



INSTALLATION INSTRUCTIONS FOR MOUNTING

LUVERNE GRILL GUARDS WITH THE FOLLOWING MODEL NOS.:
C9900T & C9925TB ON:

1999 AND NEWER SILVERADO 1500 & 2500 SERIES PICKUPS
2001 AND NEWER SILVERADO 1500 HEAVY DUTY

1. READ THE INSTRUCTIONS COMPLETELY AND CHECK TO MAKE SURE THAT ALL OF THE REQUIRED PARTS ARE ON HAND BEFORE STARTING THE INSTALLATION. THE CARTON SHOULD CONTAIN:
 - (1) CENTER RING ASSEMBLY
 - (1) END RING, RH
 - (1) END RING, LH
 - (1) UPRIGHT ASSEMBLY, RH
 - (1) UPRIGHT ASSEMBLY, LH
 - (1) END CAP PACKAGE
 - (1) HARDWARE PACKAGE
 - (1) CUSTOMER SERVICE PACKAGE

REFER TO SHEET #3 FOR GUARD ASSEMBLY INSTRUCTIONS 2-5

2. PLACE THE CENTER RING ASSEMBLY (1) FACE DOWN ON A SCRATCH-FREE SURFACE SUCH AS THE SHIPPING CARTON. INSTALL THE END RINGS (2) & (3) INTO THE ENDS OF THE CENTER RING ASSEMBLY, ALIGNING THE HOLES IN THE PARTS AS SHOWN IN FIG. 1.
3. INSTALL THE 3/8" X 1-3/4" HEX BOLTS (12) THROUGH THE HOLES IN THE RING FROM THE **BACKSIDE** OF THE GUARD AS SHOWN IN FIG. 2 AND INSTALL THE 3/8" SERRATED FLANGE NUTS (14). TIGHTEN THE BOLTS UNTIL THE CENTER RING ASSEMBLY TUBE COMPRESSES ON THE END RING TUBE AND THERE IS NO MOVEMENT IN THE END RING TUBE. WHEN FINISHED TIGHTENING, **ONE OF THE FLATS ON THE BOLT HEAD SHOULD BE PARALLEL WITH THE RING** SO THAT THE STOP INSIDE OF THE UPRIGHT CAP WILL REST ON THE FLAT AREA.
4. INSTALL THE RIGHT (4) & LEFT (5) UPRIGHTS ON THE RING ASSEMBLY (1) AS SHOWN IN FIG. 3, MAKING SURE THEY ARE CENTERED AND PARALLEL WITH THE BARS IN THE RING. FASTEN, USING THE 1/2" SERRATED FLANGE NUTS (13) ON EACH OF THE FOUR (4) STUDS. TIGHTEN ALL FOUR (4) NUTS AT THIS TIME

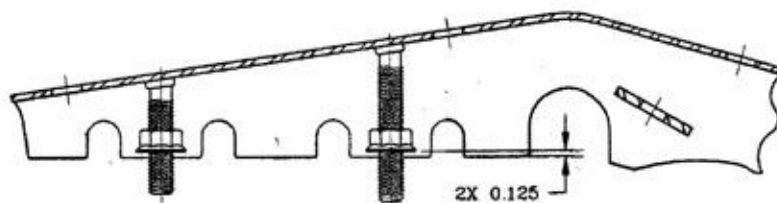
NOTE 1: MAKE SURE THE SERIAL NO. DECAL IS AT THE TOP OF THE GUARD.

NOTE 2: WHEN THE UPRIGHTS ARE ATTACHED TO THE RING THEY REST AGAINST THE SERRATED FLANGE NUTS (13) THAT ARE THREADED ONTO THE STUDS. THE DEPTH OF THESE NUTS IS SET AS CLOSE AS POSSIBLE AT THE FACTORY (SEE FIG. 8 ON SHEET #2) BUT WHEN THE GUARD IS INSTALLED THESE NUTS MAY NEED SOME MINOR ADJUSTMENTS TO ALLOW THE BEST POSSIBLE FIT. WHEN THE UPRIGHT IS ON THE RING THERE SHOULD BE APPROXIMATELY 1/32" OF GAP BETWEEN THE 5/8" DIAMETER TUBES AND THE BOTTOM OF THE SLOTS IN THE UPRIGHT. **THE UPRIGHTS MUST BE DEEP ENOUGH TO ALLOW THE UPRIGHT CAP TO FIT OVER THE FACE OF THE RUBBER.**

