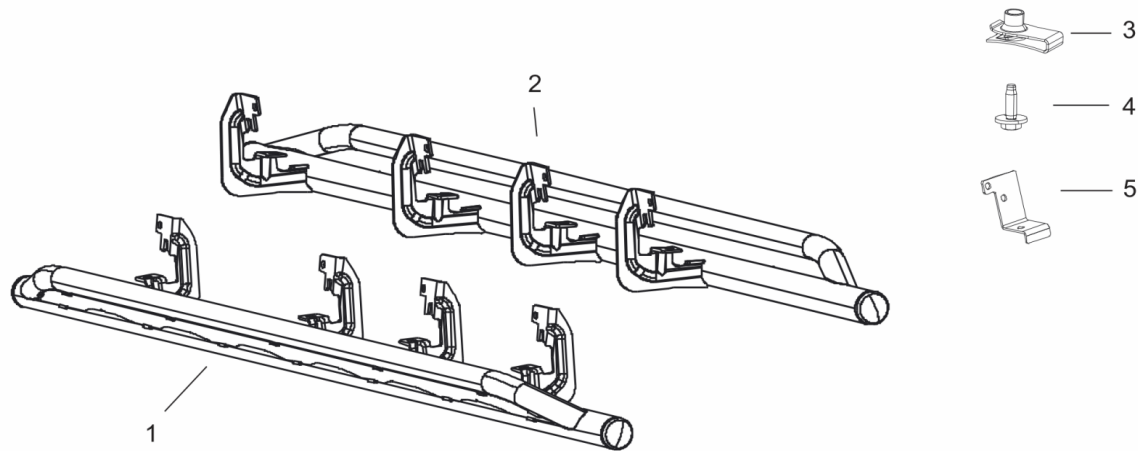


Document ID: 4585453

Rocker Panel Protector Package Installation

Installation Instructions Part Number

23413861



Kit Contents

| Item | Description | Qty: |
|------|--------------------------|------|
| 1 | Tube Assembly Left Side | 1 |
| 2 | Tube Assembly Right Side | 1 |
| 3 | M8 U-Nut | 17 |

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| Item | Description | Qty: |
|------|-----------------------|------|
| 4 | M8 Bolt | 16 |
| 5 | Reinforcement Bracket | 8 |
| 5 | Instruction Sheet | 1 |

Torque Table

8mm Hardware torque to 25N•m (18 lb ft)

Tools Required

- Rivet Nut Installation Tool P/N: BO-42151-8mm-Kit, or equivalent

Note: Rivet Nut Installation Tool can be ordered by calling 1-800 GM Tools (468-6657) or at www.gmspecialservicetools.spx.com

