



# INSTALLATION INSTRUCTIONS

## Trans4mer Grille Guard/Winch Mount For GMC Sierra 2500HD & 3500, +‘03 Kit 76248/76249

This WARN Trans4mer system can be customized to give your Chevy Silverado a wide variety of looks, front-end protection and winch mounting capability. The system starts with this strong two-tube grille guard that attaches to the truck's frame with brackets designed to handle up to a 15000 lb. winch. It is durable and good looking as a stand-alone grille guard, but can be easily upgraded with some great options! You can add a third large size tube (light bar) that adds even more protection and includes tabs for mounting auxiliary lights. The tubes can be mounted in a variety of positions to achieve the look and function that you desire. You can mount a winch carrier bracket that provides a permanent mount for a Warn winch. Finally, brush guards that protect the headlights and front corners of the truck can be easily added to any of the options above.

### **▲WARNING**

**ALWAYS USE EXTREME CAUTION WHEN DRILLING ON ANY VEHICLE. MAKE SURE THAT ALL FUEL LINES, BRAKE LINES, ELECTRICAL WIRES AND OTHER OBJECTS ARE NOT PUNCTURED OR DAMAGED WHEN/IF DRILLING ON THE VEHICLE. THOROUGHLY INSPECT THE AREA TO BE DRILLED (BOTH INBOARD AND OUTBOARD SIDE OF FRAME) PRIOR TO DRILLING, AND RELOCATE ANY OBJECTS THAT MAY BE DAMAGED. FAILURE TO INSPECT THE AREA TO BE DRILLED MAY RESULT IN VEHICLE DAMAGE, ELECTRICAL SHOCK, FIRE, OR PERSONAL INJURY.**

### **▲WARNING**

**ALWAYS COMPLETE EVERY STEP OF THE INSTRUCTIONS AS SPECIFIED. NOT DOING SO MAY RESULT IN VEHICLE DAMAGE, PERSONAL INJURY, OR DEATH.**

### **▲WARNING**

**ALWAYS WEAR SAFETY GLASSES WHEN INSTALLING THIS KIT.**

### PARTS LIST

<u>PART NO.</u>	<u>QUANTITY</u>	<u>DESCRIPTION</u>
66024/66025	2	Side Member, Black/Stainless
29366/60326	2	Grille Guard Tube, Black/Stainless
29147	4	Washer, Plastic (Black Kit only)
66418	1	Frame Extension, RH
66417	1	Frame Extension, LH
66021	1	W-Plate
66547	2	Support Plate
66023/68264	1	Upper Bracket, RH
66022	1	Upper Bracket, LH
66415	1	Bumper Bracket, RH
66416	1	Bumper Bracket, LH
66026	2	W-Plate Spacer
71899	2	Strap
66027	2	Triangular Spacer
39202	2	7/16" Nut w/Handle
62113	2	5/8" Nut w/Handle
13222	2	Tow Hook, Black

### TOOLS REQUIRED

- |  |                                 |
|--|---------------------------------|
| 10,15,& 18mm, 5/8, 11/16, 3/4. 15/16 socket, & ratchet | Tape measure & permanent marker |
| 5/8, 11/16, and 3/4 wrench                             | Flash light                     |
| 7/32 and 1/4 allen wrench                              | Needle nose pliers              |
| Center punch, 1/16", 3/16", 7/16" drill bit, & drill   | Silicone sealant                |

## TORQUE SPECIFICATIONS

### BOLT SIZE

7/16 inch  
1/2 & 5/8 inch

### TORQUE

50 lb. ft. (67.8 N-m)  
75 lb. ft. (101.7 N-m)

**NOTE:** This installation requires hole drilling. Make sure you have a drill motor and a sharp 7/16" drill bit available. Wear safety goggles.

**NOTE:** Follow the instructions step by step for fastest installation. Do not securely tighten fasteners until directed to do so.

