Fitting Instructions

Vehicle:	Toyota GR Corolla
Product:	Oil Cooler
Part number:	ATMSCGR1

Kit



Contents:

1x AIRTEC Motorsport Oil Cooler	4x M6 Washers (18mm)
2x AIRTEC Motorsport Oil Cooler Mounting Brackets	3x M6 Washers (15mm)
1x AIRTEC Motorsport Two-Piece Air Duct	8x M5x16mm Button Head Bolts
3x AIRTEC Motorsport Air Duct Mounting Brackets	8x M5x12mm Button Head Bolts
1x AIRTEC Motorsport Inner Arch Liner Grille	14x M5 Nyloc Nuts
1x AIRTEC Motorsport Sandwich Plate with Centre Bolt	32x M5 Small Washers (10mm)
2x AIRTEC Motorsport Oil Lines with Fittings	1x M4x35mm Button Head Bolts
4x Anti-Vibration Bushes	1x M4x30mm Button Head Bolts
1x Rubber Trim (For Scoop)	2x M4x25mm Button Head Bolts
1x M8x16mm Socket Head Bolt	4x M4 Nyloc Nuts
1x M8 Nyloc Nut	8x M4 Small Washers
2x M8 Small Washers (15.5mm)	2x Spacers (7mm and 5mm)
14x M6x18mm Button Head Bolts	2x Large Cable Ties (400mm)
13x M6x16mm Socket Head Bolts	

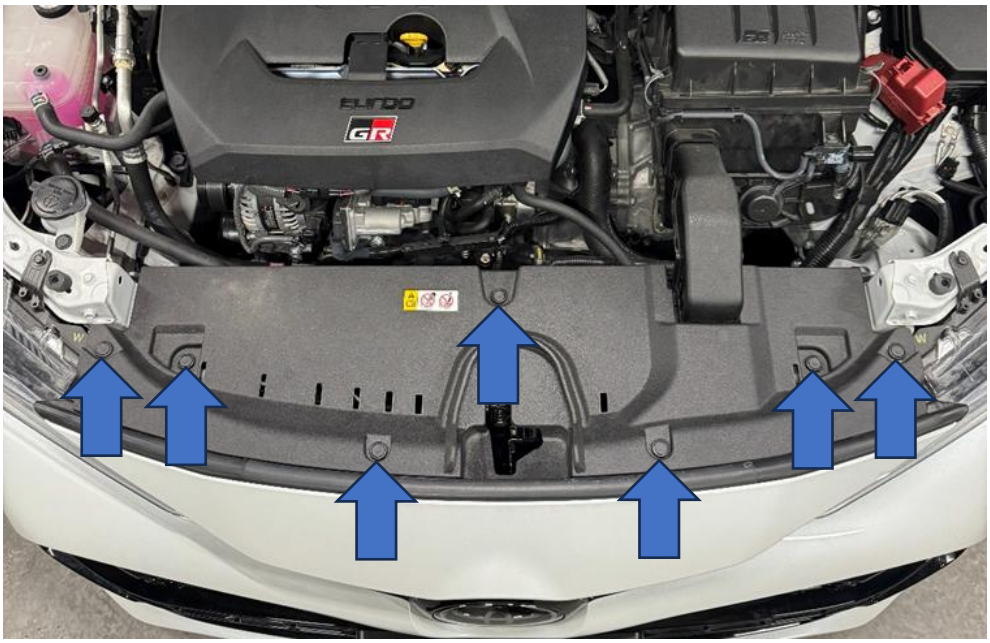
Tools Required:

Ratchet and Socket Set	Sharp Knife
Trim Removal Tool	Masking Tape
Drill and 5mm Drill Bit	

PLEASE THOROUGHLY READ THESE INSTRUCTIONS AND MAKE SURE YOU ARE FAMILIAR WITH THE STEPS BEFORE CARRYING THEM OUT

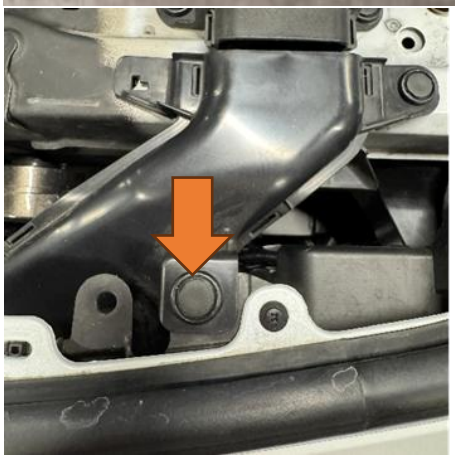
Instructions:

1. Start by removing the seven push fittings to release the slam panel cover.

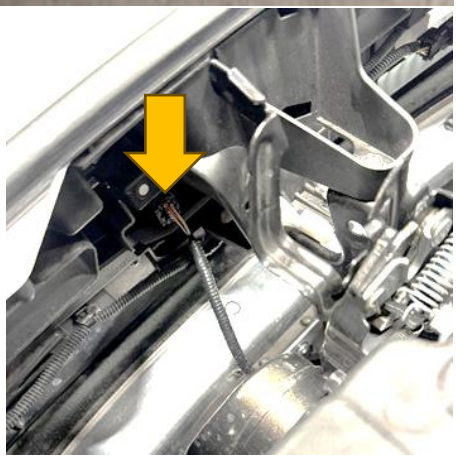


2. Now remove the three 10mm bolts (blue arrows) holding the top of the bumper along with the one push fit (orange arrow) for the air feed from the grille. The wiring connectors from the front radar (green arrow) and parking sensors (yellow arrow) can be undone at this stage.