5. INSTALL THE RIGHT (9) & LEFT (10) UPRIGHT CAPS AS SHOWN IN FIG. 4.
6. REMOVE THE RADIATOR SHROUD & GRILL. (SEE SHEET #201620)

REFER TO FIGURES 5& 6 FOR INSTALLATION STEPS 7-18

7. REMOVE THE TWO (2) TOP BOLTS THAT SECURE THE BUMPER TO THE FRAME
8. INSTALL THE TOP RIGHT HAND (16) & LEFT HAND (17) MOUNTING BRACKETS, SPACERS (18), 1/2" LOCK WASHERS (27) AND 12M X 80mm BOLTS (22) ON THE BUMPER, AS SHOWN IN FIGS. 5 & 6.
9. INSERT THE 7/16" X 3-1/4" HEX BOLTS (23) AND 7/16" LOCK WASHERS (28) INTO THE HOLES IN THE TOP MOUNTING BRACKETS.
10. INSTALL THE FOUR (4) RUBBER TRIM CHANNELS (21) ON THE BOTTOM OF THE UPRIGHTS.
11. SET THE GRILL GUARD UP TO THE FRONT BUMPER AND MAKE SURE THE BOLTS (23) IN THE TOP MOUNTING BRACKETS LINE UP WITH THE CAGE NUTS (15) IN THE GRILL GUARD UPRIGHT.
12. REMOVE THE GRILL GUARD AND TIGHTEN THE M12 BOLTS (22) THAT SECURE THE MOUNTING BRACKETS.
13. REINSTALL THE GRILL & RADIATOR SHROUD.
14. SET THE GRILL GUARD UP TO THE FRONT BUMPER AND START THE TOP BOLTS IN THE MOUNTING CLAMPS INTO THE NUTS IN THE UPRIGHT. FINGER TIGHTEN ONLY.
15. ATTACH THE BOTTOM MOUNTING BRACKETS TO THE BOTTOM OF THE UPRIGHTS WITH THE 7/16" X 1" HEX BOLTS (24) AND 7/16" LOCK WASHERS (28). FINGER TIGHTEN ONLY. (REFER TO DRAWING FIGS. 5 & 6 TO DETERMINE WHICH BOTTOM MOUNTING BRACKET SYSTEM TO USE.)
16. IF GUARD IS BEING MOUNTED ON A 1/2 TON PICKUP HOOK THE 1/2" X 4" "J" BOLT WITH THE 9/16" OPENING (25) INTO THE 1-3/16" DIAMETER HOLE IN THE BOTTOM OF THE FRAME AND THE HOLE IN THE BOTTOM MOUNTING BRACKET. SECURE WITH A 1/2" SERRATED FLANGE NUT (13). TIGHTEN THE 7/16" X 1" BOLT (24) IN THE BOTTOM OF THE UPRIGHT. IF THE GUARD IS BEING MOUNTED ON A 3/4 TON 4X4 PICKUP, HOOK THE 1/2" X 4" "J" BOLT WITH THE 1-3/8" OPENING (26) OVER THE OUTSIDE BOSS ON THE TOW HOOK INSIDE OF THE FRAME AND THE HOLE IN THE BOTTOM MOUNTING BRACKET. SECURE WITH A 1/2" SERRATED FLANGE NUT (13). TIGHTEN THE 7/16" X 1" BOLT (24) IN THE BOTTOM OF THE UPRIGHT. IF THE GUARD IS BEING MOUNTED ON A 3/4 TON 4X2 PICKUP, USE AN ACC99 BRACKET KIT (29) AND INSTALL THE 7/16" X 4" HEX BOLT AND 7/16" SERRATED FLANGE NUT THROUGH THE 1/2" HOLE IN THE LOWER SIDE OF THE FRAME. HOOK THE BOTTOM FRAME MOUNTING BRACKET OVER THE 4" BOLT INSIDE THE FRAME AND FASTEN TO THE BOTTOM UPRIGHT MOUNTING BRACKET WITH THE 7/16" X 1-3/4" BOLT AND FLANGE NUT. TIGHTEN THE 7/16" X 1" BOLT (24) IN THE BOTTOM OF THE UPRIGHT.
17. CHECK THAT THE GRILL GUARD IS CENTERED ON THE BUMPER AND THE TOP MOUNTING BRACKETS ARE IN THE PROPER POSITION. (THE TOP BOLTS SHOULD BE PERPENDICULAR TO THE BACK OF THE UPRIGHT AND NOT AT AN ANGLE.) TIGHTEN UP THE 12M BOLTS (22) SECURING THE BUMPER AND MOUNTING BRACKETS.
18. TIGHTEN UP THE TOP BOLTS SECURING THE TOP OF THE UPRIGHTS. NEXT TIGHTEN THE BOTTOM BRACKETING. RECHECK AND TIGHTEN UP THE TOP BOLTS IF REQUIRED.