- Torque Wrench
- 13mm Socket
- 3/8" drive Ratchet
- 3" 3/8" drive extension

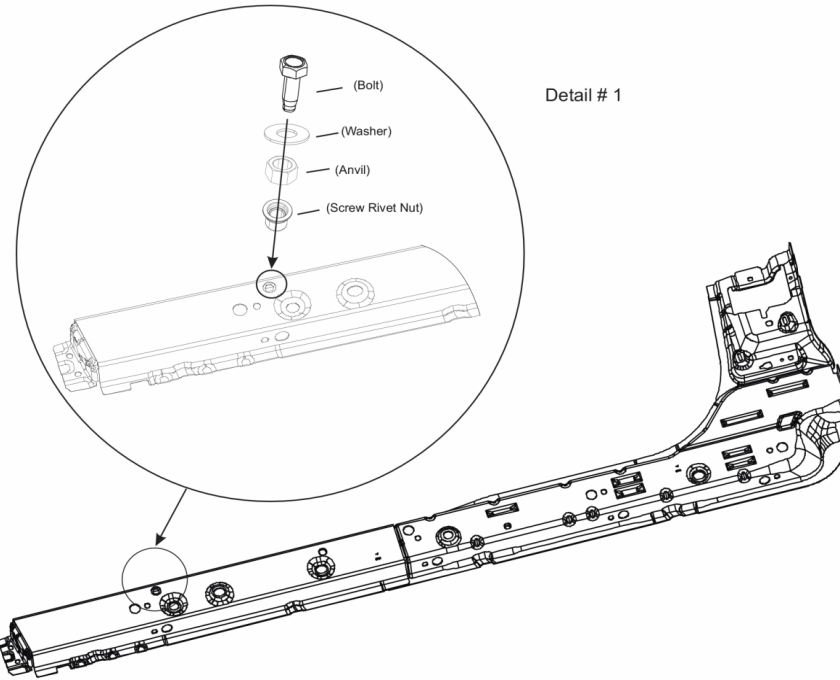
Procedure

Note: Read entire instruction sheet (5) thoroughly before starting.

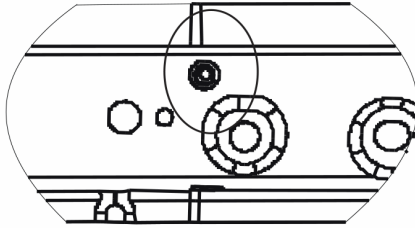
Note: Determine left hand and right hand tubular assist steps.

Caution: Use the correct fastener in the correct location. Replacement fasteners must be the correct part number for that application. Fasteners requiring replacement or fasteners requiring the use of thread locking compound or sealant are identified in the service procedure. Do not use paints, lubricants, or corrosion inhibitors on fasteners or fastener joint surfaces unless specified. These coatings affect fastener torque and joint clamping force and may damage the fastener. Use the correct tightening sequence and specifications when installing fasteners in order to avoid damage to parts and systems.

Right Hand Sides



1. Insert Bolt through Washer, Anvil onto Screw Rivet Nut, finger tight.
2. Insert Complete Assembly into Hex Hole on vehicle panel until flange of Rivet Nut is in contact with the surface of the hole.
3. Hold in place with a 9/16 box end wrench on the Hex portion of Anvil, use a 13MM socket and ratchet to tighten Bolt while holding Anvil stationary with wrench.



Detail # 2



4. Tightening of Bolt causes the Rivet Nut to crimp on the underside of the Hex hole. Apply 25 N-m of torque to the Rivet Nut tool or 3.5 turns +/- .25 turns to ensure Rivet Nut is fully collapsed.

Caution: Over-tightening of the bolt will cause damage to the thread of the Rivet Nut and Bolt.

