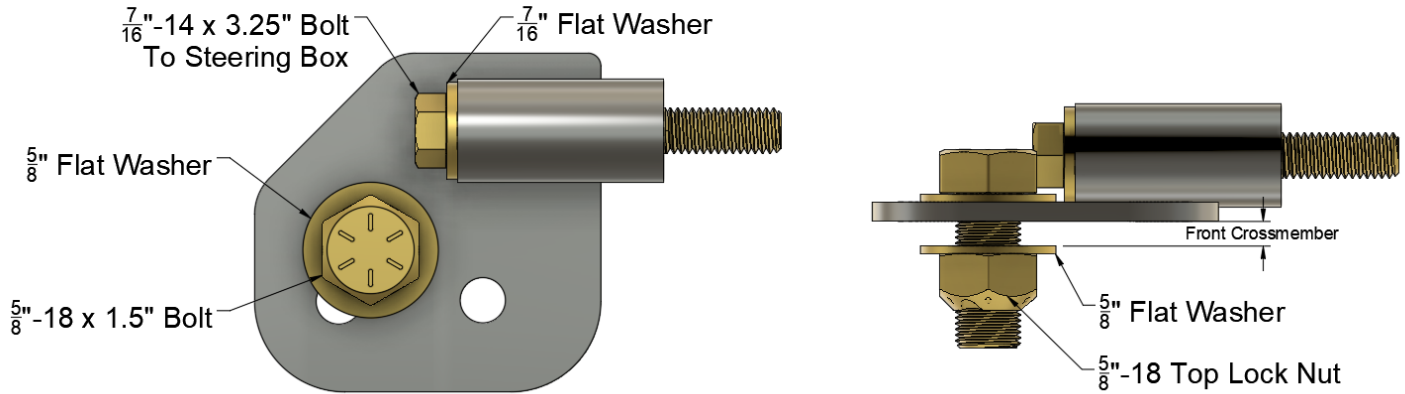
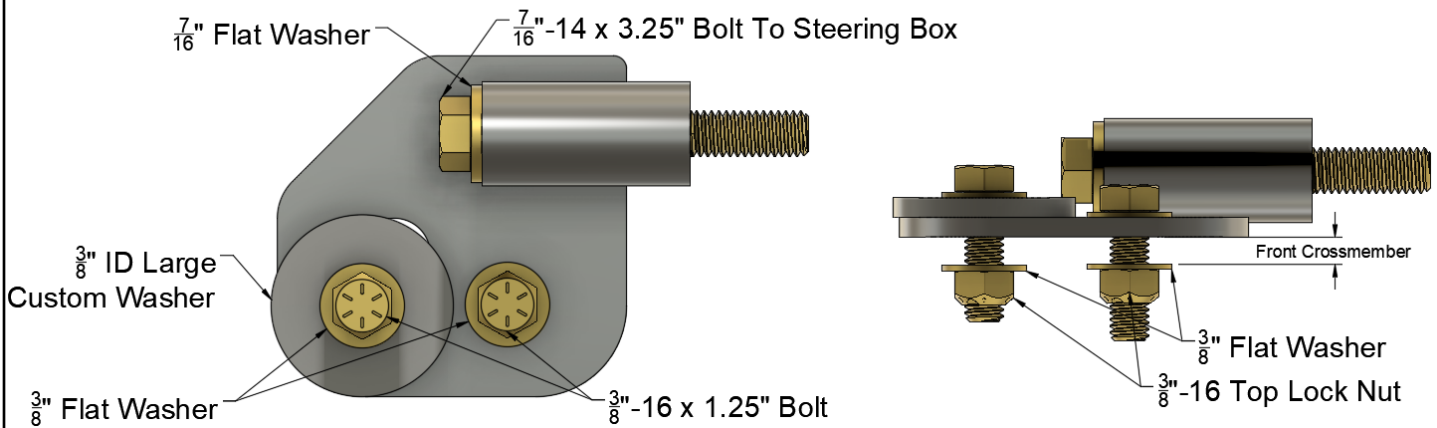