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2. PLACE THE CENTER RING ASSEMBLY (1) FACE DOWN ON A SCRATCH-FREE SURFACE SUCH AS THE SHIPPING CARTON. INSTALL THE END RINGS (2) & (3) INTO THE ENDS OF THE CENTER RING ASSEMBLY, ALIGNING THE HOLES IN THE PARTS AS SHOWN IN FIG. 1.

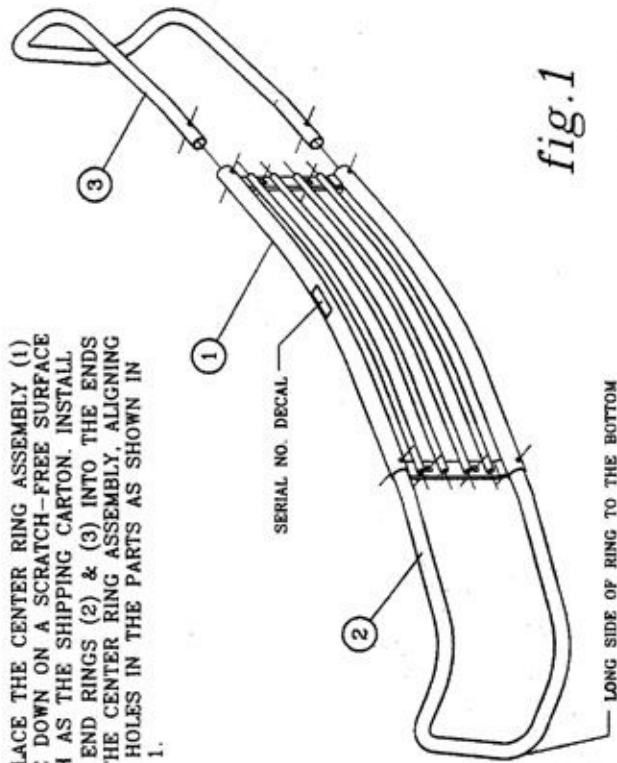


fig.1

3. INSTALL THE 3/8" X 1-3/4" HEX BOLTS (12) THROUGH THE HOLES IN THE RING FROM THE BACK SIDE OF THE GUARD AS SHOWN IN FIG. 2 AND INSTALL THE 3/8" SERRATED FLANGE NUTS (14). SEE SHEET 1 STEP #3 FOR BOLT TIGHTENING PROCEDURE.