(A) Remove the grille and bumper. The grille must be removed first to gain access to the bumper bolts. These are easy to remove if the following procedure is followed:

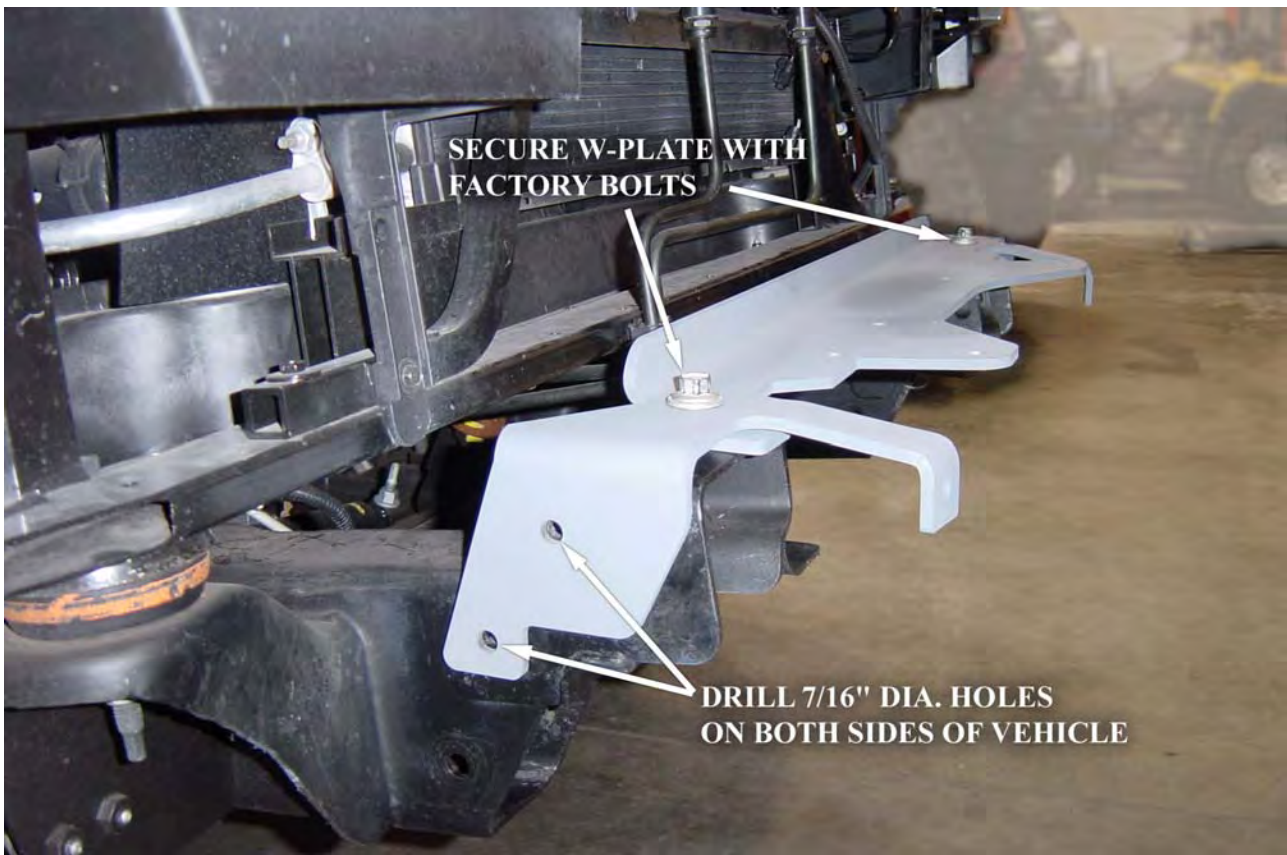
- a. Open the hood. Remove the 7 plastic fasteners that attach the plastic shroud to the top of the grille. Pry up the center pin with a screwdriver, and then pry out the collar.
- b. There are 6 clips holding the grille in place and one 5mm bolt. First remove the bolt. Then pry the inner 4 clips free then give a sharp pull at the extreme outer ends of the grille to release the other 2 clips. NOTE: it may help to pull the pins holding the headlights in place and remove the headlights to gain access to the outer clips. Remove grille.
- c. Unplug the fog lights from the bumper, if so equipped.
- d. Remove the bolt from the outer bumper braces just forward of the wheels (15mm head) on both sides.
- e. Remove the four remaining bumper bolts (15mm head) and remove bumper.

