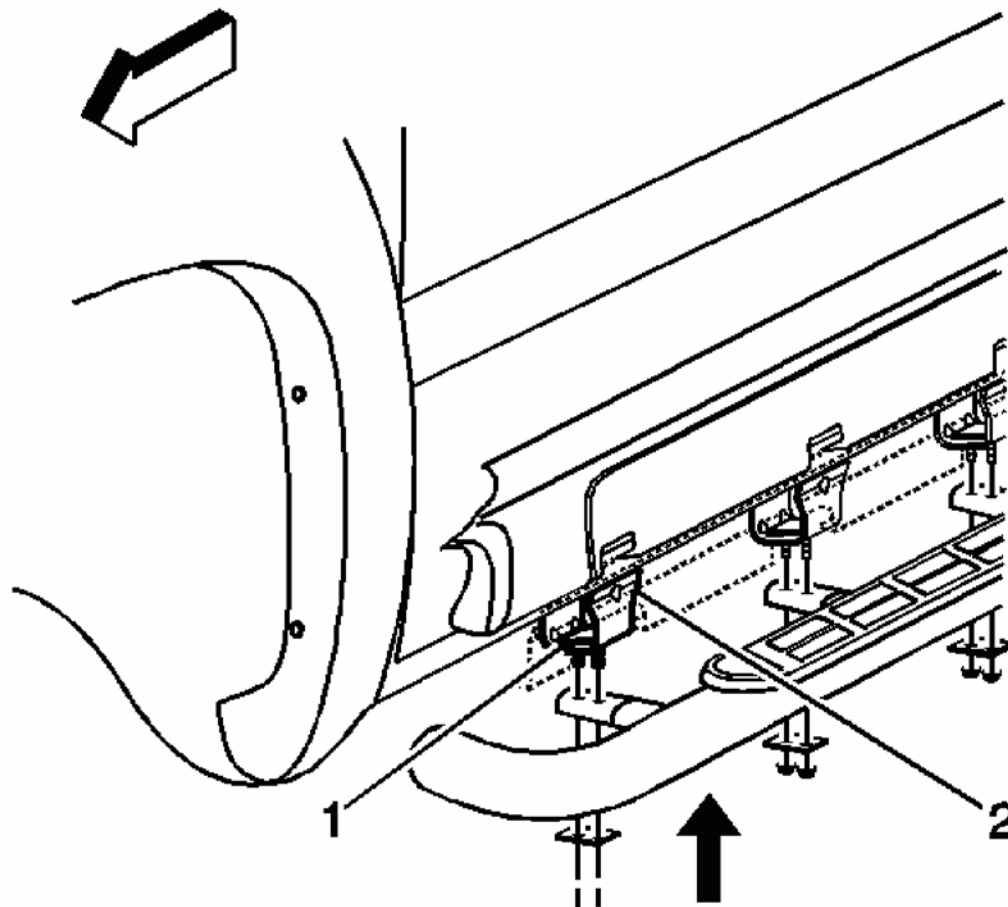


Fig. 55: Installing Stud Plates To Assist Step Brackets (Z-71)
Courtesy of GENERAL MOTORS CORP.

