

2004 Cadillac Escalade

2004 ACCESSORIES & EQUIPMENT Bumpers - C/K SUV

2004 ACCESSORIES & EQUIPMENT

Bumpers - C/K SUV

SPECIFICATIONS

FASTENER TIGHTENING SPECIFICATIONS

Fastener Tightening Specifications

Application	Specification	
	Metric	English
Front Bumper to Brace Bolts	55 N.m	41 lb ft
Front Bumper to Bracket Bolts	85 N.m	63 lb ft
Rear Bumper Plate Assembly Nuts	90 N.m	66 lb ft
Rear Frame Rail Bracket Bumper Bolts	100 N.m	74 lb ft
Side Frame Rail Bracket Bolt	40 N.m	30 lb ft

REPAIR INSTRUCTIONS

AIR DEFLECTOR REPLACEMENT - FRONT BUMPER FASCIA

Removal Procedure

1. Raise the vehicle. Refer to **Lifting and Jacking the Vehicle** in General Information.
2. Disconnect the fog lamp electrical connectors, if equipped.
3. Remove the fog lamps, if equipped. Refer to **Fog Lamp Replacement - Front** in Lighting Systems.
4. Loosen the center studs of the push-pins on the air deflector with a flat-bladed screwdriver.
5. Remove the air deflector from the front bumper fascia.

2004 Cadillac Escalade

2004 ACCESSORIES & EQUIPMENT Bumpers - C/K SUV

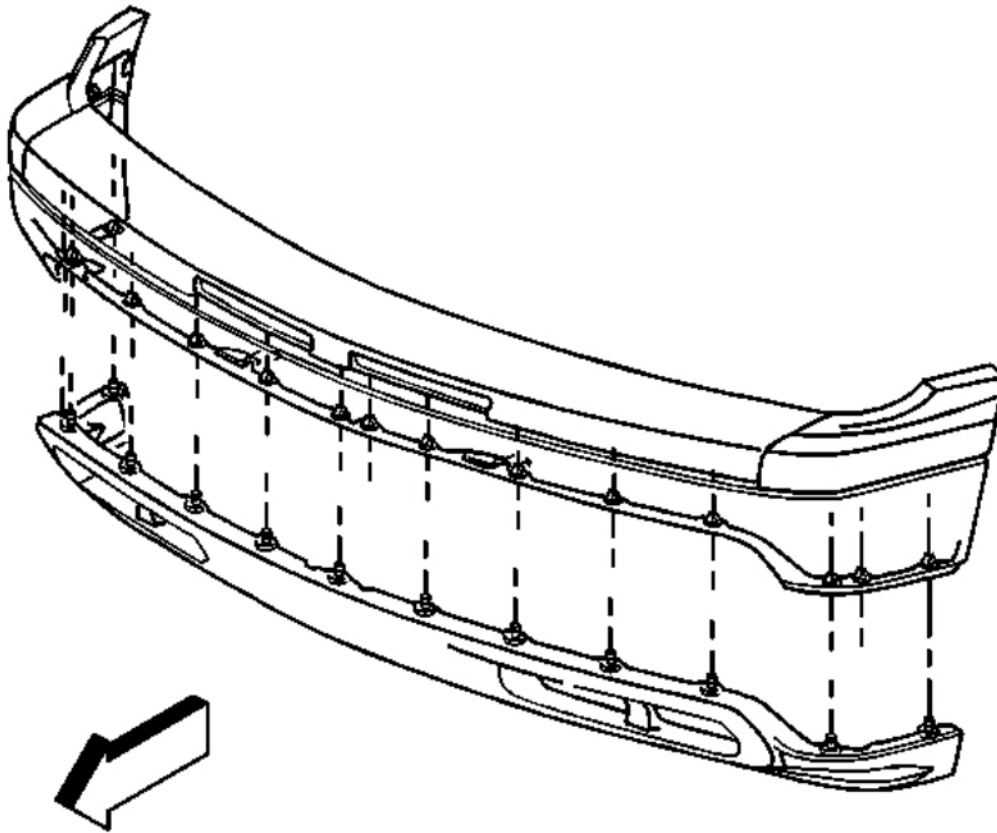


Fig. 1: Removing Front Bumper Fascia Air Deflector
Courtesy of GENERAL MOTORS CORP.

Installation Procedure

1. Position the air deflector onto the front bumper assembly.
2. Fasten the connection ends of the push-pins onto the front bumper deflector.

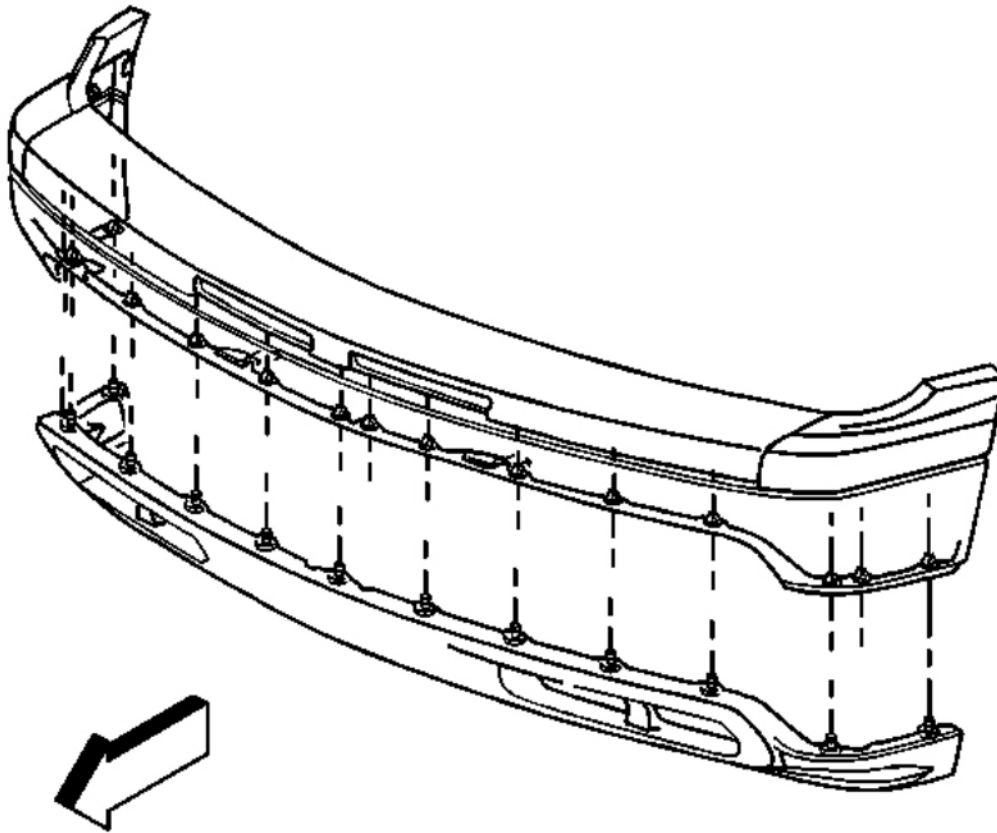


Fig. 2: Installing Front Bumper Fascia Air Deflector
Courtesy of GENERAL MOTORS CORP.

3. Install the fog lamps, if equipped. Refer to **Fog Lamp Replacement - Front** in Lighting Systems.
4. Connect the fog lamp electrical connectors, if equipped.
5. Lower the vehicle.

FASCIA REPLACEMENT - FRONT BUMPER (AVALANCHE)

Removal Procedure

1. Raise the vehicle. Refer to **Lifting and Jacking the Vehicle** in General Information.
2. Remove the brace bolt. Refer to **Brace Replacement - Front Bumper (Avalanche)**.
3. Remove the retainers (2) from the fascia (1).

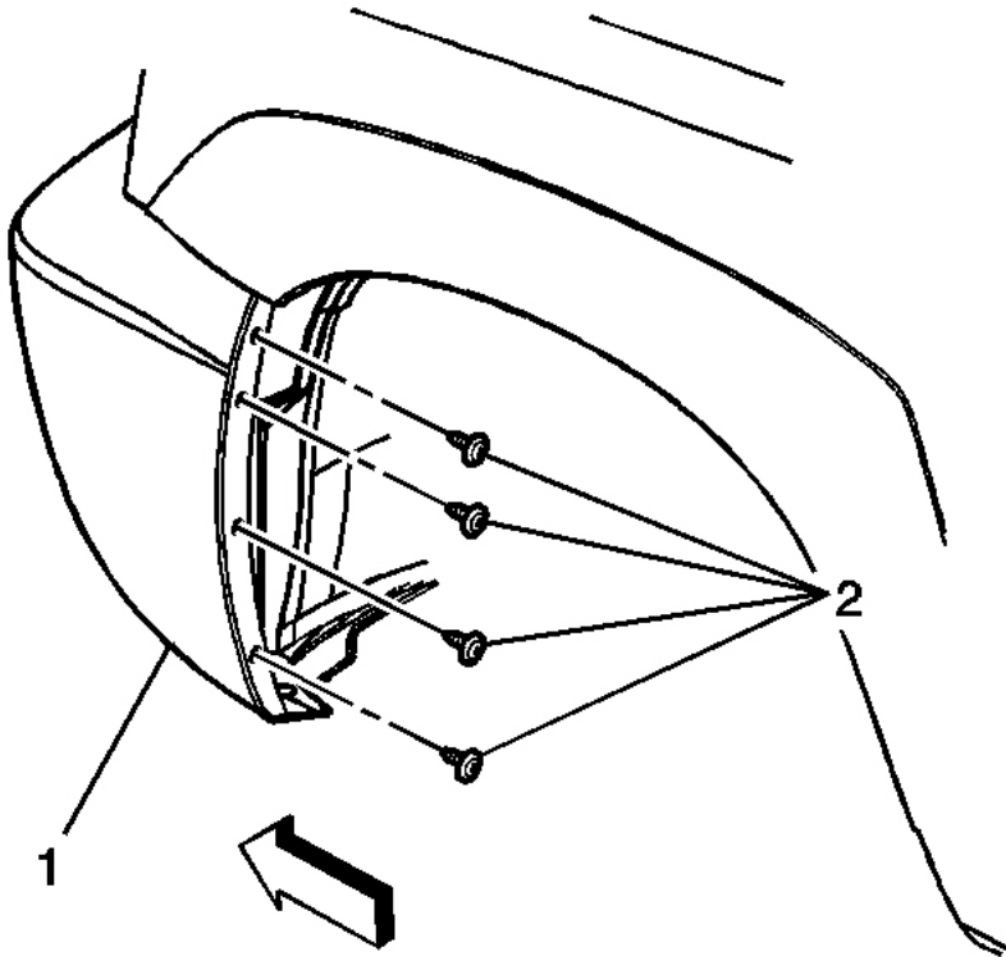


Fig. 3: Removing Retainers From Front Bumper Fascia (Avalanche)
Courtesy of GENERAL MOTORS CORP.

4. Remove the daytime running and fog lamps. Refer to **Daytime Running and Fog Lamp Assembly Replacement (Avalanche)** in Lighting Systems.
5. Release the front fascia locking fittings from the radiator grille support.
6. Pull the front fascia in order to release the front fascia from the front fender outer panel clips (1).

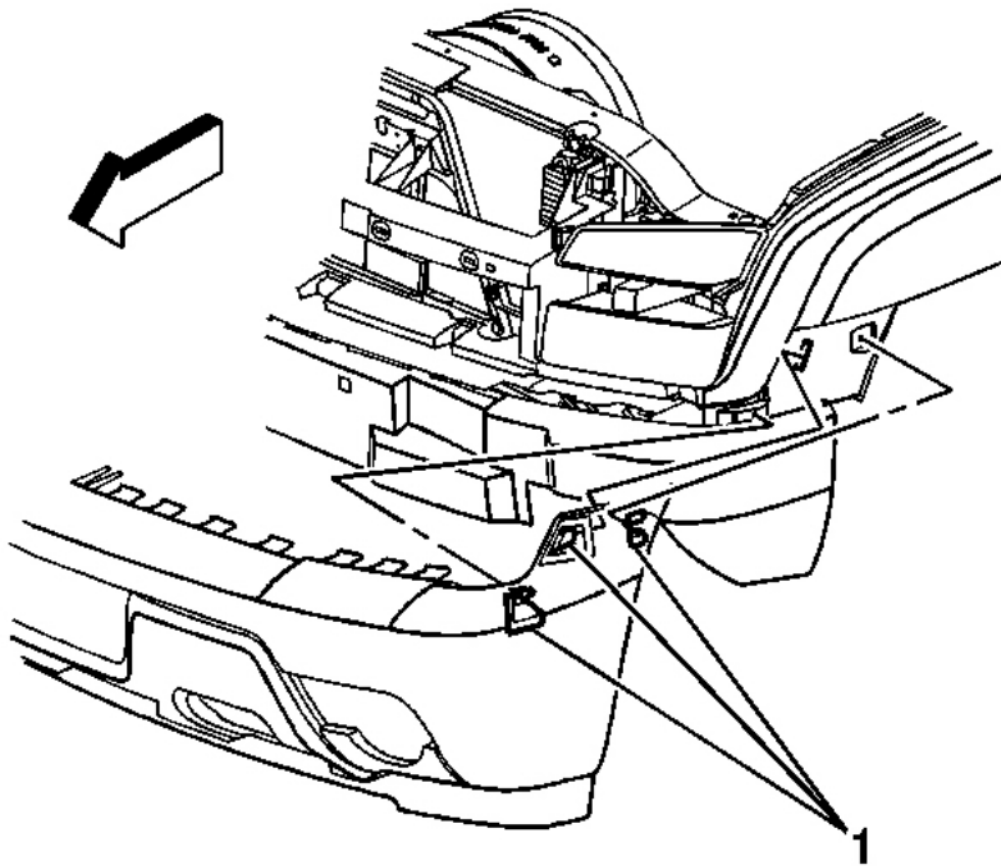


Fig. 4: Releasing Front Fascia From Front Fender Outer Panel Clips (Avalanche)
Courtesy of GENERAL MOTORS CORP.

Installation Procedure

1. Install the daytime running and fog lamps. Refer to **Daytime Running and Fog Lamp Assembly Replacement (Avalanche)** in Lighting Systems.
2. Align the front fascia clips (1) to the front fender outer panel clip retainers.
3. Push the fascia firmly in order to secure the fascia to the radiator grille support and front fender outer panel.

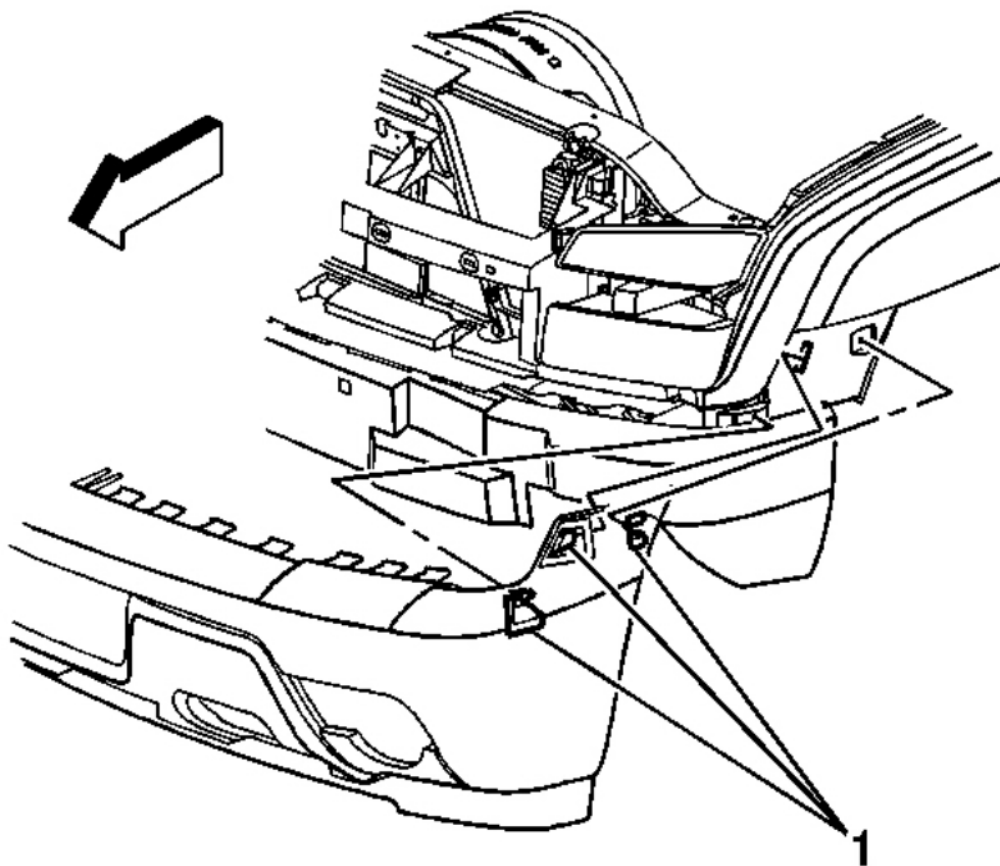


Fig. 5: Aligning Front Fascia Clips To Front Fender Outer Panel Retainers (Avalanche)
Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to Fastener Notice in Cautions and Notices.

4. Install the retainers (2) to the fascia (1).

Tighten: Tighten the retainers to 1.6 N.m (14.0 lb in)

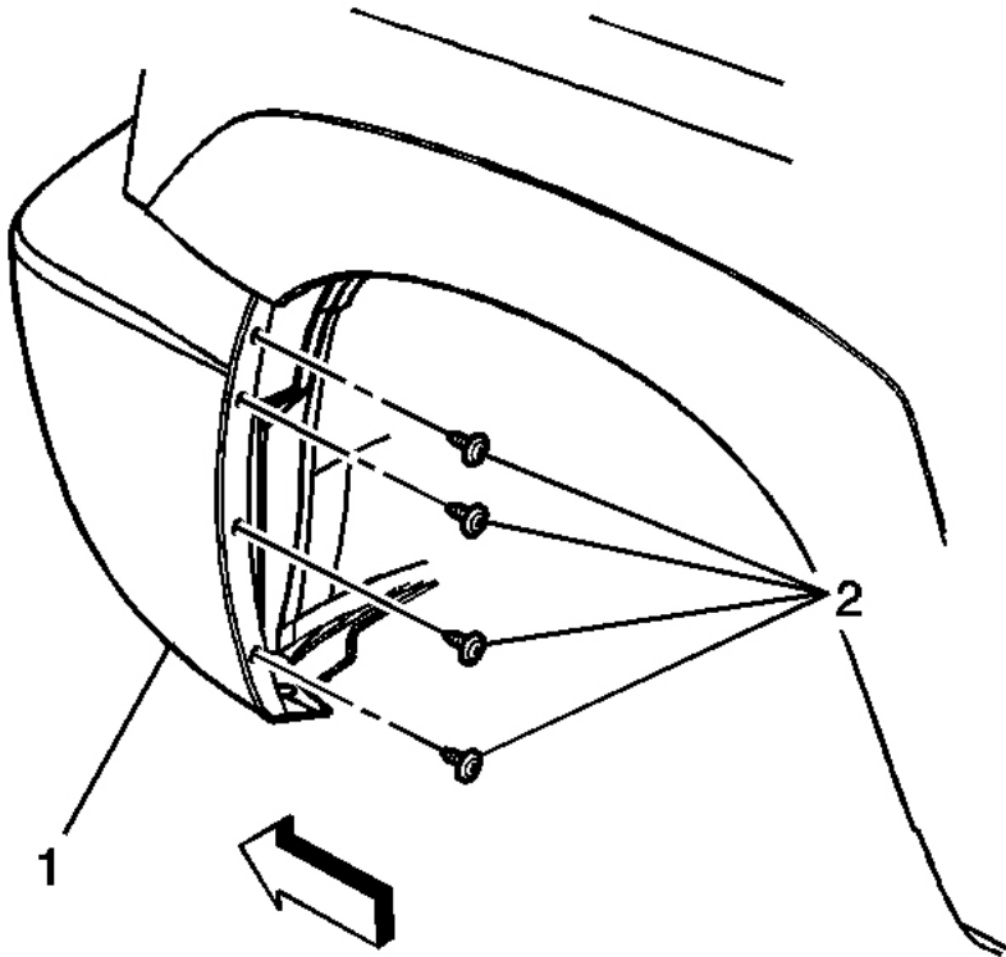


Fig. 6: Installing Retainers To Front Bumper Fascia (Avalanche)
Courtesy of GENERAL MOTORS CORP.

