



INSTALLATION INSTRUCTIONS

Trans4mer Mounting Systems

Part No. 29753 (black)

Part No. 65654 (stainless)

for full size GM pickups, and
Blazer, Yukon, Suburban, Tahoe

As you read these instructions, you will see **NOTES**, **CAUTIONS** and **WARNINGS**. Each message has a specific purpose. **NOTES** are additional information to help you complete a procedure. **CAUTIONS** are safety messages that indicate a potentially hazardous situation which, if not avoided, may result in minor or moderate injury. A **CAUTION** may also be used to alert against unsafe practice. **WARNINGS** are safety messages that indicate a potentially hazardous situation, which, if not avoided could result in serious injury. **CAUTIONS** and **WARNINGS** identify the hazard, indicate how to avoid the hazard, and advise of the probable consequence of not avoiding the hazard. **PLEASE WORK SAFELY!**

▲ WARNING

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

WEAR SAFETY GLASSES WHEN INSTALLING THIS KIT.

NOTE: Please read these instructions thoroughly before starting installation of this kit. Minor modifications may be required due to variations between vehicles.

PARTS LIST

PART NO.	QUANTITY	DESCRIPTION
37400	2	Side Member, Black
65647		Side Member, Stainless
35249	1	Frame Extension, L. H.
35250	1	Frame Extension, R. H.
29750	2	Nut Plate
29128	1	Tube Assembly, Black, 1.50
65657		Tube Assembly, Stainless, 1.50
29132	1	Tube Assembly, Black, 2.50
65658		Tube Assembly, Stainless, 2.50
29783	1	Brace, R. H.
29784	1	Brace, L. H.
34029	1	Bracket Upper R.H.
34030	1	Bracket Upper L.H.
34074	1	Silicone Sealant Tube
30073	3	Shim Plate

This **Warn Trans4mer System** can be customized to give your Chevrolet or GMC truck a wide variety of looks, front end protection and winch mounting variations. The system starts with this strong two-tube grille guard that attaches to the truck's frame with brackets designed by Warn engineers to handle up to a 9500 lb winch. It is durable and good looking as is, 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 pads for mounting auxiliary lights. The tubes can be mounted in various positions to achieve the look and function that you like. You can mount a winch carrier bracket that provides a permanent mount for a Warn winch. Or, you can add a receiver bracket that will handle the Warn Multi-mount Winch System, a draw bar or any other accessory that fits the standard 2 inch receiver tube. Finally, brush guards that protect the headlights and front corners of the truck can be added to any of the options above.

WARN PART NUMBERS FOR AVAILABLE OPTIONS

29169	Light Bar Kit, Black
29165	Winch Carrier Kit
30040	Winch Carrier Kit (M8274 winch only)
29166	Receiver kit (black only)
29768	Brush Guard Kit, Black
65866	Brush Guard Kit, Stainless

TORQUE SPECIFICATIONS

Bolt size	Torque
5/16 inch	17 LB. FT (23 N-m)
3/8 inch	30 LB. FT (40.7 N-m)
7/16 inch	50 LB. FT (67.8 N-m)
1/2 inch	75 LB. FT (101.7 N-m)

WARNING

Never fasten parts to this kit in a position that will interfere with or damage brake lines, electrical wires, fuel tank or other objects. Damage to vehicle brakes, electrical system, or other systems may occur if brackets are installed improperly, resulting in serious injury. Tighten all fasteners securely.

1. Remove the following factory parts: (Certain vehicles may not include some of these parts).
Plastic air dam underneath bumper.
Tow hooks
License plate housing
2. Check bottom surface of frame rail for protruding welds, etc. and file smooth if necessary.
3. Insert nut plates into front ends of frame rails and line up with holes in bottom of frame. Since there are two frame styles used on these trucks, examine **Figures 1-A** and **1-B** and decide which frame you have. Install the frame extensions using the set of holes shown for your frame. The shim plates are required with frame style 1-A and they must have the extra length extending to the rear as shown. A third shim plate is included to help align the grille guard with the bumper and grille if necessary. Never use washers as shims at this location. The factory tow hooks can be reinstalled using the supplied 2-1/2" bolts. Trucks with the aluminum air deflector plate will need the outer corners of the mounting tabs trimmed slightly. **DO NOT FULLY TIGHTEN BOLTS AT THIS TIME.**