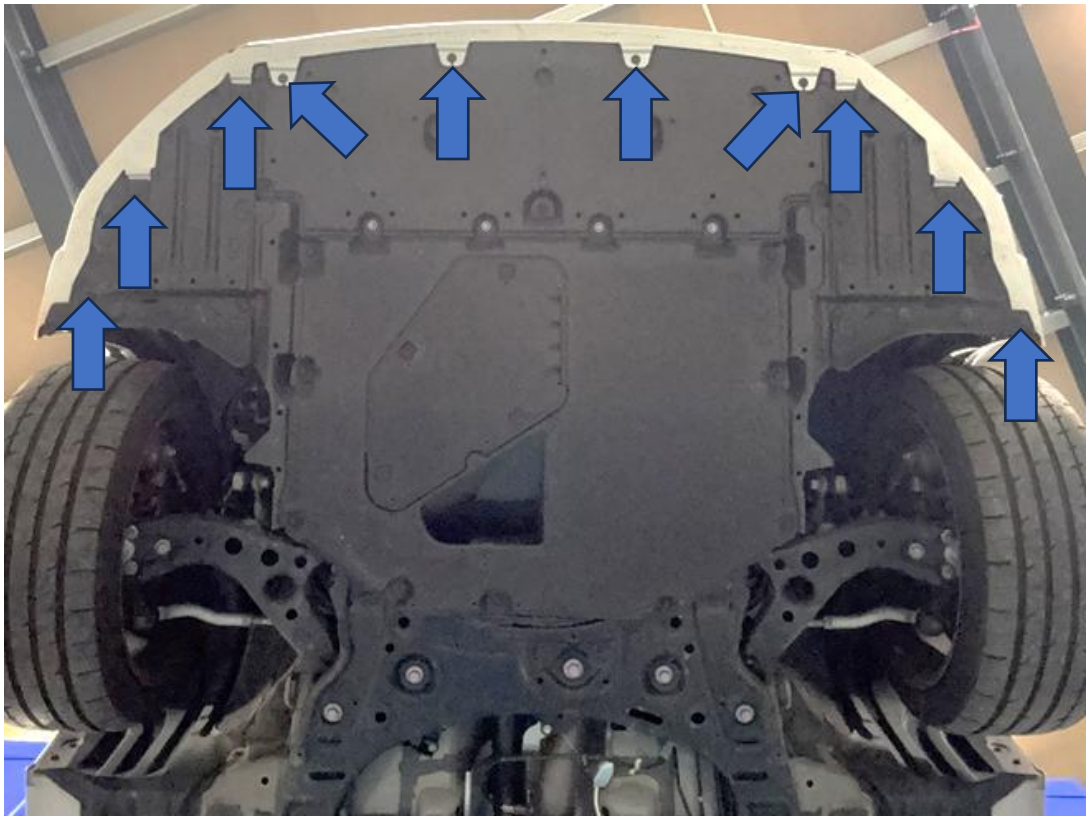






AIRTEC MOTORSPORT

3. Working under the car, remove the ten 10mm hex bolts securing the bumper underneath.



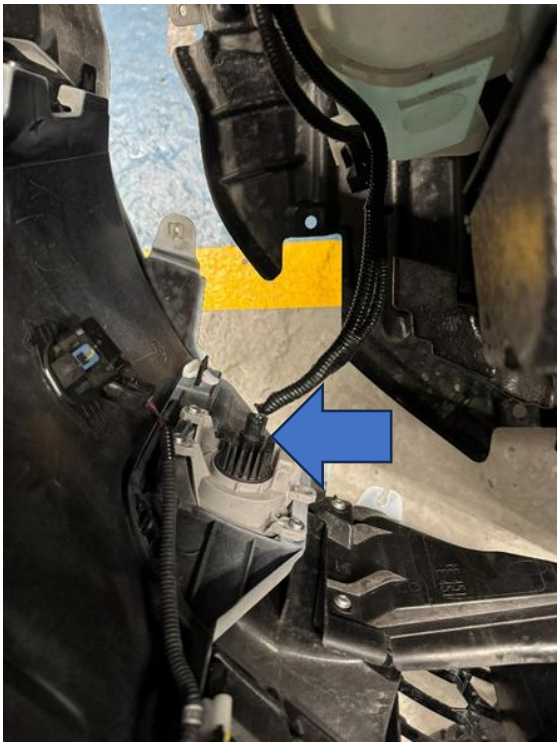
4. Inside each inner wheel arch liner, you need to remove one large push fit and one small push fit before unclipping the arch liner from the bumper.