(B) Remove the tow hooks and the plastic air baffle between the upper frame towers.

1. Place the W-Plate spacer then the plain steel spacer on top of the frame towers where the upper bumper brackets mount (refer to Figure 1). NOTE: The plain steel spacer is the exact thickness of the bumper bracket.



**Figure 1: Place spacers on frame for drilling.**



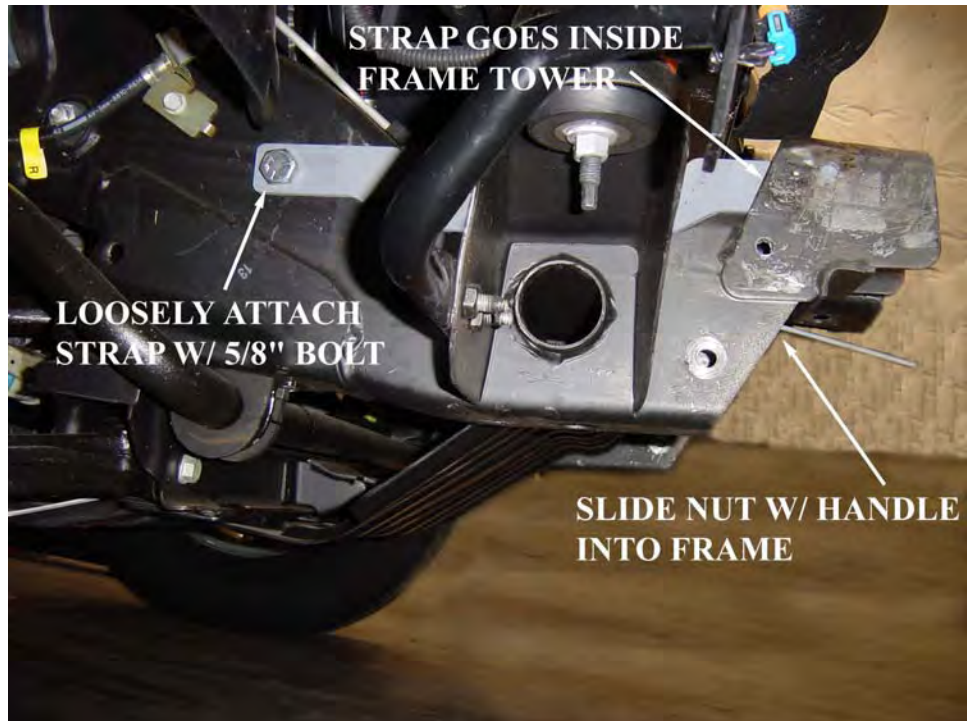
**Figure 2: Drill mounting holes for W-Plate.**

**WARNING**



**DRILLING OPERATIONS CAN CAUSE FLYING CHIPS. WEAR SAFETY GOGGLES. FLYING CHIPS CAN CAUSE EYE INJURY.**

2. Mount the W-Plate to the frame towers as shown in Figure 2. Use the holes on the sides of the W-Plate to drill the 7/16 holes in the frame and frame towers. Remove the W-Plate.
3. Loosely install the Strap (the “drop” in the Strap should be down) with the 5/8”x 1-1/2” bolt and the Nut w/ Handle. The Strap slides inside the frame tower and the front hole of the strap will line up with the upper 7/16” hole drilled in step 3. The Nut w/ Handle slides into the front of the frame.



