



INSTALLATION INSTRUCTIONS FOR MOUNTING

LUVERNE GRILL GUARDS WITH THE FOLLOWING MODEL NOS.:

330311 & 330312

330311 – ON 2003 AND NEWER CHEVROLET 1500HD & 2500 SERIES PICKUPS
330312 - ON 2003 AND NEWER CHEVROLET 2500HD & 3500 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) ASSEMBLED UPRIGHT, RH

(1) ASSEMBLED UPRIGHT, LH

(2) UPRIGHT COVERS (**CHROME GUARDS ONLY**)

(1) BRACKET PACKAGE

(1) TOP MOUNTING BRACKET, RH

(1) TOP MOUNTING BRACKET, LH

(1) BOTTOM MOUNTING BRACKET, RH

(1) BOTTOM MOUNTING BRACKET, LH

(1) FASTENER PACKAGE

(1) CUSTOMER SERVICE PACKAGE

REFER TO FIGS. 1 & 2 FOR GUARD ASSEMBLY INSTRUCTIONS 2-14

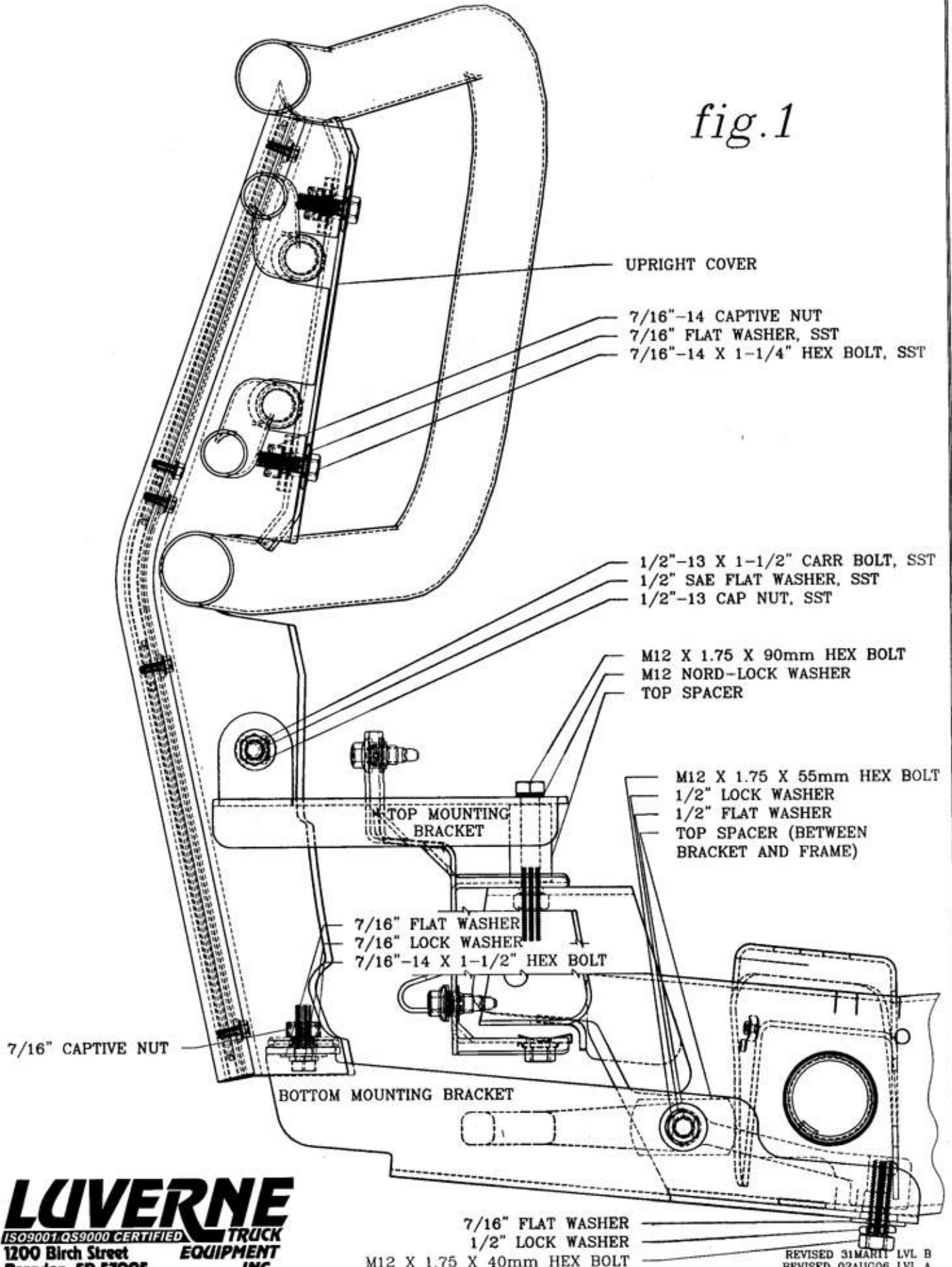
2. PLACE THE CENTER RING ASSEMBLY (ITEM #1) FACE DOWN ON A SCRATCH-FREE SURFACE SUCH AS THE SHIPPING CARTON. INSTALL THE RIGHT (ITEM #2) & LEFT (ITEM #3) UPRIGHTS ON THE RING ASSEMBLY (ITEM #1) AS SHOWN IN FIG. 2, MAKING SURE THEY ARE CENTERED AND PARALLEL WITH THE BARS IN THE RING. FASTEN WITH UPRIGHT COVERS (ITEM #29) (**CHROME GUARDS ONLY**), 7/16"-14 X 1-1/4" HEX BOLTS (ITEM #14) AND 7/16" FLAT WASHERS (ITEM #27) INTO THE 7/16"-14 CAPTIVE NUTS (ITEM #20) IN THE UPRIGHT MOUNTING PLATES. TIGHTEN TO 54 FOOT-POUNDS OF TORQUE.
4. OPEN THE HOOD AND REMOVE THE PLASTIC SHROUD OVER THE RADIATOR, BY REMOVING THE SEVEN PLASTIC DARTS THAT HOLD IT TO THE VEHICLE.
5. REMOVE THE TOP TWO BOLTS THAT HOLD THE BUMPER TO THE FRAME.
6. INSTALL THE TOP RIGHT HAND (ITEM #4) AND LEFT HAND (ITEM #5) MOUNTING BRACKETS, M12 X 1.75 X 90mm BOLTS (ITEM #15), MOUNTING BRACKET SPACER (ITEM #19) AND NORD-LOCK LOCK WASHERS (ITEM #23). FINGER TIGHTEN ONLY. (SEE FIG. 1 ON SHEET 3)