7. Install the rivets (1) that secure the assist step brackets to the rocker panel.

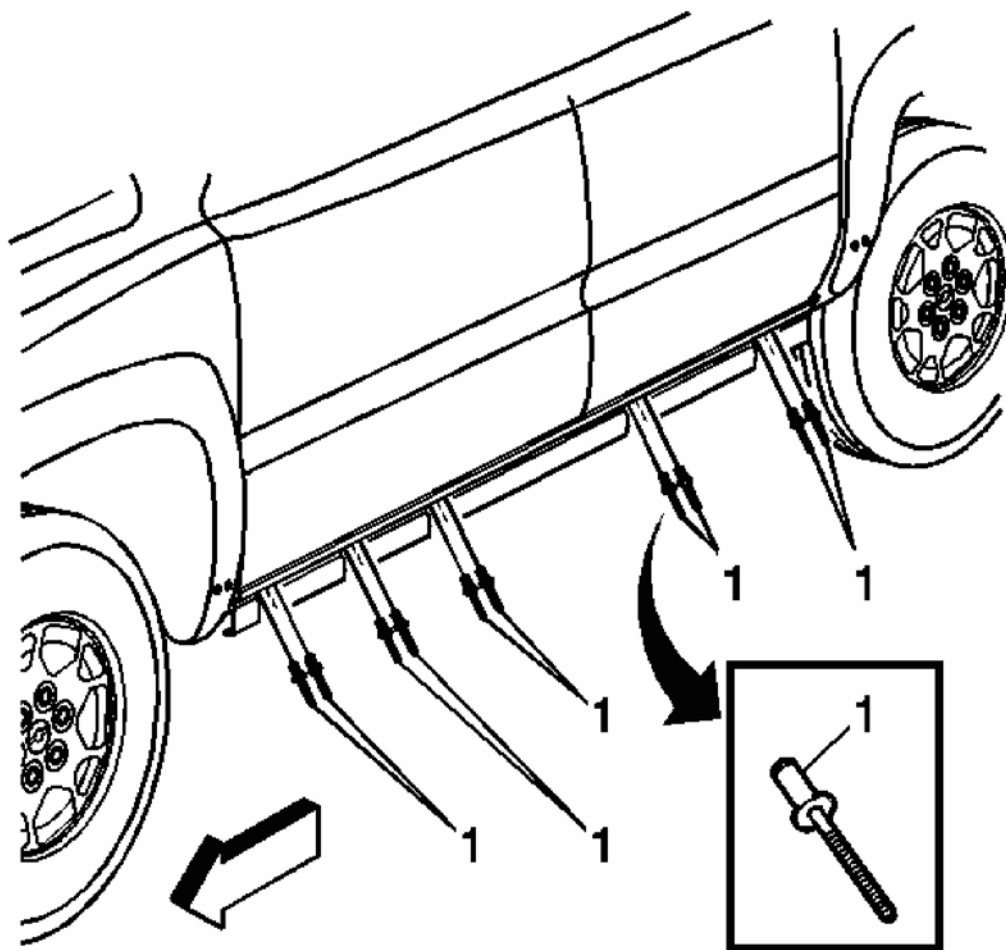


Fig. 56: Installing Rivets Securing Assist Step Brackets To Rocker Panel (Z-71)
Courtesy of GENERAL MOTORS CORP.

8. Install the rocker panel molding. Refer to **Molding Replacement - Rocker Panel (Z-71)** or **Molding Replacement - Rocker Panel (Utility)** in Exterior Trim.
9. With the aid of an assistant, install the assist step to the vehicle.
10. Install the spacers and the nuts (1).

Tighten: Tighten the bolts (1) to 29 N.m (21 lb ft).

