

1991-92 GMC Sonoma Aluminum Grille Installation Instructions



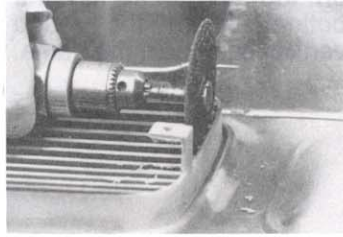
For installation of billet grilles that require cutting of the stock shell, proper tools, knowledge and skill are needed. Carriage Works is not responsible for care & accuracy of the installation, only for Fit & Finish of its products. Use a qualified installer or contact original vendor for references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

TOOLS REQUIRED:

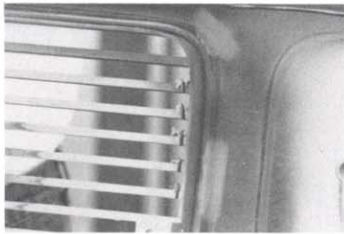
- Phillips Screwdriver
- Cutting disc or saw
- Rotary tool or rat-tail file
- Grinder
- Electric drill and 1/8" drill bit
- Rivet gun
- Files
- Sandpaper and masking tape



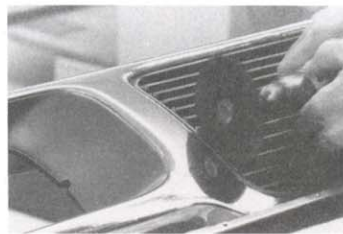
STEP 1 Remove the entire grille panel. Set it on sawhorses or a solid work surface.



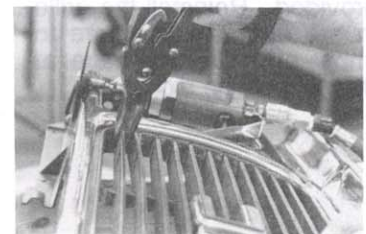
STEP 2 Working from the back side, the horizontal grille bars and the three vertical bars must be cut out, leaving the black outer rim. The two mounting brackets on the left and right sides must be left in place, so cut around them.



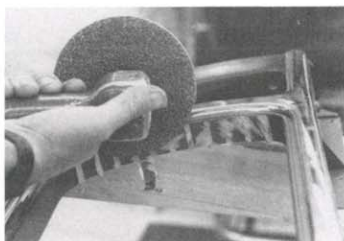
STEP 3 Use a cutting disc on an air-powered tool or electric drill (or a skill saw or hack saw) to cut the bars. To avoid cutting into the rim, leave about 1/16" of the ends of the bars. These can be dressed down later with a grinder and sandpaper.



STEP 4 It may be easier to finish the cuts from the outside.



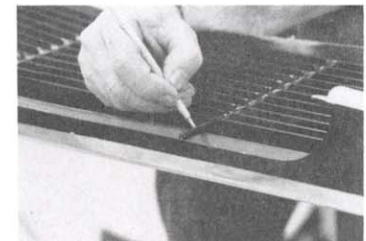
STEP 5 Because of the tight clearance in the corners, it may be easier to cut the top and bottom bars with metal shears or side cutters.



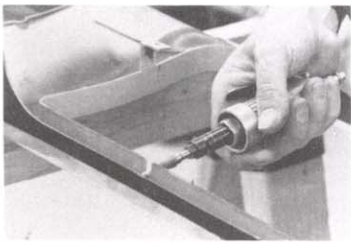
STEP 6 Dress down the cuts even with the surface of the rim using a grinder or file.



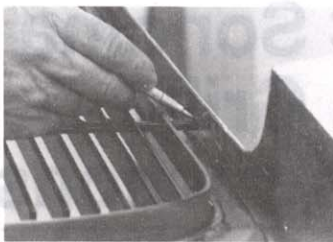
STEP 7 Sand the rim smooth. This surface will be visible with the new grille in place, so it must be smoothed and repainted.



STEP 8 Set the grille into the opening with the longer ends of the round, vertical bars toward the top. Where these bars intersect the rim, make a mark on each side of the vertical bar.



STEP 9 With a rotary tool or round file, grind notches into the rim 1/4" wide and approximately 5/8" deep, which the vertical bars will fit into.



STEP 10 With the grille in place, mark the three points on top and three on the bottom where the round vertical bars meet the frame.



STEP 11 Drill a 1/8" hole at each of these points.



STEP 12 Install the grille, attaching the vertical bars to the frame with pop rivets provided. Reinstall the grille in the truck and prepare to show off your new face at the next cruise night.



STEP 2 Working from the back side, the horizontal grille bars and the three vertical bars must be cut out, leaving the black outer rim. The two mounting brackets on the left and right side must be left in place so that the grille can be reattached to the back of the truck.



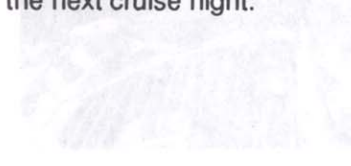
STEP 1 Remove the entire grille panel. Set it on sawhorses or a solid work surface.



STEP 4 Try to make it as close to the original as possible. If the cut is not perfect, the outside of the grille will be slightly rough.



STEP 3 Use a cutting disc on a power sander to smooth the edges of the metal. Use a hand saw to cut the bars. To avoid cutting into the rim, leave about 1/8" of the rim of the hole. These ends of the rim will be pressed down later with a rubber mallet and sandpaper.



STEP 2 Remove the four screws that hold the top of the grille in place. The top may be cut out if the grille is to be replaced with a new one.



STEP 7 Sand the rim smooth. The outside will be sanded with the new grille in place, so it must be smoothed and prepared.



STEP 6 Press down the cut ends with the suction of the rim using a quarter of an inch.



STEP 5 Push the grille into the opening with the longer ends of the round vertical bars toward the top. Where these bars meet the rim, make a mark on the side of the grille.