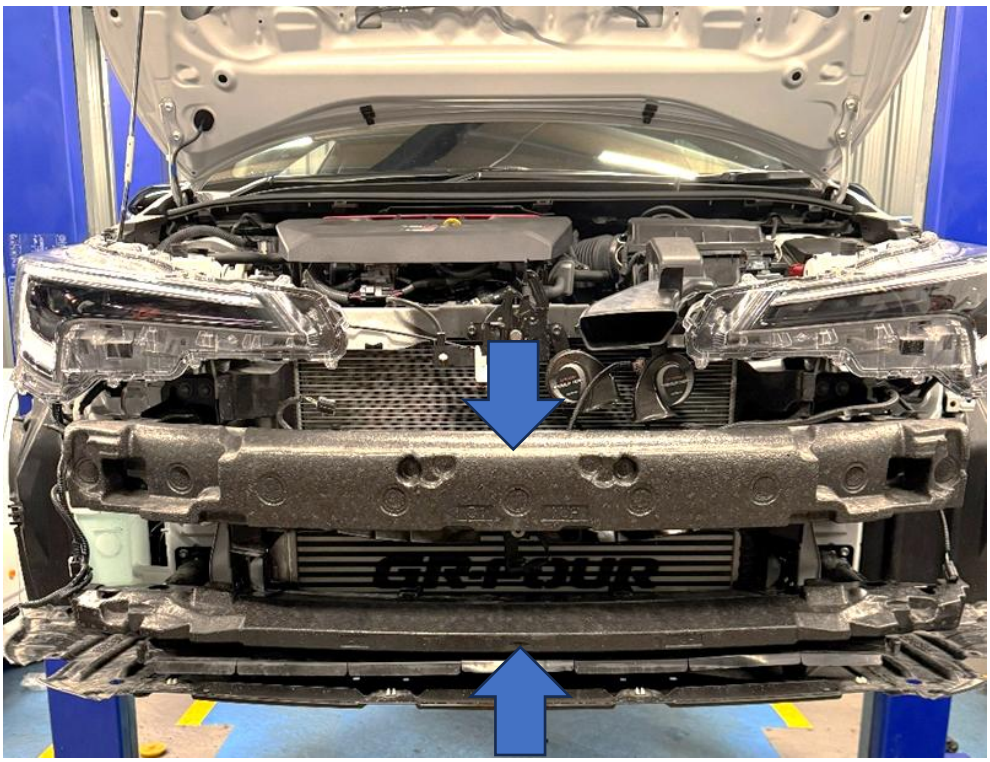


5. Now pull the bumper away from the arch and with the help of a second person, disconnect the fog light wiring plug each side before removing the bumper.



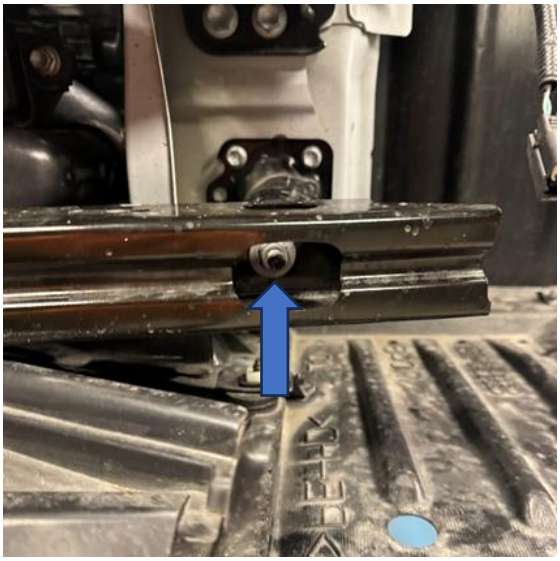


6. Remove the top and bottom foam coverings from the crash bars by pulling them free.



7. Undo the two 12mm nuts securing the lower bar in place and remove it along with the plastic guide.



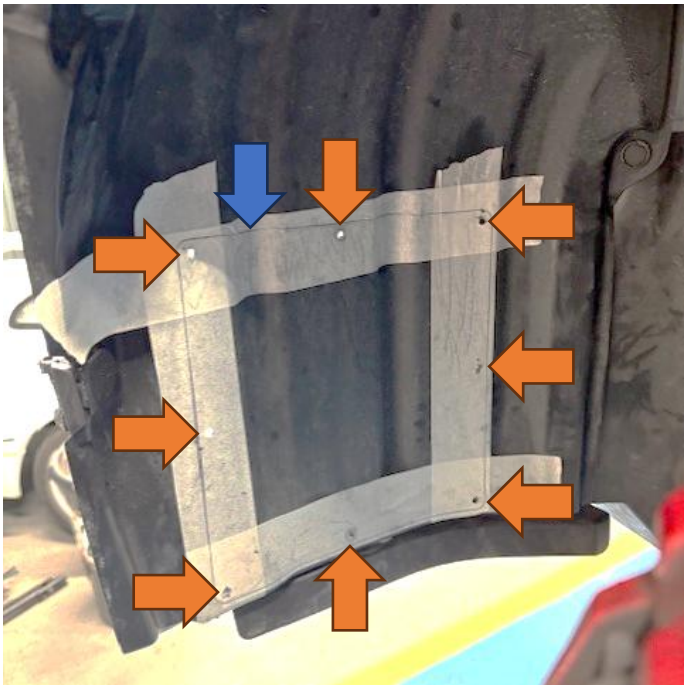


8. Now remove the right-hand side front wheel (when **facing** the car).



9. Use masking tape to mark the front of the inner arch liner as shown and then place the AIRTEC Motorsport inner arch liner grille supplied in the kit over the top. Then using a pen, mark the outline of the grille (blue arrow) as well as the eight drilling locations (orange arrows).