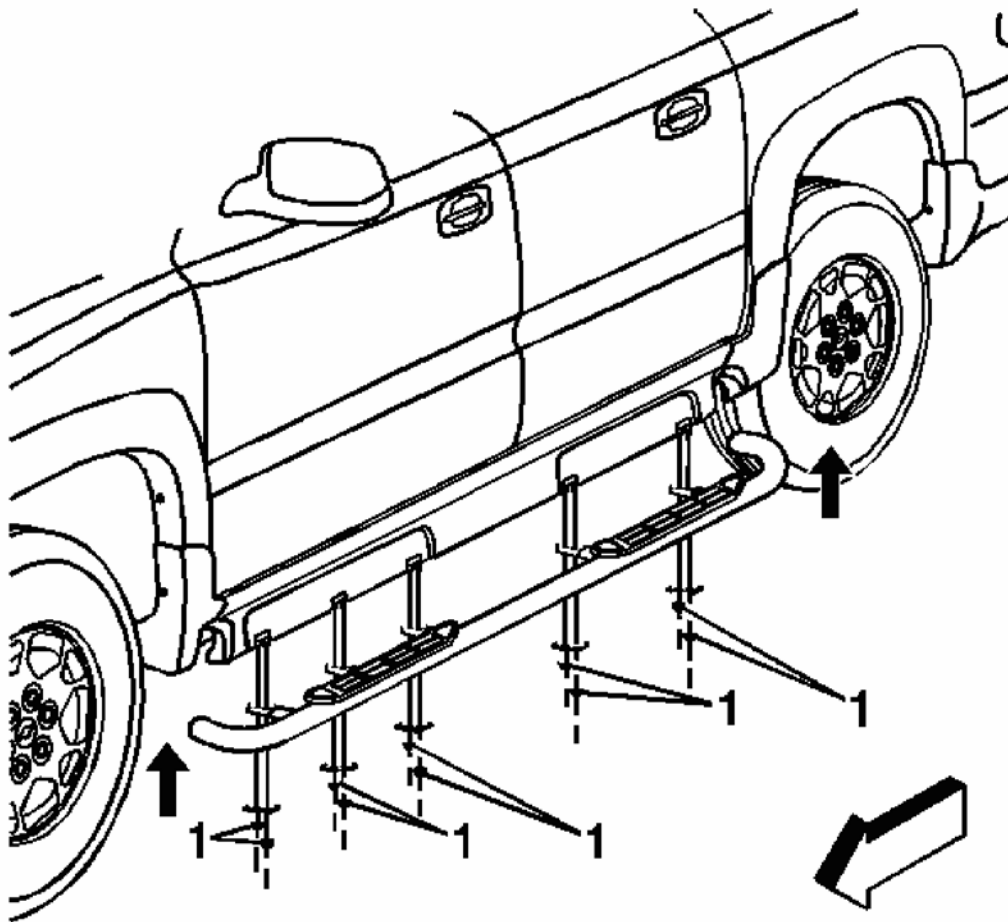


Fig. 57: Installing Assist Step Spacers & Nuts (Z-71)
Courtesy of GENERAL MOTORS CORP.

ENGINE PROTECTION SHIELD REPLACEMENT

Removal Procedure

1. Remove the frame to the shield bolts.
2. Remove the shield from the vehicle. 15 Series is shown, 25 Series is similar.

