

Document ID: 3654211

Rear End Spoiler Package Installation

[Installation Instructions Part Number](#)

23480414

Kit Contents

Qty	Description
1	Spoiler
4	Hex Flange Nut (M6)
1	Drill Template
1	Solvent Pad
1	Installation Instructions

[Tools Required](#)

- Power Drill
- Safety Glasses
- Center Punch
- Hammer
- 1/8" Drill Bit
- 7/16" Drill Bit
- 16/64" Drill Bit
- Corrosion Inhibitor [GM 12371287(US) 10953437(Canada) or equivalent]
- Masking Tape
- Torque Wrench
- Ratchet
- Extension
- Socket (10mm)
- Universal Joint
- Deburr Tool
- Rubber Roller

Vehicle Preparation

1. Temperature must be between 61°F-86°F (16°C-31°C).
2. Wash and thoroughly dry trunk lid.
3. For best results, trunk lid should be free of damage (dents, scuffs, creases, fractures, etc).

4. Do not use petroleum based cleaning products. If a strong cleaner is required, we recommend using 3M general purpose Adhesive Cleaner (P/N 08984) with a clean cloth to remove all visible contaminants (road tar, etc).

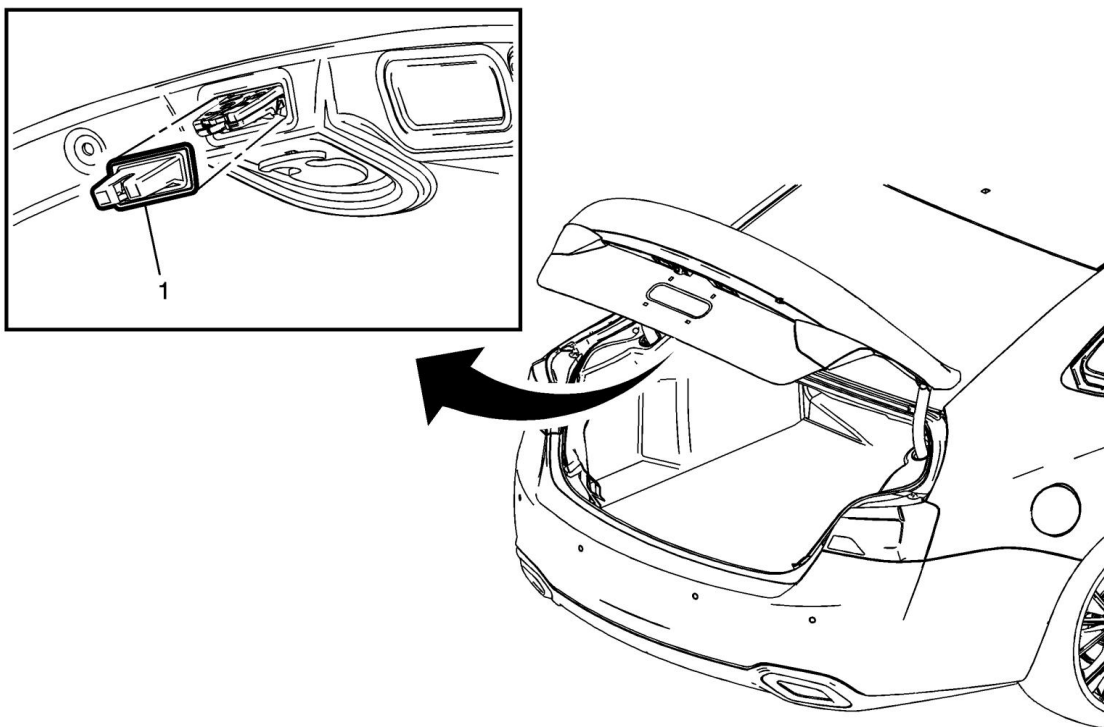
It may take the use of several cloths to obtain a clean surface. It is important to replace the cloth when soiled or you will be smearing or wiping contaminants back on the vehicle. After using the Adhesive Cleaner, use the SOLVENT PKG-BODY SURF CLNR; (P/N 12365938 14W 0849Z 0030).