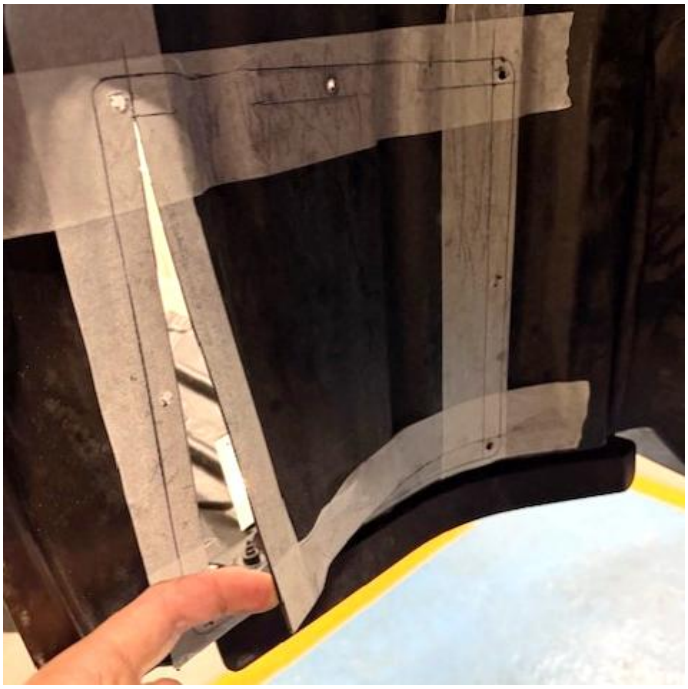




10. Take a 5mm drill bit and drill out the eight hole locations. Then measure and draw a line 14mm **inset** from the existing outline, as shown.



11. Using a sharp knife, carefully cut out the **inner** line marked in the last step.





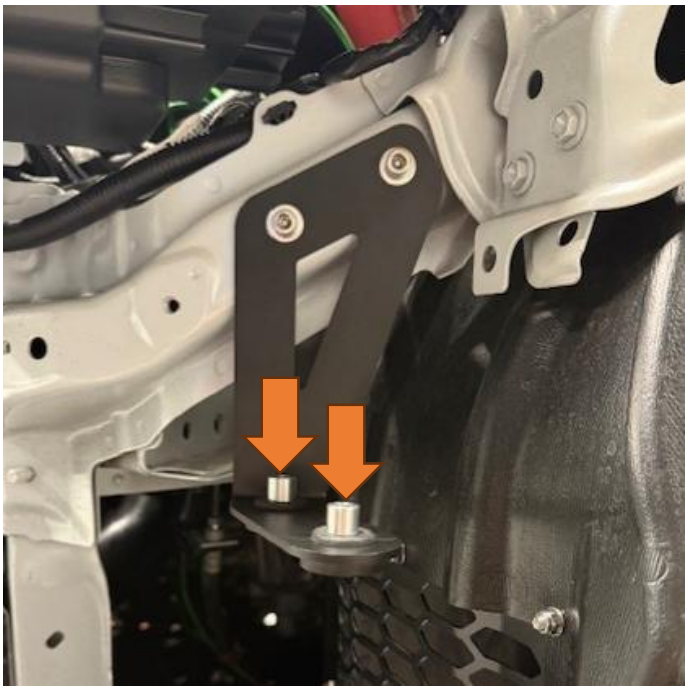
12. Now mount the mesh grille supplied in the kit with the eight M5x12mm Button Head bolts with Nyloc nuts and washers provided. Make sure the washers are place on the wheel arch side of the bolt.





13. Next, use two of the M6x16mm Socket Head bolts and 15mm washers supplied in the kit to secure the top mounting bracket to the car using the existing threads on the inner wing (blue arrows). You can then insert two of the rubber anti-vibration bushes provided into the bracket with the large section underneath. Secure using the supplied aluminium inserts in the centre (orange arrows).





14. Now take the bottom mounting bracket supplied in the kit and install the other anti-vibration rubber bushes provided and with the larger section facing upwards, as shown. Then install the remaining aluminium inserts.



15. Use two M6x18mm Button Head bolts with 18mm washers supplied in the kit to bolt the bottom mounting bracket assembly through the aluminum inserts and onto the oil cooler, as shown.



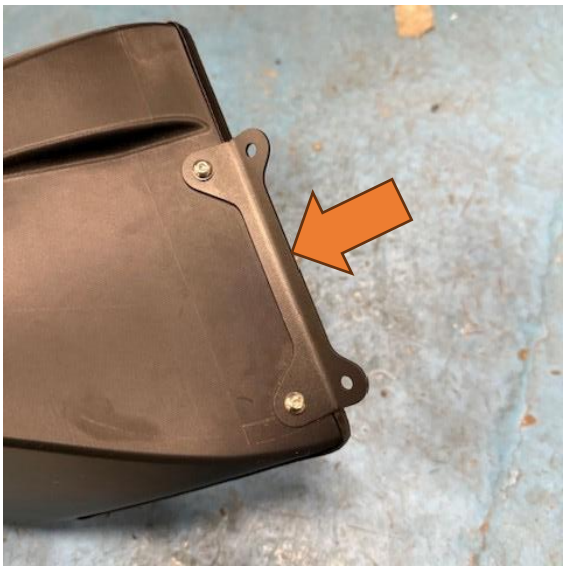
16. Now fit the oil cooler assembly onto the top mounting bracket using two M6x18mm Button Head bolts with washers but do not fully tighten yet. Then use two M6x16mm Socket Head bolts with 15mm washers and secure the lower mounting bracket to the car (orange arrows). Then fully tighten all bolts.