**Figure 3: Loosely attach strap.**





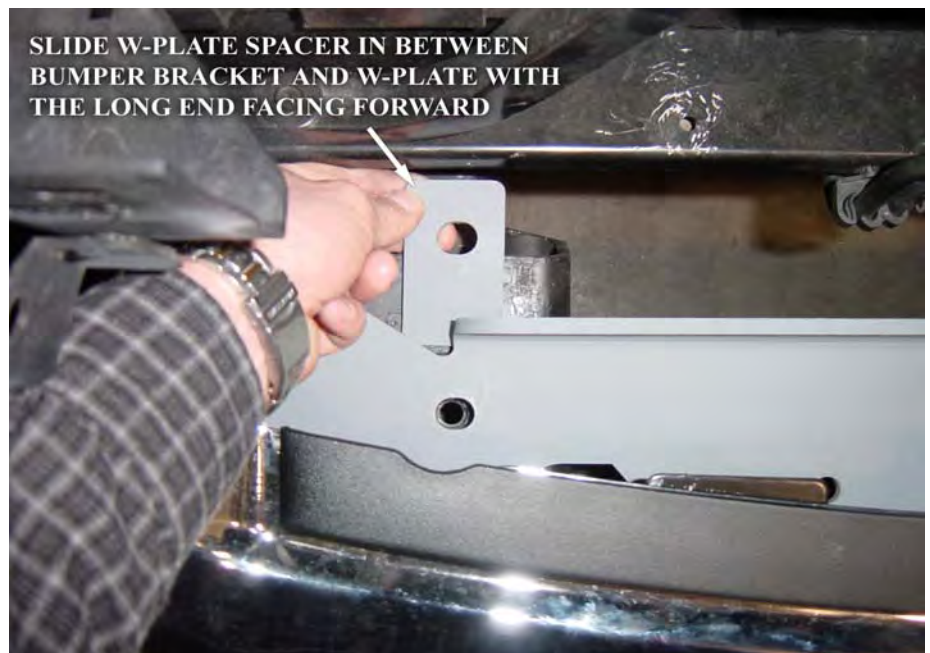
**Figure 4: Install W-Plate.**

4. Reinstall the W-Plate without the spacers. Only attach it with 7/16" x 1-1/2" bolts, lock washers and nuts. Do not tighten the bolt all the way. NOTE: The frame tower will be sandwiched between the W-Plate and the Strap. Refer to Figure 4.

5. Slide the bumper back into position. The upper tabs slide between the frame towers and the W-plate.

6. Set the W-Plate Spacers on the bumper brackets as shown in Figure 5a. The bumper bracket and Spacer slide underneath the W-Plate. Use a screwdriver as shown in Figure 5b to help align the holes.

NOTE: WHEN ALIGNING THE HOLES IT MAY HELP IF ONE OF THE 7/16" BOLTS PER SIDE IS REMOVED TEMPORARILY.