5. Place drop cloth inside trunk so that it sufficiently covers area under trunk lid.

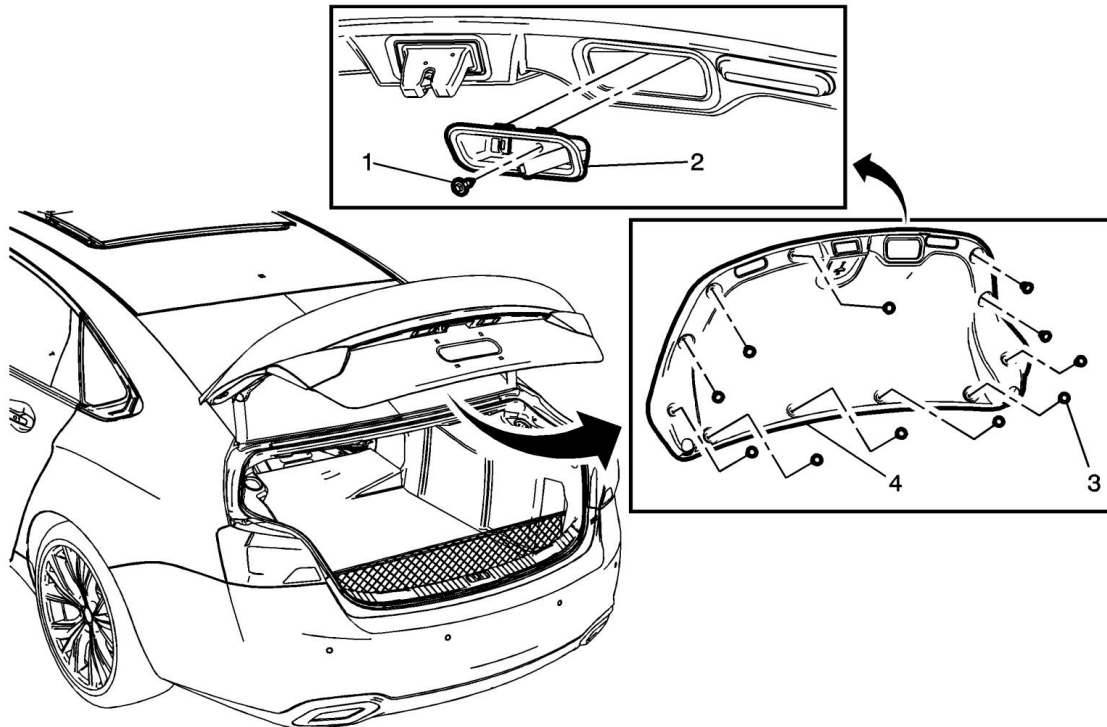
Spoiler Installation

1. Paint Spoiler as required.

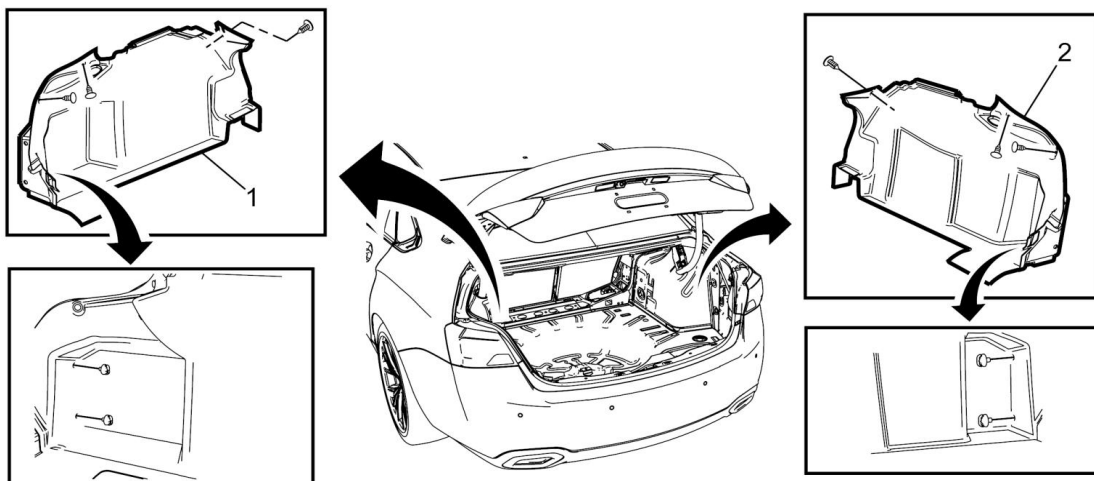
Note: Prior to finishing or refinishing refer to GM4901M-D-005 Refinish Manual for recommended products. Do not combine paint systems. Refer to paint manufacturers' recommendations for further information. For an electronic copy of GM4901M-D-005 refer to the GM Goodwrench web site at http://www.gmgoodwrench.com/gmgoodwrenchjsp/Gmspo/paint_shop.jsp.



