

54206

07-10 GMC

2500-3500 HD



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1 PC UPPER CLASS SERIES GRILLE

Recommended Tools:

Phillips / Slotted Screwdrivers
10mm Socket & Ratchet
3/8" Wrench or Nut Driver
Jig Saw/ Cut off Wheel
Disk Sander, File, Sand Paper
Drill w/ 1/4" Drill Bit
Needle Nose Pliers

Parts List / Hardware:

1	Upper Class Insert	4	#10 Flat Washers
4	10/32 Nylon Lock Nuts	4	#10 x 1 Phillips Screws
2	Custom L Brackets		
4	#10 Flat Nuts		
2	1/2" L Brackets		

Read and understand instructions before attempting installation

Step 1

Remove eight plastic fasteners from the top plastic cover and remove the plastic cover. Remove four 10 mm bolts from the top of the grill assembly to allow access behind **(1)**. Release six metal pressure clips, four from the bottom of the grill assembly & one behind each top corner of the logo plate. Release the clips that hold the outer grille shell and remove the complete grille as one unit. Remove the clips holding the logo to grille



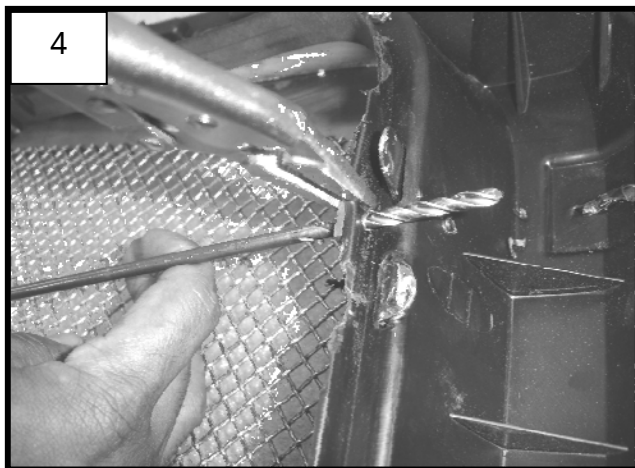
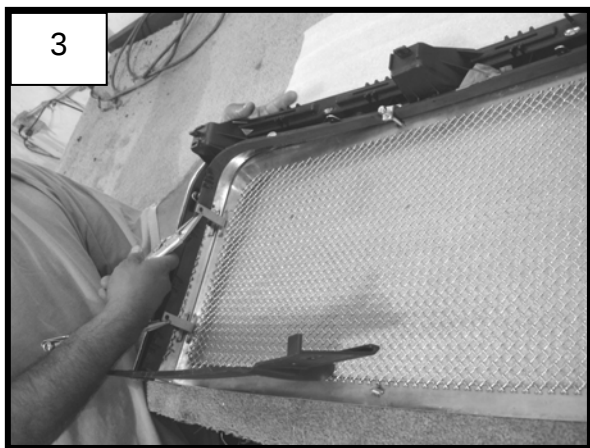
Step 2

Apply masking tape to the chrome area of grille. Using a jig saw or die grinder cut within 1/8" of contour of the grill to remove the center ribs **(2)**. **(Do not remove the top horizontal mounting section used to secure the grill assembly with the (4) 10 mm bolts. You will need this to re-install the grill assembly).** Using a disk sander and file blend the cutter marks with the contour of the grill contour.



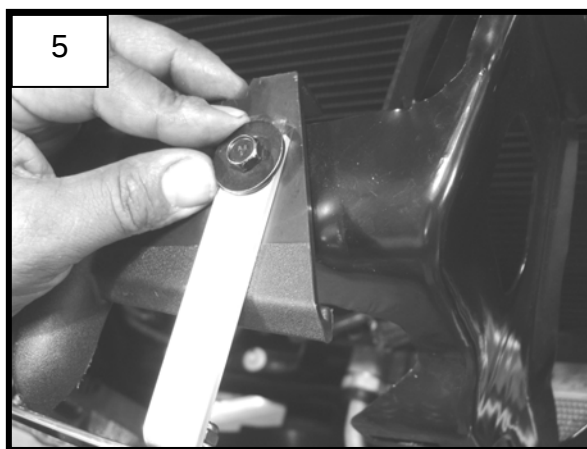
Step 3

Position your new grille from the front the grille shell then reach behind and clamp two of the side brackets using needle nose vise grips to hold it in place **(3)**. Carefully turn the grill shell over and install 2, ½" 'L' brackets, #10 flat washers & 10-32 nylon lock nuts on the two bottom studs but to not tighten yet. Using two more needle nose vise grips clamp the other two side brackets and adjust the grille in. Check position of your new insert then tighten the hardware on the two 'L' brackets on the bottom studs. Drill 4, ¼" holes using the holes in the brackets as a guide **(4)**. Next install 4 #10 x 1" Phillips screws & #10 flat nuts. Check position of your new grill insert, adjust if needed and tighten the #10 Phillips screws and flat nuts.



Step 4

Re-install the grille shell by sliding the plastic tabs from the bumper assembly through the slots in the bottom of the grille shell then press the metal pressure clips through the slots in the frame. Install 2 custom 'L' brackets on the two top studs with #10 flat washers & 10-32 nylon lock nuts but do not tighten. Position the hole at the other end of the bracket over the horizontal mounting section then line the holes in the bracket with the two center 10 mm bolt holes **(5)**. Re-install the four 10 mm bolts then re-install the upper radiator cover.



Thank you for purchasing your T-Rex billet grille. 8/13/07