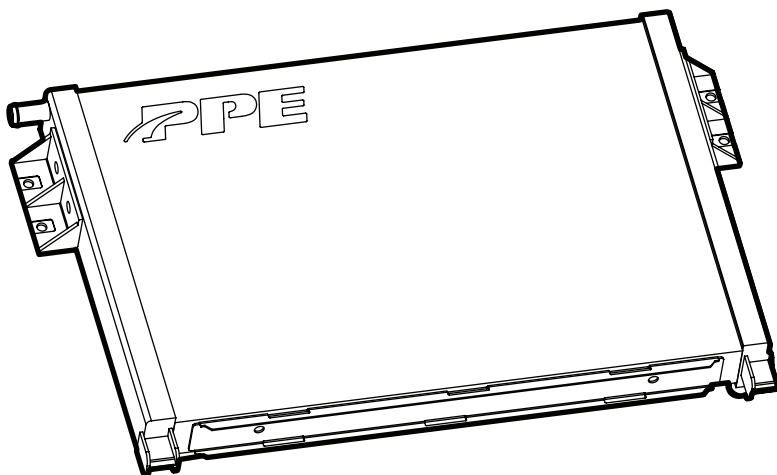




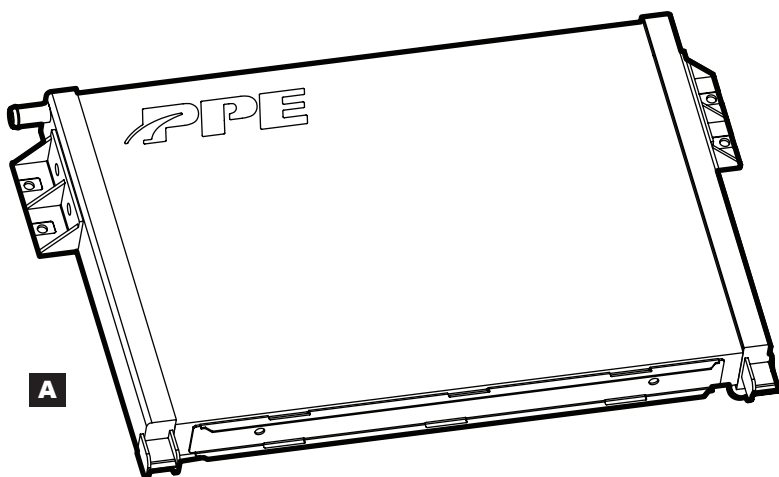
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# **2020-2024 Heat Exchanger for GM 3.0L Duramax Intercooler**

(119010300)

## ***Installation Guide***



## **CONTENTS:**

**A**    (1) Heat Exchanger for GM 3.0L Duramax Intercooler

## **Tools needed:**

*T-15 torx bit*

*10 mm socket*

*13 mm socket*

*15 mm socket*

*U-groove clip removing tool*

*Plier*

## ***Disassembly:***

**Step 1.** Turn the vehicle off and allow time to cool down before installing.

**Step 2.** With a 13 mm socket, remove the skid plate below the electric fans.(FIG 1)



**Step 3.** Disengage the inserts that secure the air deflector under the charge air coolant heat exchanger bottom bracket. This will allow for the heat exchanger removal in later steps. (FIG 2, FIG 3)





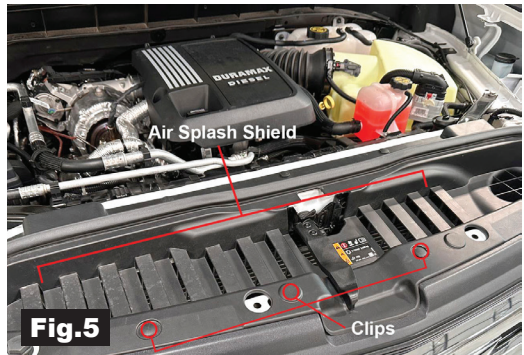
**Step 4. Draining the coolant:**

*Using a plier, pinch and disengage the coolant inlet hose spring clamp located at the lower driver side of the heat exchanger. Then disconnect the coolant hose from the heat exchanger inlet. Save coolant if reusing. (FIG 4)*



**Step 5. With a T-15 bit, remove the hood release lever.**

**Step 6. Using a U-groove clip removing tool, pop all the clips that secure the intake air splash shield, and remove the shield (FIG 5)**



**Step 7. Using a 13 mm socket, unbolt the two screws securing the hood release latch bracket, leave it on top of the upper tie bar (FIG 6). Do not disconnect the hood open sensor wire from the latch.**



## **Heat Exchanger for GM 3.0L Duramax 2020-2024 Intercooler**

**Step 8.** Using a 10 mm socket, disconnect the horn and horn bracket from the tie bar.

**Step 9.** Using a 15 mm socket, remove the left and right diagonal braces located right in front of the transmission cooler. **(FIG 7)**



**Step 10.** Disengage the coolant outlet hose spring clamp and disconnect the hose from the heat exchanger. This is located at the upper passenger side of the heat exchanger. Use paper towels to avoid spillage.

**Step 11.** Using a 10 mm socket, unbolt the left and right heat exchanger support brackets. There are four bolts on each side, two for the heat exchanger and two for the radiator. If it is too hard to access the passenger side radiator-bracket bolts, unbolt the passenger side transmission cooler bolt and lift the transmission cooler up for more room.

**Step 12.** Lift the factory heat exchanger straight up and maneuver it out from the opening created from removing the intake air splash shield.

## ***Installation:***

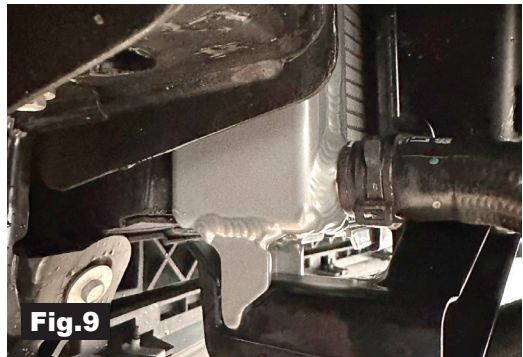
*Step 13. Install the four C-nuts to the PPE heat exchanger, two on each side.*

*Step 14. Drop in the PPE heat exchanger from the top opening created from removing the intake air splash shield. Make sure that the bottom supports are fully seated in the fan shroud slots. (FIG 8, FIG 9)*



*Step 15. Reconnect the inlet and outlet hoses, reengage both clamps.*

*Step 16. Re-install the diagonal braces, horn bracket, hood release latch bracket, intake air splash shield, and hood release lever.*





## ***Heat Exchanger for GM 3.0L Duramax 2020-2024 Intercooler***

*Step 17. Add coolant to the charge air cooler coolant reservoir (the smaller reservoir). Add coolant to the factory recommended fill level marked on the side of the reservoir (FIG 10).*



*Step 18. Drive truck for at least 15-20 minutes to purge the air in the charge air coolant loop, then top off coolant to the factory recommended fill level again.*

*Installation complete*

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