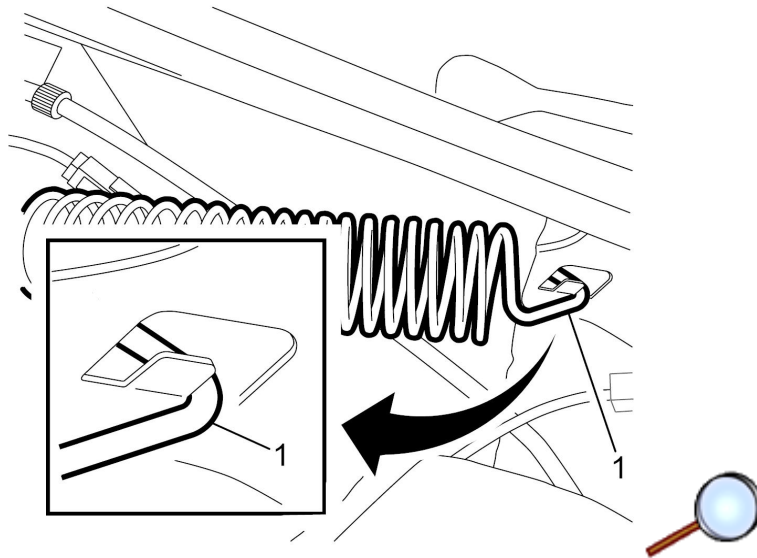
2. Using a small flat-bladed tool, pull and release the rear compartment cover (1).



3. Using a small flat-bladed tool, open the integral cover to access fastener (1). Use a small flat-bladed tool to pull and release then slide the rear compartment lid outer bumpers outward to remove fastener.
4. Remove rear compartment lid inside handle (2).
5. Remove the rear compartment lid inner panel trim retainers (3) (Qty: 11).
6. Remove the rear compartment lid inner panel trim assembly (4).