**Figure 5a: Place W-Plate Spacers on bumper brackets.**

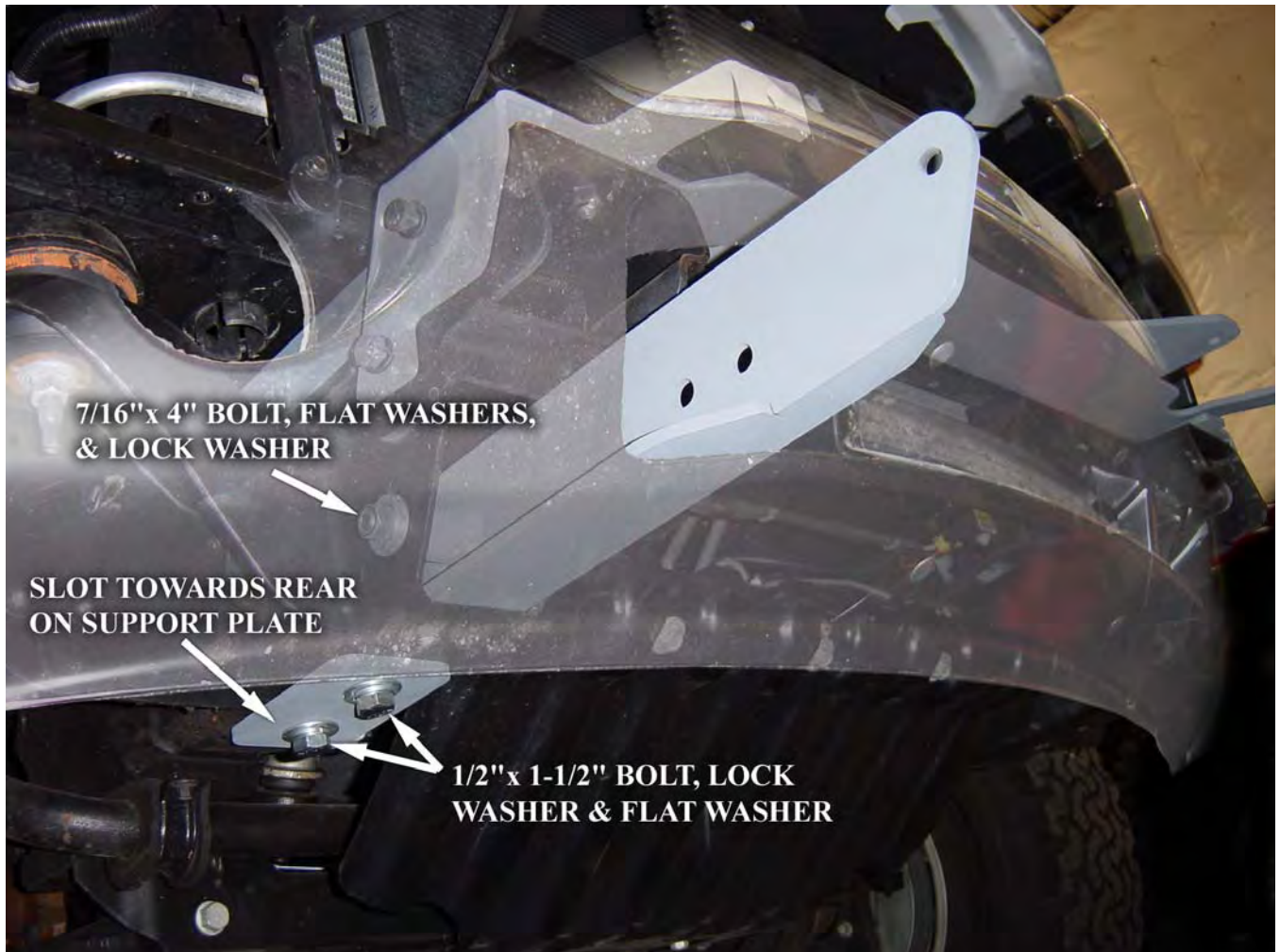


Once the holes are aligned put the six bumper factory bolts back in place, but do not tighten them yet.

- Carefully center the bumper side to side by checking the match-up to the front fenders on each side. Tighten all six bumper bolts securely. Plug fog lights back in. Reinstall plastic air baffle. The air baffle will be angled down and tight against bottom of W-Plate. Reinstall grille.
- Install the Frame Extension as shown in Figure 6. Use the Support Plates underneath the frame with the slots towards the rear of the vehicle. NOTE: Use flat washers on both sides of the 7/16" x 4" bolt.



**Figure 5b: Use screwdriver to align parts.**



**Figure 6: Install Frame Extensions.**



**Figure 7a: Drilling holes for Bumper Bracket.**



**Figure 7b: Drilling holes for Bumper Bracket.**

The Bumper Brackets are optional for winches that are 9000 lbs or less. The Bumper Brackets are required for winches capable of pulling more than 9000 lbs.

**⚠ WARNING**

**DAMAGE MAY OCCUR TO THE VEHICLE OR TRANSFORMER IF A WINCH CAPABLE OF PULLING MORE THAN 9500 LBS IS USED AND THE BUMPER BRACKETS ARE NOT INSTALLED.**