5. Install the bolt to the front fascia brace. Refer to **Brace Replacement - Front Bumper (Avalanche)** .

FASCIA REPLACEMENT - FRONT BUMPER (Z-71)

Removal Procedure

1. Remove the front fog lamps. Refer to **Fog Lamp Replacement - Front** in Lighting Systems.
2. Remove the push-pins from the lower fascia.
3. Remove the front lower fascia from the vehicle.

2004 Cadillac Escalade

2004 ACCESSORIES & EQUIPMENT Bumpers - C/K SUV

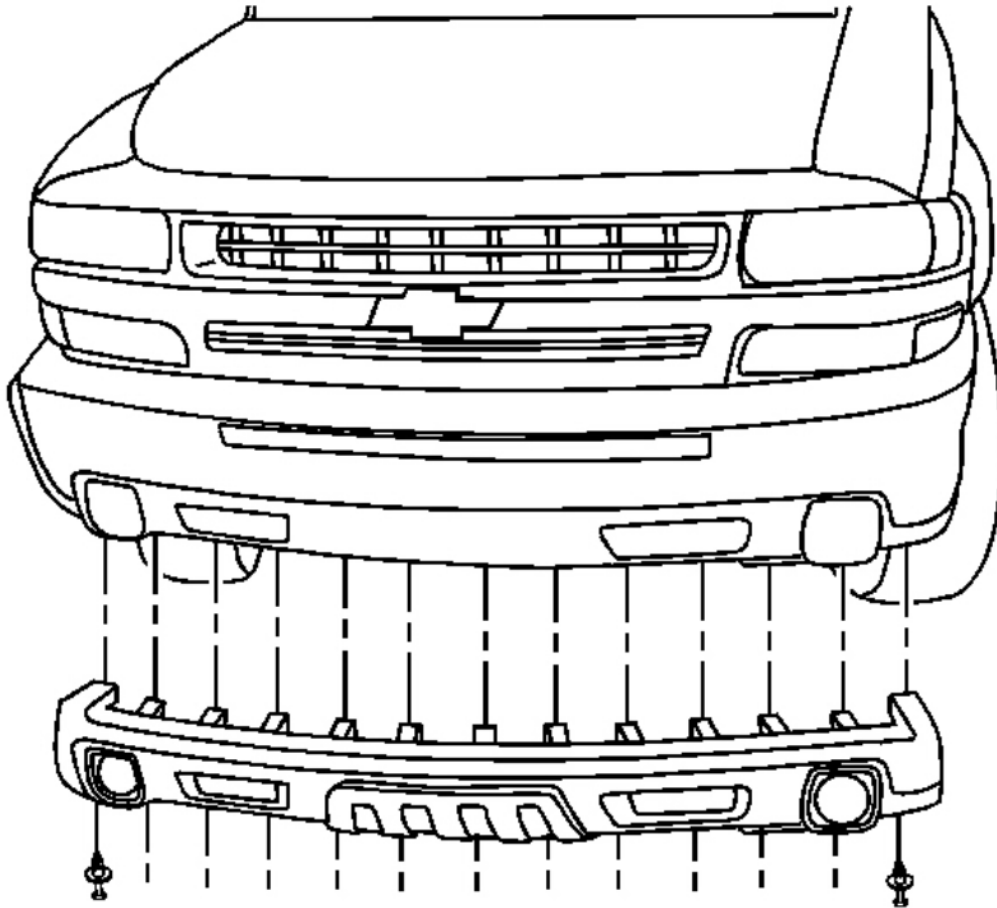


Fig. 7: Removing Front Bumper Fascia (Z-71)
Courtesy of GENERAL MOTORS CORP.

Installation Procedure

1. Install the front lower fascia to the vehicle.
2. Install the push-pins to the fascia.

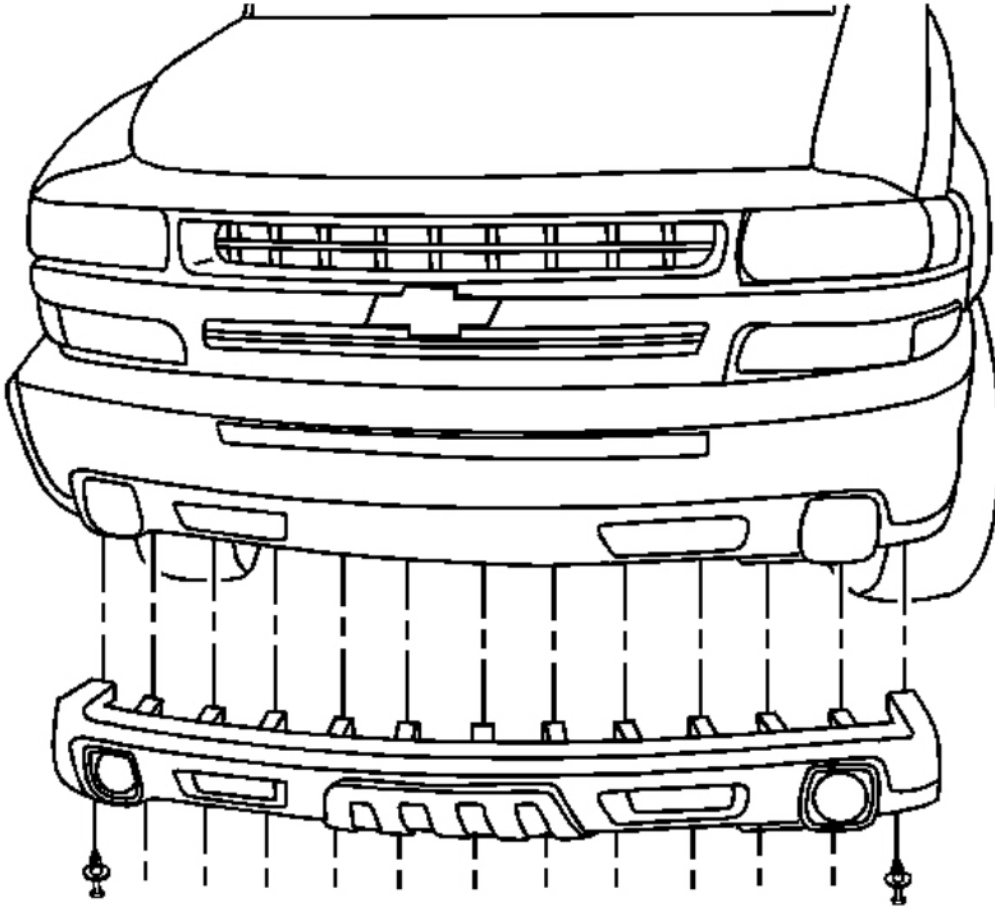


Fig. 8: Installing Front Bumper Fascia (Z-71)

Courtesy of GENERAL MOTORS CORP.

3. Install the front fog lamps. Refer to **Fog Lamp Replacement - Front** in Lighting Systems.

FASCIA REPLACEMENT - FRONT BUMPER (CADILLAC)

Removal Procedure

1. Open the hood.
2. Remove the upper air baffle. Refer to **Radiator Air Baffle and Deflector Replacement - Upper** in Engine Cooling.
3. Remove the front grille. Refer to **Grille Replacement (Cadillac)** or **Grille Replacement (Avalanche)** or **Grille Replacement (Chevrolet)** or **Grille Replacement (GMC)** in Exterior Trim.

2004 Cadillac Escalade

2004 ACCESSORIES & EQUIPMENT Bumpers - C/K SUV

4. Remove the upper fascia fasteners (1).
5. Remove the upper fascia clips.

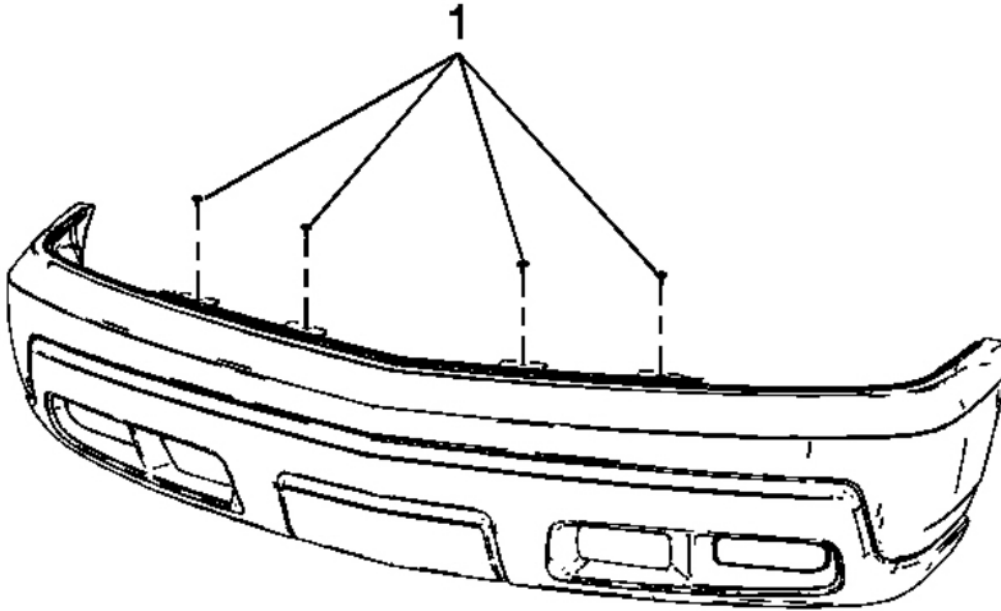


Fig. 9: Removing Upper Fascia Fasteners (Cadillac)

Courtesy of GENERAL MOTORS CORP.

6. Raise the vehicle. Refer to **Lifting and Jacking the Vehicle** in General Information.
7. Remove the 2 lower license plate fasteners (1).
8. Remove the 3 fasteners under the license plate closeout (2).

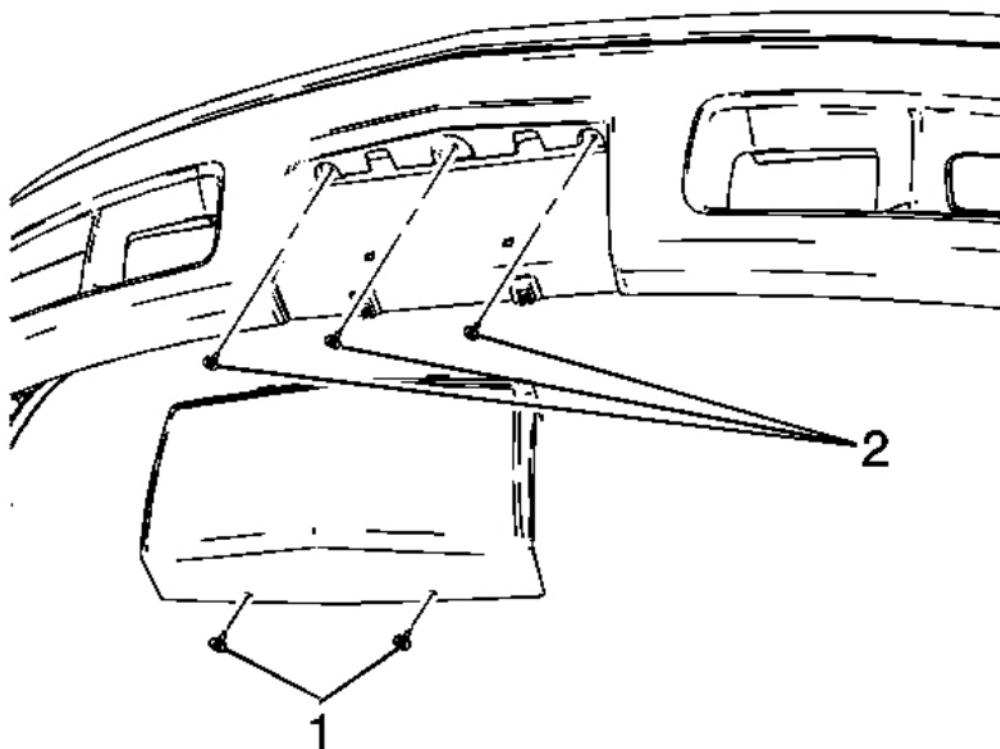


Fig. 10: Removing Lower License Plate & License Plate Closeout Fasteners
Courtesy of GENERAL MOTORS CORP.

9. Disconnect the fog lamp bulb electrical connector on the left and right side.
10. Remove the inside upper fog lamp fastener (1) on the left and right side.

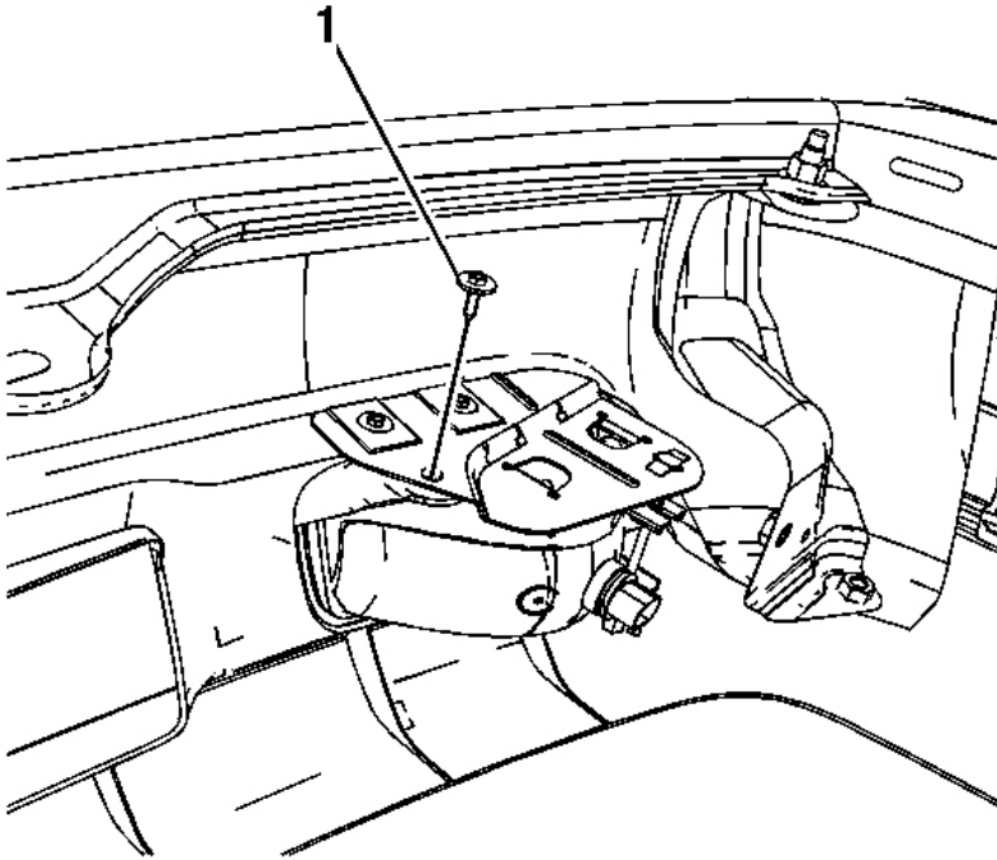


Fig. 11: Removing Inside Upper Fog Lamp Fasteners
Courtesy of GENERAL MOTORS CORP.

11. Remove the left and right front wheelhouse liner retainers to get access to the fascia T-stud bracket.
12. Install the pop-in the clip onto the fascia T-stud bracket (1) with a flat-head screwdriver (2). Release the fascia T-stud bracket from the fender T-stud.

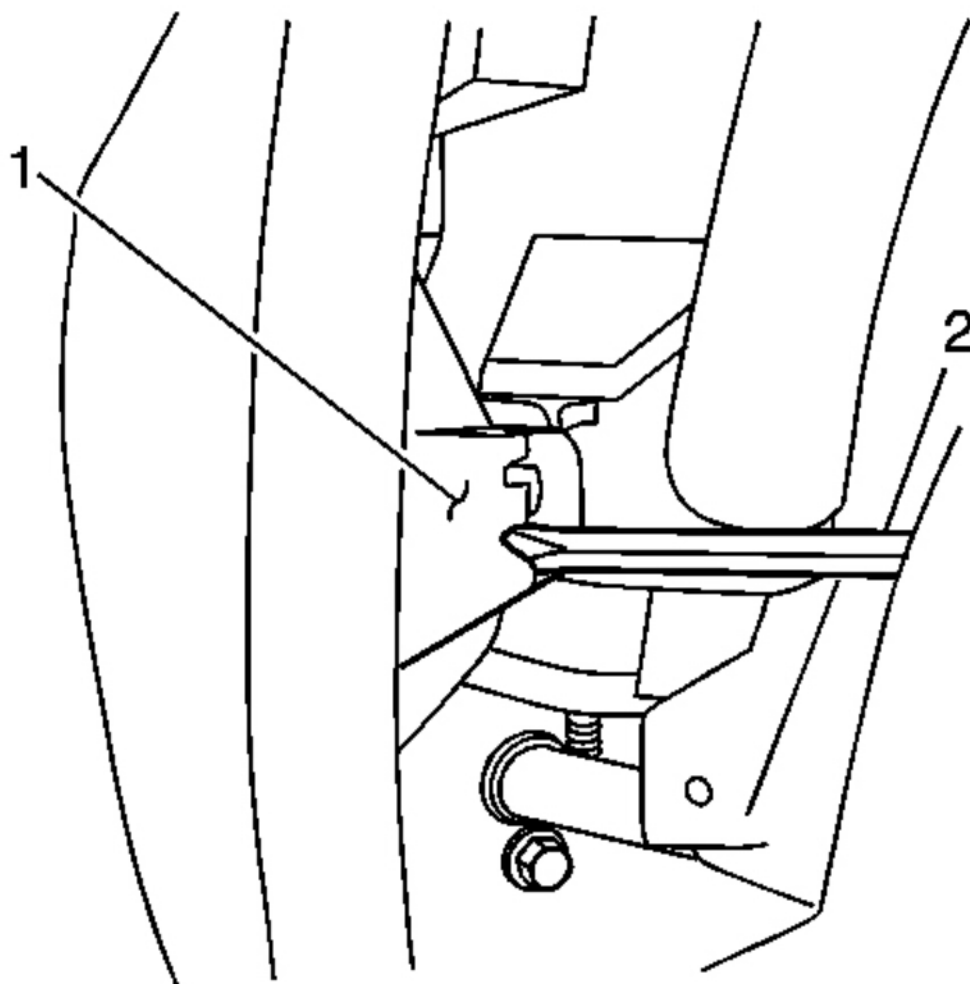


Fig. 12: Installing Pop-In Clip Onto Fascia T-Stud Bracket Using Screwdriver
Courtesy of GENERAL MOTORS CORP.