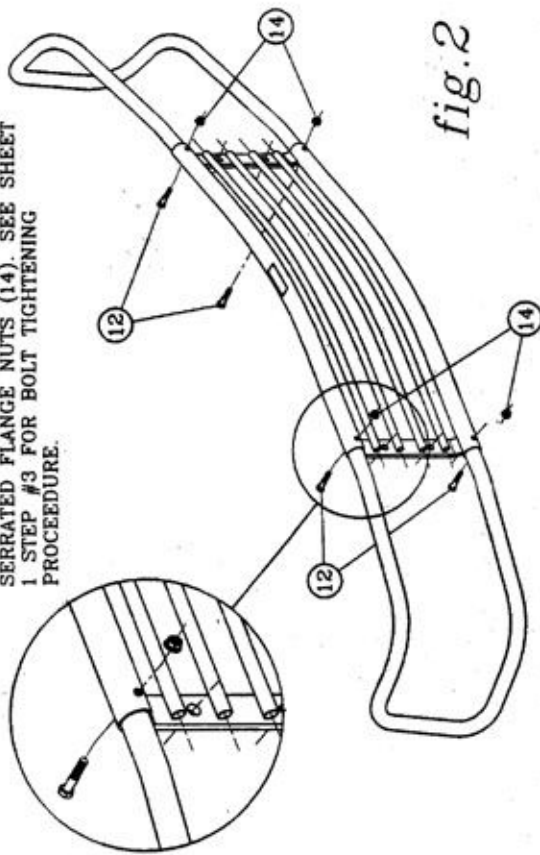


fig.2

4. INSTALL THE RIGHT (4) & LEFT (5) UPRIGHTS ON THE RING ASSEMBLY (1) AS SHOWN IN FIG. 3, MAKING SURE THEY ARE CENTERED AND PARALLEL WITH THE BARS IN THE RING. FASTEN, USING THE 1/2" SERRATED FLANGE NUTS (13) ON EACH OF THE FOUR (4) STUDS, TIGHTEN ALL FOUR (4) NUTS AT THIS TIME. SEE NOTES 1 & 2 IN STEP #4 SHEET 1 FOR MORE DETAIL ON ADJUSTMENT.

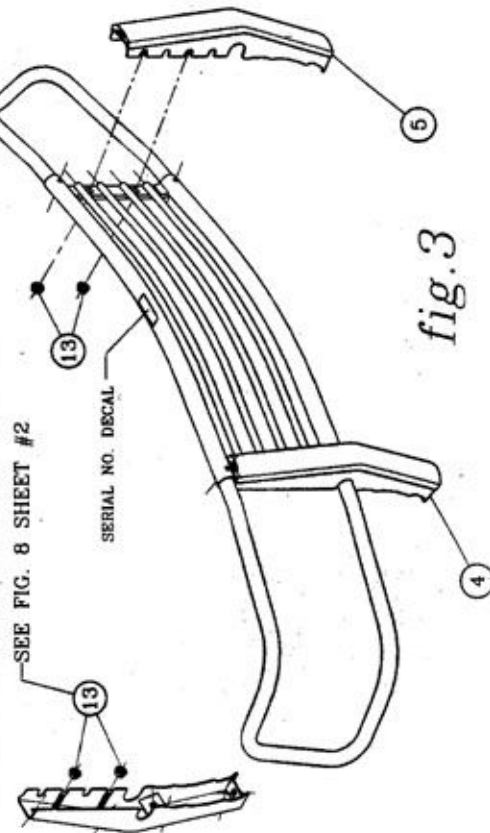


fig.3

5. INSTALL THE RIGHT (9) & LEFT (10) UPRIGHT CAPS AS SHOWN IN FIG. 4. REFER TO STEPS 7-18 FOR INSTALLATION OF THE GUARD ON THE VEHICLE