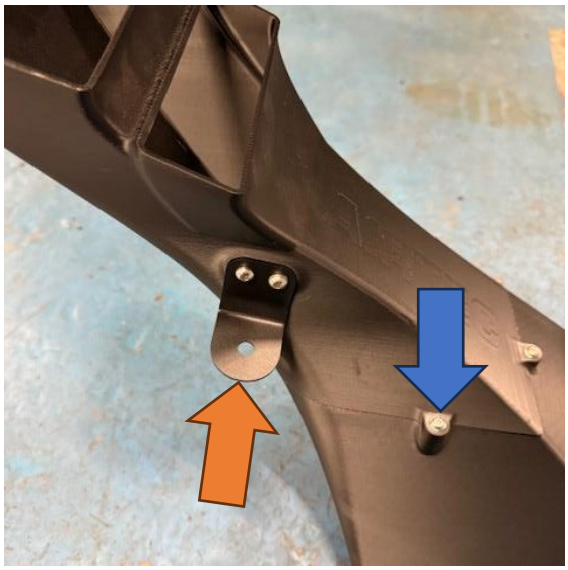


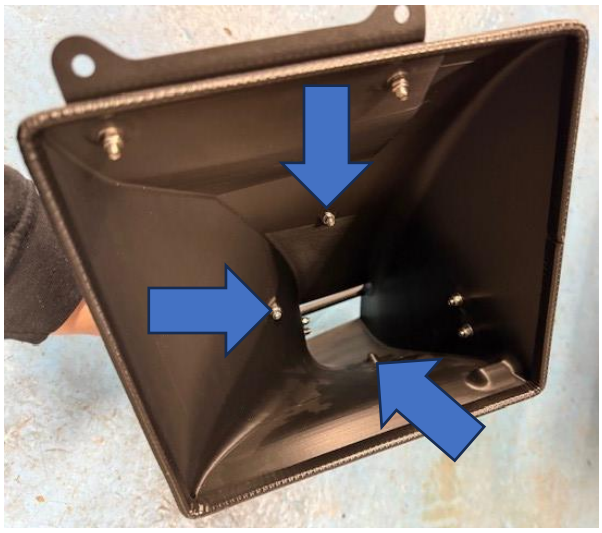


17. Secure the two-piece air duct together using the M4 bolts, washers and Nyloc nuts provided (blue arrows). The bolts come in three sizes (2x 25mm, 1x 30mm and 1x 35mm) that can only be fitted in their correct locations, so trial fit each size loosely first before fully tightening.
    When finished, you can then attach the three mounting brackets (orange arrows) to the duct using the six M5x16mm Button Head bolts, 12 washers and six Nyloc nuts supplied.
    Then attach the small rubber trim supplied in the kit around the rear of the duct (green arrow).









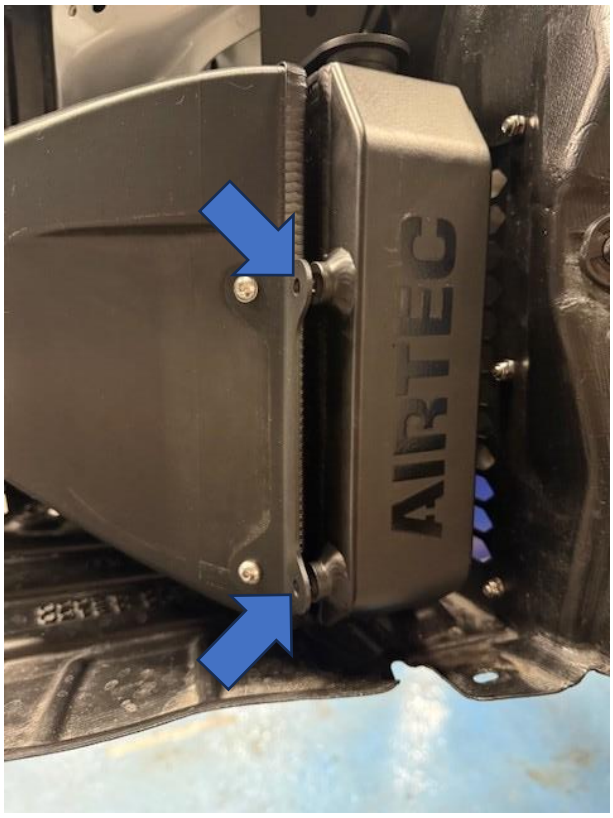


18. Now fit the air duct assembly to the car by sliding the front lower bracket over the lower crash bar post (blue arrow). Locate the upper mounting bracket bolt hole on the car (orange arrow) and secure with the M8 bolt and washer provided.