13. Remove the front fascia from the vehicle.

Installation Procedure

1. Install the T-stud bracket (1) to the fender T-stud (2) on both ends.

2004 Cadillac Escalade

2004 ACCESSORIES & EQUIPMENT Bumpers - C/K SUV

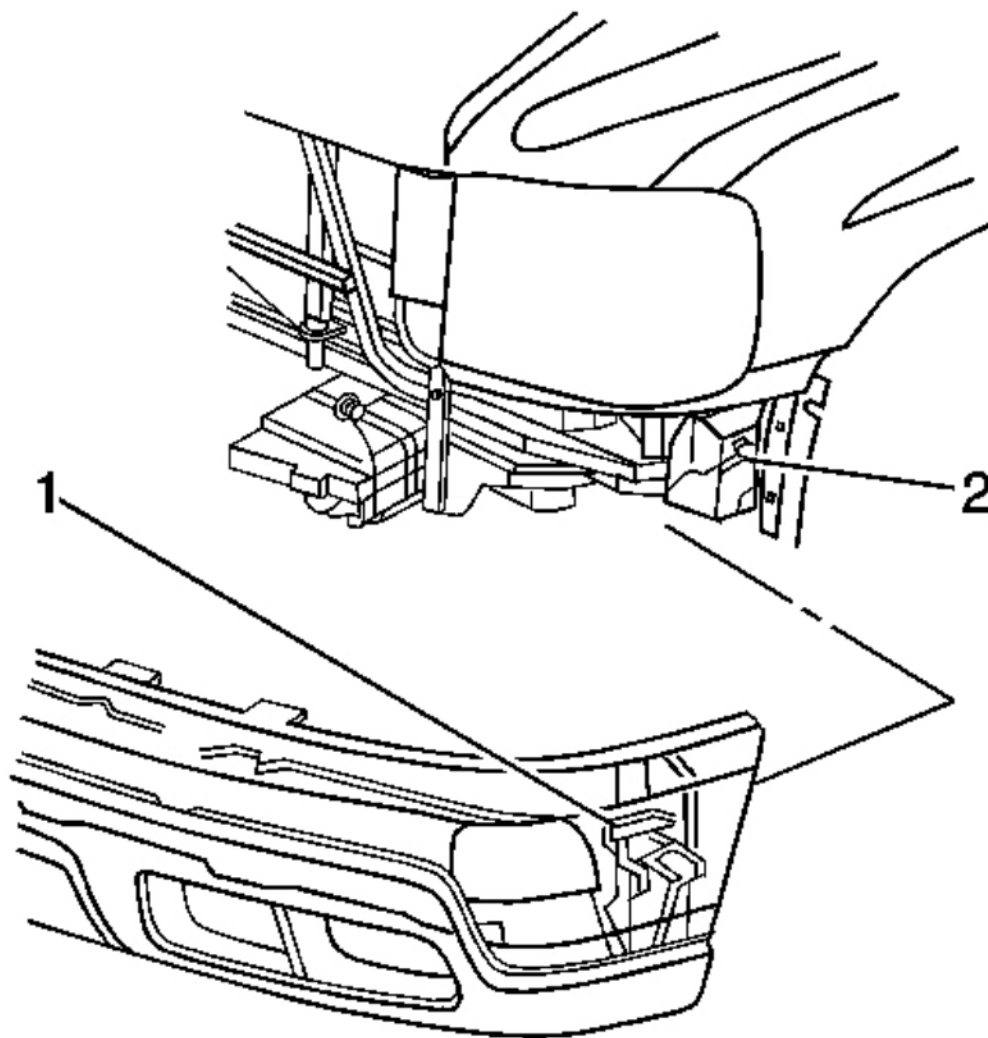


Fig. 13: Installing T-Stud Bracket To Fender T-Stud
Courtesy of GENERAL MOTORS CORP.

2. Install the left and right front wheelhouse retainers.
3. Install the inside upper fog lamp fastener (1) on the left and right side.

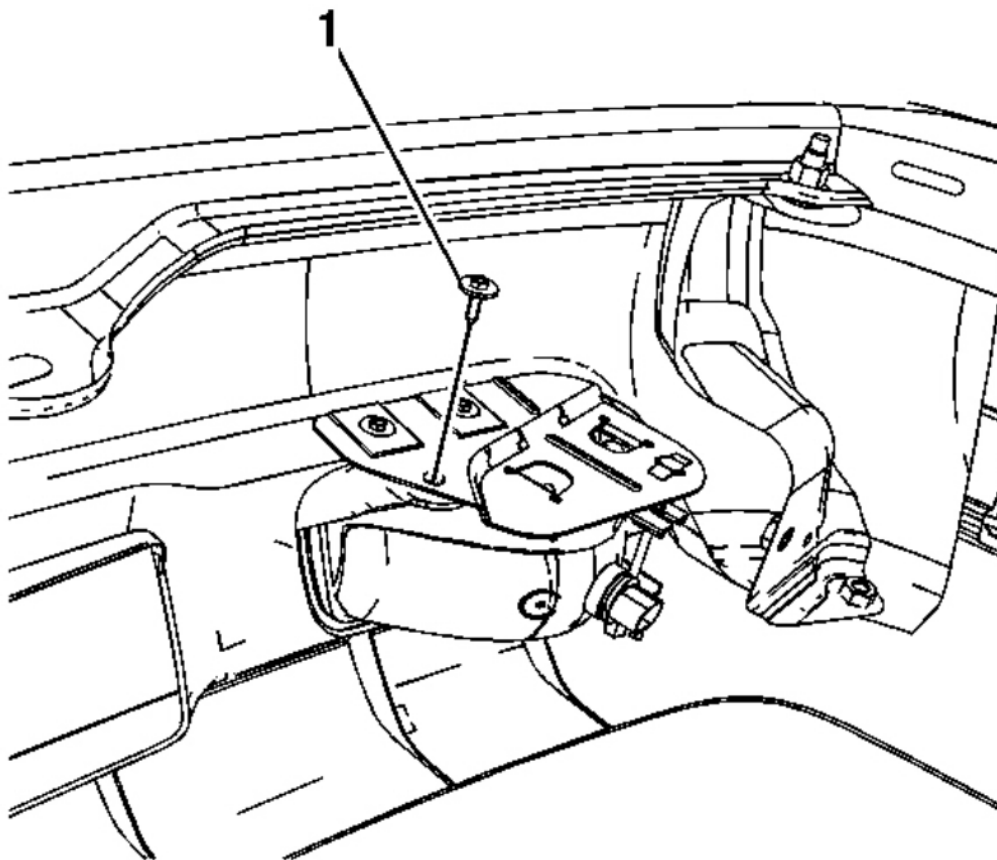


Fig. 14: Installing Inside Upper Fog Lamp Fasteners
Courtesy of GENERAL MOTORS CORP.

4. Connect the fog lamp bulb electrical connector on the left and right side.
5. Install the 3 fasteners under the license plate closeout (1).
6. Install the license plate closeout and replace the 2 lower license plate fasteners (2).

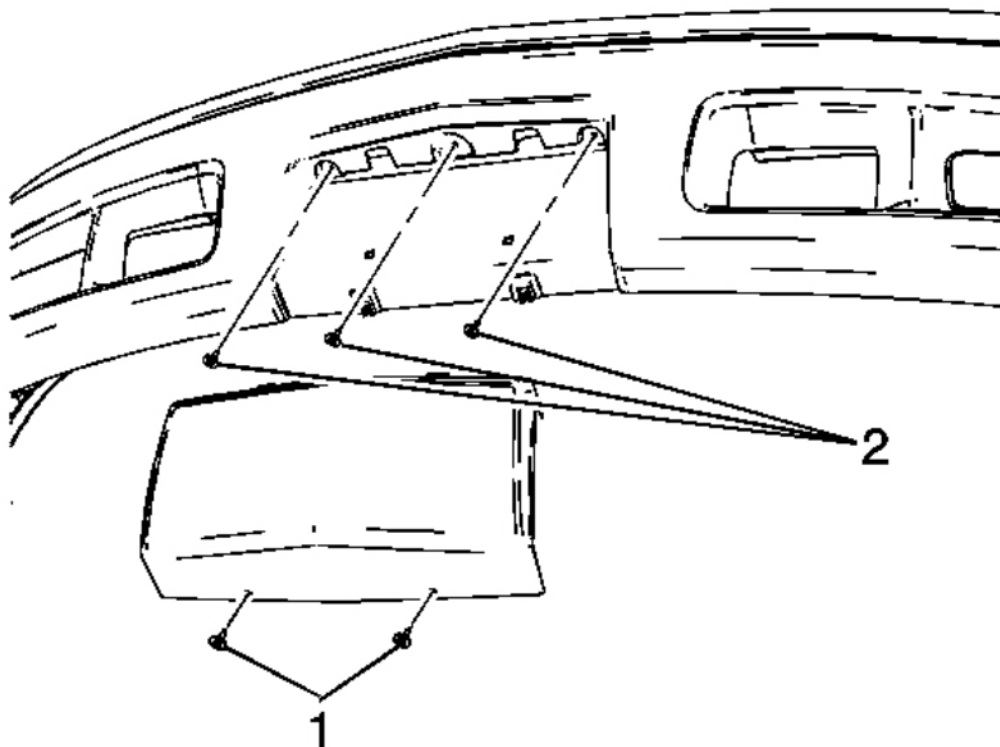


Fig. 15: Installing License Plate Closeout & Lower License Plate Fasteners
Courtesy of GENERAL MOTORS CORP.

7. Lower the vehicle. Refer to **Lifting and Jacking the Vehicle** in General Information.
8. Install the upper fascia clips.
9. Install the upper fascia fasteners (1).

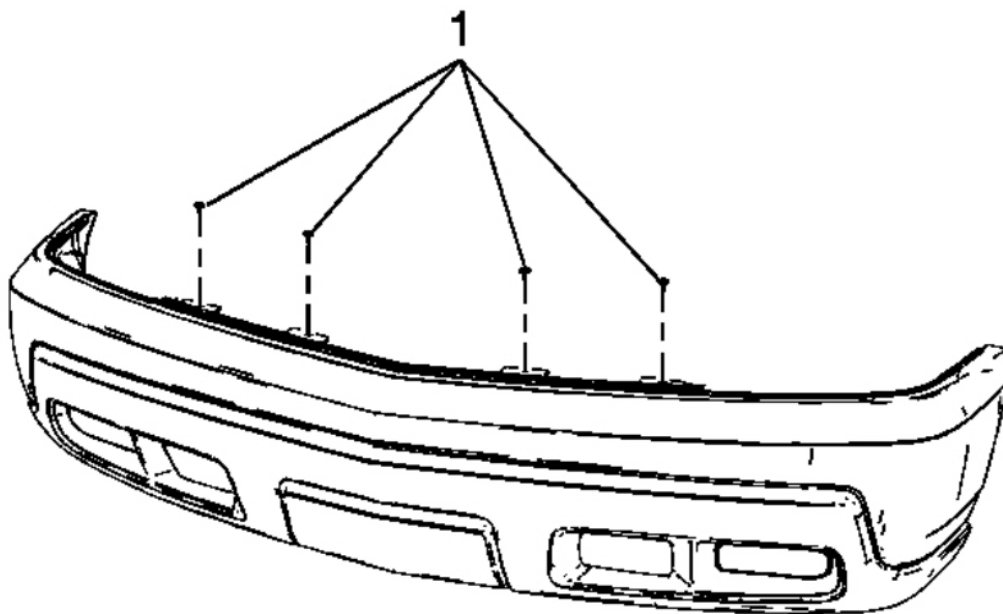


Fig. 16: Installing Upper Fascia Fasteners

Courtesy of GENERAL MOTORS CORP.

10. Install the front grille. Refer to **Grille Replacement (Cadillac)** or **Grille Replacement (Avalanche)** or **Grille Replacement (Chevrolet)** or **Grille Replacement (GMC)** in Exterior Trim.
11. Install the upper air baffle. Refer to **Radiator Air Baffle and Deflector Replacement - Upper** in Engine Cooling.
12. Close the hood.

MOLDING REPLACEMENT - FRONT BUMPER CAP

Removal Procedure

1. Open the hood.
2. Remove the upper air baffle. Refer to **Radiator Air Baffle and Deflector Replacement - Upper** in Engine Cooling.
3. Remove the front grille. Refer to **Grille Replacement (Cadillac)** or **Grille Replacement (Avalanche)** or **Grille Replacement (Chevrolet)** or **Grille Replacement (GMC)** in Exterior Trim.
4. Remove the front bumper. Refer to **Bumper Replacement - Front (Old Style)**.
5. Remove the front bumper fascia cap by depressing all the tabs and pulling up.

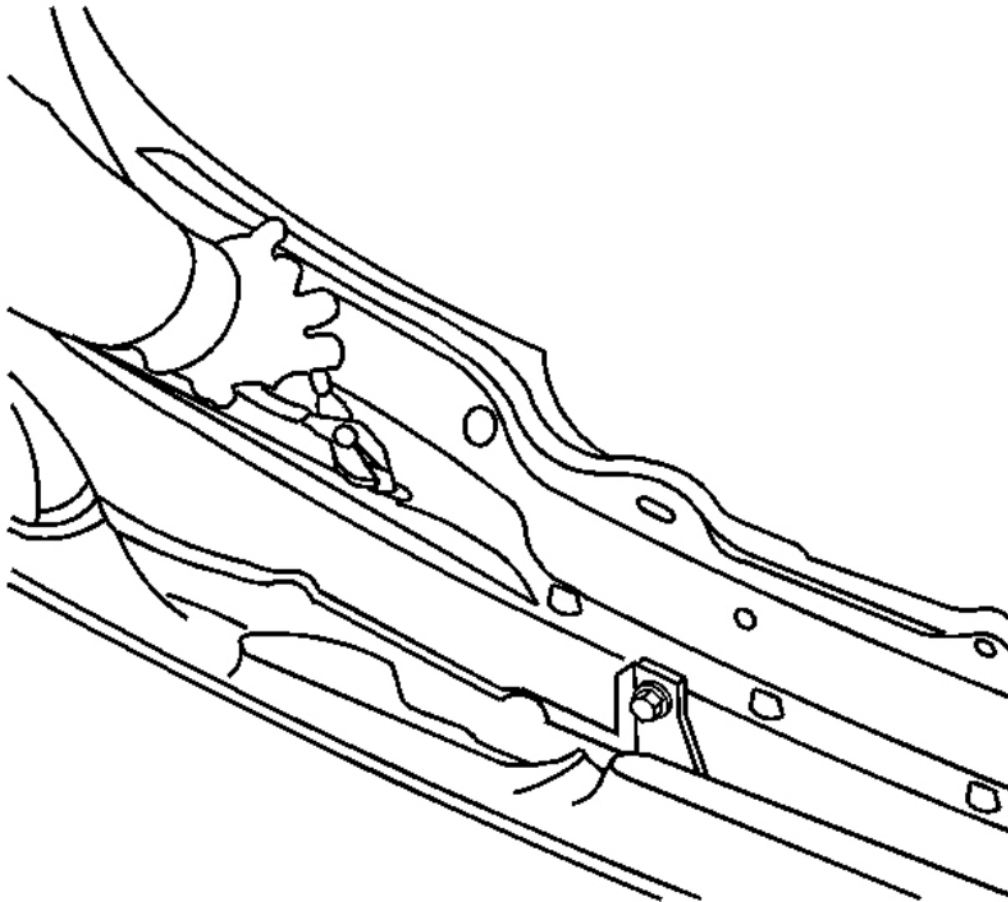


Fig. 17: Removing Front Bumper Cap Molding
Courtesy of GENERAL MOTORS CORP.

Installation Procedure

1. Position the fascia cap tabs to the slots in the bumper.
2. Install the front bumper cap to the bumper pressing into place until fully seated.
3. Install the front bumper. Refer to **Bumper Replacement - Front (Old Style)** .

2004 Cadillac Escalade

2004 ACCESSORIES & EQUIPMENT Bumpers - C/K SUV

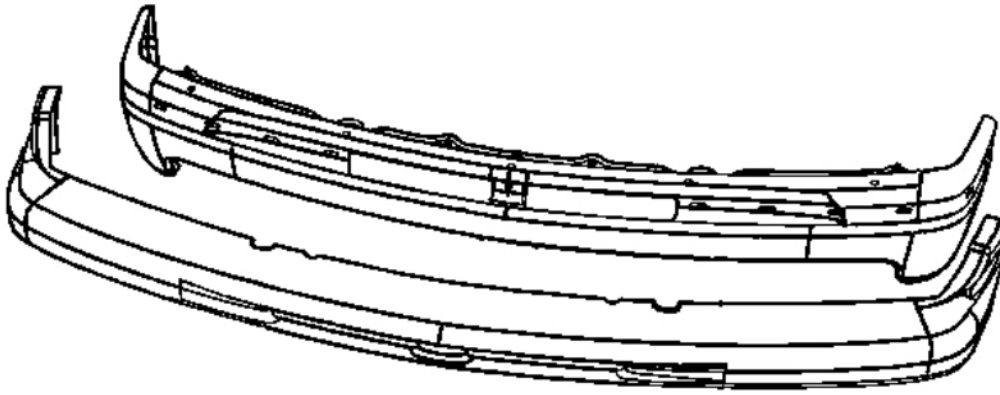


Fig. 18: Installing Front Bumper
Courtesy of GENERAL MOTORS CORP.

4. Install the front grille. Refer to **Grille Replacement (Cadillac)** or **Grille Replacement (Avalanche)** or **Grille Replacement (Chevrolet)** or **Grille Replacement (GMC)** in Exterior Trim.
5. Install the upper air baffle. Refer to **Radiator Air Baffle and Deflector Replacement - Upper** in Engine Cooling.
6. Close the hood.

BUMPER REPLACEMENT - FRONT (OLD STYLE)

Removal Procedure

1. Remove the front grille. Refer to **Grille Replacement (Cadillac)** or **Grille Replacement (Avalanche)** or **Grille Replacement (Chevrolet)** or **Grille Replacement (GMC)** in Exterior Trim.
2. Disconnect the electrical connector from the fog lamps, if equipped.

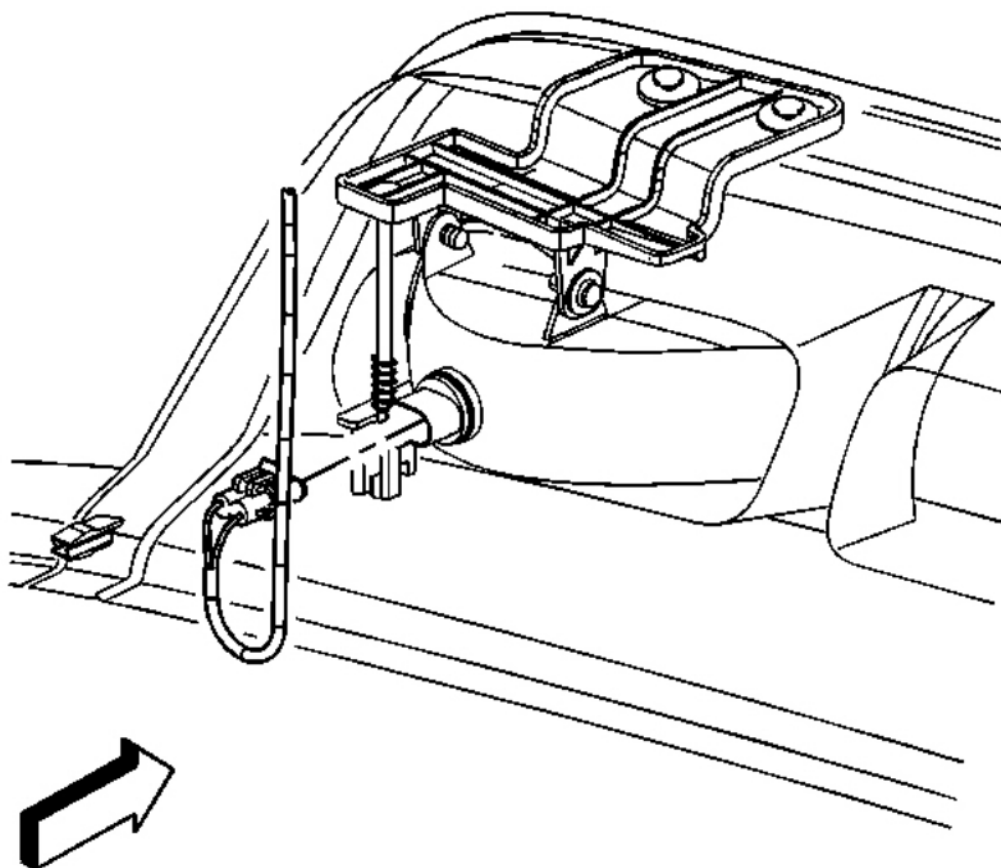


Fig. 19: Disconnecting Electrical Connector From Fog Lamps
Courtesy of GENERAL MOTORS CORP.