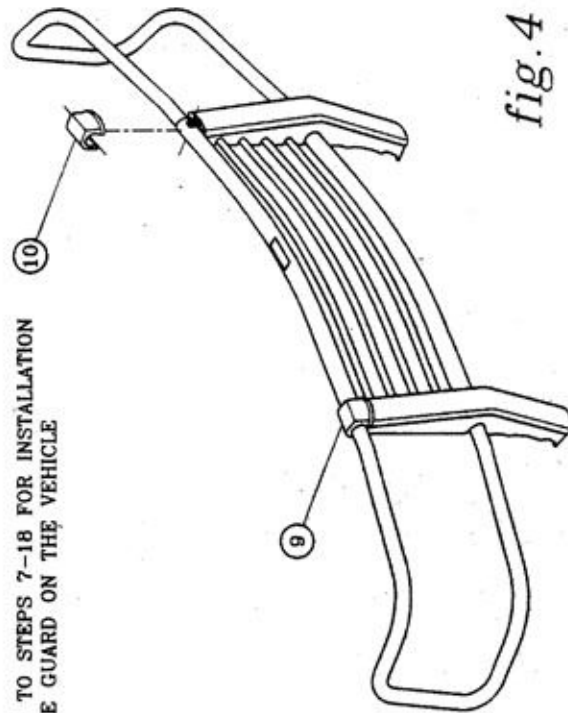
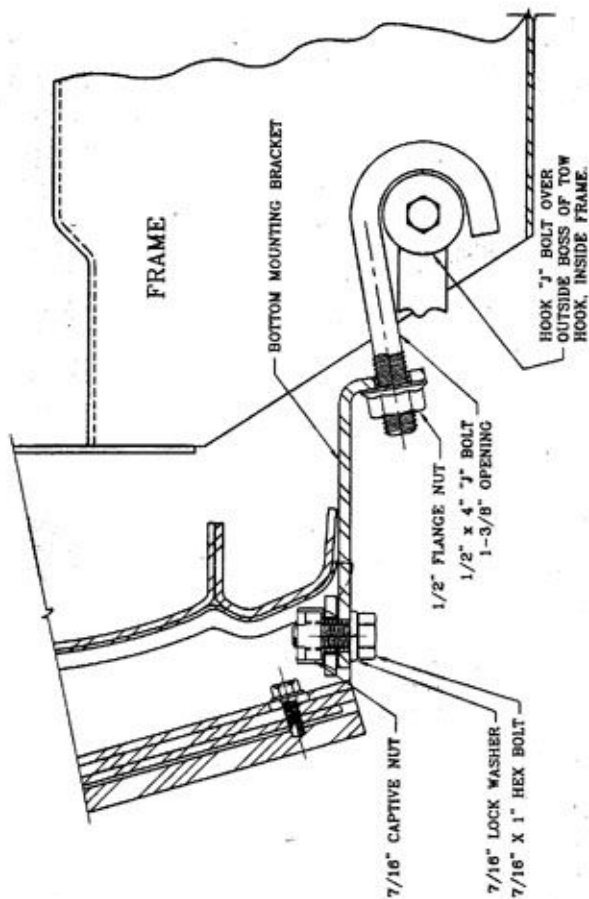
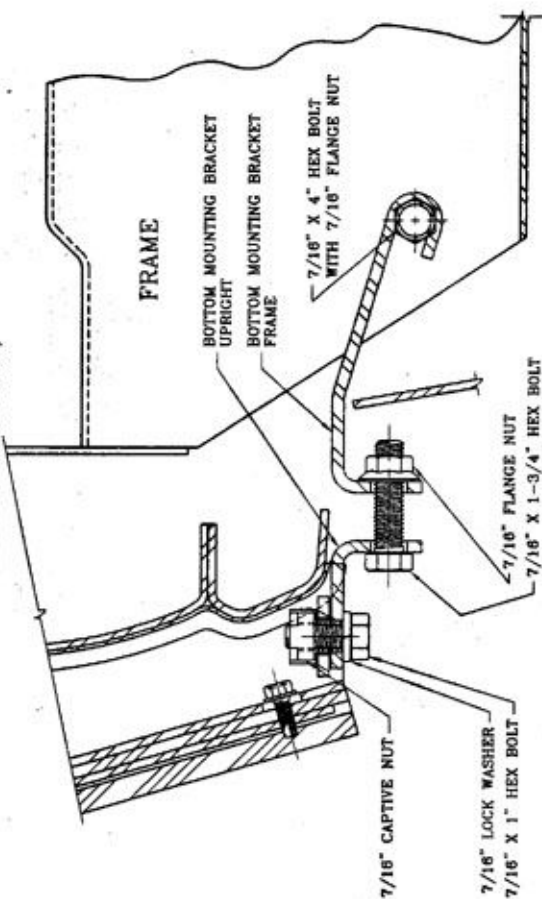


fig.4

LOWER MOUNTING BRACKET SYSTEM FOR 3/4
TON 4 X 4 PICKUPS
& 2001 AND NEWER 1500 HEAVY DUTYS



LOWER MOUNTING BRACKET SYSTEM FOR 3/4 TON 4 X 2 &
2001 AND NEWER 1500 HEAVY DUTY PICKUPS USE ACC99 (NOT
INCLUDED WITH GUARD)



