

T-REX

Billet Grilles

30183

**02-06 CADILLAC
ESCALADE &
EXT & -ESV**

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EXT & ESV**

02-06 Cadillac Escalade, Escalade ESV & EXT Models **Billet Insert – VERTICAL**

Tools Required:

Phillip Screw Driver
Dremel or Die Grinder w/ Cut-Off Wheel
Drill
3/16" Drill Bit
Vise Grips or Clamps (4)

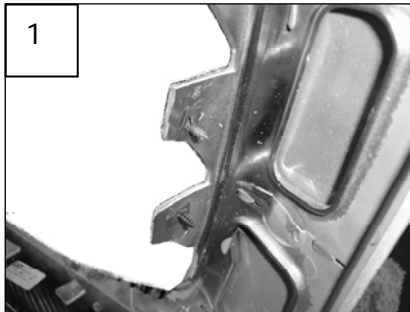
Parts List:

1 Billet Insert (66 Bars)	1 "Z" Extension Bracket
6 #8 x 3/4 Phillip Screws	2 6-32 x 1/2" Machine Screws
6 #8 Flat Nuts	2 6-32 Nylon Lock Nuts
1 #10 Phillip Screw & Nut	2 1/2" x 1" x 1" L Bracket w/ 3/16" – 5/16"
1 1/4-20 x 3/4 Bolt, Washer & Nut	1 1/2" L Bracket w/ 3/16" – 5/16"

Read and understand instructions before attempting installation

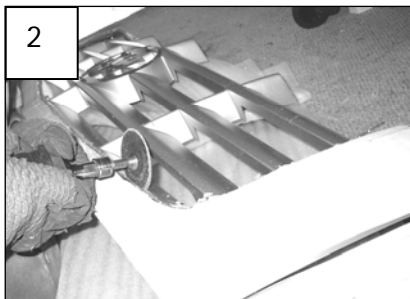
Step 1

Remove the black cover attached to the top of the grille. Remove the 10mm bolt in the center. Unfasten the two clips securing the grille in each corner. Apply masking tape to the painted surfaces of the grille.



Step 2

Note the tabs/brackets on each end of the billet insert. Center the billet insert behind the grille shell to visualize where these brackets mount. **DO NOT CUT** the plastic on each end of the opening where these brackets mount (1). Make your cut along the bottom about 1/16" – 1/8" inside the chrome ring (2); this will leave a small plastic border inside of the opening. Remember it is better to cut less than cut too much. Clean your cut with sandpaper or files so there is a smooth edge around the opening.



Step3

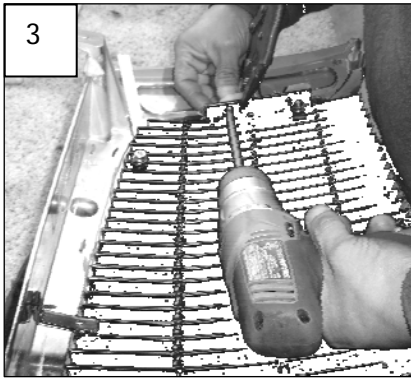
Center the grille behind the chrome ring. Bend the brackets on the grille so they sit flat against the grille shell (4 & 5). Failure to do this may cause excessive gap between the billet and grille shell.

Use vise grips to clamp the grille to the grille shell (4 &5). There should be a minimal gap (1/16" to 1/8") between the chrome ring and the face of the billet insert. If there is major gap, adjust the brackets and firmly press the insert forward to the chrome ring; re-clamp with vise grips.

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(Step 3 Continued)

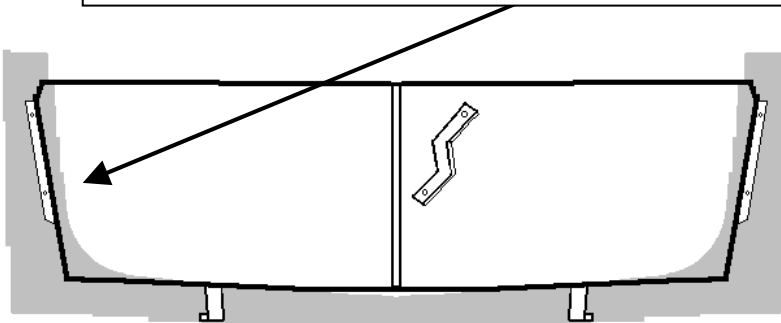


Bend the brackets on the bottom so they sit flat against the bottom of the grille shell (Failure to do this may cause excessive gap between the billet and grille shell).

Once you have the correct fitment of the grille; drill the mounting holes. Drill a 3/16" hole through the shell at each mounting hole. Fasten the billet to the grill shell using the #8 screws and flat nuts **(3)**.

Attach the 1/2" L brackets to the billet grille on top; use the machine screws and nuts. These brackets secure the plastic radiator cover.

Do not cut the plastic edge that is needed to mount these brackets on each end.



If there is excessive gap between the face of the billet and the grille shell, the lower brackets may need to be adjusted. Bending the brackets will change the position of the grille.



Step4

Install the grille shell back on the vehicle. Attach the 'Z shaped' extension bracket to the center tab on top of the billet with the 1/4"x 20 bolts, nuts and washers. Attach the other side using the # 10 Screw and nut. If re-installing the factory logo, use a heat gun (a hair drier will work) on the back of the factory emblem. Heat it enough so the tape is warm and pliable, at this time the emblem will peel off by prying with even pressure. Let the tape cool and then re-attach the emblem to the billet insert. You can also use new double-sided tape if the tape is torn during removal. Use the factory fasteners to re-install the plastic cover. It may be necessary to slightly enlarge the holes so it fits properly. ***Thank you for purchasing a T-Rex billet grille. 4/24/06***