3. Remove the retaining bolts (1, 2) from the front bumper.
4. Remove the brace bolt (3) from the front bumper.

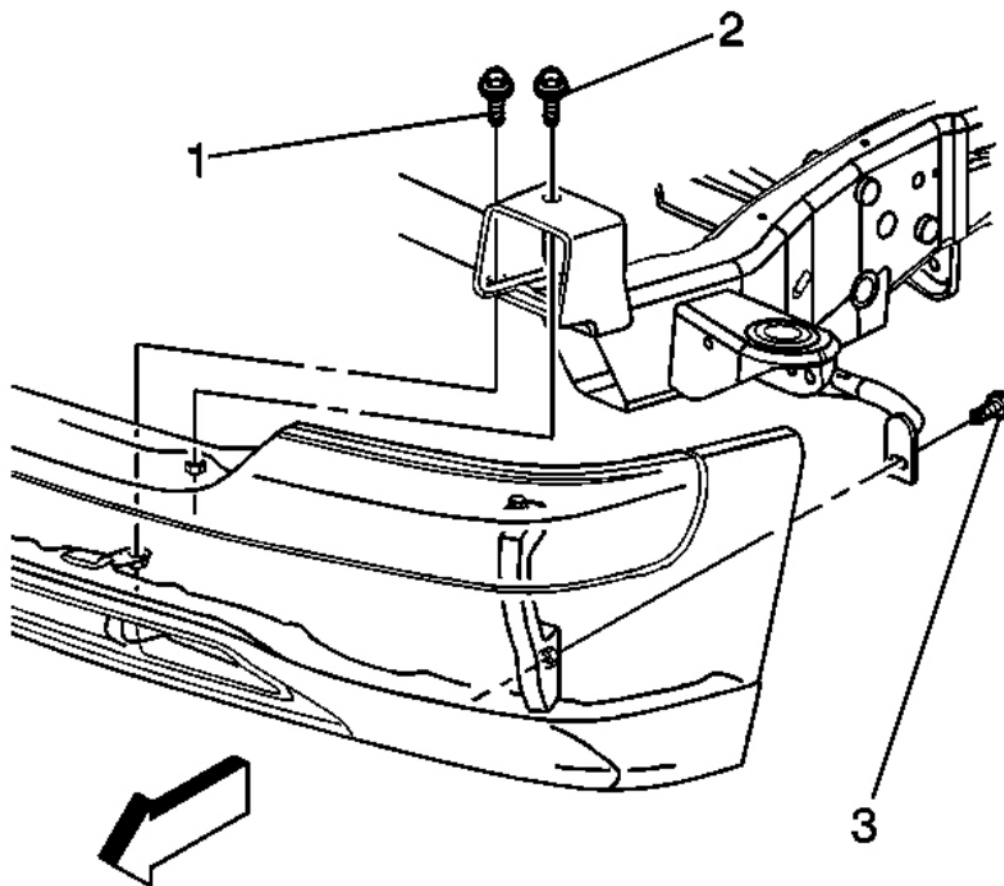


Fig. 20: Removing Front Bumper Retaining Bolts & Brace Bolt (Old Style)
Courtesy of GENERAL MOTORS CORP.

5. Remove the front bumper assembly from the vehicle.
6. Remove the air deflector from the bumper if necessary. Refer to **Air Deflector Replacement - Front Bumper Fascia**.
7. Remove the fog lamps, if equipped. Refer to **Fog Lamp Replacement - Front** in Lighting Systems.

Installation Procedure

1. Install the fog lamps, if equipped. Refer to **Fog Lamp Replacement - Front** in Lighting Systems.
2. Install the air deflector to the bumper if necessary. Refer to **Air Deflector Replacement - Front Bumper Fascia**.
3. Position the front bumper assembly on the vehicle.

NOTE: Refer to Fastener Notice in Cautions and Notices.

IMPORTANT: Tighten the bolts in the following sequence.

4. Install the retaining bolts (1, 2) to the front bumper.

Tighten:

1. Tighten the bracket bolt (1) to 85 N.m (63 lb ft).
2. Tighten the bracket bolt (2) to 85 N.m (63 lb ft).
3. Tighten the brace bolt to 55 N.m (41 lb ft).

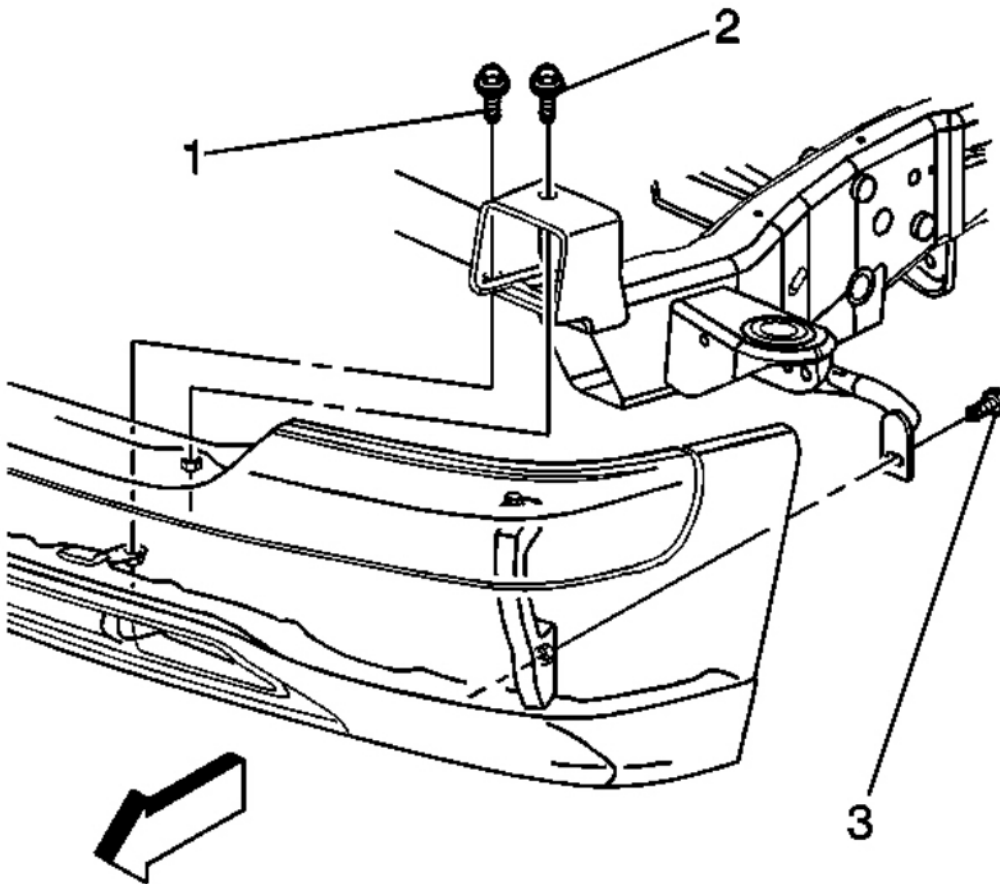


Fig. 21: Installing Front Bumper Retaining Bolts (Old Style)
Courtesy of GENERAL MOTORS CORP.

5. Connect the electrical connector to the fog lamps, if equipped.

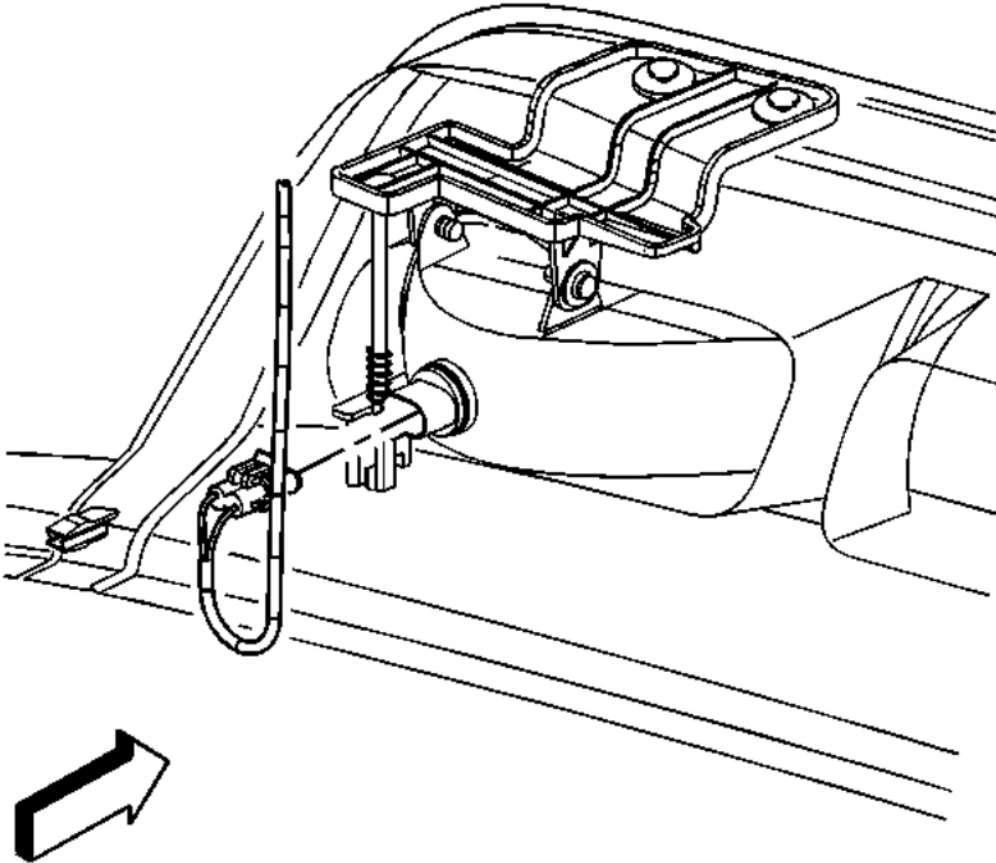


Fig. 22: Connecting Electrical Connector To Fog Lamps
Courtesy of GENERAL MOTORS CORP.

6. Install the front grille Refer to **Grille Replacement (Cadillac)** or **Grille Replacement (Avalanche)** or **Grille Replacement (Chevrolet)** or **Grille Replacement (GMC)** in Exterior Trim.

BUMPER FILLER REPLACEMENT - FRONT SIDE (OLD STYLE)

Removal Procedure

1. Remove the front grille. Refer to **Grille Replacement (Cadillac)** or **Grille Replacement (Avalanche)** or **Grille Replacement (Chevrolet)** or **Grille Replacement (GMC)** in Exterior Trim.
2. Disconnect the electrical connector from the fog lamps, if equipped.

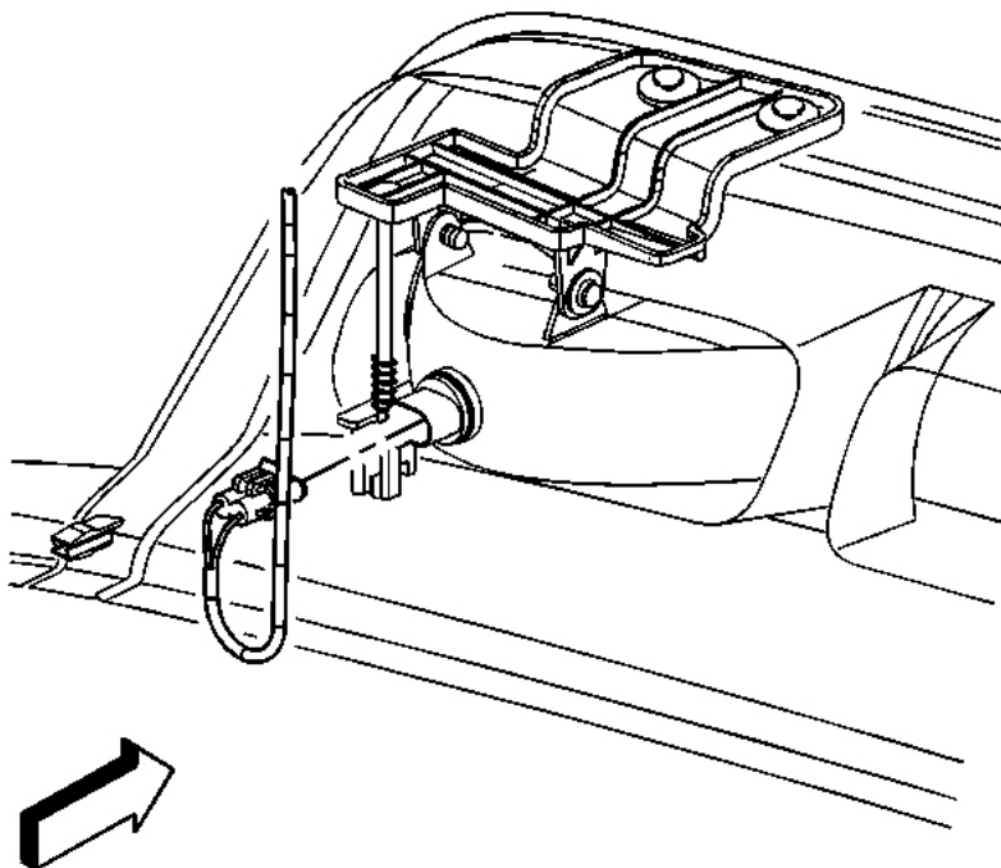


Fig. 23: Disconnecting Electrical Connector From Fog Lamps
Courtesy of GENERAL MOTORS CORP.

3. Remove the retaining bolts (1, 2) from the front bumper.
4. Remove the brace bolt (3) from the front bumper.

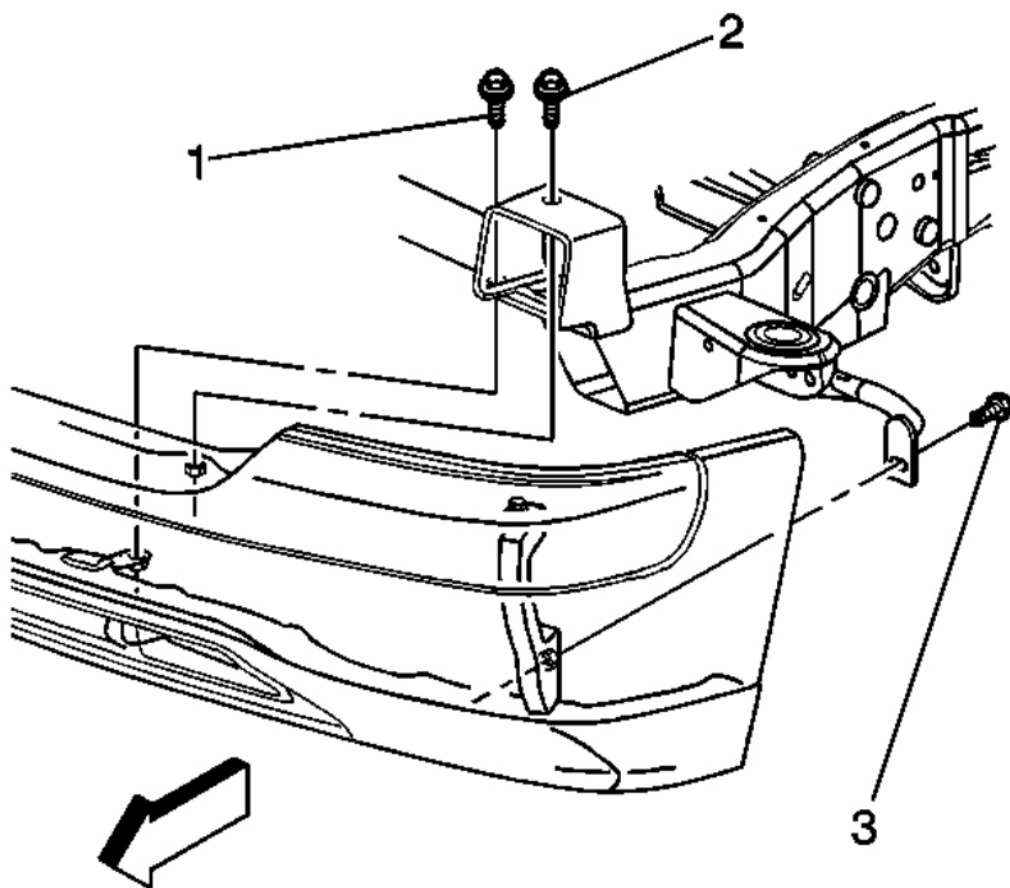


Fig. 24: Removing Front Bumper Retaining Bolts & Brace Bolt (Old Style)
Courtesy of GENERAL MOTORS CORP.

5. Remove the front bumper assembly from the vehicle.
6. Remove the air deflector from the bumper if necessary. Refer to **Air Deflector Replacement - Front Bumper Fascia**.
7. Remove the fog lamps, if equipped. Refer to **Fog Lamp Replacement - Front** in Lighting Systems.
8. Remove the S clip securing the bumper filler panel to the wheelhouse splash shield.
9. Remove the fastener securing the filler panel to the radiator support.
10. Remove the fastener securing the filler panel to the headlamp bracket.
11. Remove the bumper filler from the vehicle.