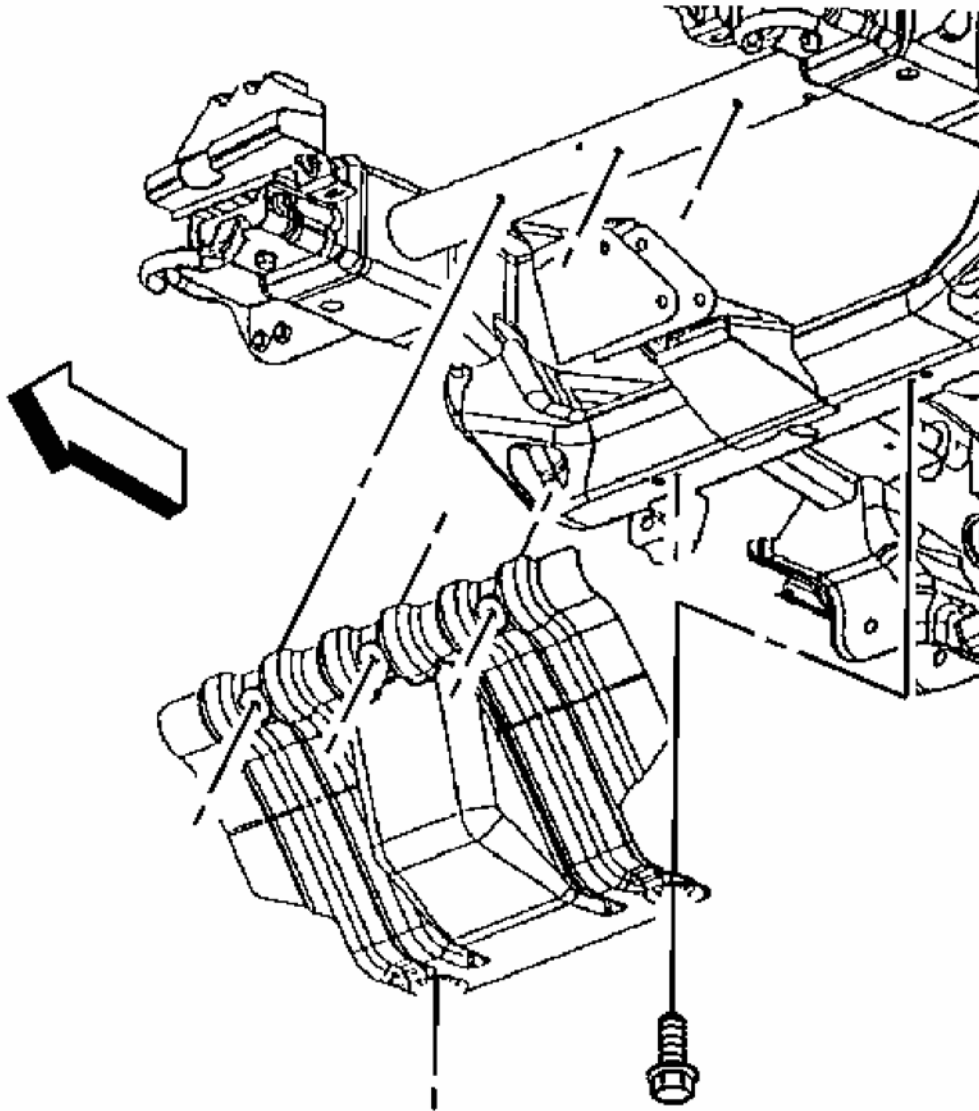


Fig. 58: View Of Engine Protection Shield
Courtesy of GENERAL MOTORS CORP.

Installation Procedure

1. Install the shield to the vehicle. 15 Series is shown, 25 Series is similar.

NOTE: Refer to Fastener Notice in Cautions and Notices.

2. Install the shield to frame bolts.

Tighten: Tighten the bolts to 20 N.m (15 lb ft).