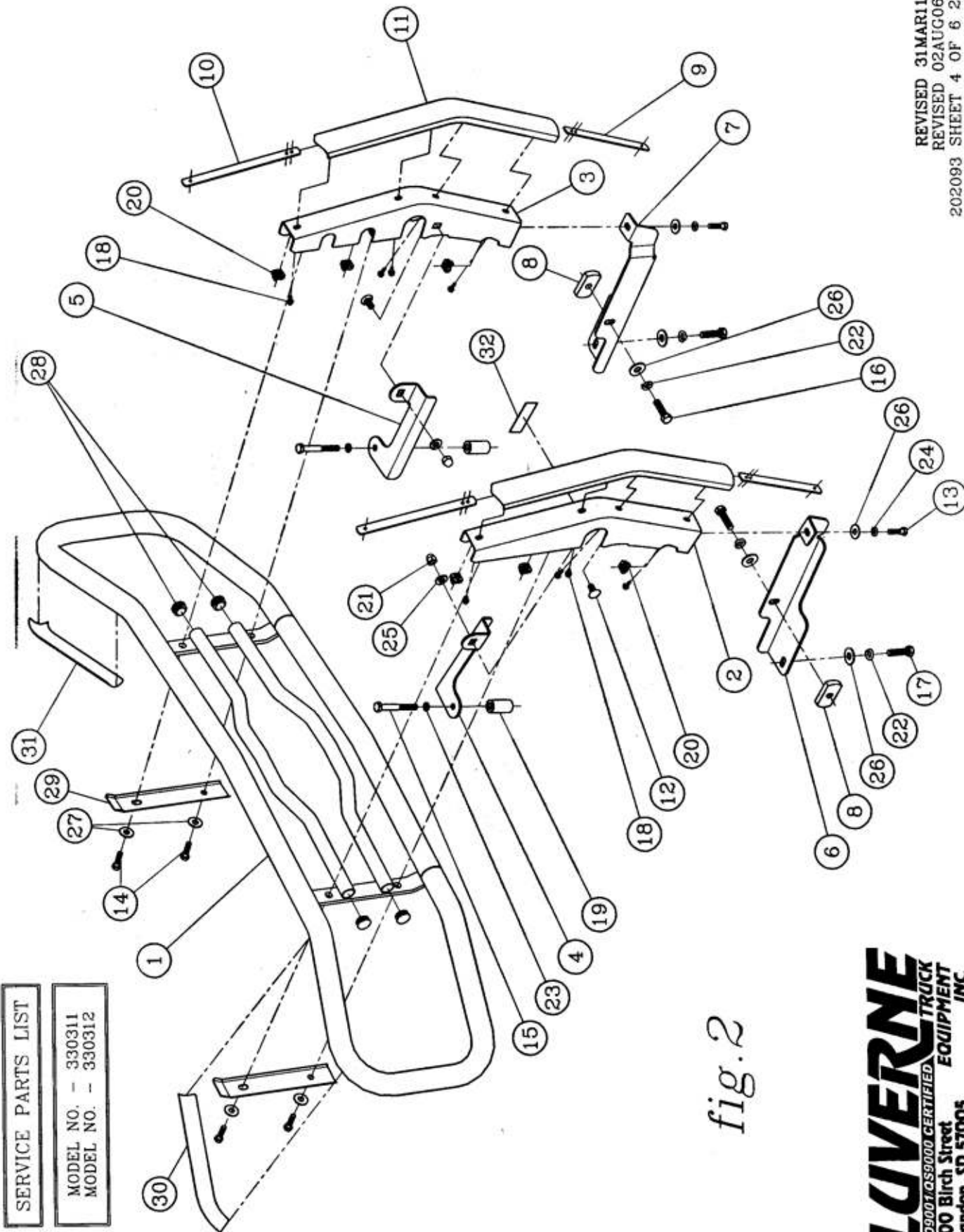
LUVERNE
ISO9001 QS9000 CERTIFIED TRUCK
EQUIPMENT
INC.
1200 Birch Street
Brandon, SD 57005