1973-1980 Vehicles Only



1981-1991 Vehicles Only

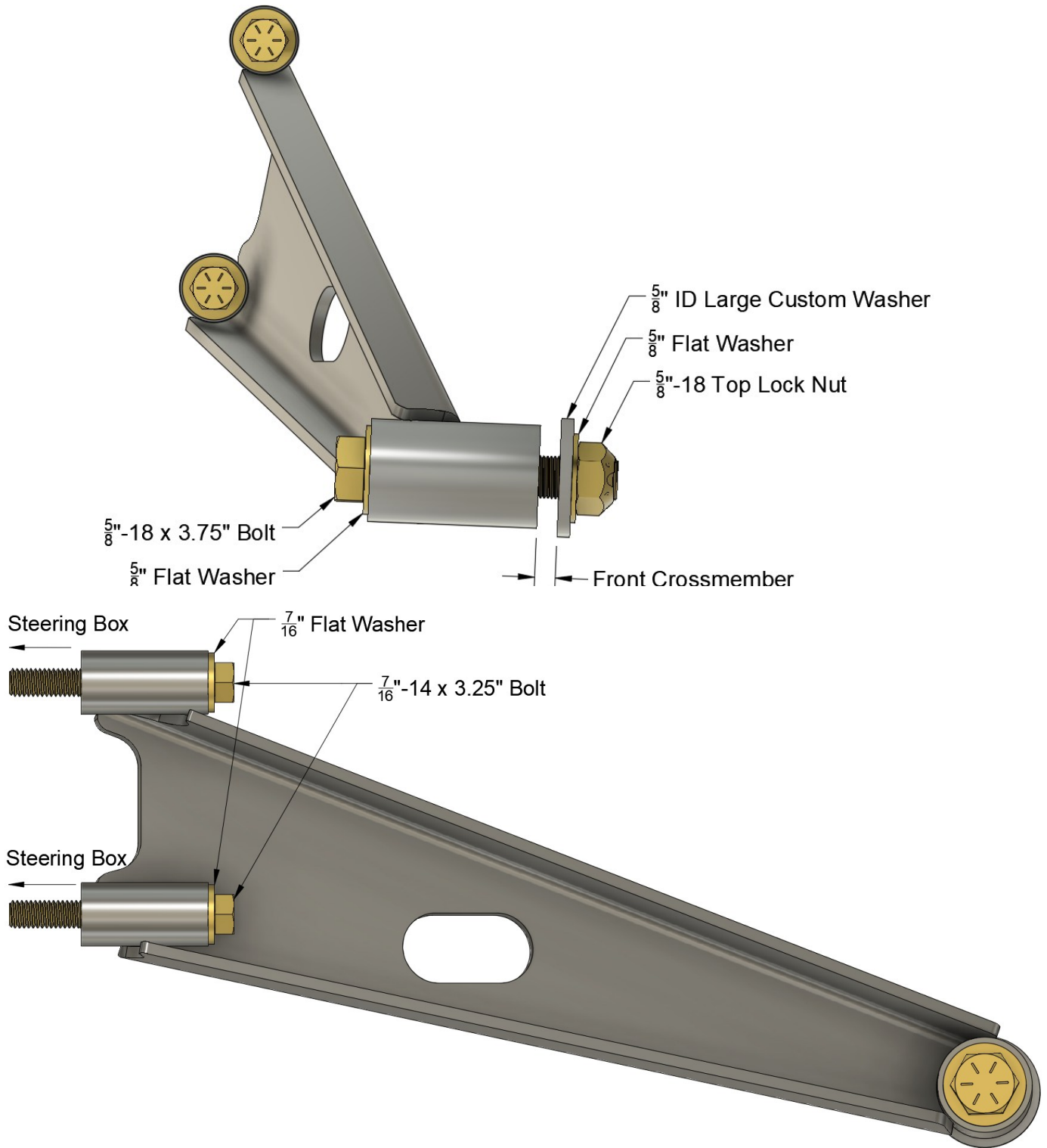


1967-1972 4WD GMC/Chevy Trucks Installation

1. Remove the two rearward steering box bolts and sleeves.
2. Install the two remaining 3.5" (67-72) bolts through the main steering box brace bracket and snug them up into the steering box.
3. Mark the crossmember by pushing a marker or punch through the end of the steering box brace. Remove the steering box brace from the truck.
4. Drill a 1/2" hole through the crossmember where marked. Make sure to watch out for brake lines and hoses.
5. Re-install the steering box brace using the provided 1/2"-13 x 1.25" bolt and washers through the crossmember.
6. Torque all bolts to appropriate values in table on previous page. Steering box bolts are a periodic maintenance point, especially with hard off-road use. Make sure they stay tight, check them often.

1973-1991 4WD GMC/Chevy Trucks Installation

1. Remove the two rearward steering box bolts and sleeves.
2. Install the two remaining $\frac{7}{16}$ "-14 x 3.25" bolts through the main steering box brace bracket and snug them up into the steering box. Starting in the early 80's many GM trucks came with oil coolers that may interfere with the larger brace, we have added a hole to the body of the brace for your oiler cooler lines to pass through.
3. Mark the crossmember by pushing a marker or punch through the end of the steering box brace. Remove the steering box brace from the truck.
4. Drill a $\frac{5}{8}$ " (73-91) hole through the crossmember where marked. Make sure to watch out for brake lines and hoses.
5. Re-install the steering box brace using the provided $\frac{5}{8}$ "-18 x 3.75" bolt and washers through the crossmember. The 1-3/4" large washer will be installed on the front side of the crossmember in conjunction with the standard $\frac{5}{8}$ " washer (see illustration).
6. Torque all bolts to appropriate values in table on previous page. Steering box bolts are a periodic maintenance point, especially with hard off-road use. Make sure they stay tight, check them often.



1973-1991 2WD GMC/Chevy Trucks Installation

1. Remove the two forward most steering box bolts and spacers.
2. Install two of the provided 7/16"-14 x 3.25" bolts and washers into the steering box holes.
3. Mark the crossmember by pushing a marker or punch through the end of the steering box brace. Remove the steering box brace from the truck.
4. Drill a 5/8" hole through the crossmember where marked, make sure to watch out for brake lines and hoses.
5. Re-install the steering box brace using the provided 5/8"-18 x 1.5" bolt and washers through the crossmember.
6. Torque all bolts to appropriate values in table on previous page.