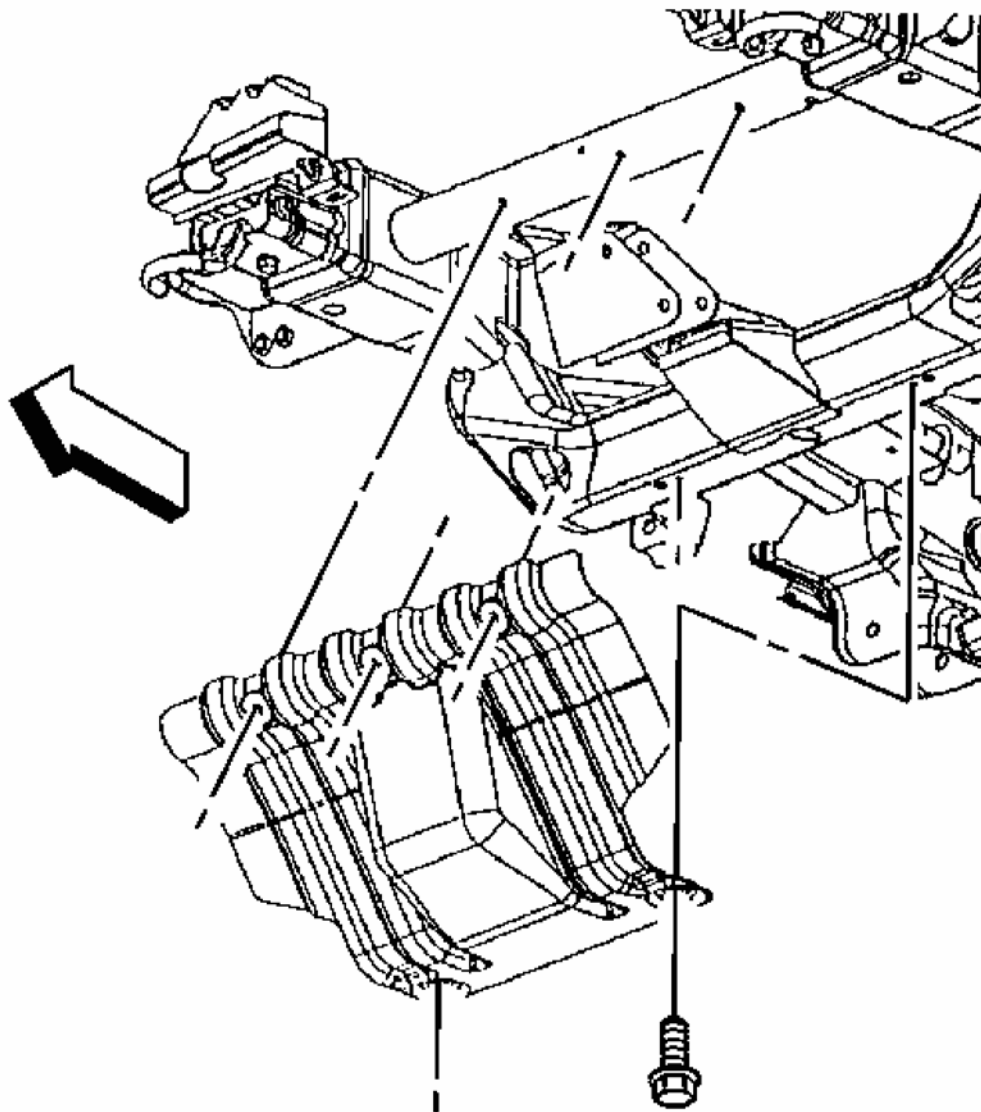


Fig. 59: View Of Engine Protection Shield
Courtesy of GENERAL MOTORS CORP.

DAMAGED CAGE NUT SERVICE

Removal Procedure

1. Remove the battery ground (negative) cable.

CAUTION: Refer to Battery Disconnect Caution in Cautions and Notices.