REVISED 31MAR11 LVL B
REVISED 02AUG06 LVL A
202093 SHEET 1 OF 6 28APR05

6. REMOVE THE BOTTOM AND INSIDE BOLTS THAT SECURE THE TOW HOOKS TO THE FRAME.
7. INSTALL THE BOTTOM RIGHT HAND (ITEM #6) AND LEFT HAND (ITEM #7) MOUNTING BRACKETS ONTO THE FRAME USING THE 40mm BOLTS (ITEM #17), 1/2" LOCK WASHERS (ITEM #22) AND 7/16" FLAT WASHERS (ITEM #26) INTO THE BOTTOM OF THE FRAME. INSTALL THE 1/2" SPACERS (ITEM #8) 55mm BOLTS (ITEM #16), 1/2" LOCK WASHERS (ITEM #22) AND 7/16" FLAT WASHERS (ITEM #26) INTO THE SIDE OF THE FRAME. TIGHTEN BOLTS TO 75 FOOT-POUNDS OF TORQUE. (STEPS 6-10 SEE FIG. 1 ON SHEET 3).
8. SET THE GRILLE GUARD UP ON THE FLANGES OF THE BOTTOM MOUNTING BRACKETS AND INSTALL THE 7/16"-14 X 1-1/2" HEX BOLTS (ITEM #13), 7/16" LOCK WASHERS (ITEM #24) AND 7/16" FLAT WASHERS (ITEM #26) IN THE BOTTOM BRACKETS. FINGER TIGHTEN ONLY.
9. FASTEN THE TOP MOUNING BRACKETS TO THE UPRIGHT USING THE 1/2"-13 X 1" SST ROUND HEAD BOLTS (ITEM #12), 1/2" SST SAE FLAT WASHERS (ITEM #25) AND 1/2"-13 SST CAP NUTS (ITEM #21). FINGER TIGHTEN ONLY.
10. CHECK THAT THE GRILL GUARD IS CENTERED ON THE BUMPER AND THE REAR OF THE UPRIGHT CUTOUT IS APPROXIMATELY 1/2" AWAY FROM THE FACE OF THE BUMPER.
11. TIGHTEN THE 7/16" BOLTS THAT FASTEN THE BOTTOM MOUNTING BRACKETS TO THE MOUNTING PLATES IN THE UPRIGHTS TO 54 FOOT-POUNDS OF TORQUE.
12. TIGHTEN THE TOP BRACKET MOUNTING BOLTS (ITEM #15) TO THE FRAME TO 117 NM (86.3 ft. lbs.)
13. TIGHTEN THE 1/2" BOLTS THAT FASTEN THE TOP MOUNTING BRACKETS TO THE UPRIGHT TO 75 FOOT-POUNDS.
14. REINSTALL THE RADIATOR SHROUD.

fig.1





SERVICE PARTS LIST	
MODEL NO. -	330311
MODEL NO. -	330312

fig. 2

LIVERNE
 ISO9001/TS9000 CERTIFIED
 TRUCK EQUIPMENT
 INC
 1200 Birch Street
 Brandon, SD 57005

