

Part # GU29001, GU39000, GU39001-2WD Instructions

Bolt-In Steering Box Brace Kits for 1967-1991 Full-Size GMC/Chevy

GU29001 Bill of Materials				GU39000 Bill of Materials		GU39001-2WD Bill of Materials	
QTY	Description		QTY	Description	QTY	Description	
1	GU29001 - 67-72 4	WD Brace	1	GU39000-1 - Brace	1	GU39001-2WD Brace	
1	GU29001 - Front Clip		1	GU39000-2 - Front Clip	2	7/16"-14 x 3.5" Grade 8 Bolt	
3	7/16"-14 x 3.5" Grade 8 Bolt		1	GU39000-3625" Washer	2	7/16" Grade 8 SAE Flat Washer	
3	7/16" Grade 8 SAE Flat Washer		1	GU39000-4375" Washer	1	5/8"-18 x 1.5" Grade 8 Bolt	
1	1/2"-13 x 1.25" Grade 8 Bolt		2	3/8"-16 x 1.25" Grade 8 Bolt	1	5/8"-18 Grade C Top Lock Nut	
1	1/2"-13 Grade C Top Lock Nut		2	3/8"-16 Grade C Top Lock Nut	2	5/8" Grade 8 SAE Flat Washer	
2	2 1/2" Grade 8 SAE Flat Washer		4	3/8" Grade 8 SAE Flat Washer			
2	2 3/8"-16 x 1.25" Grade 8 Bolt		3	7/16"-14 x 3.25" Grade 8 Bolt			
2	3/8"-16 Grade C Top Lock Nut		3	7/16" Grade 8 SAE Flat Washer			
4	3/8" Grade 8 SAE Flat Washer		1	5/8"-18 x 3.75" Grade 8 Bolt			
			2	5/8"-18 Grade C Top Lock Nut			
			4	5/8" Grade 8 SAE Flat Washer			
			1	5/8"-18 x 1.5" Grade 8 Bolt		67-'87 ('91) straight axle GM trucks otorious for frame problems be-	
Torque Specs						the steering box, even with stock	
Bolt Size Torque Spec Locations					nt tires. Large tires and lockers only		
3/8" 24 ft-lb Front C		Front Crossme	nt Crossmember Clip (67-72, 81-91 4wd)			e the flex problems worse and flex	
7/16" 80 ft-lb		Steering Gear Box Bolts (All Braces)				tually leads to cracks. This steer- ox brace goes to the source of the	
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'67-'72 4WD GMC/Chevy Trucks "Clip" Installation

The small bracket or "clip" goes on the front side of the crossmember. Remove the front lower steering box bolt. Install the clip with the provided 7/16"-14 x 3.5" bolt and washer, the bolt will pass through the clip tube and thread into the lower front steering box hole. Next install the two provided 3/8"-16 x 1.25" bolts and washers through the two existing crossmember holes. Some enlarging of the existing crossmember holes may be required.

Front Crossmember Through Main Brace (67-72)

Front Crossmember Brace and Clip (73-91 2wd & 4wd)

1973-1980 4WD GMC/Chevy Trucks "Clip" Installation

The small bracket or "clip" goes on the front side of the crossmember. Remove the front upper steering box bolt and spacer. Install the clip with the provided 7/16"-14 x 3.25" bolt and washer, the bolt will pass through the clip tube and thread into the front upper steering box hole. Next install the provided 5/8"-18 x 1.5" bolt and washers through the existing crossmember hole. Some enlarging of the existing crossmember hole may be required.

1981-1991 4WD GMC/Chevy Trucks "Clip" Installation

The small bracket or "clip" goes on the front side of the crossmember. Remove the front upper steering box bolt and spacer. Install the clip with the provided 7/16"-14 x 3.25" bolt and washer, the bolt will pass through the clip tube and thread into the front upper steering box hole. Next install the two provided 3/8"-16 x1.25" bolts and washers through the two existing crossmember holes, the bolt closest to the center of the truck will also use the provided 1-3/4" washer between the clip and standard 3/8" washer (see illustration).

1/2"

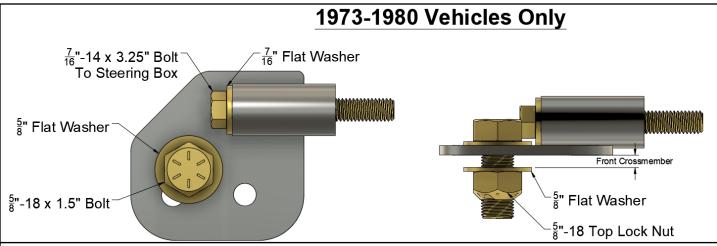
5/8"

59 ft-lb

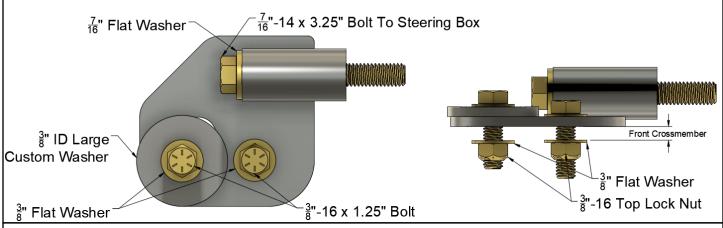
125 ft-lb

problem by stopping the flex before

cracks can start.



1981-1991 Vehicles Only

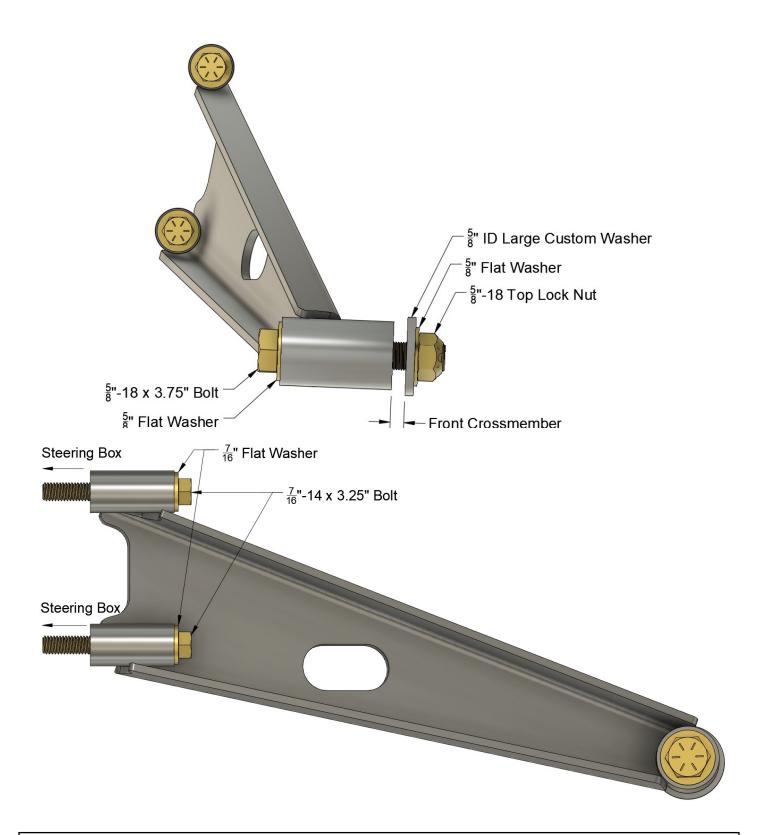


1967-1972 4WD GMC/Chevy Trucks Installation

- 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 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 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 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 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.