2. Remove the frame bolt (2) from the frame crossmember nut.

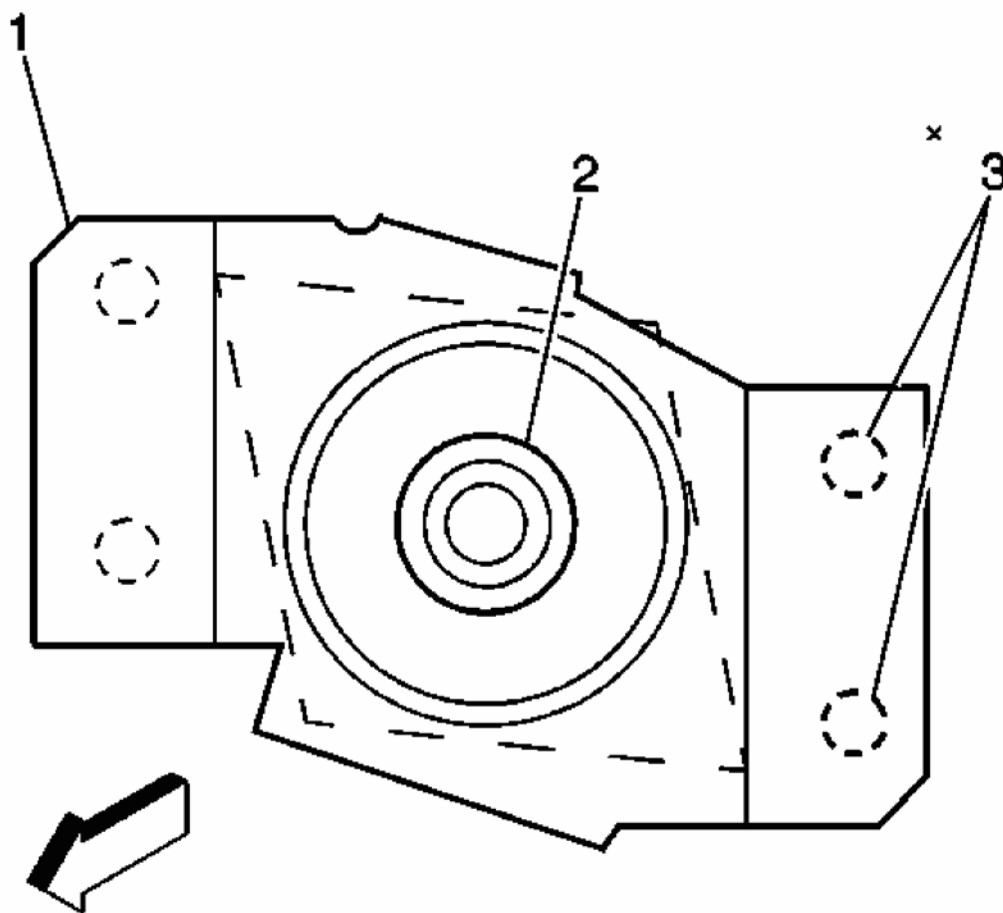


Fig. 60: Removing Frame Bolt From Frame Crossmember Nut
Courtesy of GENERAL MOTORS CORP.

IMPORTANT: The frame crossmember nut retainer will be reused if not damaged from the stripped out bolt.

3. Break away the spot welds (1) on one side of the frame crossmember nut retainer with an air chisel.
4. Lift one side of the frame crossmember nut retainer (enough to remove the frame crossmember nut).