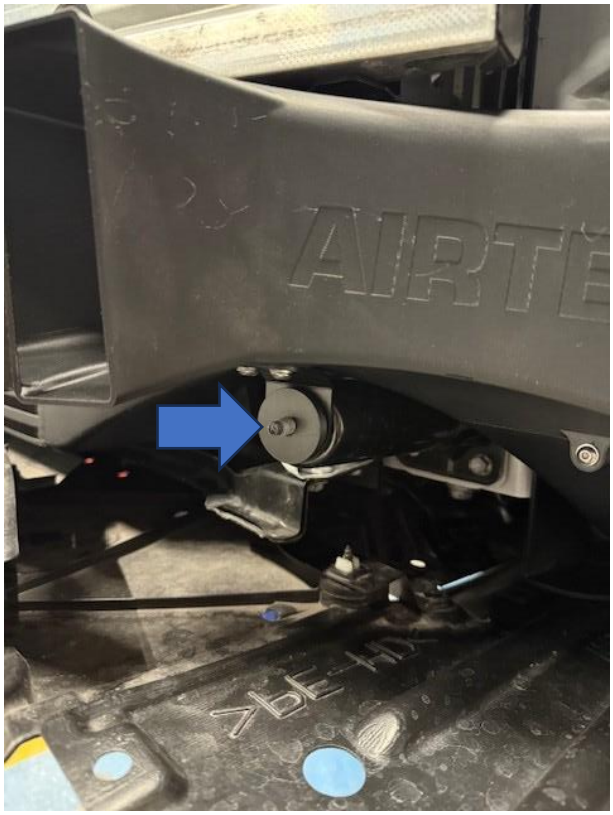




19. Now attach the rear of the air duct to the front of the oil cooler using two of the provided M5x12mm Button Head bolts with small washers.



20. Before reinstalling the lower crash bar, fit the 5mm spacer supplied in the kit over the front lower air duct mounting bracket, as shown (blue arrow). On the other side, place the 7mm spacer provided over the other threaded post that secures the crash bar (orange arrow). Then refit the crash bar using the original nuts.



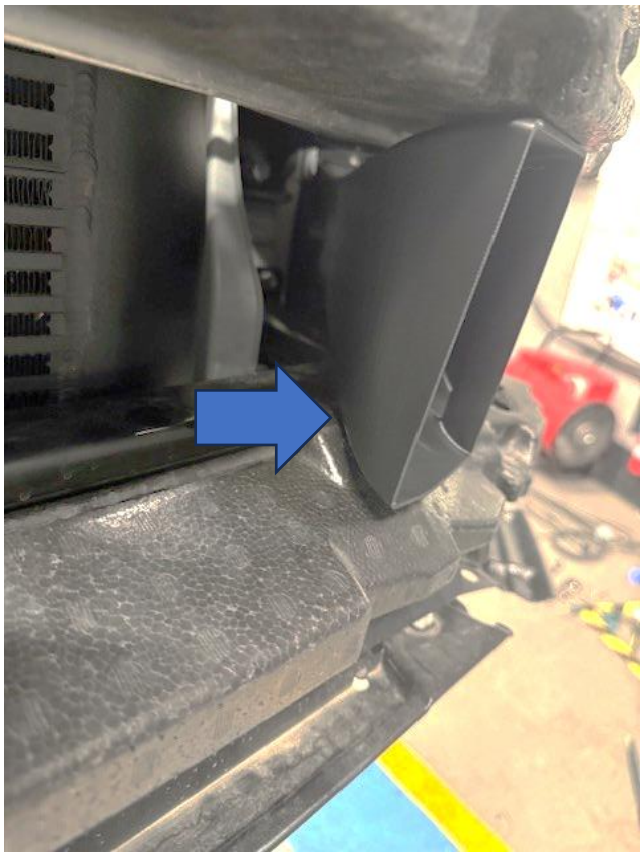


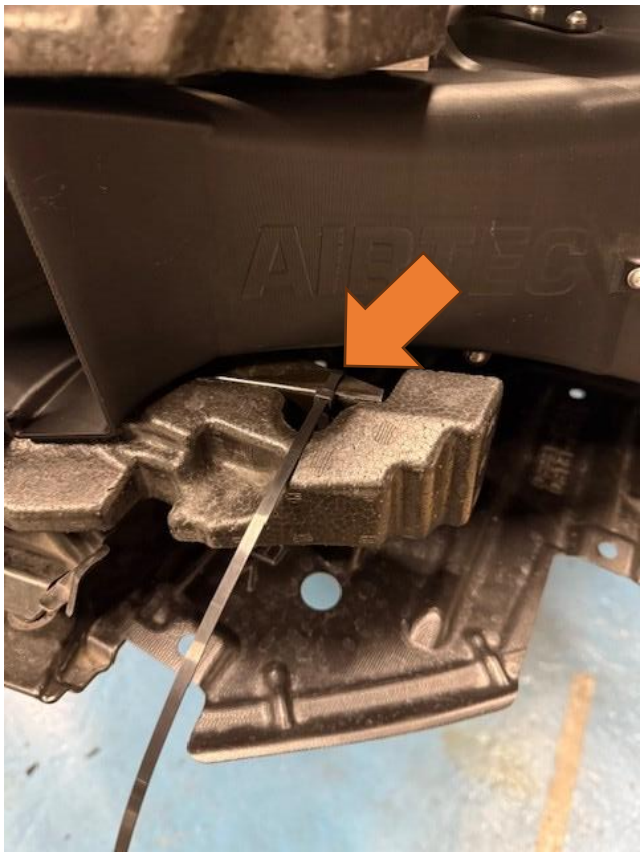
21. Now refit the foam cover over the top crash bar.