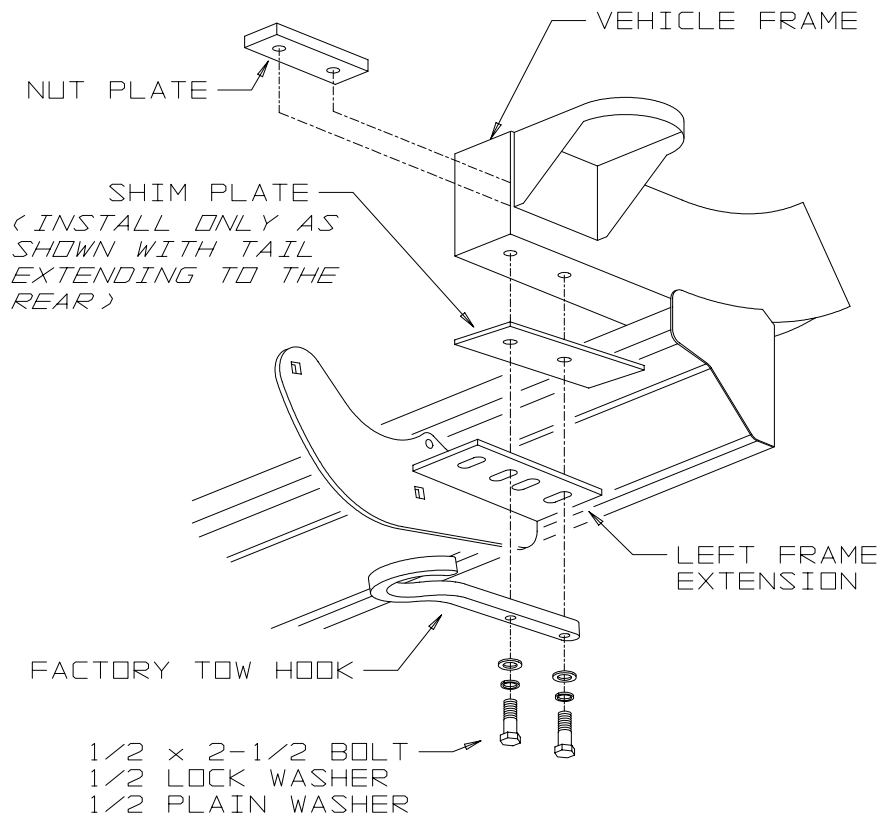


Figure 1A

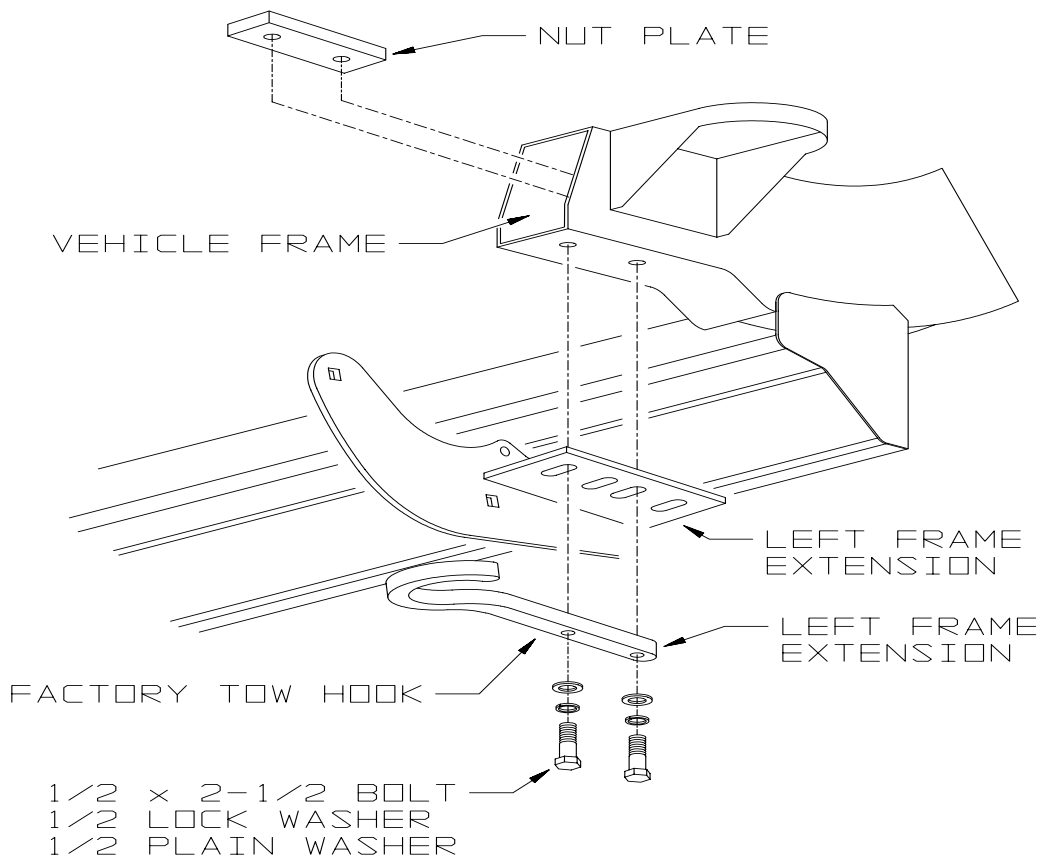


Figure 1B

NOTE: On a few vehicles with frame style 1B, the frame extensions may be tight against the bumper. This will force the side member plates to be too far apart, making it appear that the straight tubes are too short. (25" is the correct length). When this