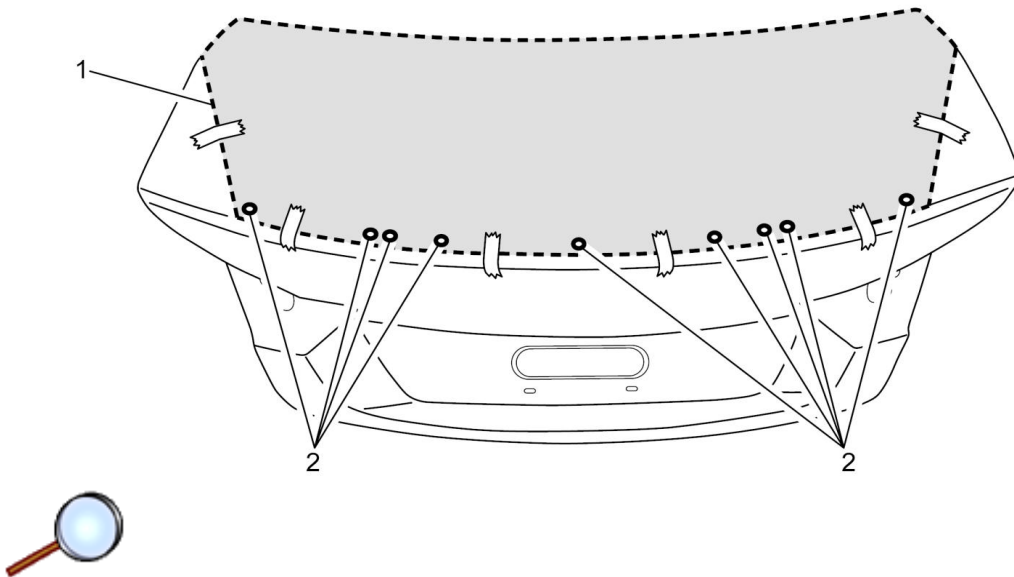
7. Reposition the left (1) and right (2) side rear compartment side trim panels enough to gain access to the left and right rear compartment lid hinge springs.



Warning: When a hood hold open device is being removed or installed, provide alternate support to avoid the possibility of damage to the vehicle or personal injury.

Warning: Approved safety glasses and gloves should be worn when performing this procedure to reduce the chance of personal injury.

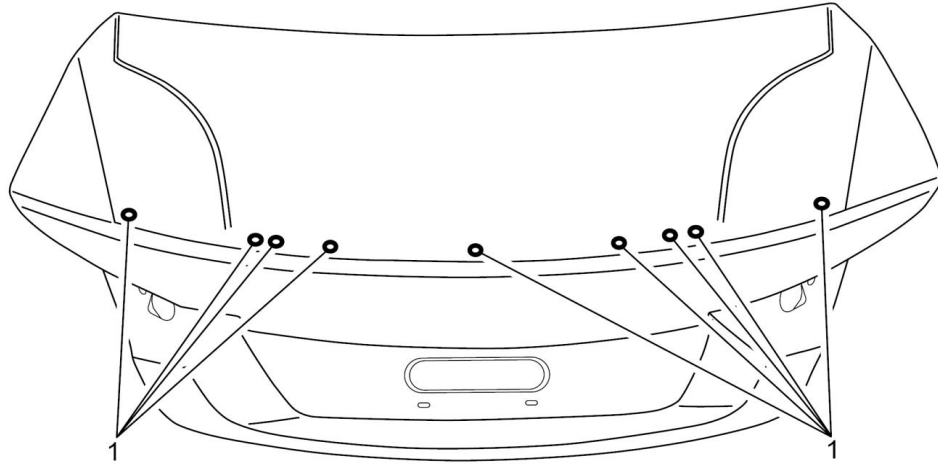
8. Pull the left and right rear compartment lid springs backwards and unhook from the front position on the lid hinge spring bracket and install springs onto the rear-most position on the lid hinge spring bracket (1).



Caution: Always check scale, size and position of all templates before drilling. Failing to do so may cause damage to the vehicle, misalignment of components or the inability to install the accessory.

Note: Use existing template that is included with kit.

