



INSTALLATION INSTRUCTIONS FOR MOUNTING

LUVERNE GRILL GUARDS WITH THE FOLLOWING MODEL NOS.:
G0300T & G0325T ON:

2003 AND NEWER GMC SIERRA 1500, 1500HD & 2500 SERIES PICKUPS

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) OUTER RING ASSEMBLY
- (1) UPRIGHT PACKAGE:
 - (1) UPRIGHT ASSEMBLY, RH
 - (1) UPRIGHT ASSEMBLY, LH
 - (1) BRACKET PACKAGE
 - (1) END CAP PACKAGE
 - (1) FASTENER PACKAGE
 - (1) CUSTOMER SERVICE PACKAGE

REFER TO FIGS. 1, 2, 3 & 4 FOR GUARD ASSEMBLY INSTRUCTIONS 2-17

2. PLACE THE CENTER RING ASSEMBLY (1) FACE DOWN ON A SCRATCH-FREE SURFACE SUCH AS THE SHIPPING CARTON. INSTALL THE RIGHT (2) & LEFT (3) 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 (10) ON EACH OF THE FOUR (4) STUDS. TIGHTEN ALL FOUR (4) NUTS AT THIS TIME

NOTE 1: WHEN THE UPRIGHTS ARE ATTACHED TO THE RING THEY REST AGAINST THE SERRATED FLANGE NUTS (10) THAT ARE THREADED ONTO THE STUDS. THE DEPTH OF THESE NUTS IS SET AS CLOSE AS POSSIBLE AT THE FACTORY (SEE FIG. 5 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 1-1/4" 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.

3. INSTALL THE TWO UPRIGHT CAPS (7 RH) & (27 LH) ON TO THE RING AND UPRIGHTS AND FASTEN WITH THE 1/4-20 X 3/8" BUTTON HEAD SCREWS (8), AS SHOWN IN FIG. 4.

NOTE 2: ON THE 2005 MODELS, IT WILL BE NECESSARY TO REMOVE THE SHROUDS THAT SURROUND THE TOW HOOKS, BEFORE INSTALLING THE GRILLE GUARD. REMOVE THE TWO SCREWS ON EACH SIDE OF THE FRAME THAT SECURE THE SHROUD TO THE VEHICLE AND DISCARD.

REMOVE THE GRILL OR FAN SHROUD

4. OPEN THE HOOD AND REMOVE THE SIX (6) PLASTIC RIVETS THAT SECURE THE TOP FAN SHROUD TO THE GRILLE. . (OPTIONAL PROCEEDURE) IF YOU REMOVE ALL OF THE PLASTIC RIVETS AND REMOVE THE FAN SHROUD, WITH A LONG SOCKET EXTENSION AND A UNIVERSAL JOINT YOU CAN REACH THE TOP BUMPER BOLTS WITHOUT REMOVING THE GRILLE. THIS WILL ALLOW YOU TO MOUNT, ALIGN AND TIGHTEN THE TOP MOUNTING BRACKETS AND GRILLE GUARD AT ONE TIME.



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REVISED 28JUL03 LVL B
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201791 SHEET 1 09SEP02