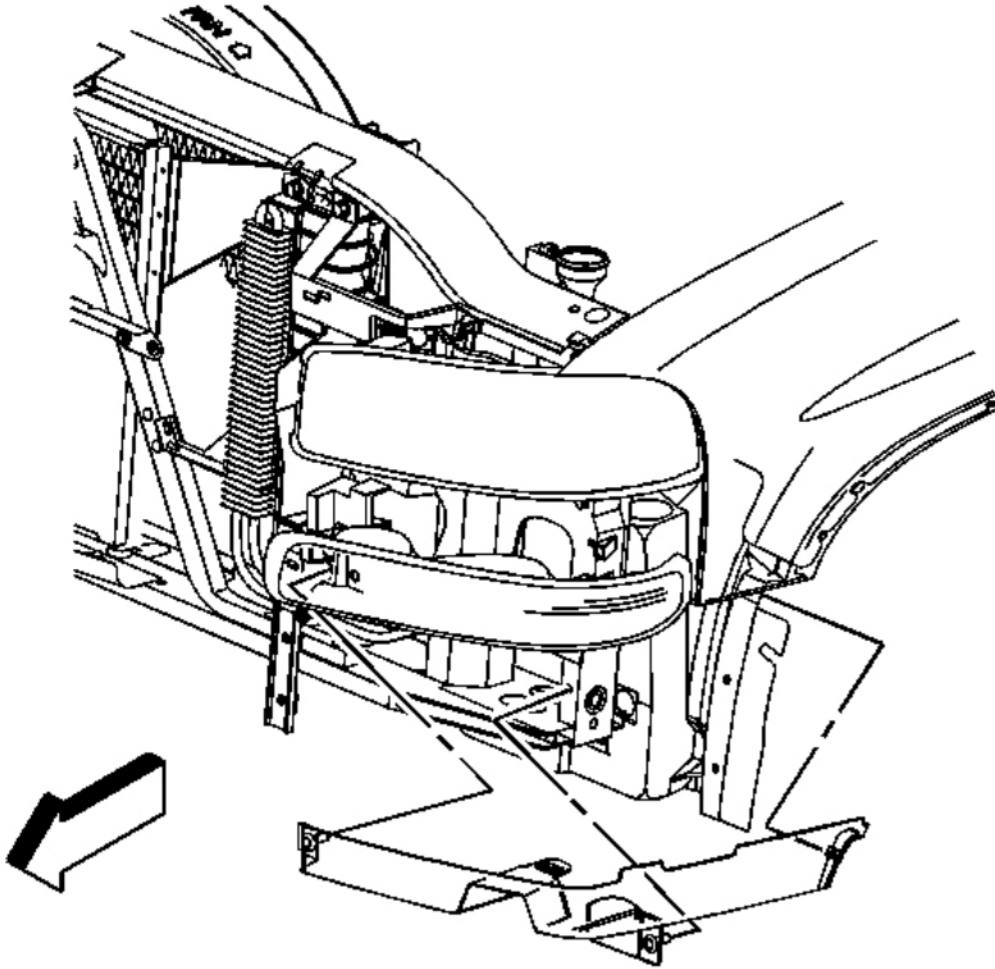


Fig. 25: Removing Front Side Bumper Filler (Old Style)
Courtesy of GENERAL MOTORS CORP.

Installation Procedure

1. Install the bumper filler from the vehicle.

NOTE: Refer to Fastener Notice in Cautions and Notices.

2. Install the fasteners securing the filler panel to the headlamp bracket and the radiator support.

Tighten: Tighten the filler panel to the headlamp bracket and the radiator support to 9 N.m (80 lb in).

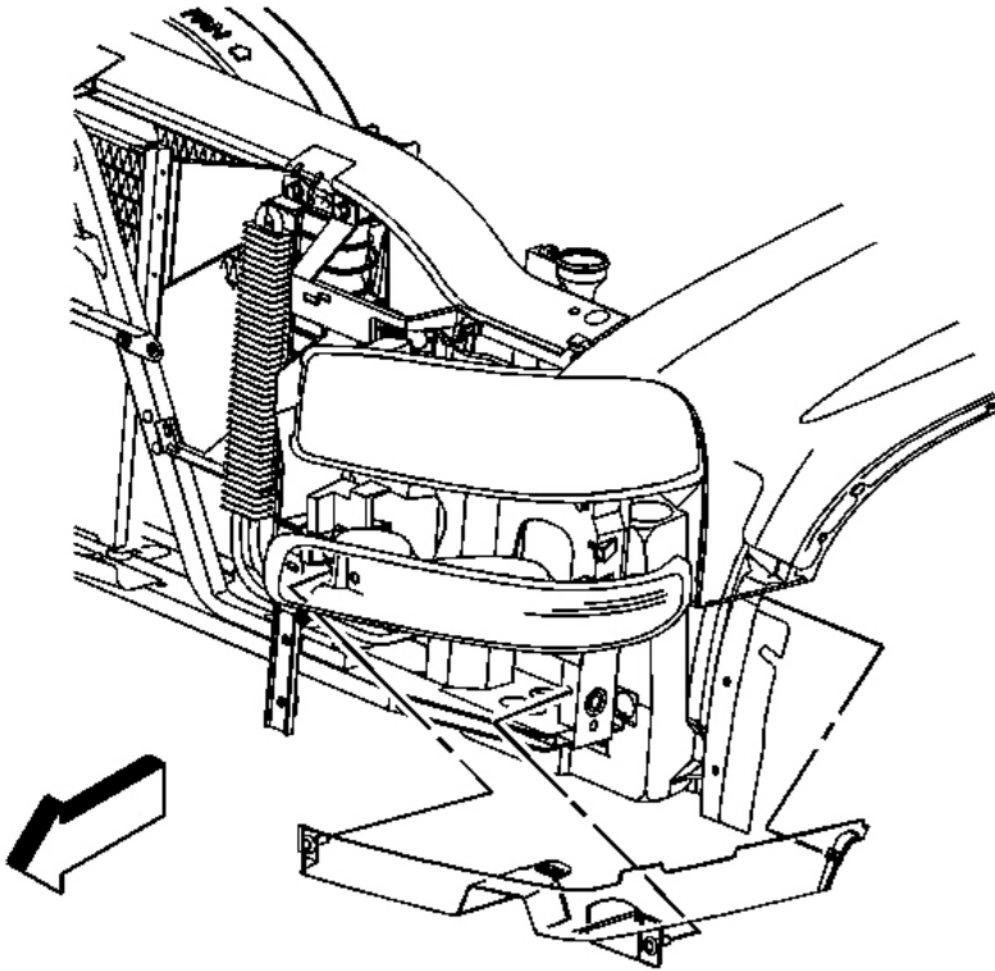


Fig. 26: Installing Front Side Bumper Filler (Old Style)
Courtesy of GENERAL MOTORS CORP.

3. Install the fog lamps, if equipped. Refer to **Fog Lamp Replacement - Front** in Lighting Systems.
4. Install the air deflector to the bumper if necessary. Refer to **Air Deflector Replacement - Front Bumper Fascia**.
5. Position the front bumper assembly on the vehicle.

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

IMPORTANT: Tighten the bolts in the following sequence.

6. Install the retaining bolts (1, 2) to the front bumper.

Tighten:

1. Tighten the bracket bolt (1) to 85 N.m (63 lb ft).
2. Tighten the bracket bolt (2) to 85 N.m (63 lb ft).
3. Tighten the brace bolt to 55 N.m (41 lb ft).

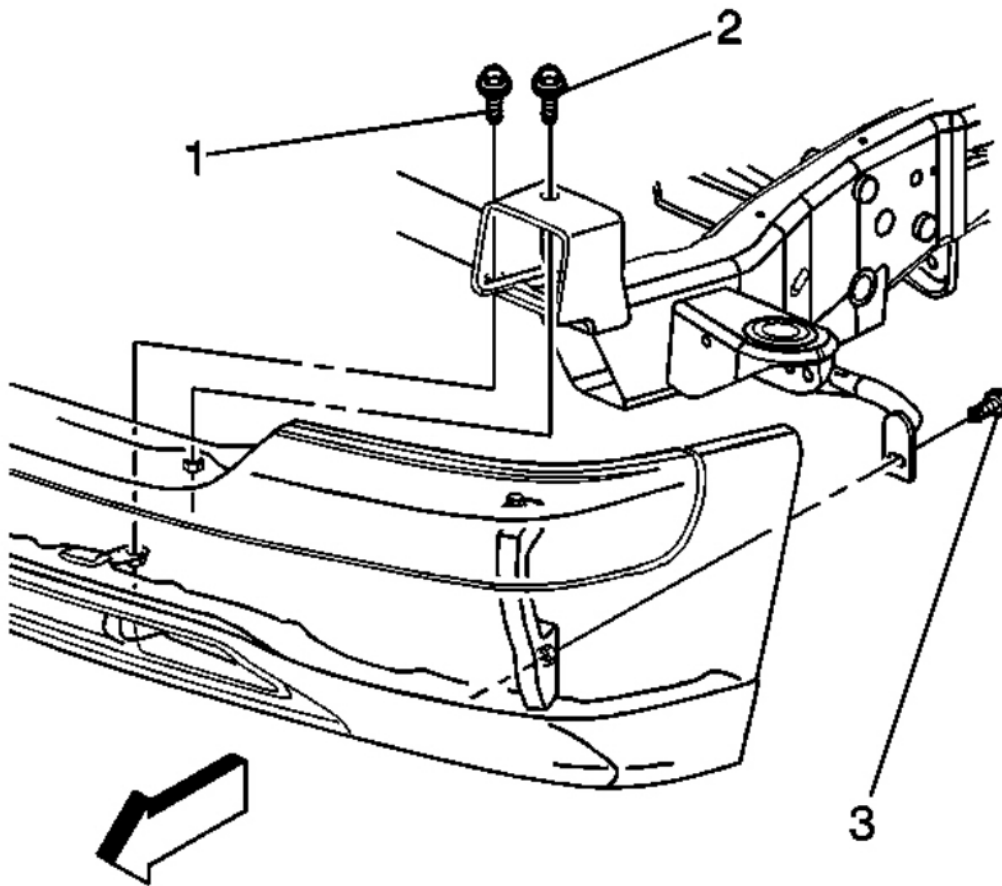


Fig. 27: Installing Front Bumper Retaining Bolts (Old Style)
Courtesy of GENERAL MOTORS CORP.

7. Connect the electrical connector to the fog lamps, if equipped.

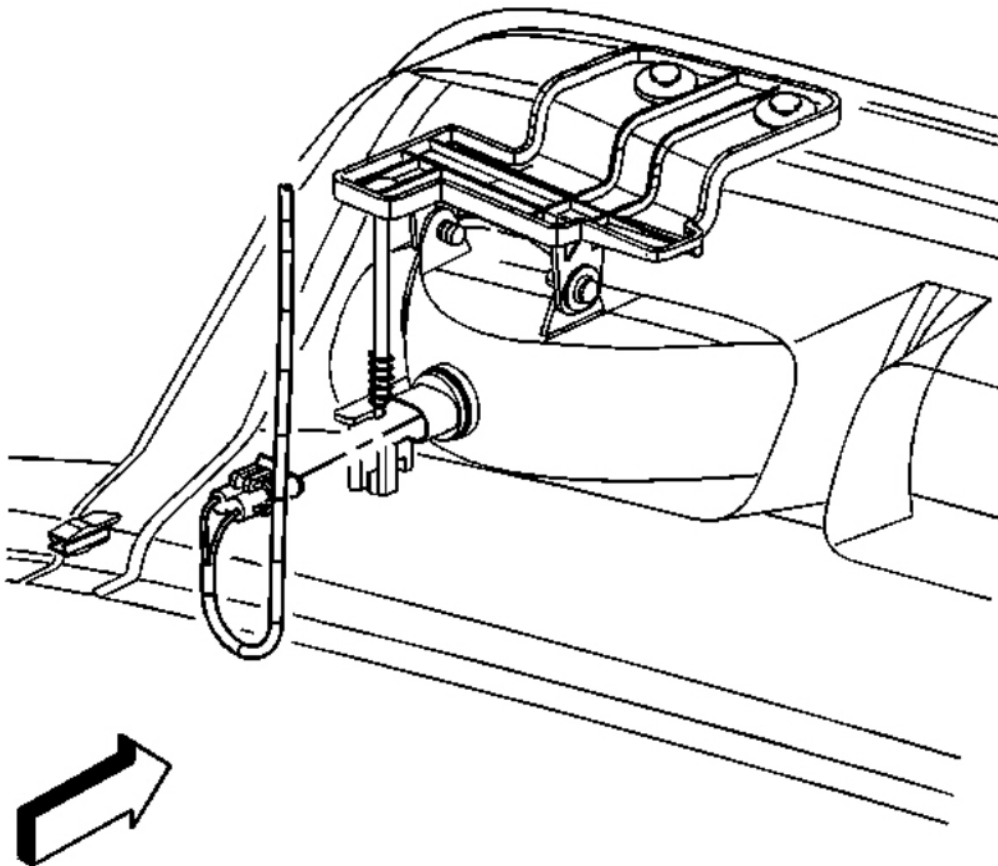


Fig. 28: Connecting Electrical Connector To Fog Lamps
Courtesy of GENERAL MOTORS CORP.

8. Install the front grille. Refer to **Grille Replacement (Cadillac)** or **Grille Replacement (Avalanche)** or **Grille Replacement (Chevrolet)** or **Grille Replacement (GMC)** in Exterior Trim.

BRACKET REPLACEMENT - FRONT BUMPER (2500)

1. Remove all related panels and components.
2. Remove the damaged bumper bracket.
3. Visually inspect the frame and restore all damage to factory specifications using 3-dimensional measuring.

IMPORTANT: If the vehicle is equipped with tow hooks, discard original fasteners.

2004 Cadillac Escalade

2004 ACCESSORIES & EQUIPMENT Bumpers - C/K SUV

4. Align the replacement bracket lower bolt holes with tow hook mounting locations and install the bolts (1) supplied.

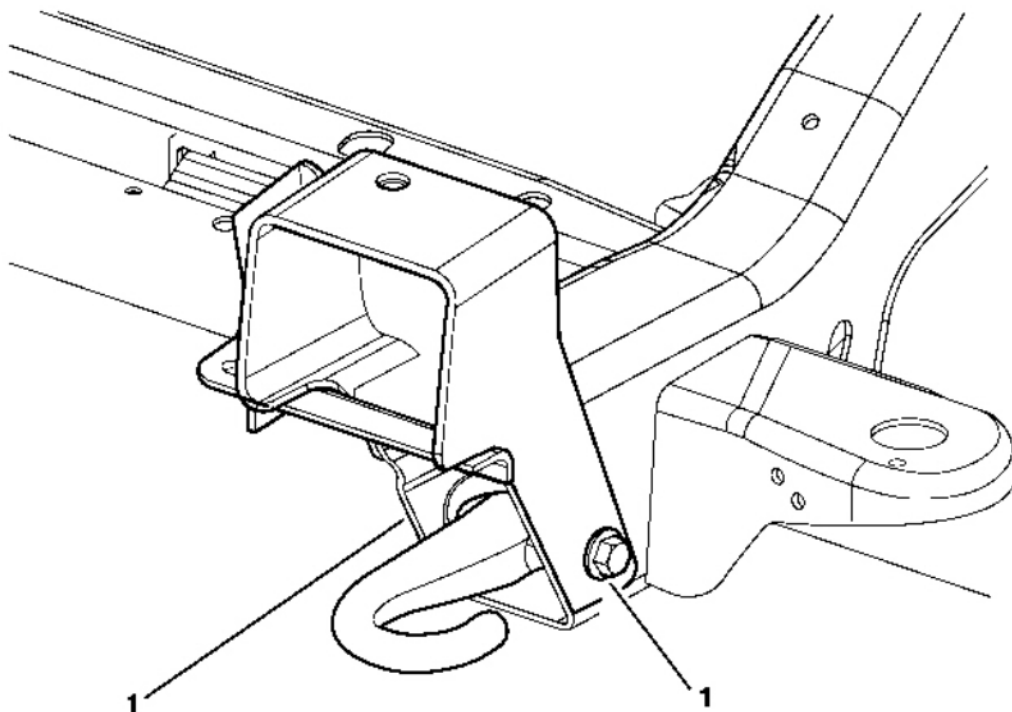


Fig. 29: Aligning Replacement Bracket Lower Bolt Holes & Installing Bolts (2500)
Courtesy of GENERAL MOTORS CORP.

5. Align the front edge of bracket with front edge of frame and mark upper bolt locations (1) on frame.

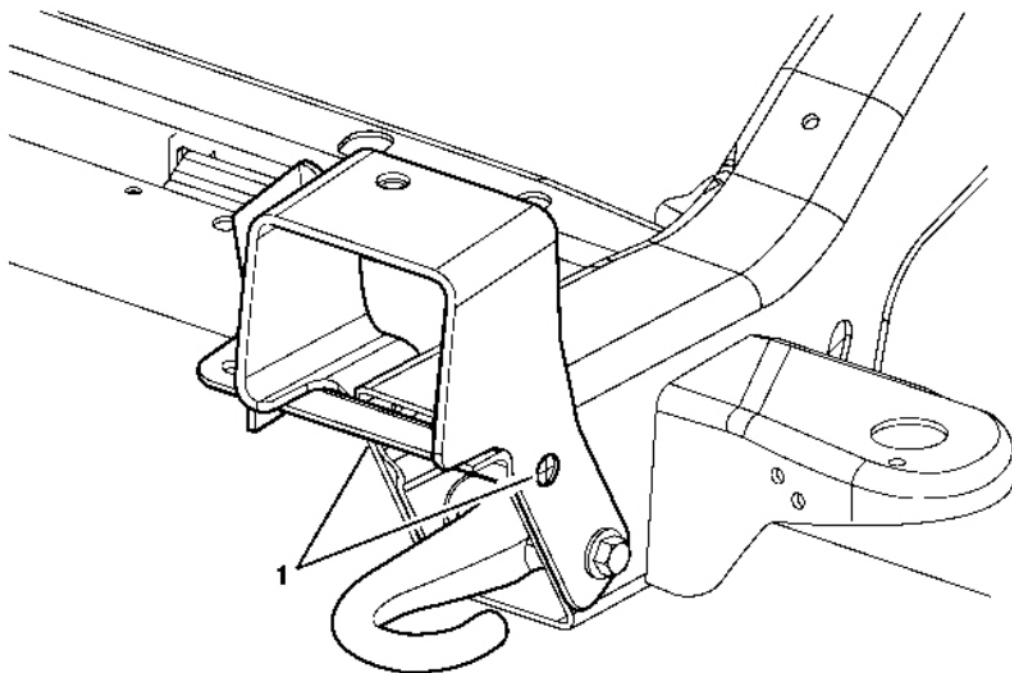


Fig. 30: Aligning Front Edge Of Bracket & Marking Upper Bolt Locations On Frame (2500)
Courtesy of GENERAL MOTORS CORP.

6. Rotate the bracket forward and drill 13 mm (1/2 in) holes in frame at upper bolt locations.
7. Rotate the bracket back into position.

2004 Cadillac Escalade

2004 ACCESSORIES & EQUIPMENT Bumpers - C/K SUV

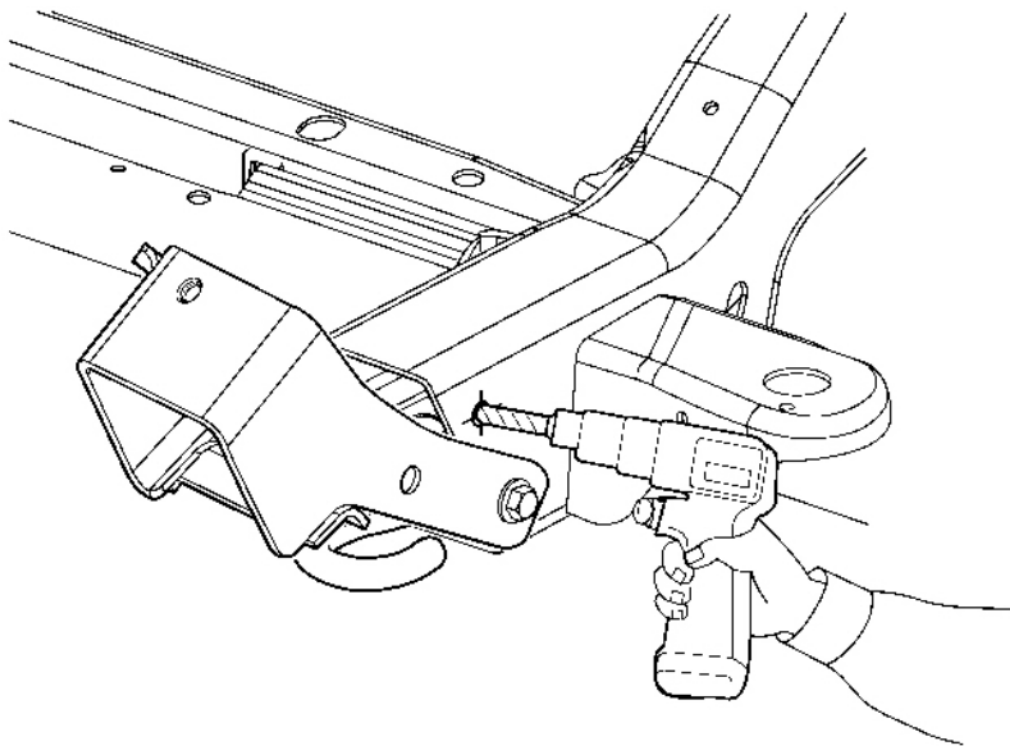


Fig. 31: Drilling Holes In Frame At Upper Bolt Locations (2500)

Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to Fastener Notice in Cautions and Notices.