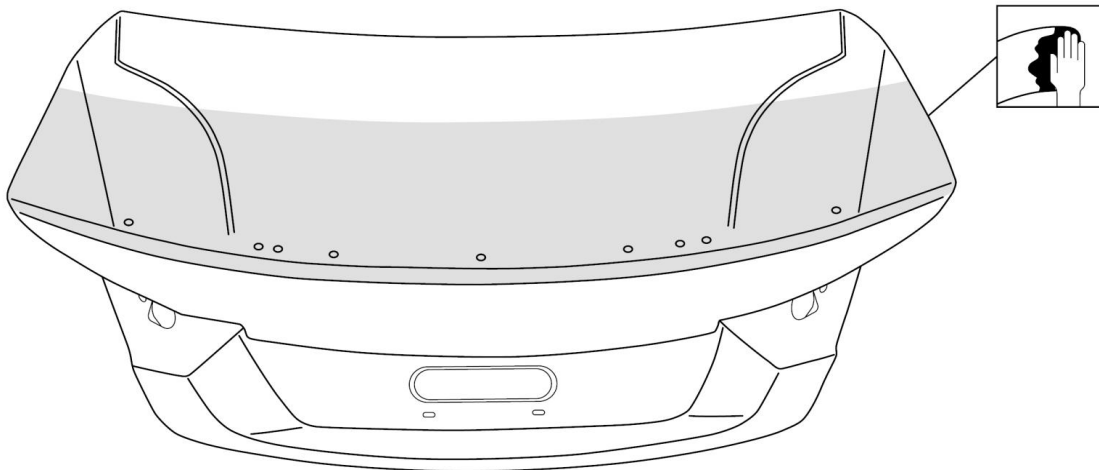
9. Use supplied template and align it on the trunk lid.
10. Secure drill template (1) to trunk lid using masking tape. Start in the center and work towards the sides. Make sure template lays flat on the trunk lid.
11. Center punch 9 hole locations (2) marked on drill template.
12. Remove the template from the trunk lid. Do Not Discard.



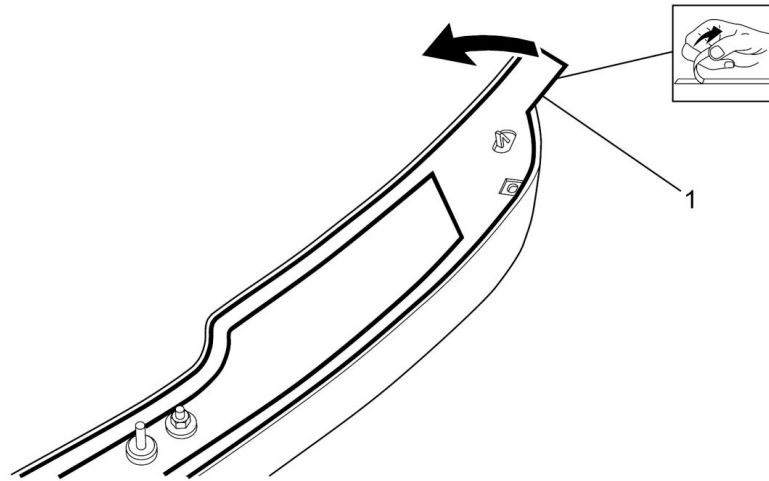
13. Drill 9 x 1/8" pilot holes in each of the center punched locations (1).
14. Enlarge the holes in the outer sheet metal to the final size indicated on the drill template.

Note: CARE SHOULD BE TAKEN DURING THE DRILLING OF THE INNER SHEET METAL NOT TO DAMAGE THE OUTER SHEET METAL.

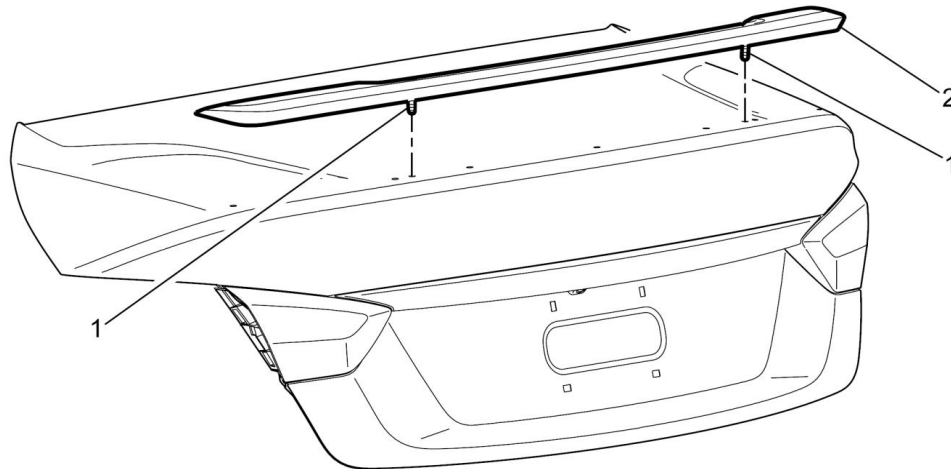
15. De-burr all holes drilled in the sheet metal, take care on outer sheet metal to de-burr both side of the panel. If holes are not de-burred properly, the fasteners will not function correctly.
16. Treat all drilled locations with corrosion inhibitor.