5. Once Rivet Nut is installed, turn Bolt clockwise to loosen and remove it from the Rivet Nut

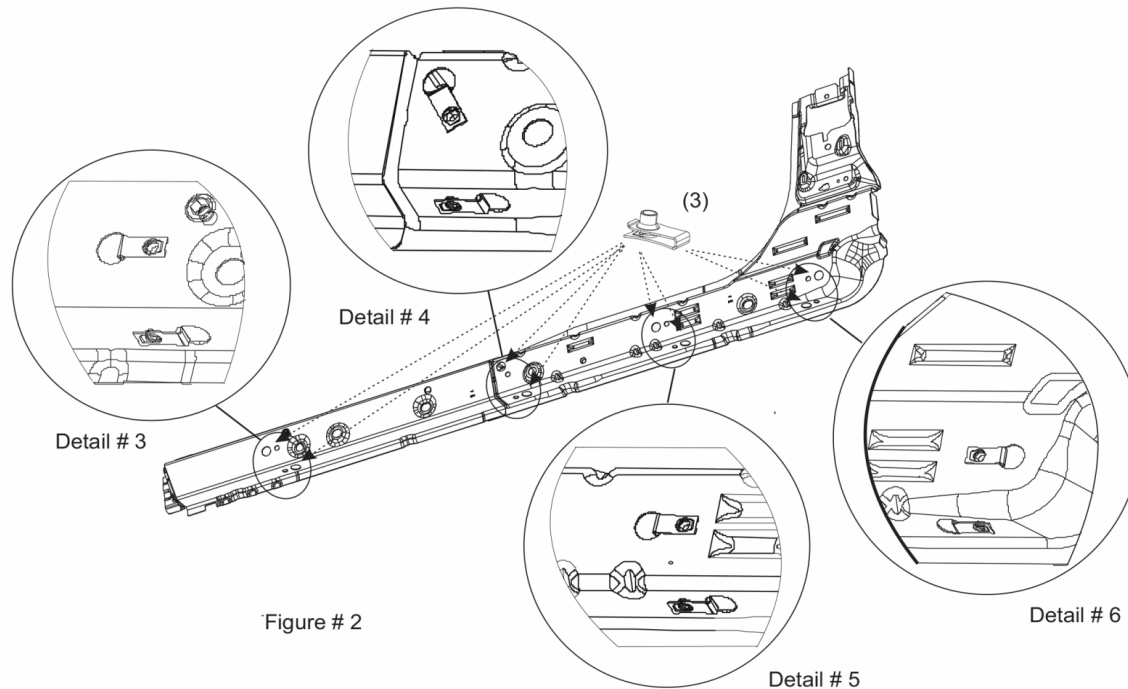


Figure # 2



6. Install U-nuts Item # 3 onto existing holes in inner rocker panel. Refer to Figure # 2 for locations and orientation of U-nuts. Install the U-nuts with the threads inside of the inner rocker panel.

Note: On some vehicles it may be necessary to discard hole plugs to install the U-nuts.