occurs, refer to **Figure 1C** and break out the spacer plugs. This will allow the parts to move forward enough to match the bumper correctly.

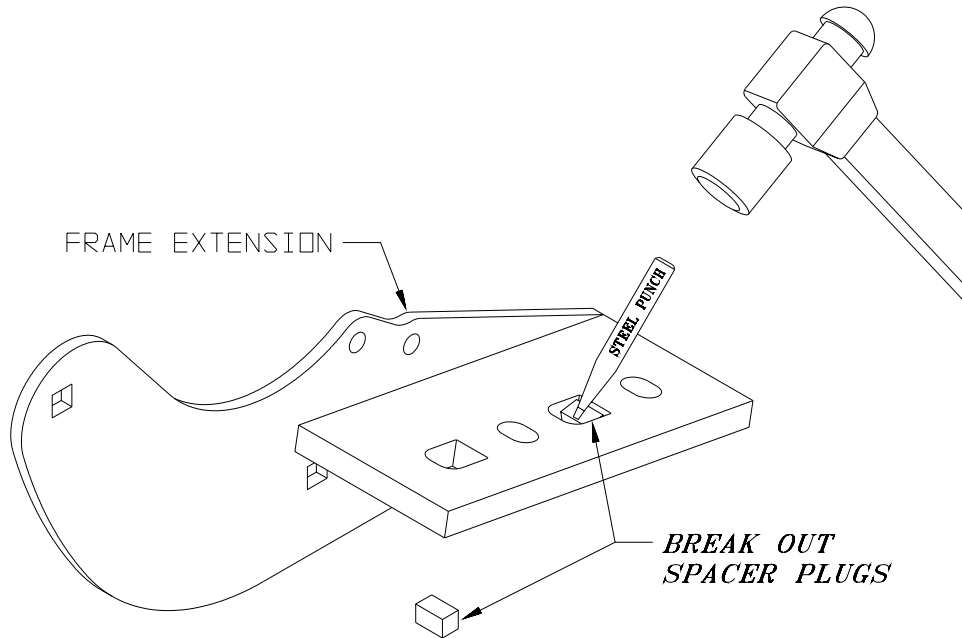


Figure 1C

4. If an air dam is being used, refer to **Figure 2** and cut slots as shown. Slide the air dam over the frame extensions, but do not attach to the bumper at this time.