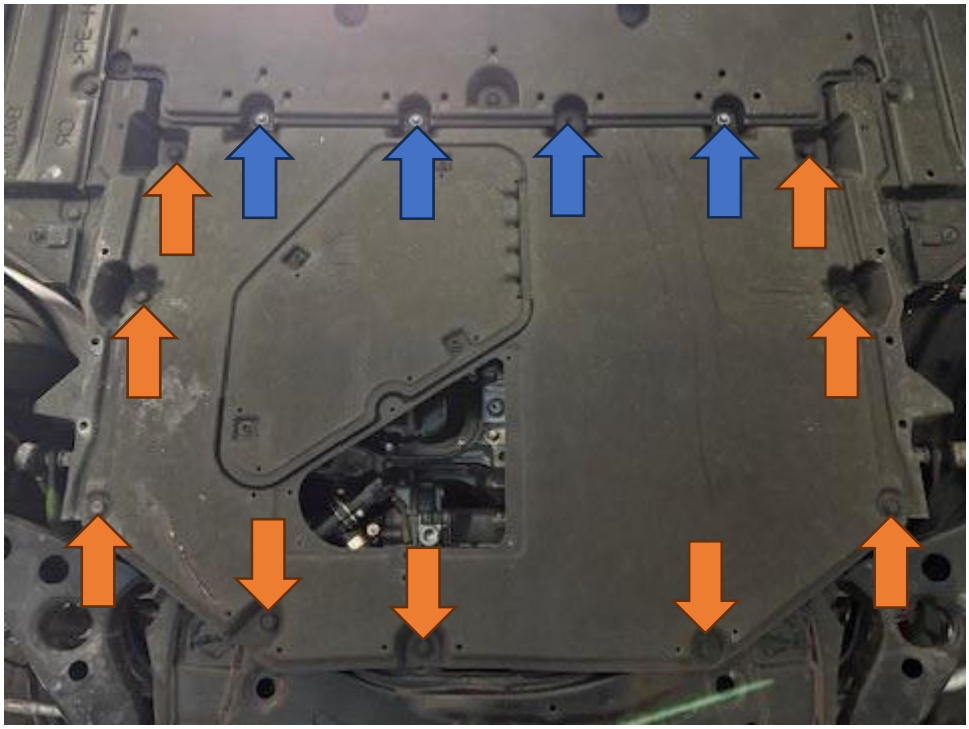
22. The foam cover for the lower crash bar will need trimming for the air duct (blue arrow). Use a sharp knife to slowly trim the foam until it fits. Then secure the foam to the crash bar with a cable tie (orange arrow).







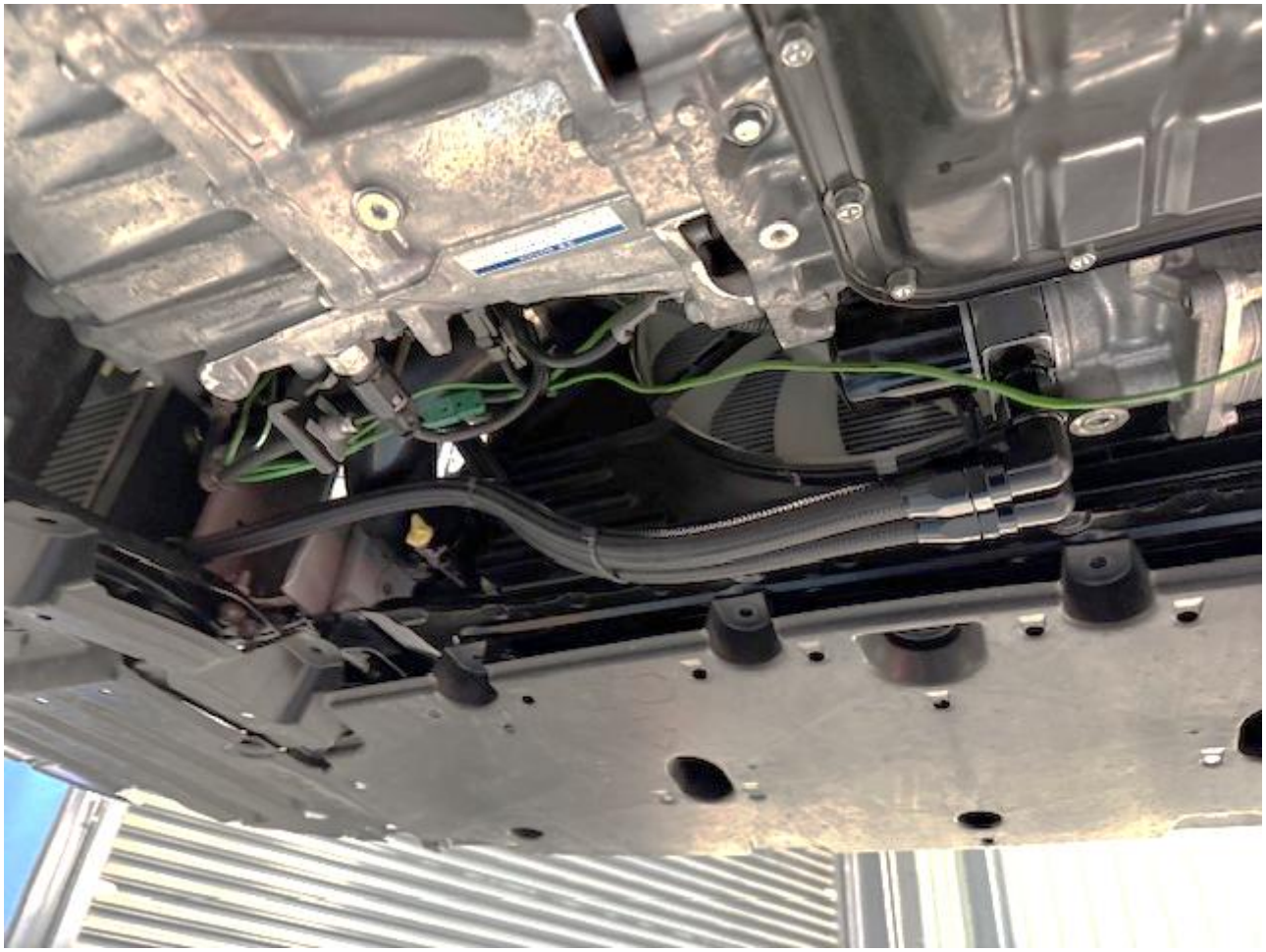
23. Remove the under tray by undoing the four bolts (blue arrows) and nine push fit clips (orange arrows).