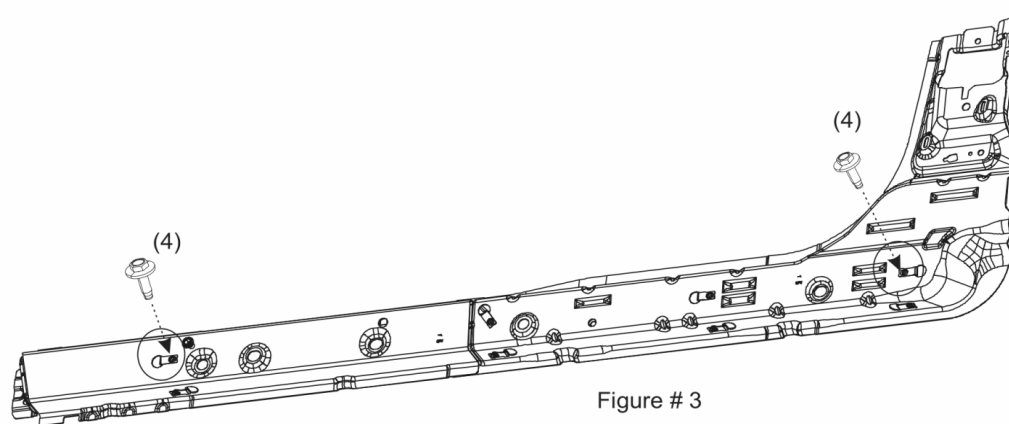


Figure # 3



7. Loosely insert the M8 bolt (Item # 4) into U-nut in upper rocker panel, front and rear location.

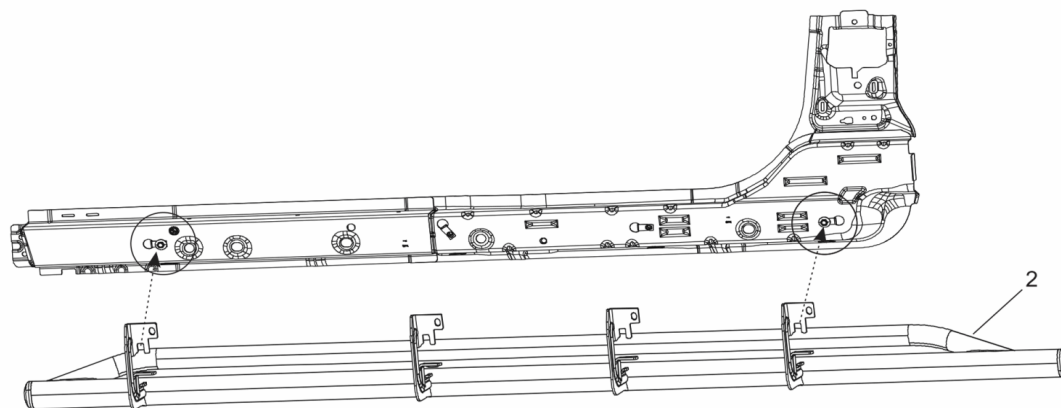
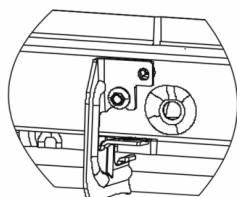
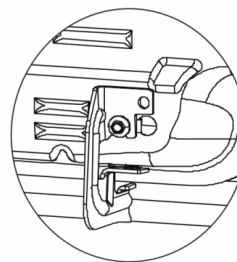


Figure # 4



Detail # 7



Detail # 8



8. Place the front and rear Rocker protector's brackets on the loosely install M8 bolts.

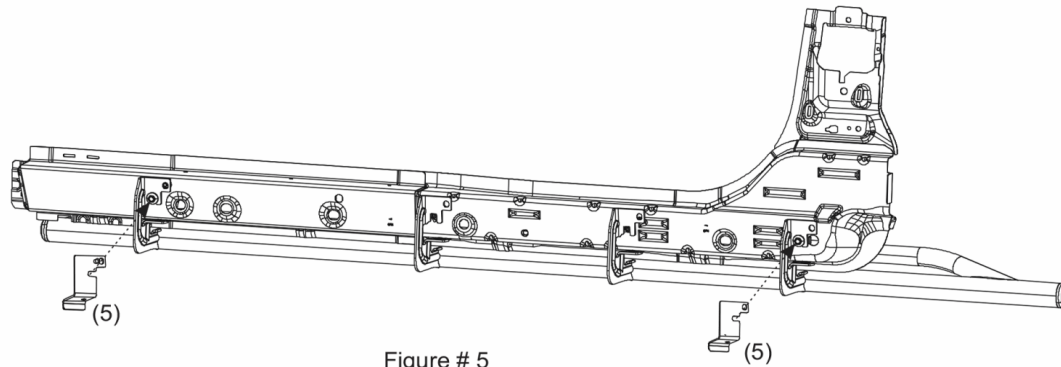
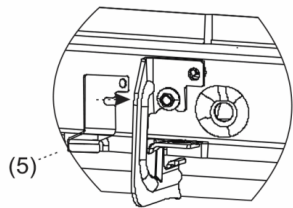
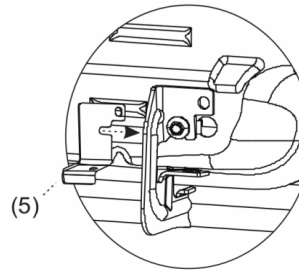