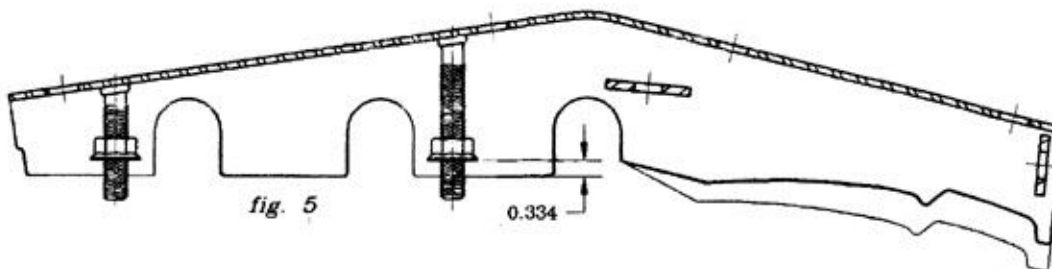
5. REMOVE THE SCREW HOLDING THE FAN SHROUD TO THE RADIATOR SUPPORT.
6. TO REMOVE THE GRILLE, PULL STRAIGHT OUT ON THE ENDS OF THE GRILLE THAT ARE BETWEEN THE TOP AND BOTTOM LIGHT HOUSING AND THE CENTER OF THE GRILLE. THE GRILLE WILL COME STRAIGHT OUT.
7. REMOVE THE TWO (2) TOP BOLTS THAT SECURE THE BUMPER TO THE FRAME
8. INSTALL THE TOP RIGHT HAND (12) & LEFT HAND (13) MOUNTING BRACKETS, SPACERS (14), 12mm NORD-LOCK WASHERS (23) AND 12M X 120mm BOLTS (18) ON THE BUMPER, AS SHOWN IN FIGS. 1 & 4.
9. INSERT THE 7/16" X 3-3/4" HEX BOLTS (19) AND 7/16" LOCK WASHERS (24) INTO THE HOLES IN THE TOP MOUNTING BRACKETS.
10. INSTALL THE FOUR (4) RUBBER TRIM CHANNELS (17) ON THE BOTTOM OF THE UPRIGHTS.
11. SET THE GRILLE GUARD UP TO THE FRONT BUMPER AND MAKE SURE THE BOLTS (19) IN THE TOP MOUNTING BRACKETS LINE UP WITH THE CAPTIVE NUTS (11) IN THE GRILL GUARD UPRIGHT.
12. **IMPORTANT!** REMOVE THE GRILL GUARD AND TIGHTEN THE M12 BOLTS (18) THAT SECURE THE MOUNTING BRACKETS TO 117 NM (86.3 ft. lbs.)

REINSTALL THE GRILLE

13. 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.
14. ATTACH THE BOTTOM MOUNTING BRACKETS TO THE BOTTOM OF THE UPRIGHTS WITH THE 7/16" X 1" HEX BOLTS (20) AND 7/16" LOCK WASHERS (24). FINGER TIGHTEN ONLY. (REFER TO DRAWING FIGS. 1, 2 & 3 TO DETERMINE WHICH BOTTOM MOUNTING BRACKET SYSTEM TO USE.)
15. IF GUARD IS BEING MOUNTED ON A ½ TON PICKUP HOOK THE ½" X 4" "J" BOLT WITH THE 9/16" OPENING (21) INTO THE 1-3/16" DIAMETER HOLE IN THE BOTTOM OF THE FRAME AND THE HOLE IN THE BOTTOM MOUNTING BRACKET. SECURE WITH A ½" SERRATED FLANGE NUT (10). TIGHTEN THE 7/16" X 1" BOLT (20) IN THE BOTTOM OF THE UPRIGHT. IF THE GUARD IS BEING MOUNTED ON A ¾ TON 4X4 PICKUP, HOOK THE ½" X 4" "J" BOLT WITH THE 1-3/8" OPENING (22) OVER THE OUTSIDE BOSS ON THE TOW HOOK INSIDE OF THE FRAME AND THE HOLE IN THE BOTTOM MOUNTING BRACKET. SECURE WITH A ½" SERRATED FLANGE NUT (10). TIGHTEN THE 7/16" X 1" BOLT (20) IN THE BOTTOM OF THE UPRIGHT. IF THE GUARD IS BEING MOUNTED ON A ¾ TON 4X2 PICKUP, USE A #201775 BRACKET KIT (26) AND INSTALL THE 7/16" X 4" HEX BOLT AND 7/16" SERRATED FLANGE NUT THROUGH THE ½" 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 (20) IN THE BOTTOM OF THE UPRIGHT.
16. 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.
17. 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.

SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	201731	1	RING WELDMENT - CHROME
1	201768	1	RING WELDMENT - BLACK
2	201782	1	UPRIGHT WELDMENT - CHROME, RH
2	201810	1	UPRIGHT WELDMENT - BLACK, RH
3	201783	1	UPRIGHT WELDMENT - CHROME, LH
3	201811	1	UPRIGHT WELDMENT - BLACK, LH
4	105302	2	RUBBER EXTRUSION - 22.500"
5	200949	2	TAPPING BAR - 7.500"
6	200856	2	TAPPING BAR - 11.000"
7	201818	1	END CAP - UPRIGHT, RH
8	105286	2	BUTTON HEAD SCREW - 1/4-20 X 3/8
9	103715	8	SELF TAPPING SCREW - 1/4-20 X 5/8
10	100123	10	SERRATED FLANGE NUT - 1/2-13
11	100083	4	CAPTIVE NUT - 7/16-14
12	201624	1	MOUNTING BRACKET - TOP, RH
13	201625	1	MOUNTING BRACKET - TOP, LH
14	103256	2	MOUNTING BRACKET - SPACER, TOP
15	201739	2	MOUNTING BRACKET - BOTTOM
16	201740	2	MOUNTING BRACKET - BOTTOM, 2500
17	201312	4	RUBBER CHANNEL - 9.500"
18	103440	2	HEX HEAD SCREW - M12 X 1.75 X 120mm, ZP
19	103264	2	HEX HEAD SCREW - 7/16-14 X 3-3/4, ZP
20	103468	2	HEX HEAD SCREW - 7/16-14 X 1, ZP
21	100112	2	"J" BOLT - 1/2-13 X 4 X .562, ZP
22	104369	2	"J" BOLT - 1/2-13 X 4 X 1.375, ZP
23	105949	2	WASHER - 12mm NORD-LOCK, ZP
24	100078	4	WASHER - 7/16 LOCK, ZP
25	105293	4	TUBE PLUG - Ø1-1/4
26	201775	1	MOUNTING BRACKET KIT - 4X2, 201775
27	201819	1	END CAP - UPRIGHT, LH



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LOWER MOUNTING BRACKET SYSTEM FOR
1500HD & 2500 4 X 4 PICKUPS

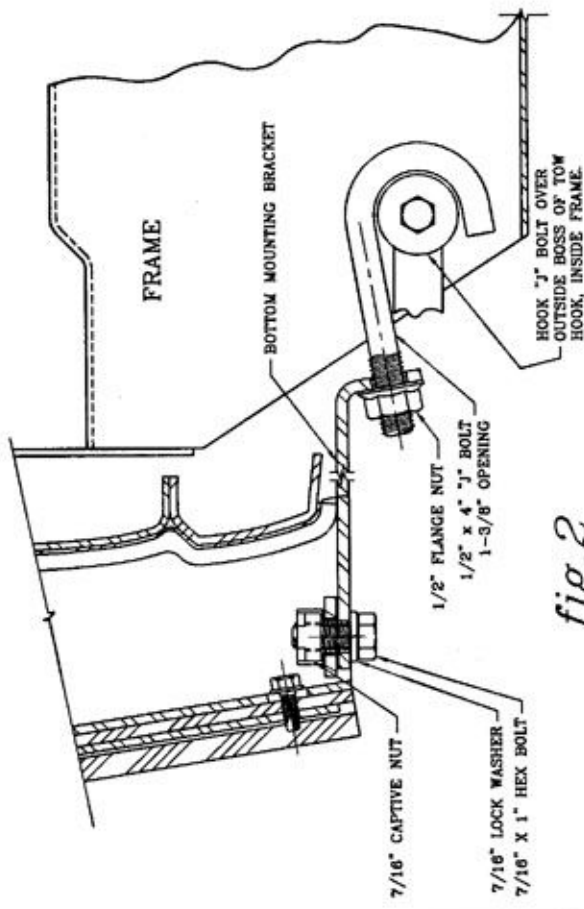


fig. 2

LOWER MOUNTING BRACKET SYSTEM FOR 1500HD & 2500 4 X 2
USE KIT #201775 (NOT INCLUDED WITH GUARD)