5. Remove the frame crossmember nut.

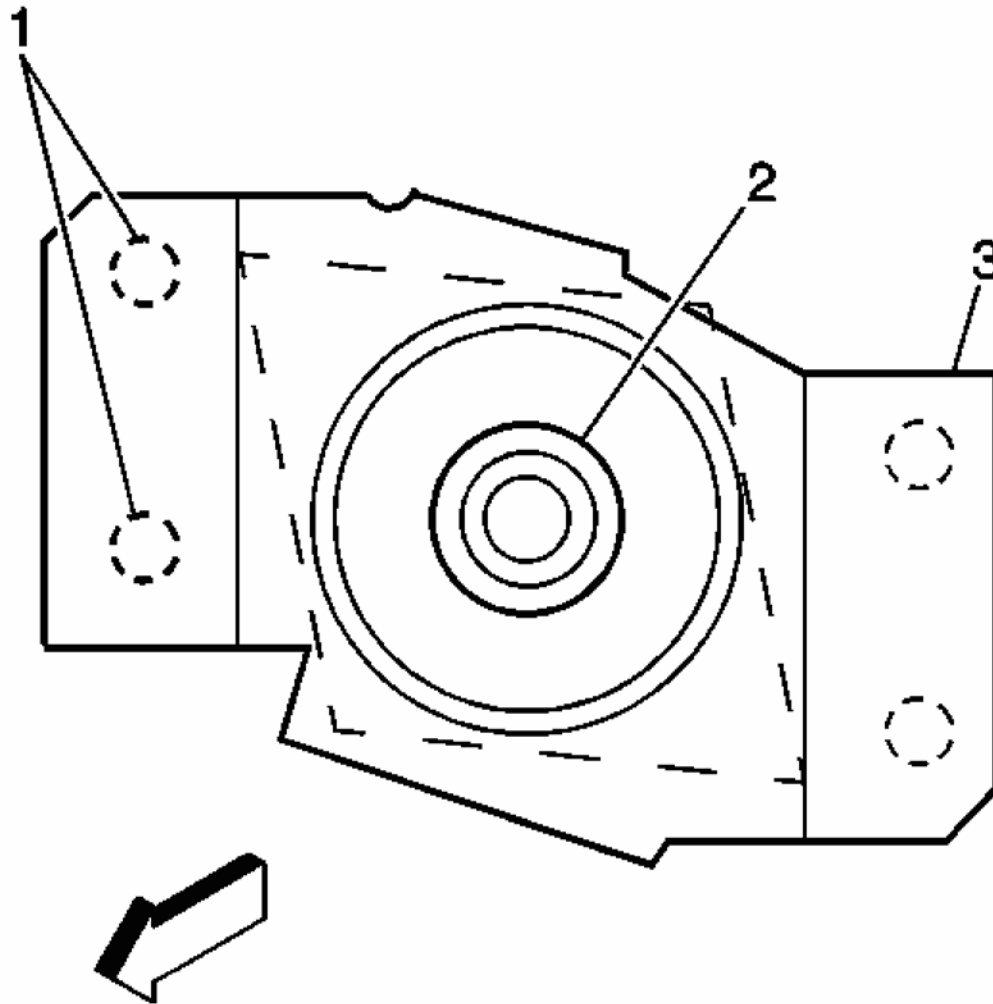


Fig. 61: Breaking Away Spot Welds On Side Of Frame Crossmember Nut Retainer
Courtesy of GENERAL MOTORS CORP.

Installation Procedure

1. Install the frame crossmember nut (2).

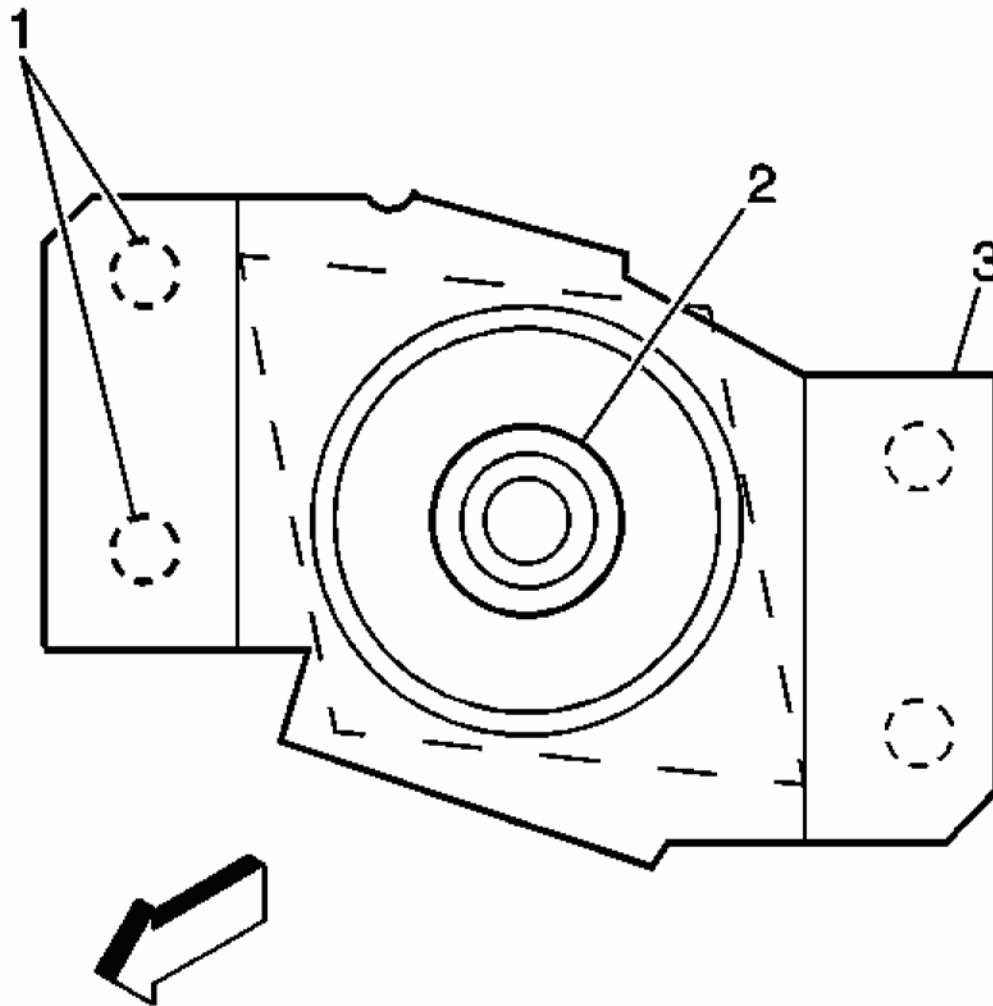


Fig. 62: Installing Frame Crossmember Nut
Courtesy of GENERAL MOTORS CORP.