8. Install the fasteners supplied.

Tighten: Tighten the torque bracket fasteners to 70 N.m (52 lb ft).

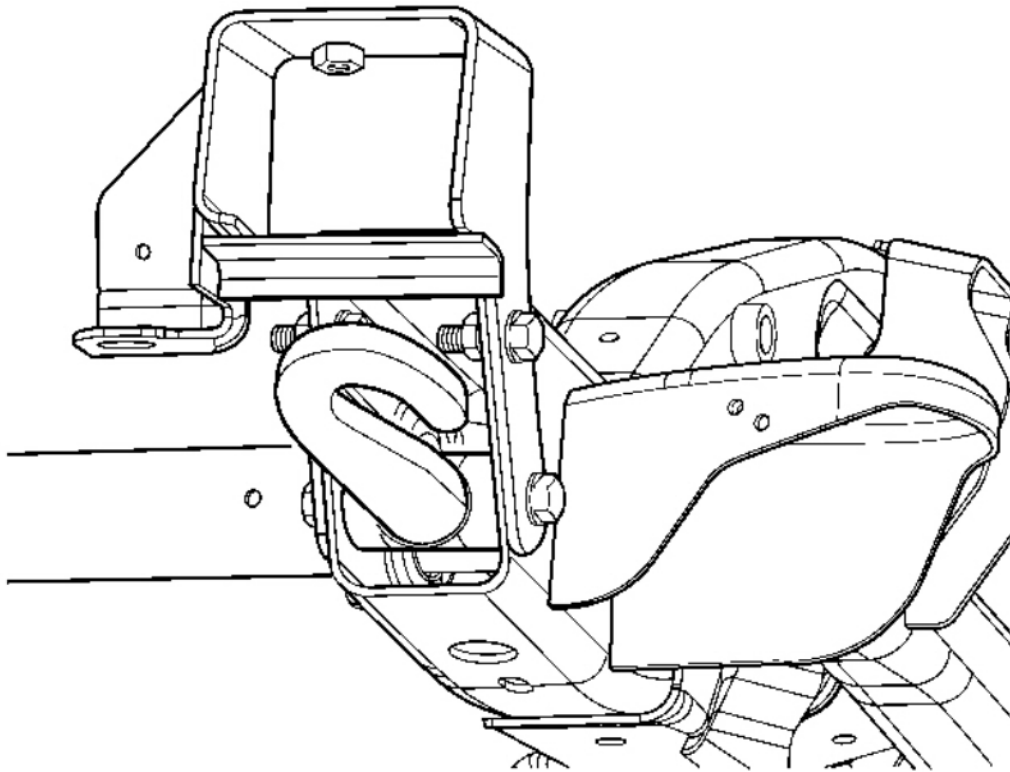


Fig. 32: Installing Torque Bracket Fasteners (2500)
Courtesy of GENERAL MOTORS CORP.

BRACKET REPLACEMENT - FRONT BUMPER (1500)

1. Remove all related panels and components.
2. Remove damaged bumper bracket.

IMPORTANT: Do not remove any material from end of frame rail.

3. Position the service template on the end of the frame rail. Use 3M's Repositionable Adhesive or equivalent.
4. Drill three 13 mm (1/2 in) holes at locations indicated on template.

IMPORTANT: Prior to refinishing, refer to the Publication GM 4901M-D-2000 "GM Approved Refinish Materials" for recommended products. Do not combine paint systems. Refer to paint manufacturer's recommendations.

2004 Cadillac Escalade

2004 ACCESSORIES & EQUIPMENT Bumpers - C/K SUV

5. Apply approved anti-corrosion primer to bare metal surfaces.
6. Position replacement bumper bracket.

NOTE: Refer to Fastener Notice in Cautions and Notices.

7. Install the bolts.

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

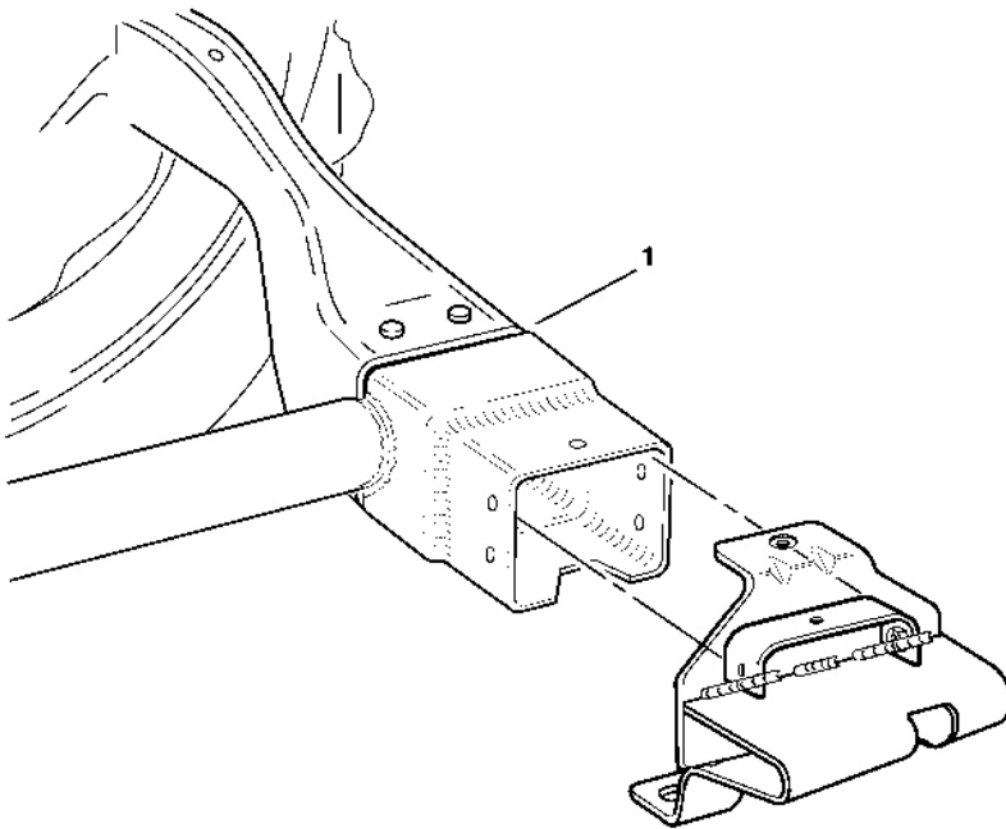


Fig. 33: Replacing Front Bumper Bracket (1500)
Courtesy of GENERAL MOTORS CORP.

BRACE REPLACEMENT - FRONT BUMPER (AVALANCHE)

Removal Procedure

1. Remove the brace bolt (2) from the front bumper fascia.
2. Remove the brace bolt (3) from the outboard mounting brace plate.
3. Remove the brace (1) from the vehicle.

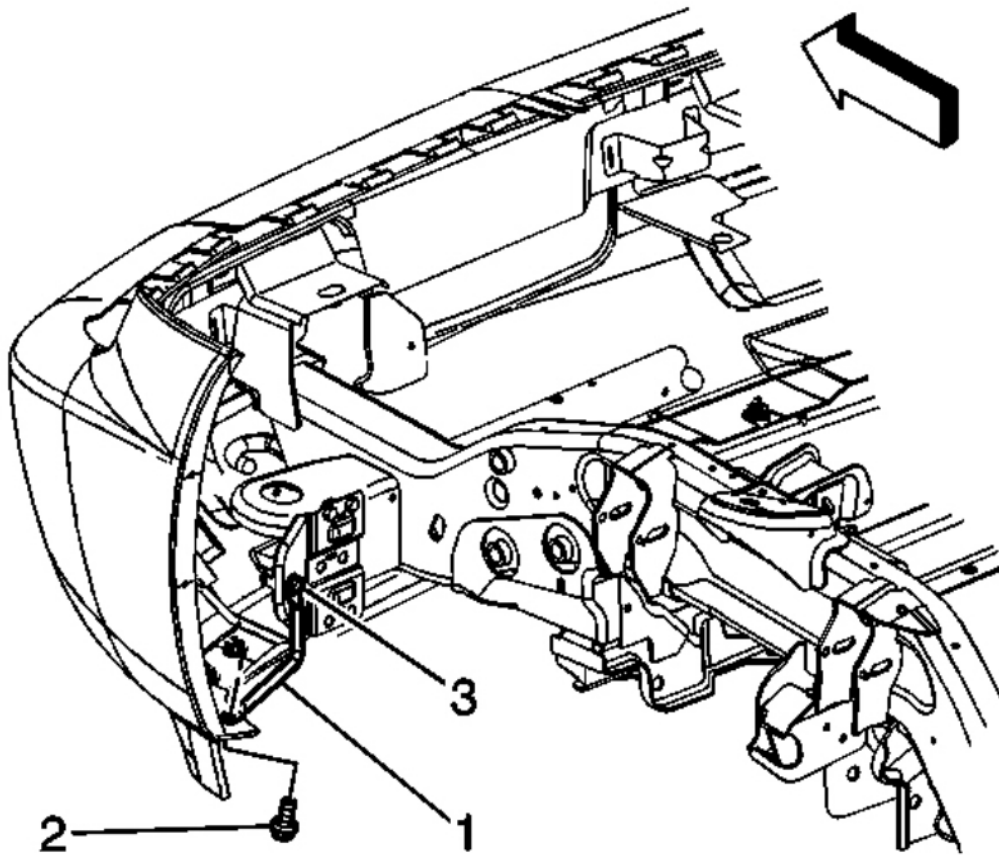


Fig. 34: Removing Front Bumper Brace (Avalanche)
Courtesy of GENERAL MOTORS CORP.

Installation Procedure

1. Install the brace (1) to the vehicle.

NOTE: Refer to Fastener Notice in Cautions and Notices.

2. Install the 2 bolts that retain the brace to the fascia and the outboard brace plate.

Tighten:

- Tighten the front bumper fascia brace bolt (2) to 15 N.m (11 lb ft).
- Tighten the front bumper outboard brace plate bolt (3) to 9 N.m (80 lb in).

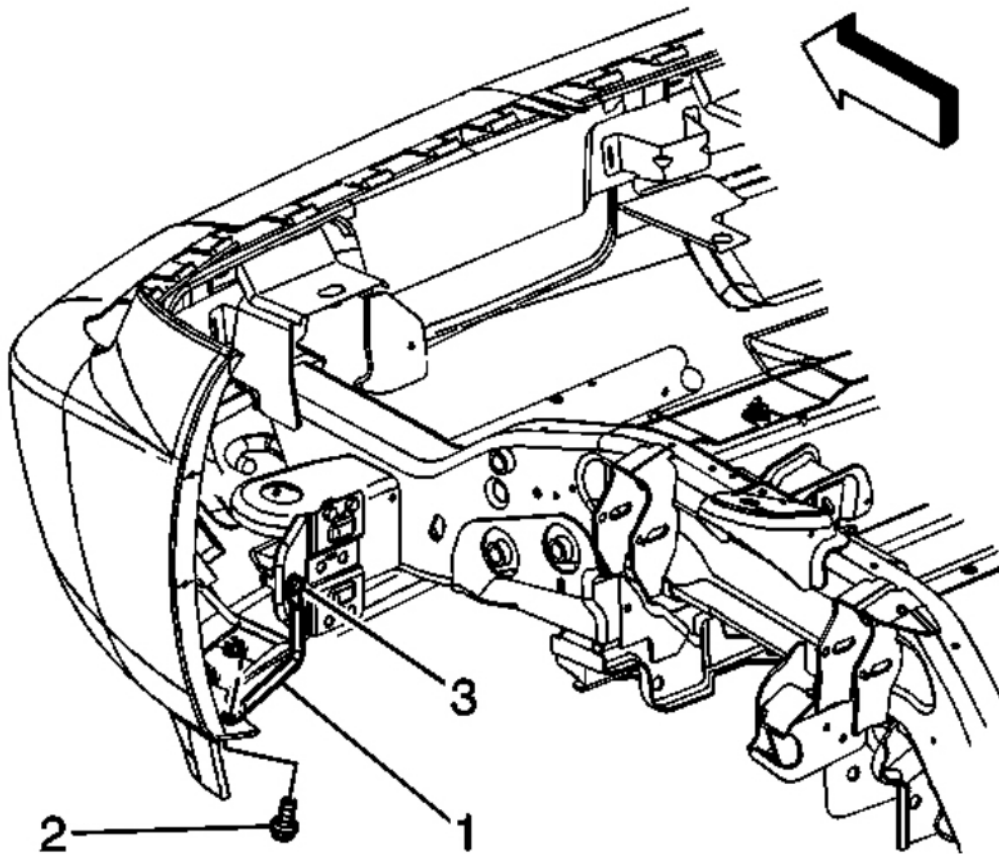


Fig. 35: Installing Front Bumper Brace (Avalanche)
Courtesy of GENERAL MOTORS CORP.

FASCIA REPLACEMENT - REAR BUMPER

Removal Procedure

1. Remove the top fascia retainers.
2. Disconnect the license plate lamp harness.
3. Raise and support the vehicle with suitable safety stands. Refer to **Lifting and Jacking the Vehicle** in General Information.

4. Remove the push-pin retainers from the underside of the fascia.
5. Remove the fascia from the impact bar.

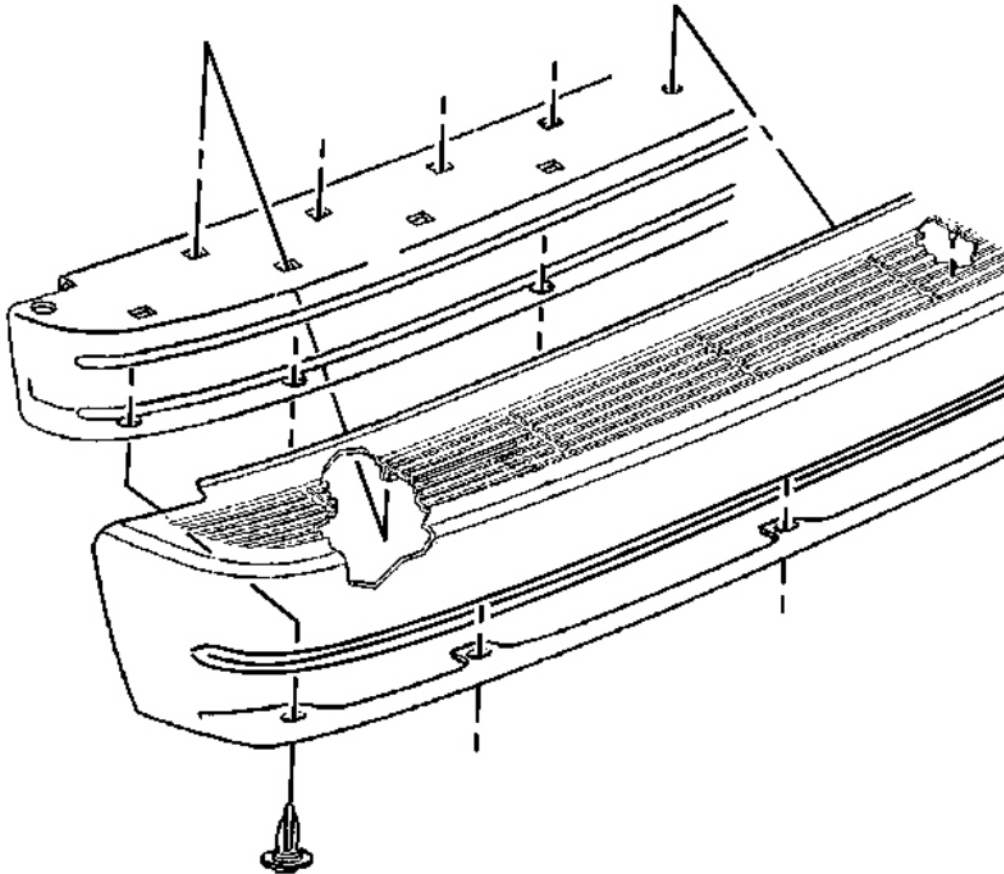


Fig. 36: Removing Rear Bumper Fascia
Courtesy of GENERAL MOTORS CORP.

Installation Procedure

1. Align the locator pin of the fascia to the hole in the impact bar.
2. Press the push-pin retainers into the underside of the fascia.
3. Remove the safety stands, and lower the vehicle.
4. Connect the license plate lamp harness.
5. Install the top fascia retainers.

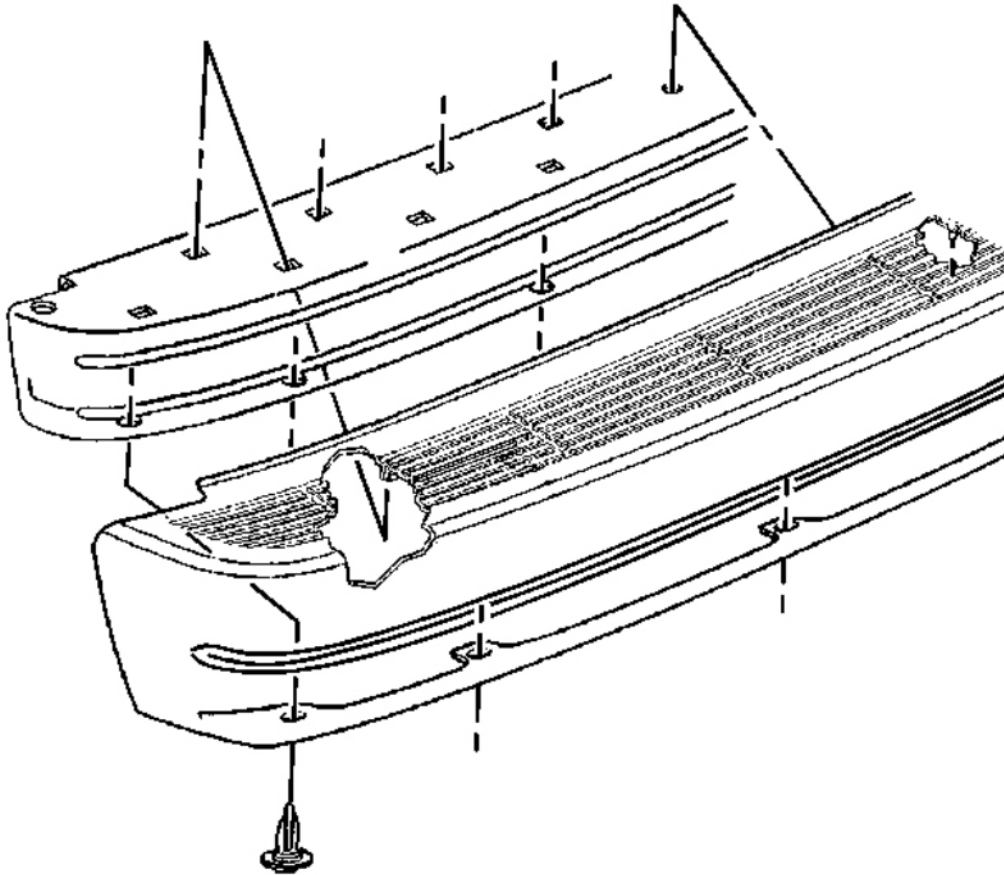


Fig. 37: Installing Rear Bumper Fascia
Courtesy of GENERAL MOTORS CORP.