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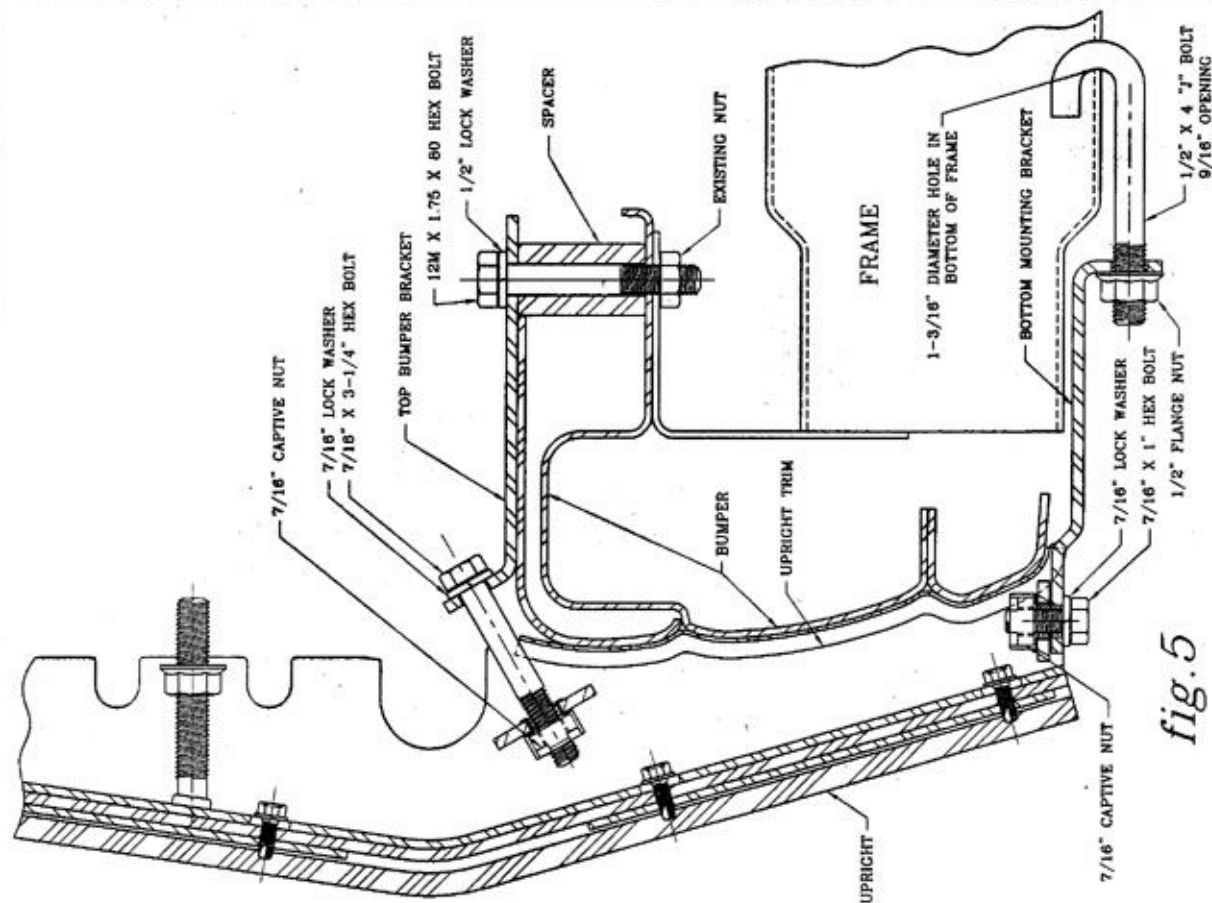