2. Install the lower frame crossmember nut retainer into place to insure proper placement and working condition of the frame crossmember nut.
3. Install the spot weld (3) frame crossmember nut retainer in the original location.

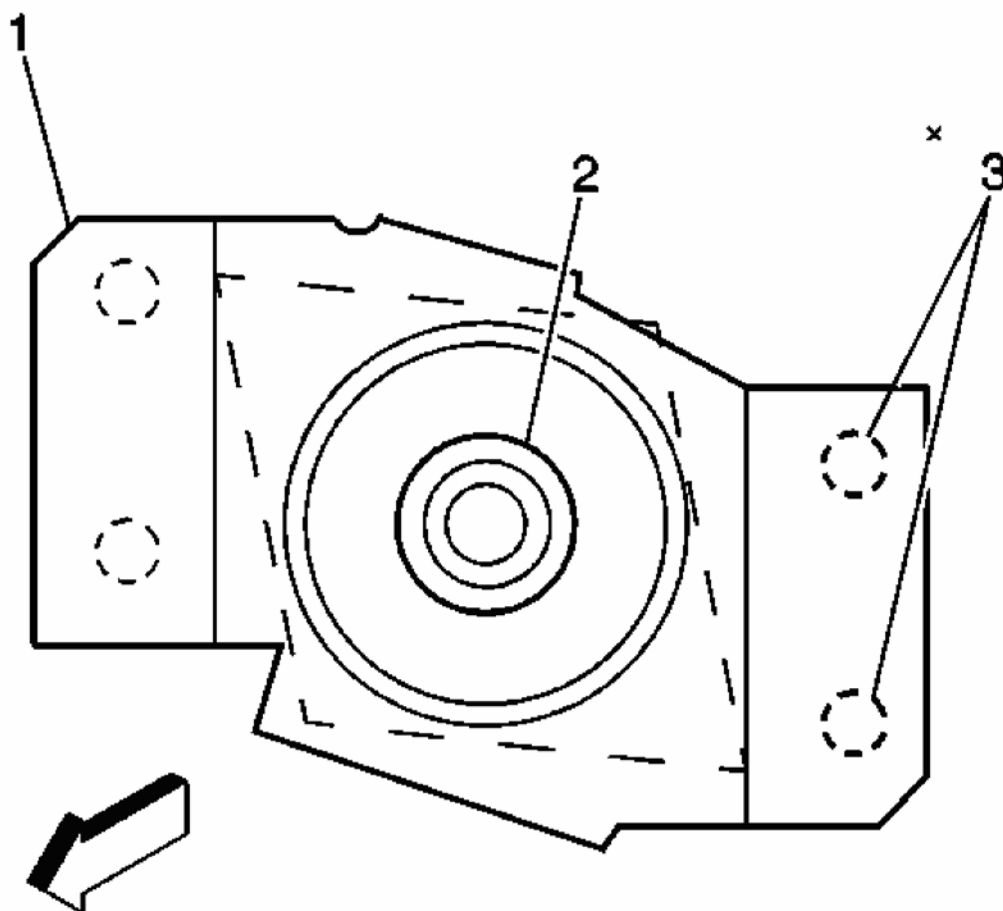


Fig. 63: Installing Spot Weld Frame Crossmember Nut Retainer
Courtesy of GENERAL MOTORS CORP.

4. Clean and prepare the welded surfaces.

NOTE: Refer to Fastener Notice in Cautions and Notices.

5. Install the new frame bolt to the frame crossmember nut.

Tighten: Tighten the bolt to 180 N.m (133 lb ft).

6. With a pressure pot apply the anticorrosion compound GM P/N 12346225 or equivalent and coat the inside of the repair area through any access hole thoroughly.
7. Connect the battery ground (negative) cable.

2004 Cadillac Escalade
2004 ACCESSORIES & EQUIPMENT Frame & Underbody - C/K SUV

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