SERVICE PARTS LIST MODEL #330311

ITEM	PART NO.	QTY	DESCRIPTION
1	202055	1	RING WELDMENT - CHROME
2	202061	1	UPRIGHT WELDMENT - CHROME, RH
3	202062	1	UPRIGHT WELDMENT - CHROME, LH
4	202069	1	MOUNTING BRACKET - TOP, RH
5	202070	1	MOUNTING BRACKET - TOP, LH
6	202089	1	MOUNTING BRACKET - BOTTOM, RH
7	202090	1	MOUNTING BRACKET - BOTTOM, LH
8	201922	2	UPRIGHT SPACER - BLACK
9	200295	2	TAPPING BAR - 10.000", C9900T
10	202038	2	TAPPING BAR - 11.500", 330460
11	202067	2	RUBBER EXTRUSION - MACHINED, 330310
12	104993	2	ROUND HEAD BOLT - 1/2"-13 X 1", SST
13	100070	2	HEX HEAD SCREW - 7/16"-14 X 1-1/2", ZP
14	105939	4	HEX HEAD SCREW - 7/16"-14 X 1-1/4", SST
15	106928	2	HEX HEAD SCREW-M12 X 1.75 X 90mm, ZP
16	105107	2	HEX HEAD SCREW-M12 X 1.75 X 55mm, ZP
17	103437	2	HEX HEAD SCREW-M12 X 1.75 X 40mm, ZP
18	103715	8	SELF TAPPING SCREW - 1/4"-20 X 5/8"
19	106316	2	TOP MOUNTING BRACKET SPACER
20	100083	6	CAPTIVE NUT - 7/16"-14
21	104994	2	HEX CAP NUT - 1/2"-13, SST
22	100121	4	LOCK WASHER - 1/2", ZP
23	105949	2	NORD-LOCK WASHER - 12mm, ZP
24	100078	2	LOCK WASHER - 7/16", ZP
25	104995	2	FLAT WASHER - SAE, 1/2", SST
26	100081	6	FLAT WASHER - 7/16", ZP
27	103286	4	FLAT WASHER - 7/16", SST
28	105293	4	TUBE PLUG - Ø1-1/4" X 14-20 GA.
29	202543	2	UPRIGHT COVERS (CHROME GUARDS ONLY)
30	106901	1	DECAL - MATTE BLACK, RH, 330460
31	106902	1	DECAL - MATTE BLACK, LH, 330460
32	100252	1	DECAL - LOGO, 1 X 3

SERVICE PARTS LIST MODEL #330312

ITEM	PART NO.	QTY	DESCRIPTION
1	202055	1	RING WELDMENT - CHROME
2	202081	1	UPRIGHT WELDMENT - CHROME, RH
3	202082	1	UPRIGHT WELDMENT - CHROME, LH
4	202069	1	MOUNTING BRACKET - TOP, RH
5	202070	1	MOUNTING BRACKET - TOP, LH
6	202089	1	MOUNTING BRACKET - BOTTOM, RH
7	202090	1	MOUNTING BRACKET - BOTTOM, LH
8	201922	2	UPRIGHT SPACER - BLACK
9	202038	2	TAPPING BAR - 11.500", 330460
10	202038	2	TAPPING BAR - 11.500", 330460
11	202087	2	RUBBER EXTRUSION - MACHINED, 330312
12	104993	2	ROUND HEAD BOLT - 1/2"-13 X 1, SST
13	100070	2	HEX HEAD SCREW - 7/16"-14 X 1-1/2", ZP
14	105939	4	HEX HEAD SCREW - 7/16"-14 X 1-1/4", SST
15	106928	2	HEX HEAD SCREW-M12 X 1.75 X 90mm, ZP
16	105107	2	HEX HEAD SCREW-M12 X 1.75 X 55mm, ZP
17	103437	2	HEX HEAD SCREW-M12 X 1.75 X 40mm, ZP
18	103715	8	SELF TAPPING SCREW - 1/4"-20 X 5/8"
19	106316	2	TOP MOUNTING BRACKET SPACER
20	100083	6	CAPTIVE NUT - 7/16"-14
21	104994	2	HEX CAP NUT - 1/2"-13, SST
22	100121	4	LOCK WASHER - 1/2", ZP
23	105949	2	NORD-LOCK WASHER - 12mm, ZP
24	100078	2	LOCK WASHER - 7/16", ZP
25	104995	2	FLAT WASHER - SAE, 1/2", SST
26	100081	6	FLAT WASHER - 7/16", ZP
27	103286	4	FLAT WASHER - 7/16", SST
28	105293	4	TUBE PLUG - Ø1-1/4" X 14-20 GA.
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30	106901	1	DECAL - MATTE BLACK, RH, 330460
31	106902	1	DECAL - MATTE BLACK, LH, 330460
32	100252	1	DECAL - LOGO, 1 X 3