fig. 5

LOWER MOUNTING BRACKET SYSTEM
FOR 1/2 TON PICKUPS

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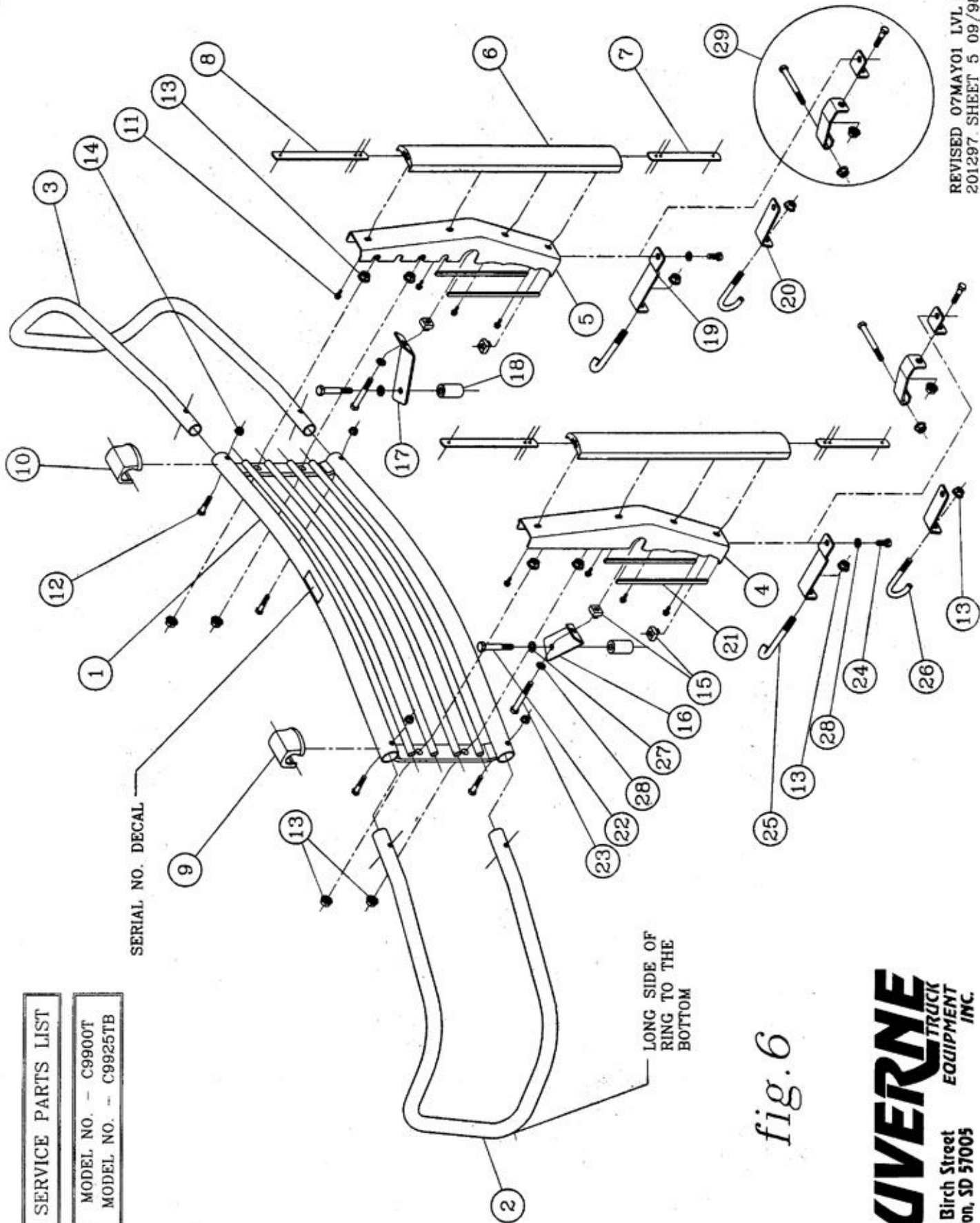