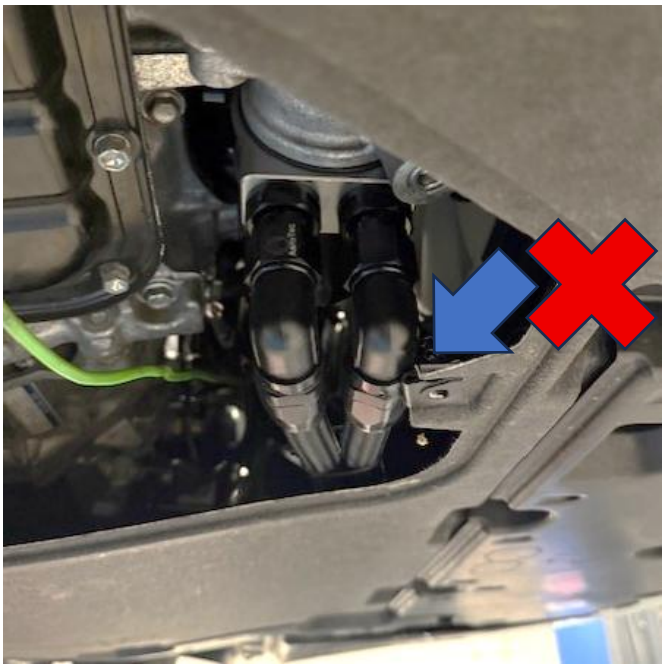
24. Locate and remove the oil filter and fit the AIRTEC Motorsport sandwich plate supplied in the kit and secure with the centre bolt provided. Then fit the oil filter; we recommend fitting a new one.
Please note: It is beneficial to angle the sandwich plate slightly towards the engine so there is sufficient clearance when the under tray goes back on – please see Step 26 for more information.

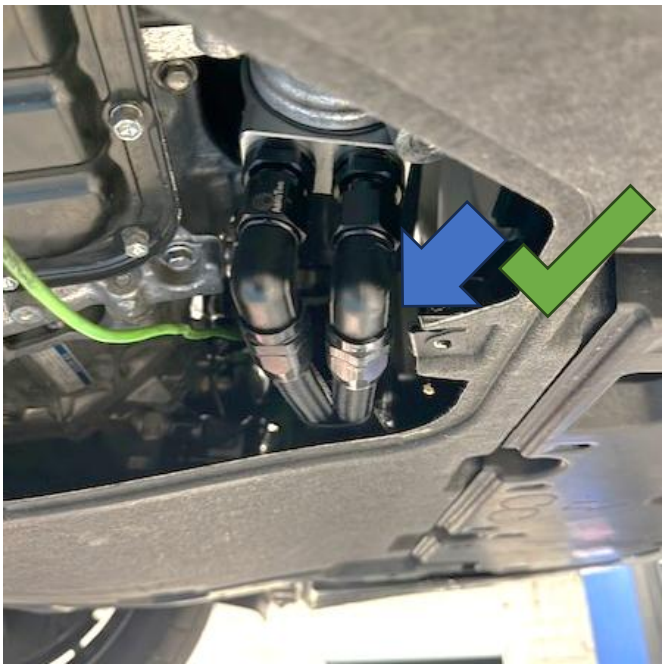


25. Attach and secure the oil lines from the sandwich plate to the oil cooler as shown. Secure the lines together with the cable ties provided in the kit and once everything is tight, reinstall the undertray.



26. Make sure the oil lines are not rubbing on the inspection panel cover bolt. If they do, the whole sandwich plate assembly may need to be adjusted.





27. Before refitting the front bumper, remove the original air duct by undoing the three screws.



28. Finally, top up the oil and start the car. Look immediately for leaks from any of the four connections and the oil filter. If there is, turn the engine off and retighten the fittings if needed.
    Then let the car get to full operating temperature, recheck the oil level and top up if required. Once the level is correct, refit the bumper in reverse of removal.