Figure # 5



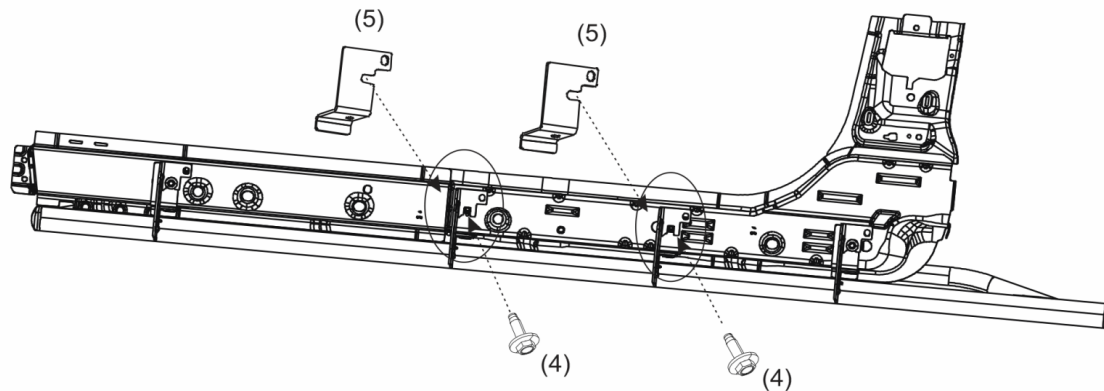
Detail # 10



Detail # 11



9. Slide Reinforcement bracket, Item # 5, on loosely installed bolts, between panel and Rocker protector's bracket.



10. Loosely install the M8 bolt into the top U-nut position for the middle brackets and slide the Reinforcement brackets in position.

