

## Astra Mk5 1.9 CDTi Airtec Intercooler fitting instructions



1. Remove front grill (3 x T25 Torx bolts) then pull upwards, be careful not to break clips.



2. Remove the 4 x T20 screws, securing the inner wheel arch liner to the bumper



3. Bottom of bumper - remove 3 securing pins by pulling centres of pin out first



4. Un-clip both sides of the bumper by carefully but firmly towards you



5. Disconnect the fog light wiring 'Blue clips'
6. Remove 2 plastic clips, un-clip bumper and carefully remove (disconnect Airflow sensor on back of bumper grill)



7. If you have headlight washers fitted, place bucket underneath to drain water
8. Remove foam end caps of crash bar and drill out alloy rivets as shown



9. Remove headlight bolts (3x 8mm bolts) then un-clip by pulling red centre insert out of clip

10. Remove 10mm bolt securing washer bottle



11. Remove the 6 x 13mm bolts securing the slam panel (3 each side)



12. To remove slam panel, lift upwards, un-clip Air feed pipe and un-clip wiring loom from panel so it's free to be removed and placed to one side.



13. Remove the 2 jubilee clips on the left & 1 jubilee clip on the right hand side of the alloy boost pipes



14. Remove Torx10 bolt and remove pipe



15. Undo the jubilee clip on the Turbo and remove the rubber connecting hose

16. Remove 4 x T10 bolts securing Air-con radiator to standard Intercooler

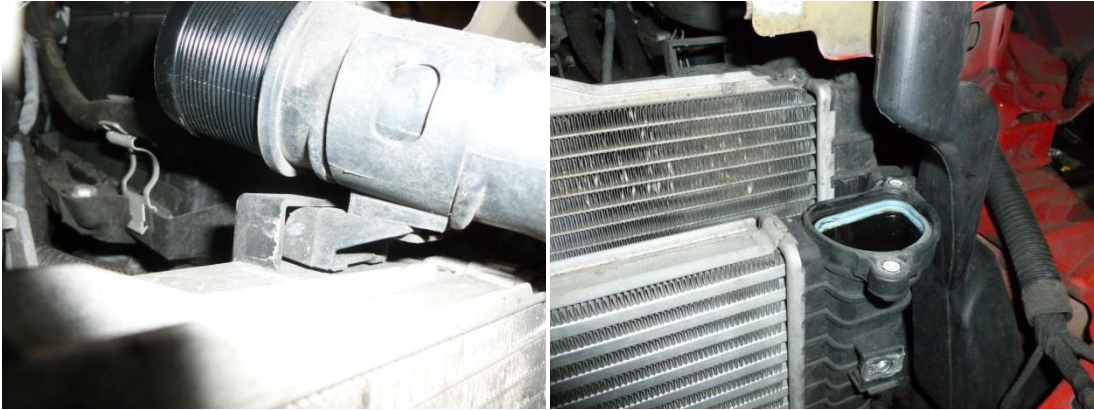
17. Unclip left hand side Air-con pipe and also unclip wiring from right hand side of standard intercooler