STEP PAD REPLACEMENT - REAR BUMPER

Removal Procedure

1. Remove the bumper. Refer to **Bumper Replacement - Rear**.
2. Remove the side molding push-pins.
3. Release the step pad from the bumper by prying up on the step pad.
4. Remove the step pad.

2004 Cadillac Escalade

2004 ACCESSORIES & EQUIPMENT Bumpers - C/K SUV

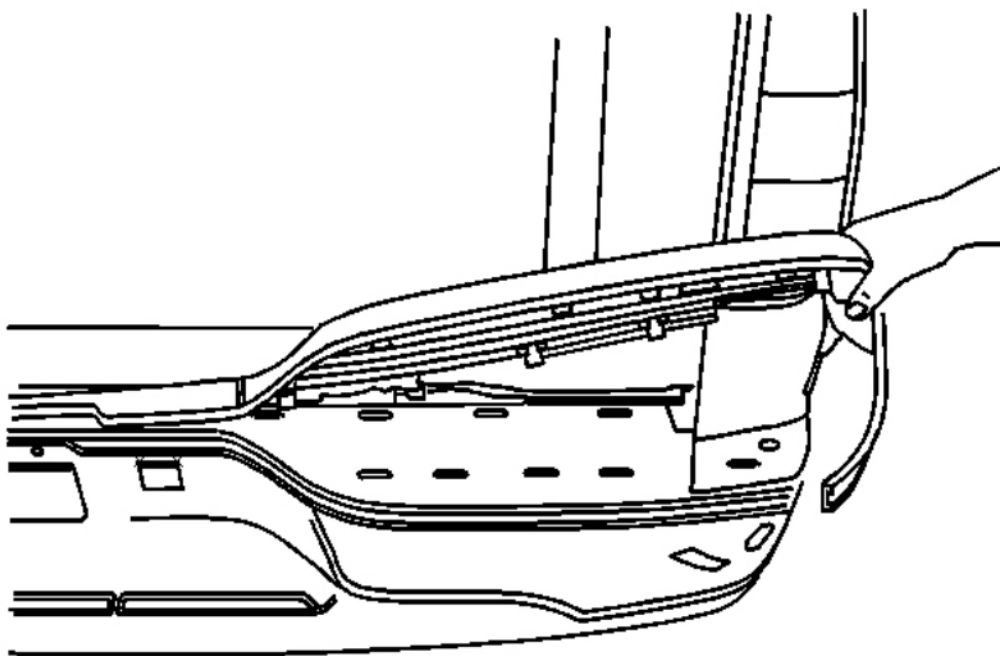


Fig. 38: Removing Rear Bumper Step Pad
Courtesy of GENERAL MOTORS CORP.

Installation Procedure

1. Install the step pad to the bumper by pushing down on the clips.
2. Insert the side molding push-pins.

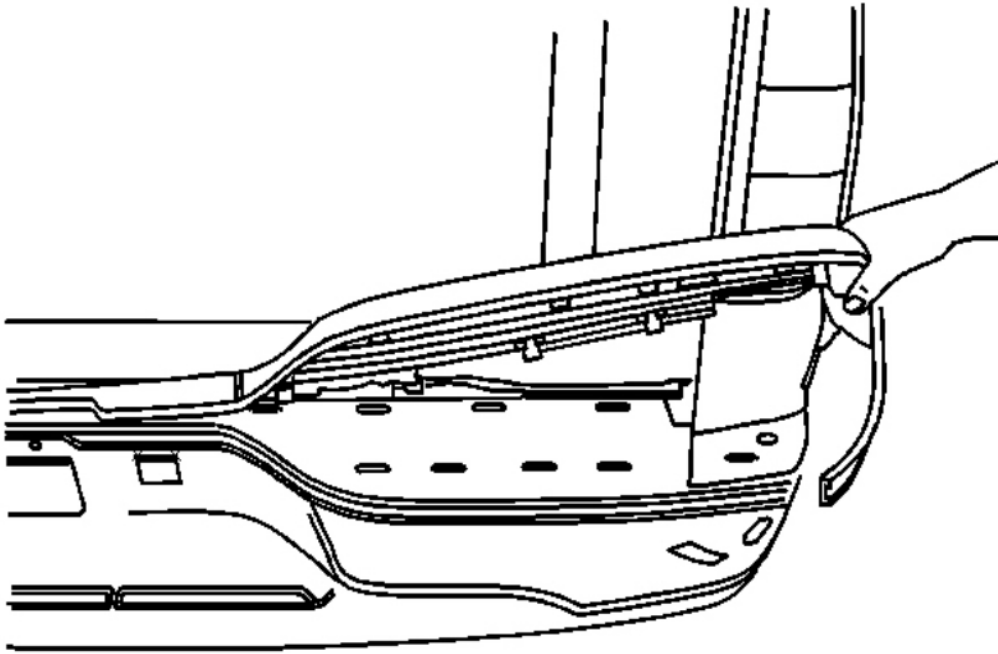


Fig. 39: Installing Rear Bumper Step Pad
Courtesy of GENERAL MOTORS CORP.

3. Install the bumper. Refer to **Bumper Replacement - Rear**.

STEP PAD REPLACEMENT - TOP REAR BUMPER

Removal Procedure

1. Using a trim removal tool or suitable replacement, gently pry upward on the top step pad to release the retainers.
2. Lift up on the step pad and remove from the vehicle.

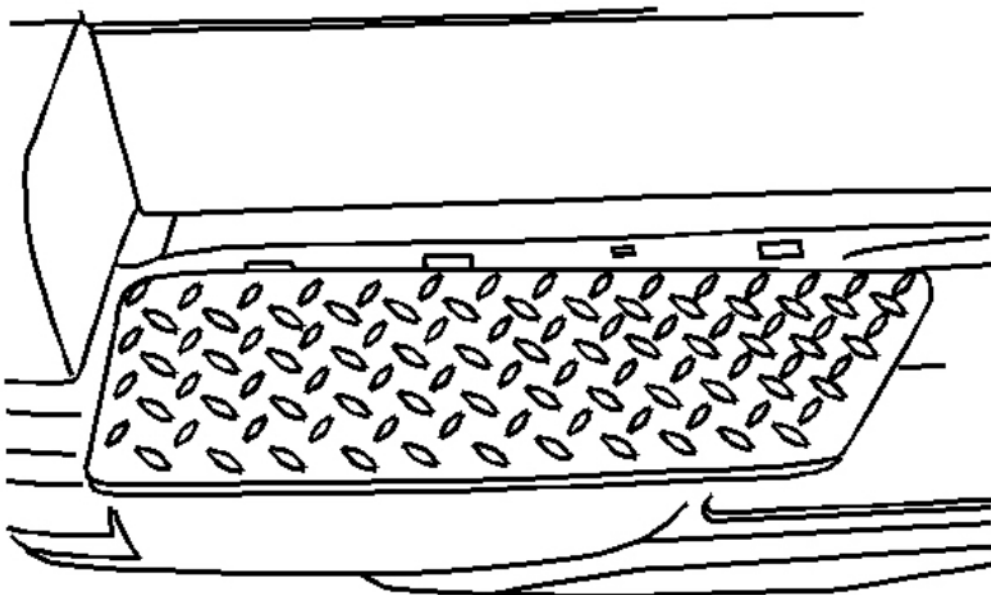


Fig. 40: Removing Top Rear Bumper Step Pad
Courtesy of GENERAL MOTORS CORP.

Installation Procedure

1. Align the top step pad with the holes in the bumper.
2. Push firmly downward to fully seat the step pad retainers into the bumper.

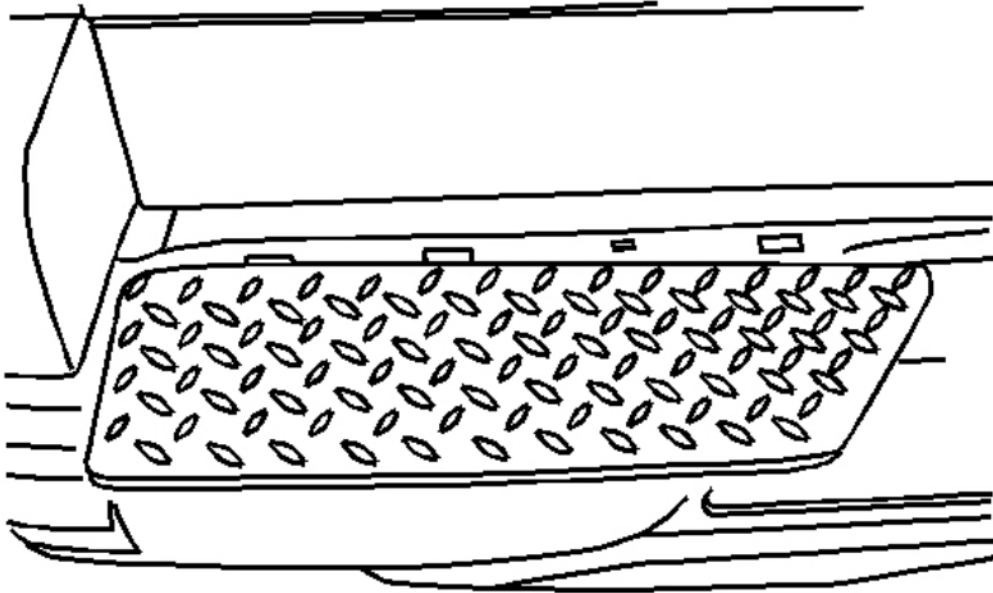


Fig. 41: Installing Top Rear Bumper Step Pad
Courtesy of GENERAL MOTORS CORP.

STEP PAD REPLACEMENT - CENTER REAR BUMPER

Removal Procedure

1. Using a trim removal tool or suitable replacement, gently pry upward on the center step pad to release the retainers from the bumper.
2. Lift up on the step pad and remove from the vehicle.

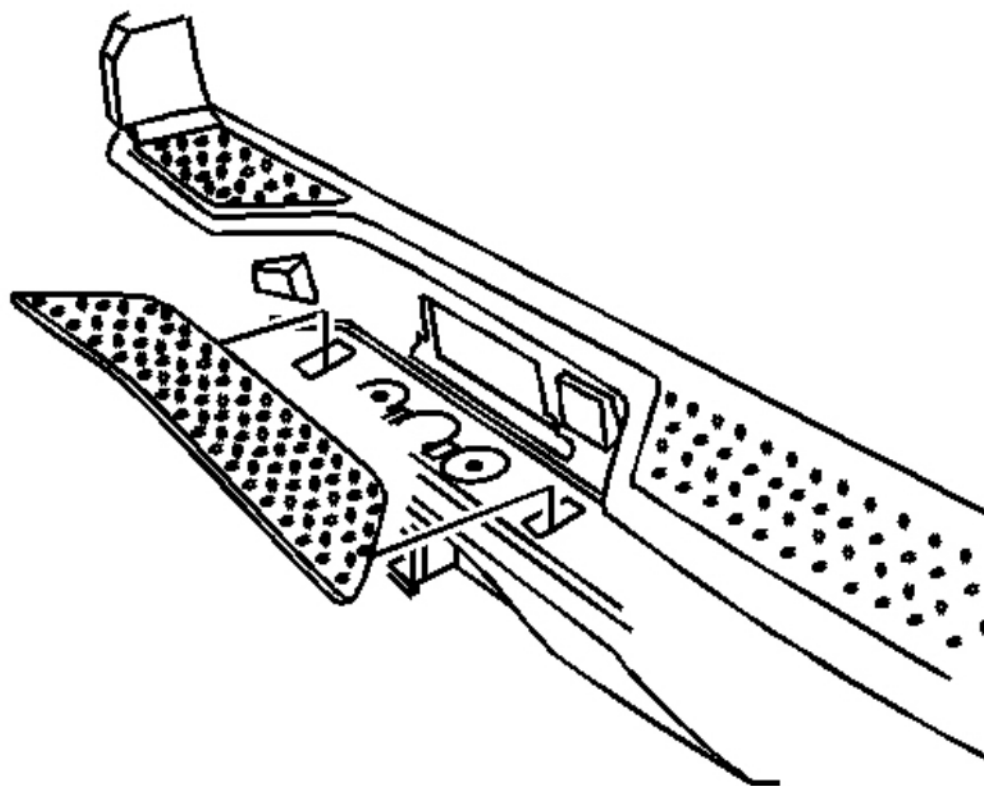


Fig. 42: Removing Center Rear Bumper Step Pad
Courtesy of GENERAL MOTORS CORP.

Installation Procedure

1. Align the center step pad with the holes in the bumper.
2. Push firmly downward to fully seat the step pad retainers into the bumper.

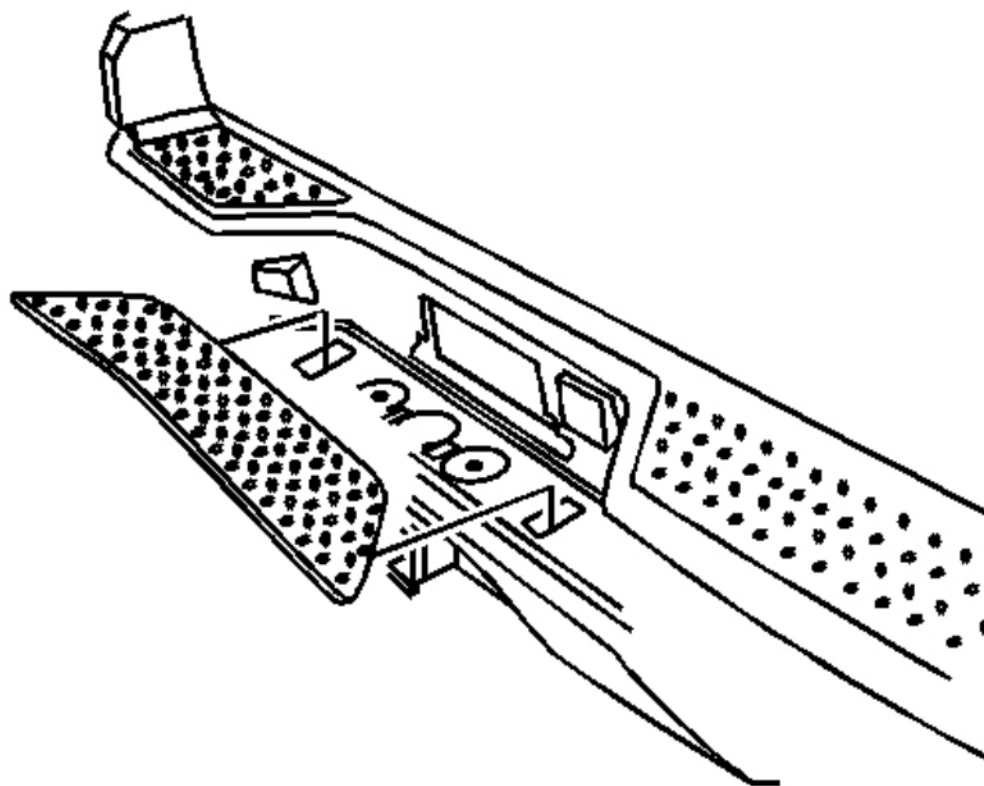


Fig. 43: Installing Center Rear Bumper Step Pad
Courtesy of GENERAL MOTORS CORP.

STEP PAD REPLACEMENT - SIDE REAR BUMPER

Removal Procedure

1. Using a trim removal tool or suitable replacement, gently pry upward to release the retainers.
2. Lift up on the step pad and remove from the vehicle.

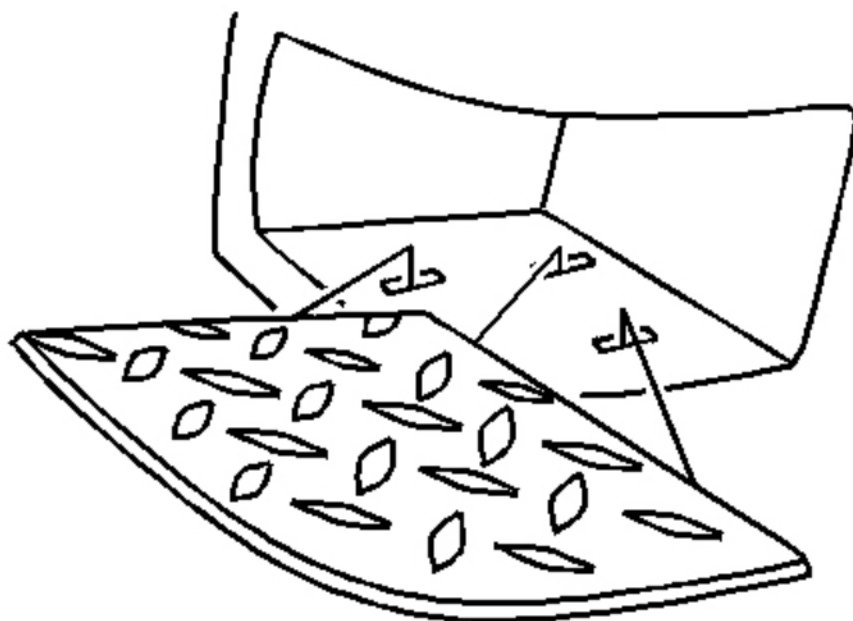


Fig. 44: Removing Side Rear Bumper Step Pad
Courtesy of GENERAL MOTORS CORP.

Installation Procedure

1. Insert the side step pad into the opening on the bumper.
2. Push firmly downward to fully seat the step pad retainers into the bumper.

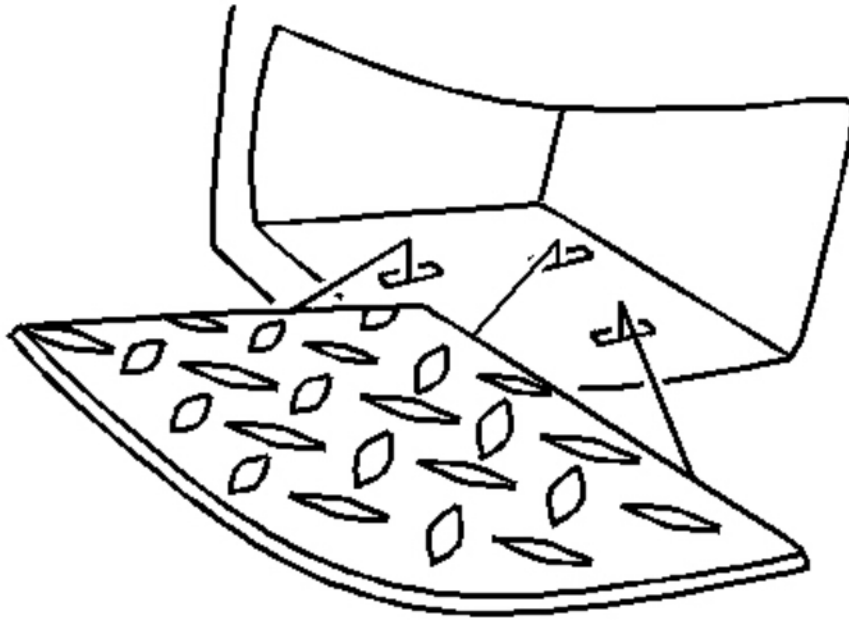


Fig. 45: Installing Side Rear Bumper Step Pad
Courtesy of GENERAL MOTORS CORP.

