

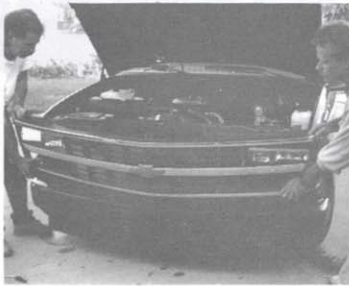
1988 And Later Chevrolet Aluminum Grille Instructions

For installation of billet grilles that require cutting of the stock shell, proper tools, knowledge and skill are needed. Carriage Works is not responsible for care & accuracy of the installation, only for Fit & Finish of its products. Use a qualified installer or contact original vendor for references to complete all instructions.



TOOLS REQUIRED:

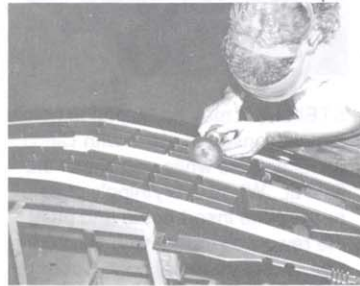
- Phillips screwdriver
- Masking tape
- Cutting disk or saw
- Grinder
- Sandpaper
- Files
- Drill
- 1/8" Drill bit



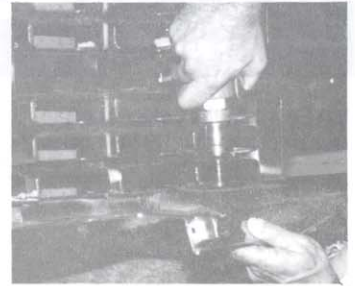
STEP 1 Remove the grille. There are four screws across the top under the hood, one at the bottom center and one behind each parking lens.



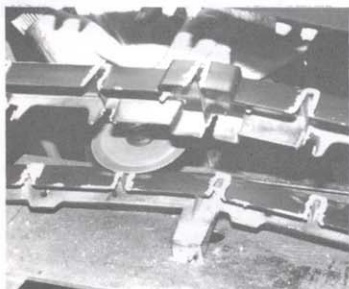
STEP 2 Cover the top, center and lower bars with masking tape to protect the chrome finish. Remove the lower valence.



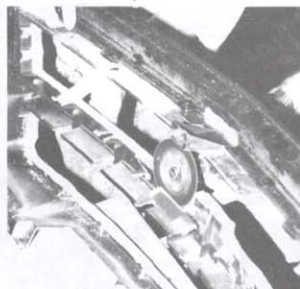
STEP 3 Cut the "egg crate" sections out of the grille. A cutting disc on an air-powered tool or electric drill works best, but a hack saw or saber saw will also do the trick. Be careful not to cut into the horizontal bars; the cuts will be dressed down cleanly later.



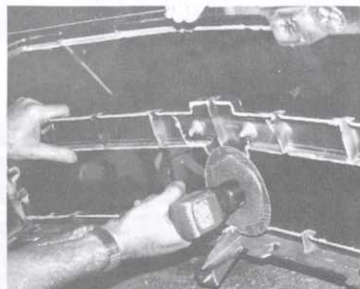
STEP 4 After cutting as deep as possible with the cutting disc from the front, turn the grille over and finish the cuts from the back side.



STEP 5 The "posts" where the egg crate sections attached must be ground down flush with the horizontal bars to halfway back from the front edge.



STEP 6 Trim the horizontal bars to a depth of 3/4 inch. They taper from back to front and must be squared to match the square grille insert bars. Mark the trim line with a strip of 3/4-inch masking tape, then trim the bars with the grinding disc.



STEP 7 Smooth and clean up the cut edges with a grinder.



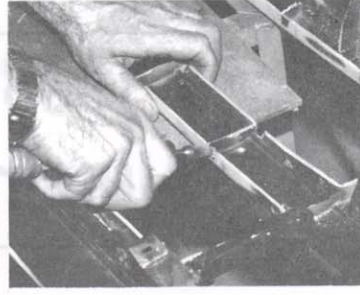
STEP 8 With 80 grit sandpaper, smooth and round the edges where the "egg crate" was cut out. Follow up with 150 grit paper to smooth the surface and remove the old finish in preparation for painting.



STEP 9 Because insert bars are square and fit snugly, file the corners of the openings with a square-edge file.



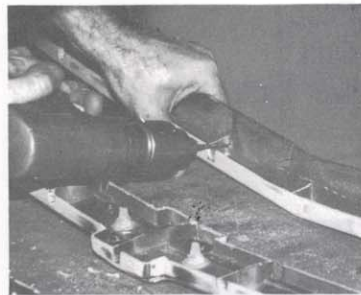
STEP 10 Trial fit the grille insert and mark where the frame must be notched for the vertical support bars to fit flush.



STEP 11 With a rotary tool (or rat-tail file), grind notches into the horizontal bars for the vertical supports.



STEP 12 Again trial fit the insert. Be sure the bars are flush with the face of the grille shell in front, and note any place where the frame needs additional trimming. Then mark where the upright bars contact the outer frame.



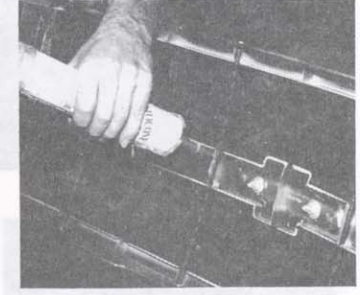
STEP 13 In the center of these scribe marks drill 1/8-inch holes.



STEP 14 It may be helpful to hold the grille insert in place with Cleco panel holders while you check the final fit. When everything's okay, remove the insert again and paint the reworked frame with '87-'90 GM accent charcoal poly, Code #58.



STEP 15 You're finally ready to install the grille insert. Attach the vertical support bars to the frame with the eight pop rivets supplied.



STEP 16 You may want to stabilize the center bar to the vertical bars with silicone.



STEP 17 Reinstall the completed grille in the truck and you're ready to turn some cats green with envy at the next cruise night !