**⚠ WARNING**



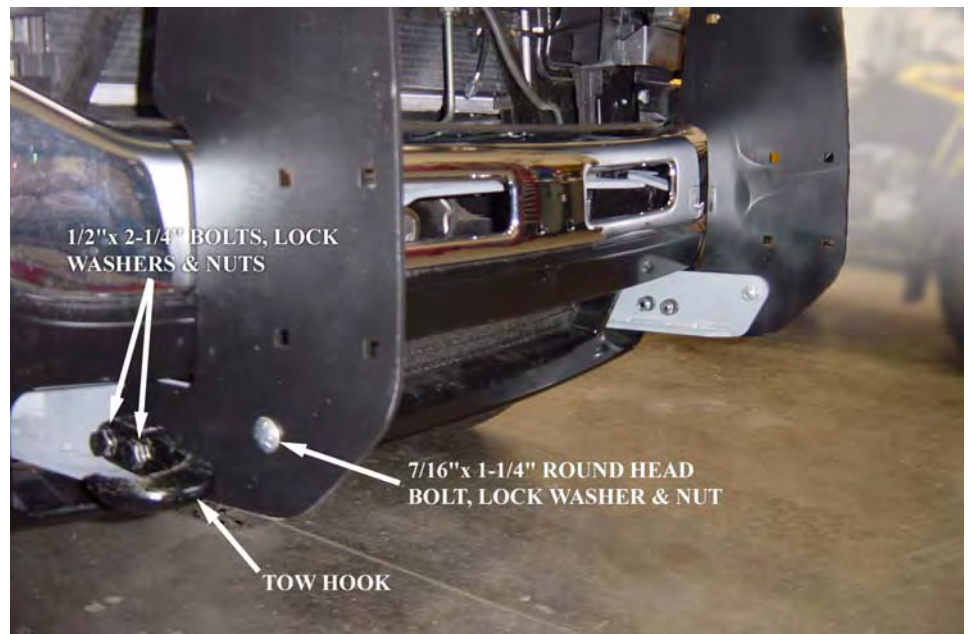
**DRILLING OPERATIONS CAN CAUSE FLYING CHIPS. WEAR SAFETY GOGGLES. FLYING CHIPS CAN CAUSE EYE INJURY.**

9. Mark the bumper on both sides in the location shown in Figure 7a and 7b. Drill the hole in the bumper first with a 1/16" drill bit. Using a flashlight look in the hole and determine if the drilled holes line up with the holes in the W-plate. If not re-drill in the correct location. Then drill the holes with the 7/16" drill bit.

10. Reinstall the plastic grille.

11. Install the Side Members onto the Frame Extensions as shown in Figure 8 and include the Tow Hooks at the inner lower holes. Leave fasteners loose.