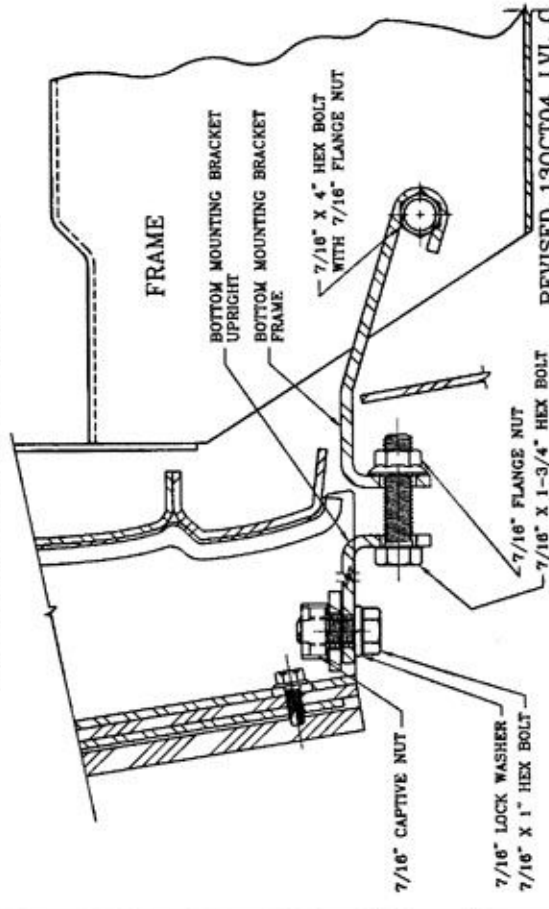


fig. 3

LOWER MOUNTING BRACKET SYSTEM
FOR 1500 SERIES PICKUPS

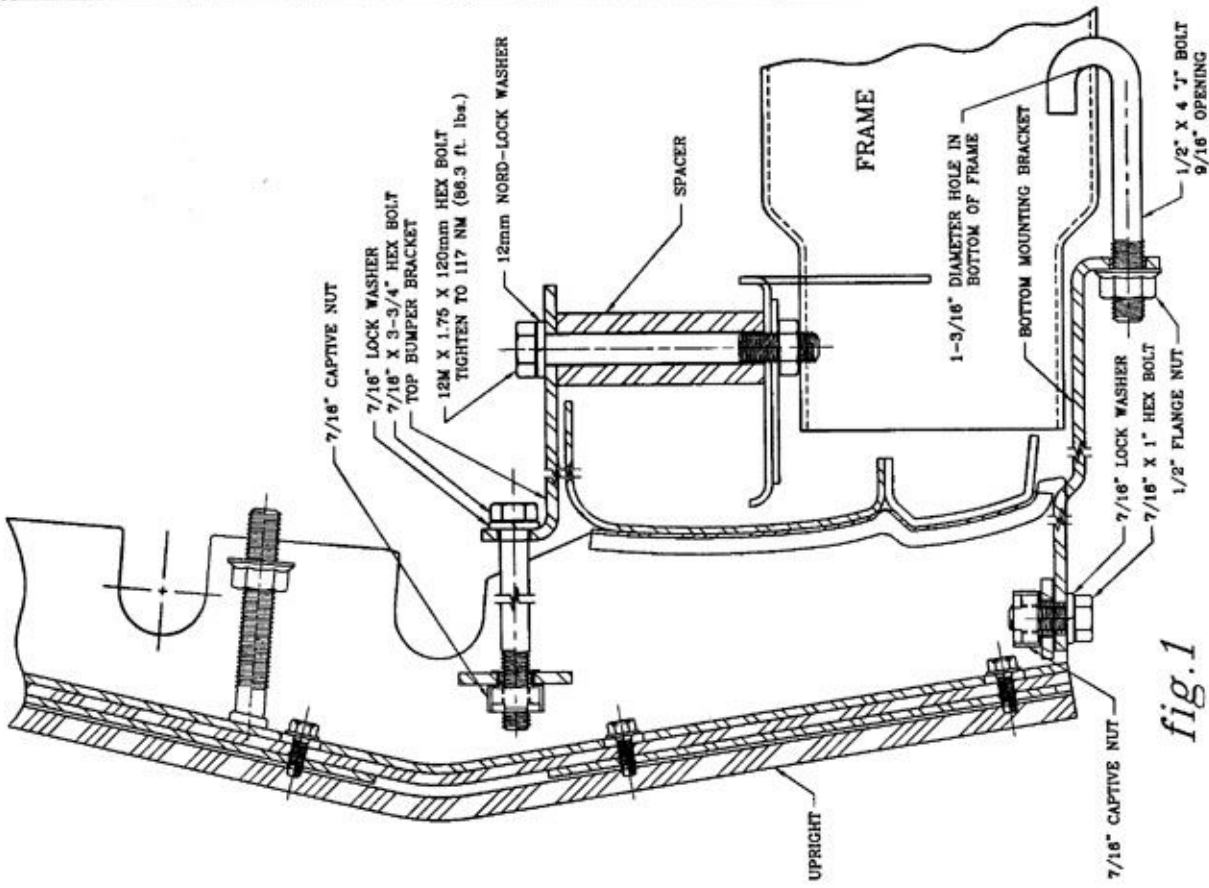


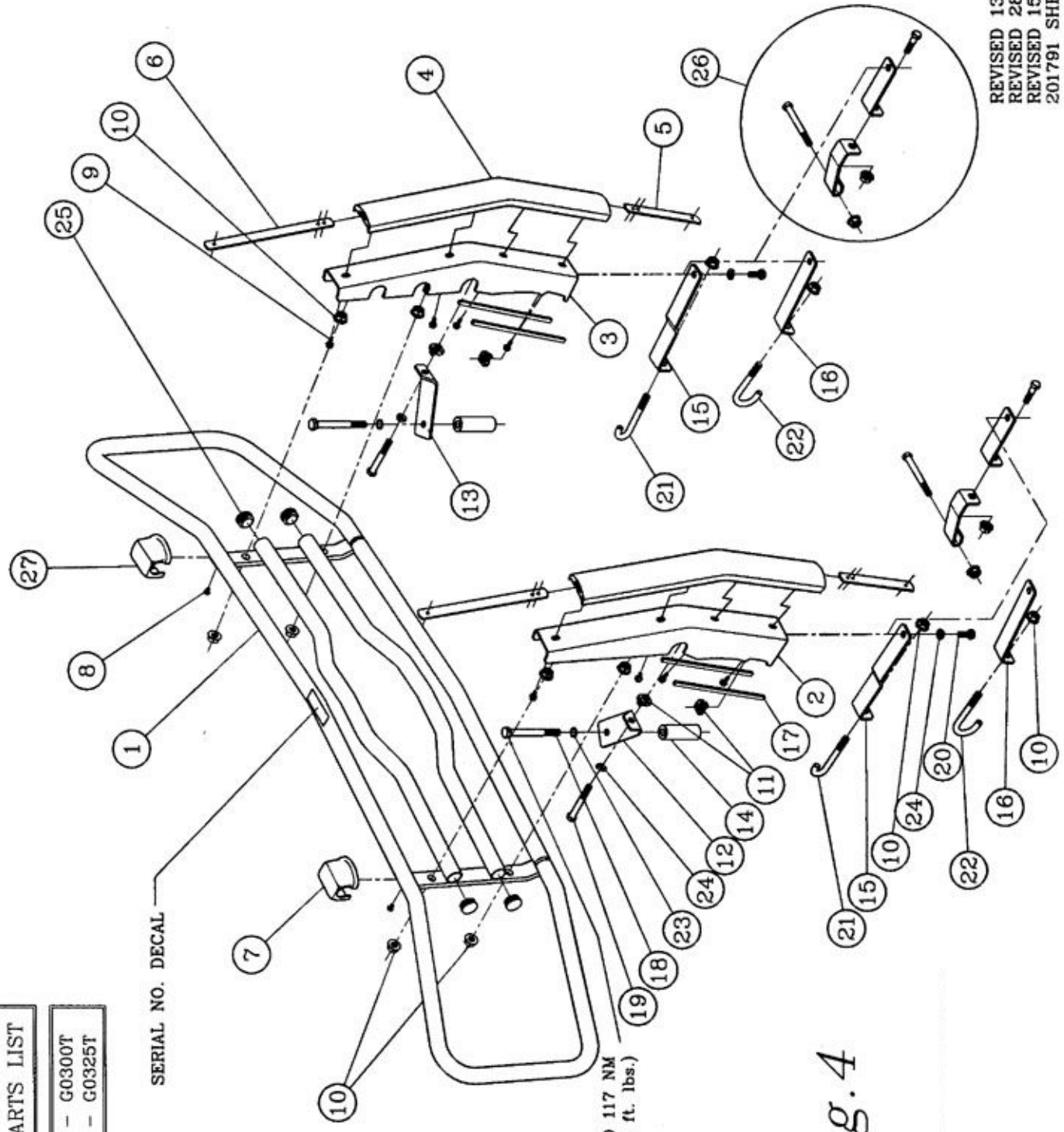
fig. 1

REVISED 13OCT04 LVL O
REVISED 28JUL03 LVL B
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 REVISED 28JUL03 LVL B
 REVISED 15MAY03 LVL A
 201791 SHEET 5 09SEP02

SERVICE PARTS LIST	
MODEL NO. -	G0300T
MODEL NO. -	G0325T

SERIAL NO. DECAL



TIGHTEN BOLTS TO 117 NM
 (86.3 ft. lbs.)

fig. 4