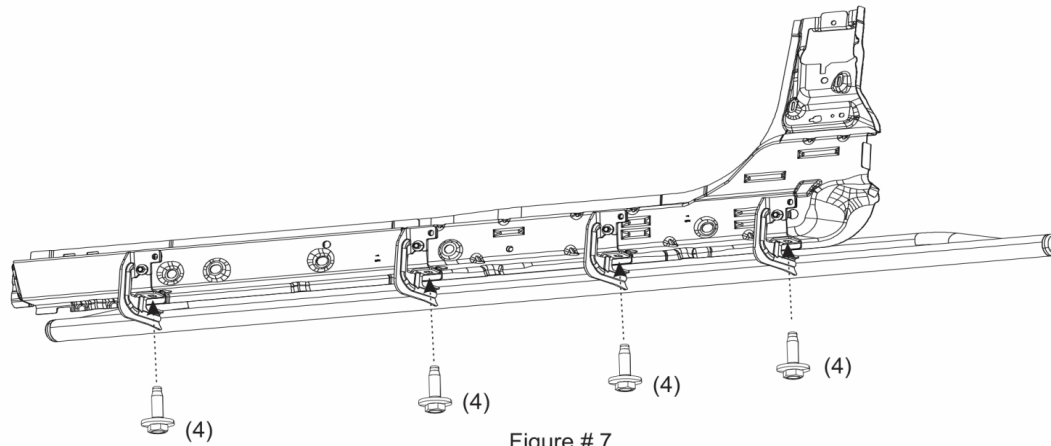


Figure # 7



11. Insert M8 bolt (Item # 4) through bracket, Reinforcement bracket (Item # 5), panel into U-nut (Item # 3).

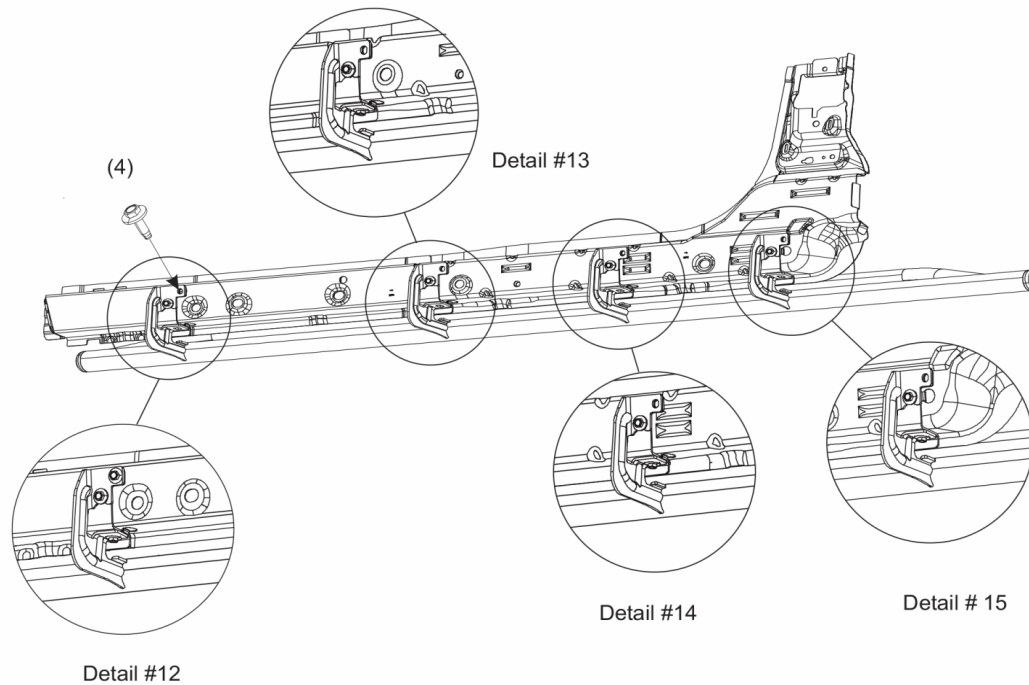
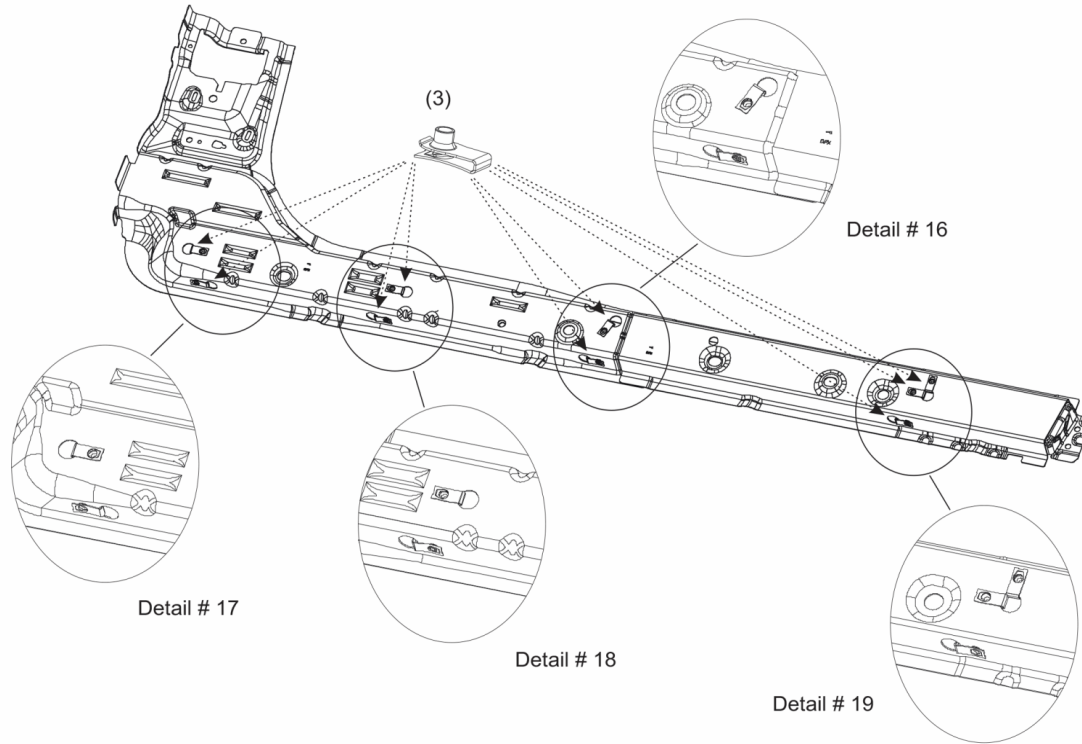


Figure # 8



12. Insert M8 bolt through bracket, Reinforcement bracket into Rivet Nut.

13. Tighten the M8 bolts (4) in positions to 25 N-m (18 lb ft).

Left Hand Side

Note: Left hand side do not require a Rivet Nut to be installed

Install U-nuts (Item # 3) onto existing holes in inner rocker panel. Refer to Figure # 9 for locations and orientation of U-nuts. Install the U-nuts with the threads inside of the inner rocker panel.

Repeat instruction from step 6 to 11.

Tighten the M8 bolts (4) in positions to 25 N-m (18 lb ft) .