12. If a winch carrier is being used, install it at this time (Figure 9b).

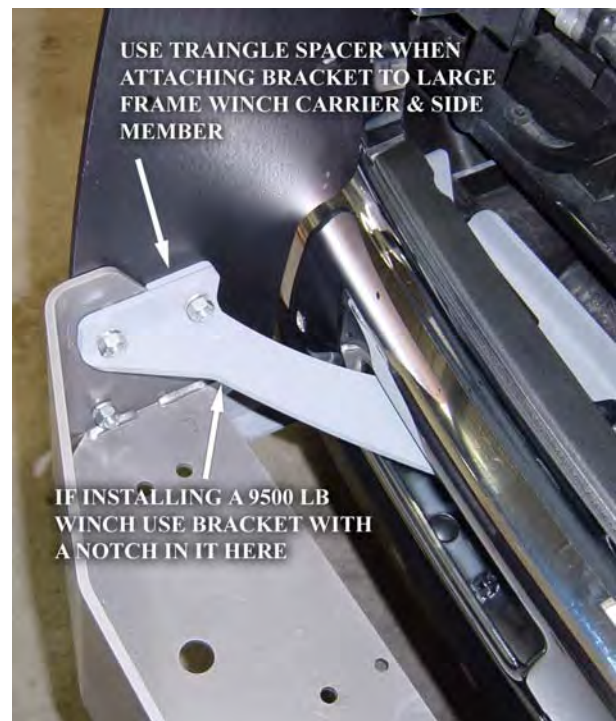


**Figure 8: Side Member Installation (grille not pictured).**





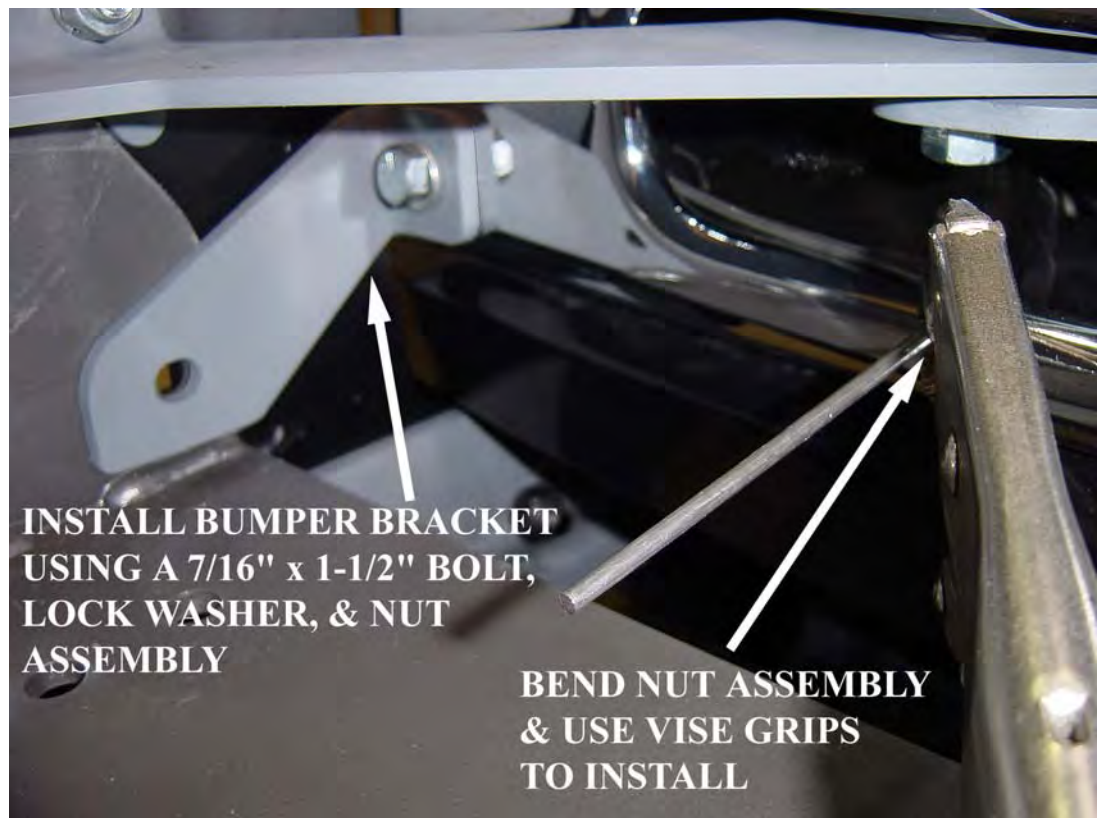
**Figure 9a: Bracket Attachment w/o Winch Carrier**



**Figure 9b: Bracket Attachment w/ Winch Carrier**

13. Install the Upper Brackets to the Side Members as shown in Figure 9a or 9b, depending on the use of a winch carrier or not. If a Warn 9500 lb winch is being used the Right Upper Bracket with the notch in it will have to be used. The notch allows the bracket to clear the motor. Use 7/16" carriage bolts, lock washers, and nuts to mount them to the side members, or if it is a stainless steel kit use the stainless steel button head screws and lock nuts. Use the 1-1/4" x 7/16 bolts, lock washers, and nuts to mount the brackets to the W-Plate.

14. Install the bumper brackets as shown in Figure 10. Put silicone sealant around the hole in the bumper before bolting the bracket in place. Hold the nut assembly with a pair of vise grips to line it up with the hole in the W-Plate, and attach it with a 1-1/2" x 7/16 bolt and lock washer. Use a 7/16" carriage bolt or button head to secure the bumper bracket and winch carrier to the side member.