18. Remove 2 x T10 bolts securing top of standard intercooler to radiator, then remove top rubber hose

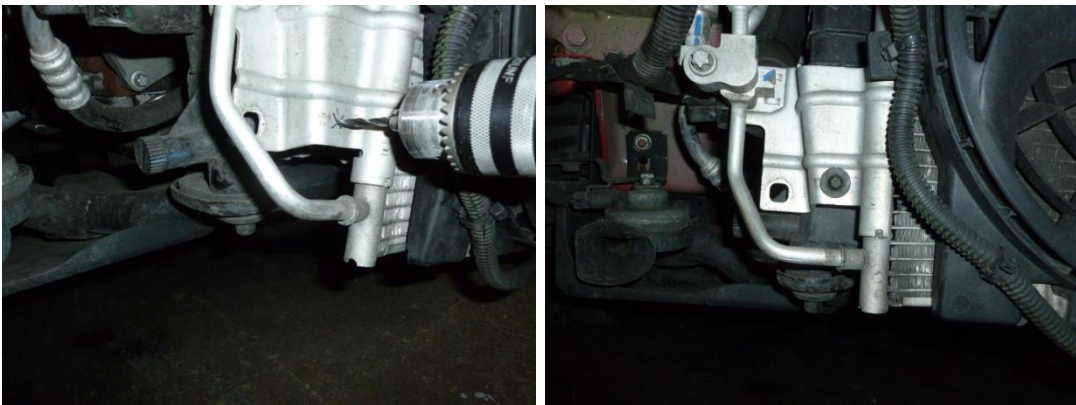


19. Now un-clip intercooler top from radiator and remove both top intercooler pipes

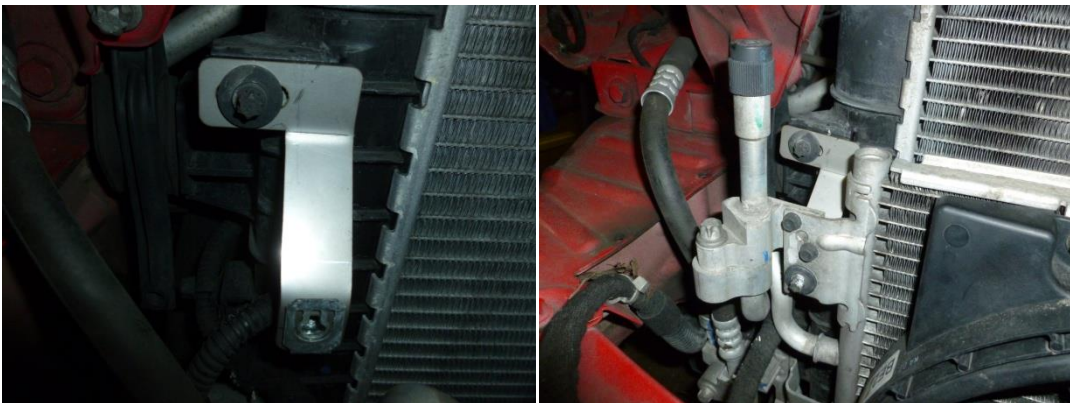


20. Then carefully 'take your time' slide intercooler downwards to remove (Jack up vehicle if you require extra clearance for removal)

21. Now we have to secure the A/C radiator, drill 8mm hole on the bottom left of the A/C condenser



22. Take the small 'L' shaped bracket and place on the standard radiator , use original bolt and tread fixing taken from standard Vauxhall intercooler



23. With the left hand side secured we can now secure the right hand side. Place the alloy spacer as show and use bolt provide to secure (goes though back of radiator), the bracket will hook into the radiator and secure with original fixings



24. With the A/C radiator secured we can fit the Intercooler, place the intercooler as shown and check you have @ least 5-10mm clearance from the original fan assembly



25. Drill 2 x 5mm holes (no bigger) and secure with screws provided (Tip. Use the lower securing brace to help position the intercooler before drilling). Once intercooler is secure install lower brace as shown



26. Reposition horns on top of each other as shown



27. Now it's time to install the boost pipes, install the 180 degree onto the turbo housing (shorter end onto the housing), then the longer of the 2 alloy straights joiner that with the short 90 degree silicon hose, install short alloy straight and finally larger 90 degree silicon hose. If unsure please see photo.



28. On to the right hand side and install the 45 degree silicon hose from the kit onto the intercooler, then install 'S' alloy boost pipe as shown and fit hump hose to alloy pipe onto original Vauxhall boost pipe, then once happy with position tighten hoses and fit securing bolt for Alloy boost hose



29. With the slam panel fitted check clearance of alloy boost pipe to the panel itself, if required install protective edging supplied, if hitting readjust alloy boost pipe and silicon hoses to give you enough clearance.

30. Installing protective edging as shown



31. All whats left to do now is refit bumper etc in reverse order of removal.

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lower prices = AIRTEC cooling solutions**