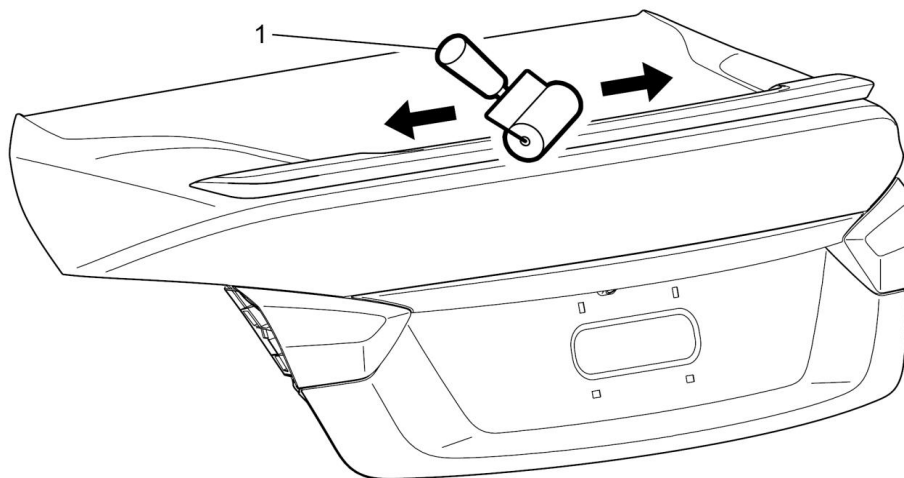
17. Using alcohol wipes, clean area where spoiler will be installed.



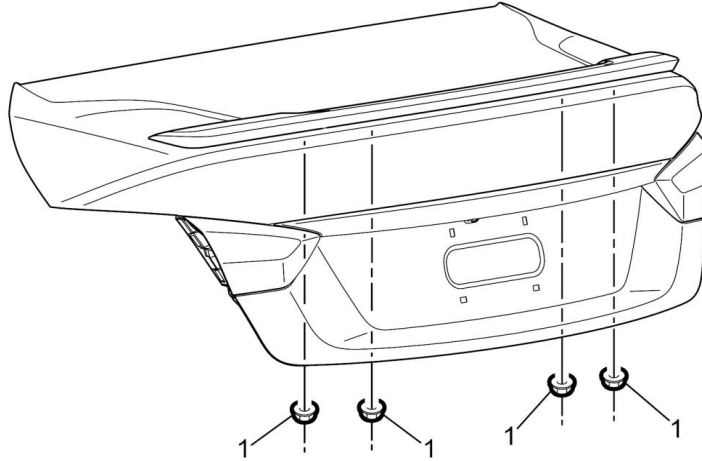
18. Remove tape liner (1) by using the pull tabs.



19. Carefully install the rear spoiler (2) by inserting the studs (1) into the holes in the trunk lid. Before allowing the plastic retainers to engage or tape to contact the trunk lid, make sure the spoiler is centered. Once this is confirmed push down and engage studs into plastic retainers.



20. Using a rubber roller (1), apply 15 PSI of equal pressure along the entire perimeter of the spoiler to ensure good tape adhesion.



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.

21. Using a ratchet and extension, install 4x M6 hex flange nuts (1).
22. Tighten all 4X M6 hex flange nuts to a torque of 6 N·m (4.4 ft.lbs).
23. Reinstall deck-lid inner liner and any other removed components.