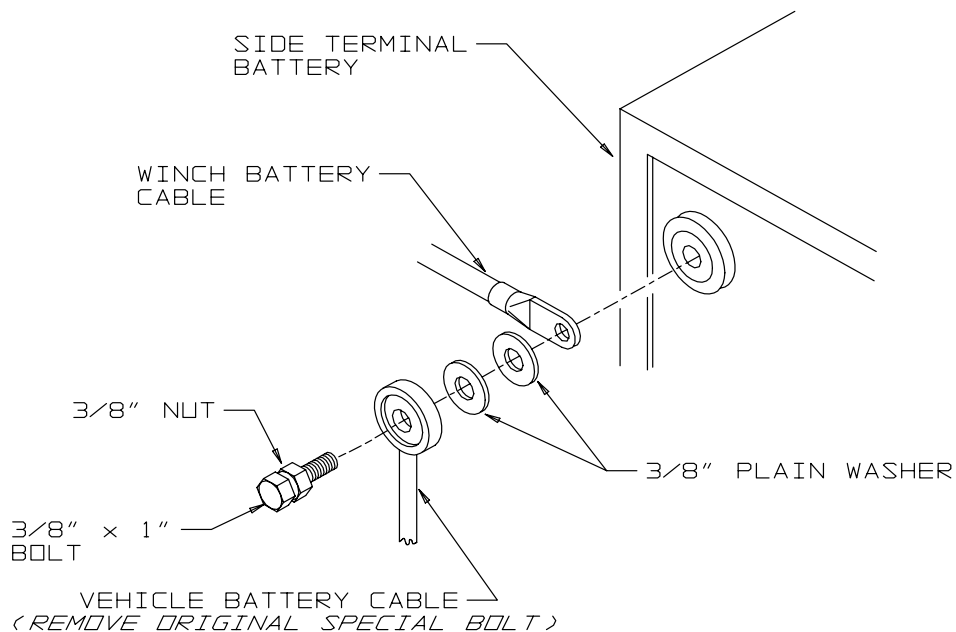
**Figure 10: Install Bumper Bracket**

15. Tighten all fasteners that were used in this kit to specified torque. Torque factory bolts to factory specs.
16. Reinstall the plastic shroud that attaches to the top of the grille.
17. Install the winch (if applicable) referring to the instructions packaged with the winch.
18. Install the lower Grille Guard Tube as shown in Figure 9. Use the plastic washers at the ends of the Tubes if it is a black kit (not applicable for stainless).
19. Make the winch electrical connections (if applicable) to the side terminal battery using the supplied hardware shown in Figure 12.



**MOUNT GRILLE GUARD TUBES WITH 3/8" x 1" BUTTON HEAD BOLTS. USE PLASTIC WASHERS ON BLACK KIT ONLY**

**Figure 11: Mount Grille Guard Tubes.**



**Figure 12: Battery Cable installation.**



## **Warn Industries**

### **Stainless Steel Truck Accessories**

#### **What to expect:**

Polished stainless steel combines the beauty of a chrome-like appearance with extreme durability and corrosion resistance. With a minimum amount of care, the appearance will last almost indefinitely. Unlike platings or coatings, there is nothing to peel off or wear away that would allow corrosion underneath.

The actual appearance may not be exactly like new chrome in either the degree of luster or color. There may be fine polishing lines visible up close and small differences between mating parts of an assembly. A grille guard, for instance, may have small differences between the round tubing and the flat plate. The backside of a part may not be as highly polished as the front. However, part of the beauty and appeal of stainless actually lies in the smooth “hand-worked” appearance.

There also is a possibility that small rust spots can appear on stainless products. They are usually due to minor iron contamination on the surface as a result of normal manufacturing and handling processes. This minor rust, if it occurs at all, is easy to remove and will not tend to spread.

#### **Recommended care:**

Regular washing with fresh water and mild car wash detergents followed by rinsing and drying with a soft towel is the best minimum care. Beyond that, any cleaner/wax recommended for automotive finishes will work well to remove minor stains and scuffs, enhance the shine and provide protection. Always use clean soft cotton cloths. In most cases, this will be all that is required for many years. For more serious blemishes or a rust spot, use a cream metal polish recommended for stainless, aluminum, etc. Try to rub in the direction of the original polishing lines. Ultimately, any stainless part can be restored to a brilliant shine with power buffing processes.

#### **Caution:**

Do not use steel wool or any type of metal scraper. Do not use “Scotch Brite” pads or abrasive powdered cleaners. Do not try to clean with muriatic acid or any other acid.

#### **Stainless Fasteners**

Stainless steel fasteners are included in many of the stainless kits. These fasteners provide similar corrosion resistance and appearance as the rest of the kit. However, stainless fasteners are prone to galling when installed in similar stainless material. It is a good idea to apply a small amount of anti-seize compound to the threads when installing them. Care should also be taken when tightening the fasteners to prevent rounding or deforming the corners of the bolts. Make sure the wrenches are the correct size and fit properly. In the case of socket heads, the wrench should have sharp, un-worn edges. With a few precautions during assembly the products should provide years of service.