BUMPER REPLACEMENT - REAR

Removal Procedure

1. Disconnect the license plate lamp harness.

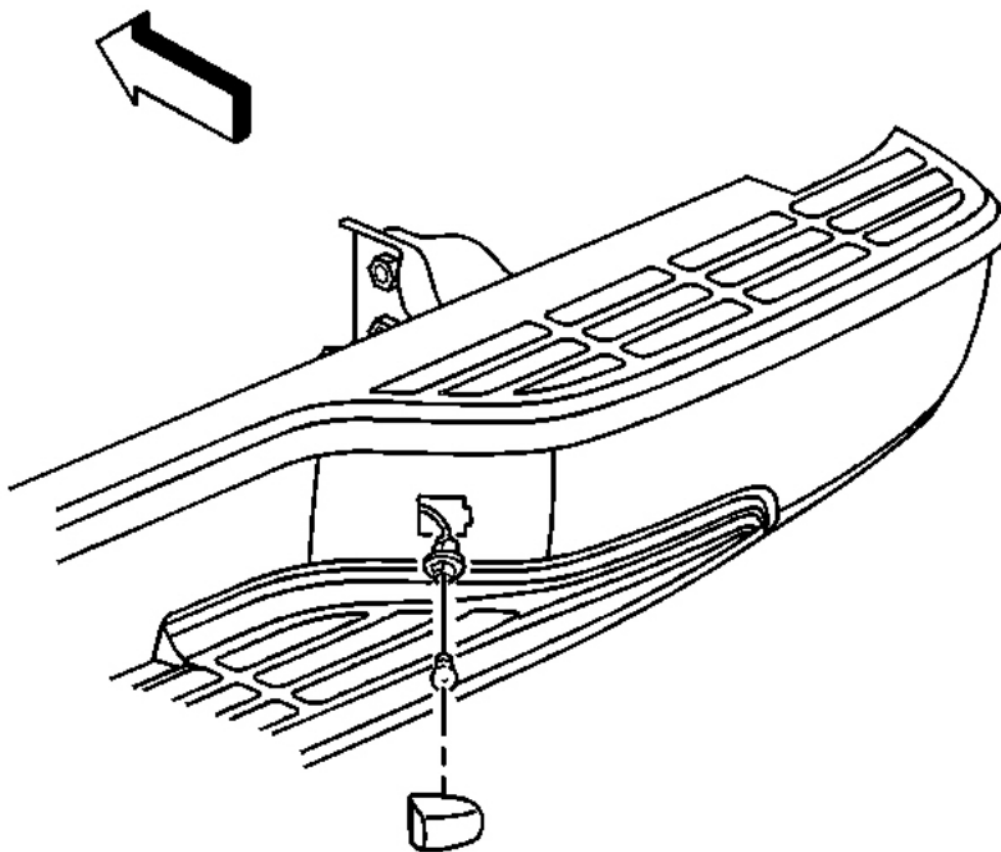


Fig. 46: Disconnecting License Plate Lamp Harness
Courtesy of GENERAL MOTORS CORP.

2. Remove the impact bar nut (1).
3. Remove the plate nuts (2).
4. Remove the lower frame rail to bracket bolt (3).
5. Remove the side frame rail to bracket bolt (4).

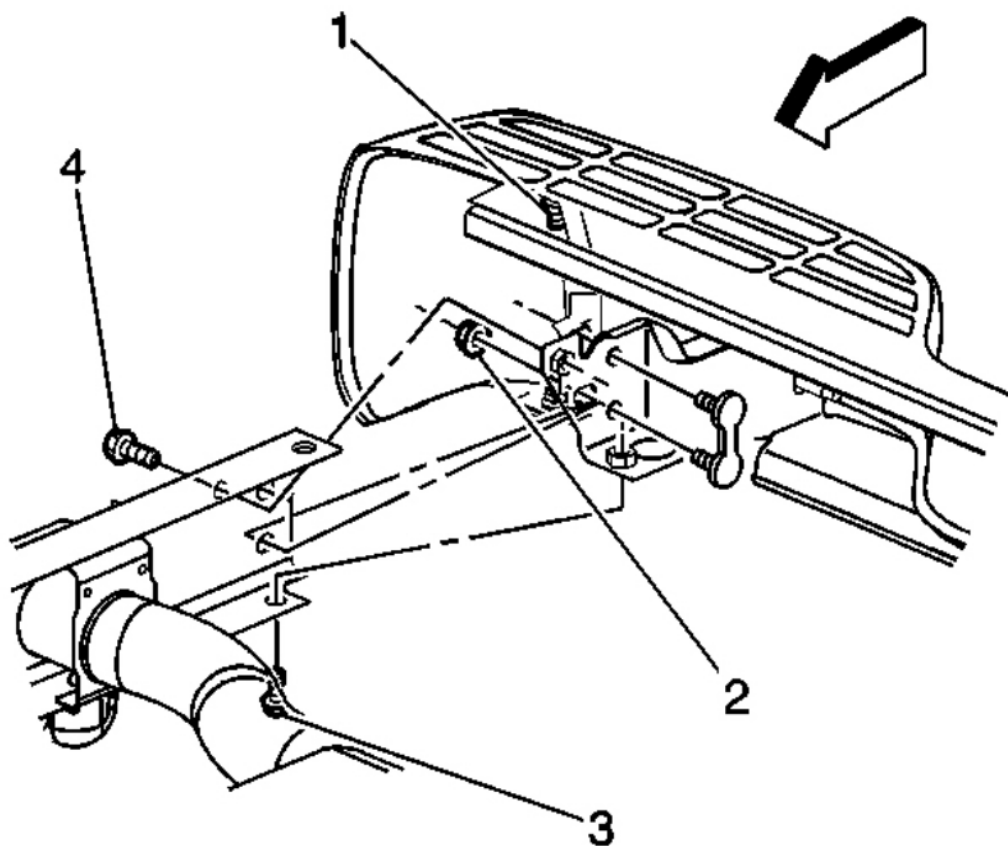


Fig. 47: Removing Impact Bar Nut, Plate Nuts & Frame Rail Bolts
Courtesy of GENERAL MOTORS CORP.

6. Remove the rear trailer hitch to bumper bolts (1), if equipped.
7. Remove the rear bumper from the vehicle.

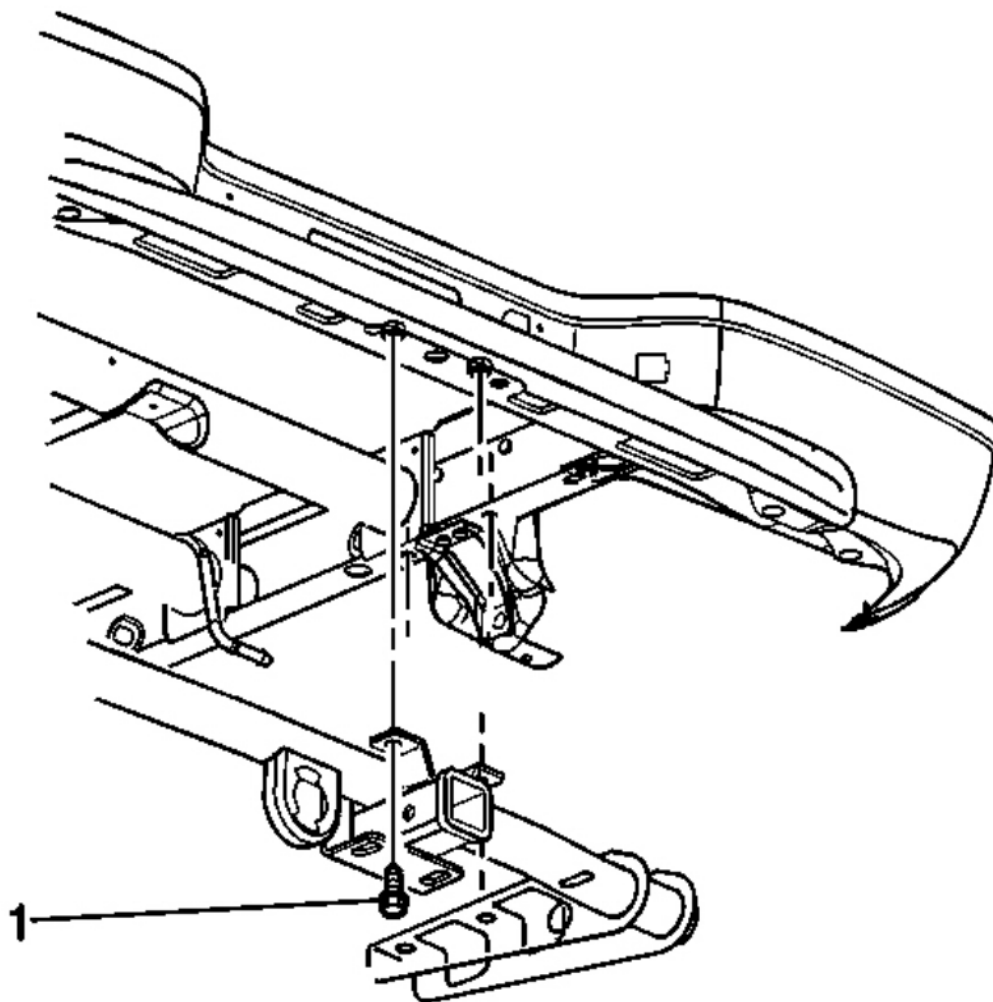


Fig. 48: Removing Rear Trailer Hitch To Bumper Bolts
Courtesy of GENERAL MOTORS CORP.

Installation Procedure

1. Position the rear bumper onto the vehicle.
2. Install the rear trailer hitch to bumper bolts (1), if equipped.

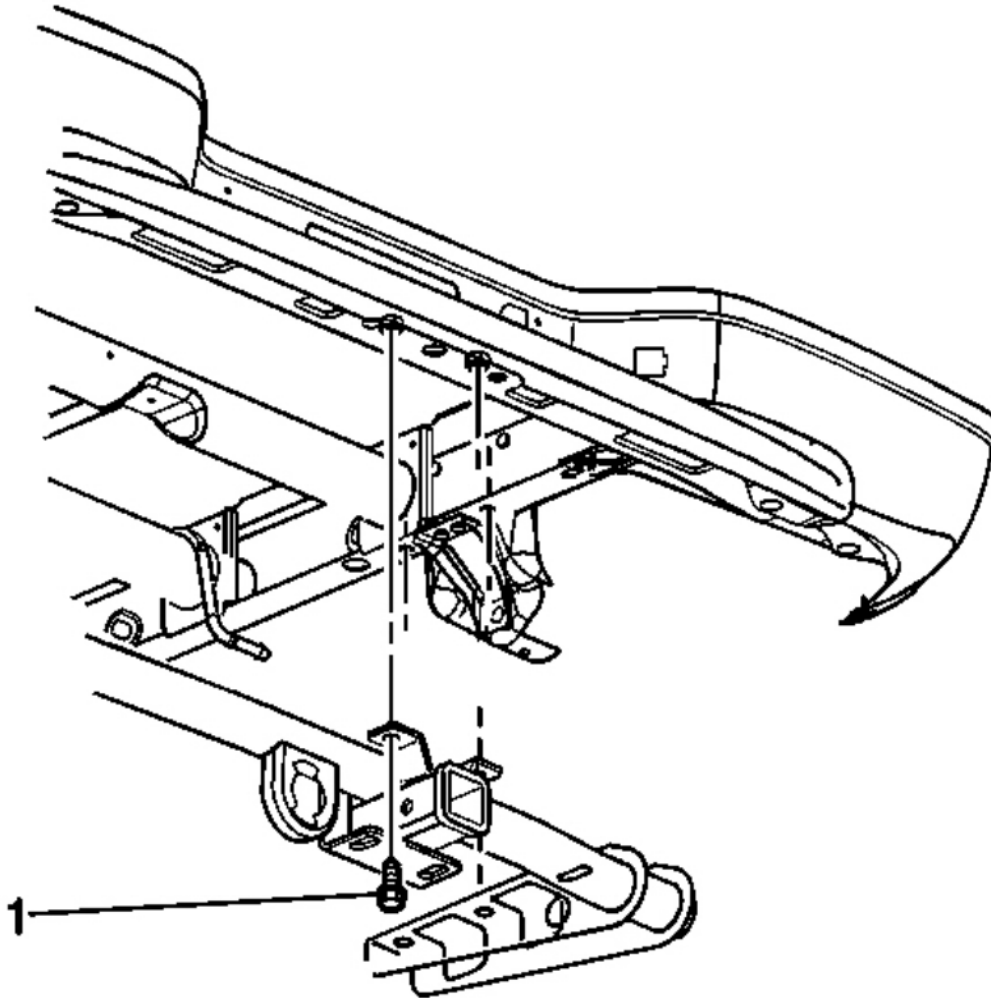


Fig. 49: Installing Rear Trailer Hitch To Bumper Bolts
Courtesy of GENERAL MOTORS CORP.

NOTE: Refer to Fastener Notice in Cautions and Notices.

3. Install the impact bar nut (1).

Tighten: Tighten the impact bar nut (1) to 50 N.m (37 lb ft).

4. Install the plate nuts (2).

Tighten: Tighten the plate nuts (2) to 90 N.m (66 lb ft).

5. Install the lower frame rail to bracket bolt (3).

Tighten: Tighten the lower frame rail to bracket bolt (3) to 100 N.m (74 lb ft).

6. Install the side frame rail to bracket bolt (4).

Tighten: Tighten the side frame rail to bracket bolt (4) to 40 N.m (30 lb ft).

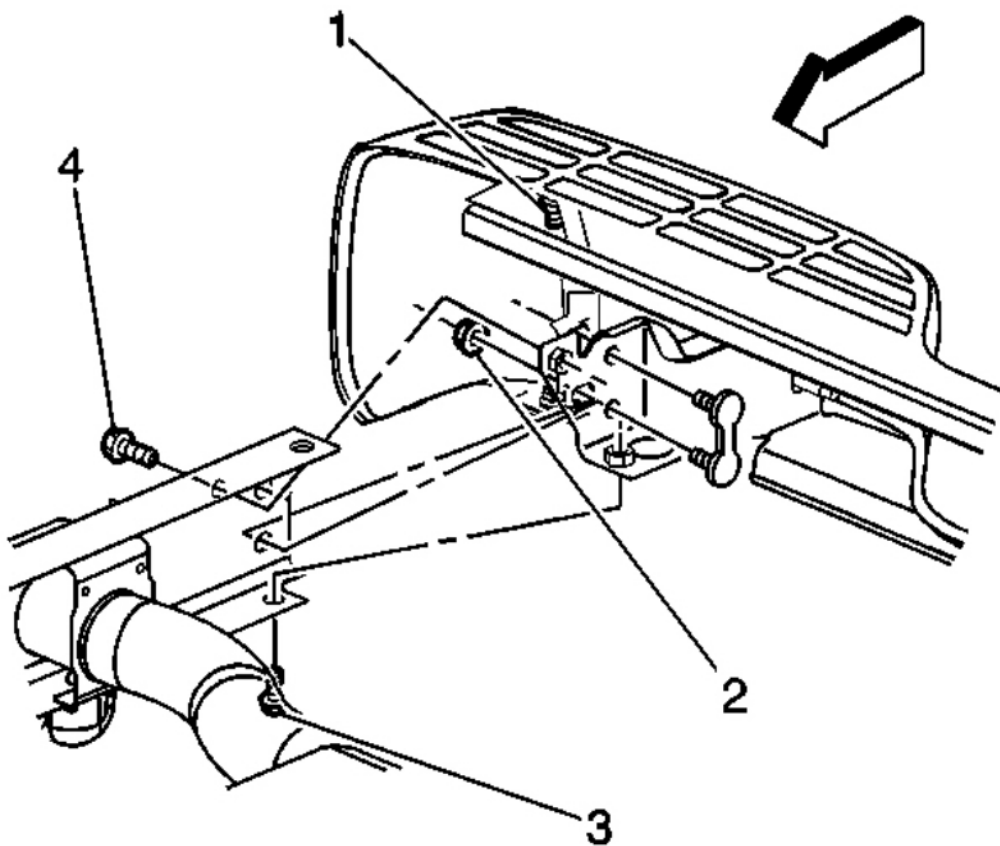


Fig. 50: Installing Impact Bar Nut, Plate Nuts & Frame Rail Bolts
Courtesy of GENERAL MOTORS CORP.

7. Install the bumper step pad. Refer to **Step Pad Replacement - Rear Bumper**.
8. Install the license plate lamp harness.

2004 Cadillac Escalade

2004 ACCESSORIES & EQUIPMENT Bumpers - C/K SUV

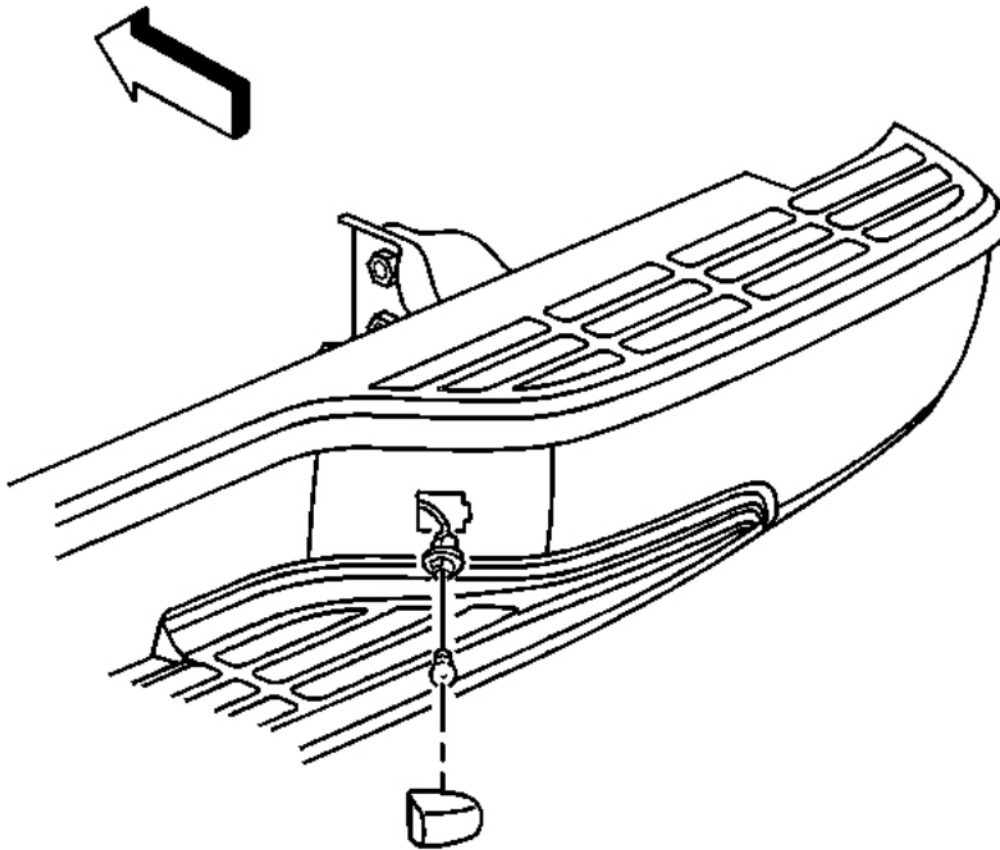


Fig. 51: Installing License Plate Lamp Harness
Courtesy of GENERAL MOTORS CORP.