fig. 6

SERVICE PARTS LIST

MODEL NO. - C9900T

MODEL NO. - C9925TB

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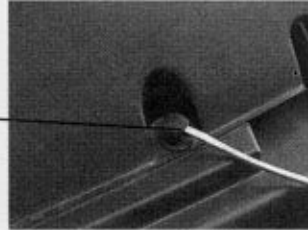
SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	201286	1	RING WELDMENT - CHROME
1	201309	1	RING WELDMENT - BLACK
2	201289	1	END RING - CHROME, RH
2	201310	1	END RING - BLACK, RH
3	201290	1	END RING - CHROME, LH
3	201311	1	END RING - BLACK, LH
4	201279	1	UPRIGHT WELDMENT - CHROME, RH
4	201306	1	UPRIGHT WELDMENT - BLACK, RH
5	201280	1	UPRIGHT WELDMENT - CHROME, LH
5	201307	1	UPRIGHT WELDMENT - BLACK, LH
6	104359	2	RUBBER EXTRUSION - 22.000"
7	200949	2	TAPPING BAR - 7.500"
8	201295	2	TAPPING BAR - 10.000"
9	103710	1	END CAP - UPRIGHT, RH
10	103711	1	END CAP - UPRIGHT, LH
11	103715	8	SELF TAPPING SCREW - 1/4-20 X 5/8
12	103713	4	HEX HEAD SCREW - 3/8 X 1-3/4
13	100123	10	SERRATED FLANGE NUT - 1/2-13
14	100181	4	SERRATED FLANGE NUT - 3/8-16
15	100083	4	CAPTIVE NUT - 7/16-14
16	201298	1	MOUNTING BRACKET - TOP, RH
17	201299	1	MOUNTING BRACKET - TOP, LH
18	104362	2	MOUNTING BRACKET - SPACER, TOP
19	201300	2	MOUNTING BRACKET - BOTTOM
20	201332	2	MOUNTING BRACKET - BOTTOM, 2500
21	201312	4	RUBBER CHANNEL - 9.500"
22	104361	2	HEX HEAD SCREW - M12 X 1.75 X 80mm, ZP
23	100833	2	HEX HEAD SCREW - 7/16-14 X 3-1/4, ZP
24	103468	2	HEX HEAD SCREW - 7/16-14 X 1, ZP
25	100112	2	"J" BOLT - 1/2-13 X 4 X .562, ZP
26	104369	2	"J" BOLT - 1/2-13 X 4 X 1.375, ZP
27	100121	2	WASHER - 1/2 LOCK, ZP
28	100078	4	WASHER - 7/16 LOCK, ZP
29	201363	1	MOUNTING BRACKET KIT - ACC99

RADIATOR SHROUD & GRILLE REMOVAL PROCEDURE

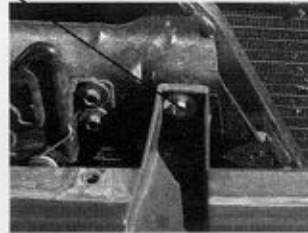
REMOVE THE PLASTIC SHROUD

1. PRY UP THE CENTER PINS FROM THE SEVEN (7) PLASTIC RETAINERS USING A FLAT BLADED SCREWDRIVER AND REMOVE.



REMOVE THE GRILLE

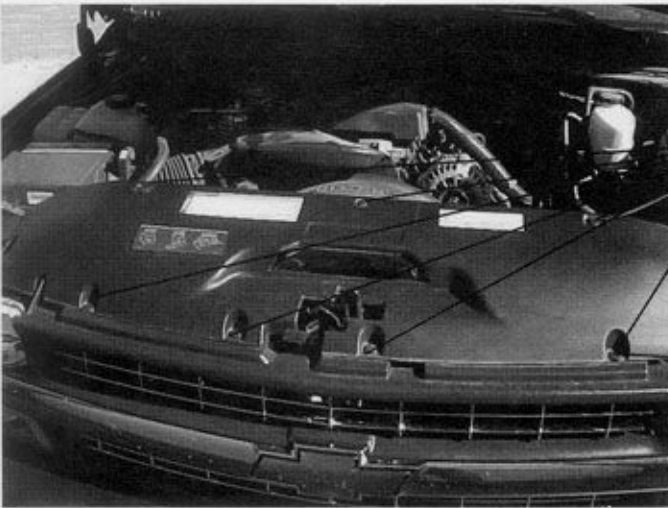
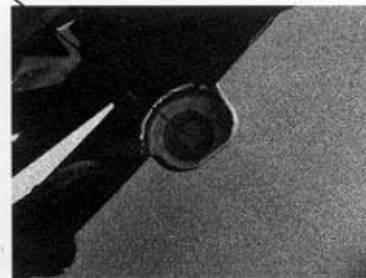
2. REMOVE THE 10mm SCREW FROM THE TOP OF THE GRILLE.



3. TURN THE FOUR (4) ¼ TURN FASTENERS COUNTER-CLOCKWISE WITH A PHILLIPS SCREWDRIVER.

4. BY APPLYING FIRM PRESSURE ON THE ENDS OF THE GRILLE, PULL THE OUTER ENDS OF THE GRILLE FORWARD AND AWAY FROM THE BODY. CAREFULLY REMOVE THE GRILLE.

BUMPER BOLTS TO BE REMOVED IN STEP #7



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