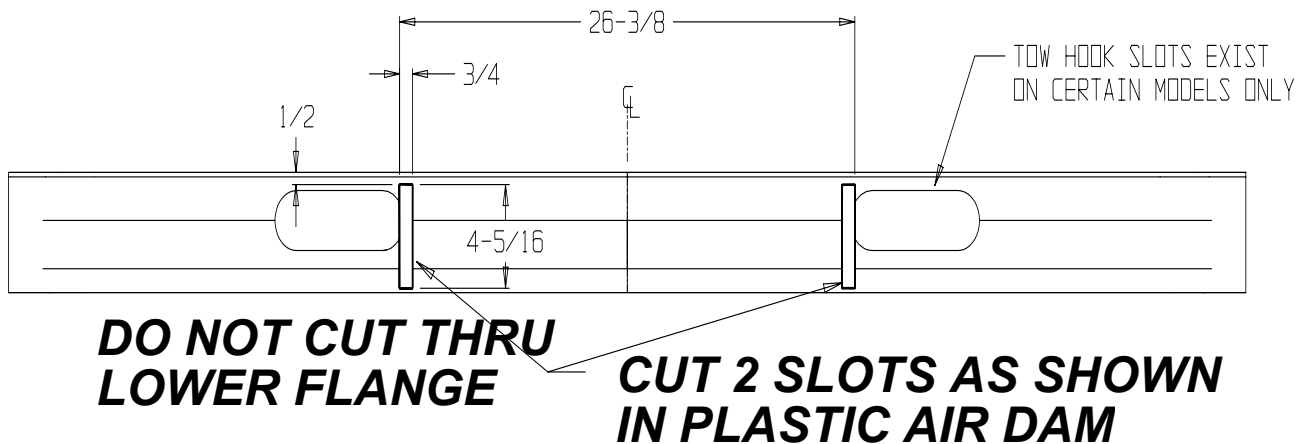


Figure 2

5. Install the side members onto the inside surfaces of the frame extensions as shown in **Figure 3**.

IF BRUSH GUARDS ARE BEING INSTALLED REFER TO BRUSH GUARD INSTALLATION INSTRUCTIONS AT THIS TIME

6. If the Trans4mer is being installed as a grille guard and a winch is not being mounted at this time, install the tubes in any desired position as shown in **Figure 3**. If the Winch Carrier or the

Receiver Kit is being added, install a tube only in the top position and then refer to the specific instructions packaged with those items.

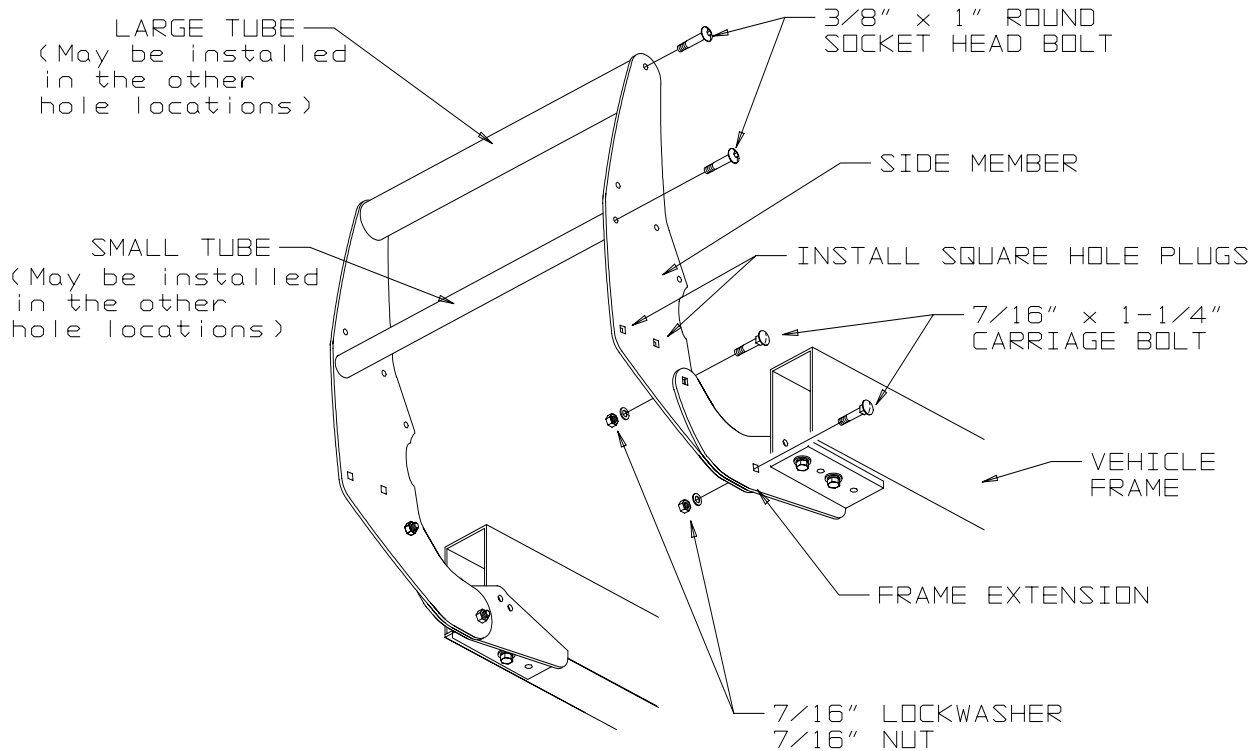


Figure 3

- Align the entire assembly with the vehicle and tighten all fasteners securely, except for the air dam which should be left loose to improve access for step 8.



WARNING



Drilling operations can cause flying chips. **WEAR SAFETY GOGGLES.** Flying chips can cause eye injury.

- Refer to **Figure 4** and drill a 3/8" hole in each frame rail using the hole in the frame extension as a guide. Choose the hole that best matches the particular frame style on your truck. It is suggested that a 3/8" drill be used at first to make a center mark, then switch to a smaller size (1/8 - 3/16") and drill thru, then finish the hole with a 3/8" drill. Install the bolt using spacer washers as required to fill the space. It is helpful to tape the washers together in a tight pack to hold them in place while inserting the bolt.

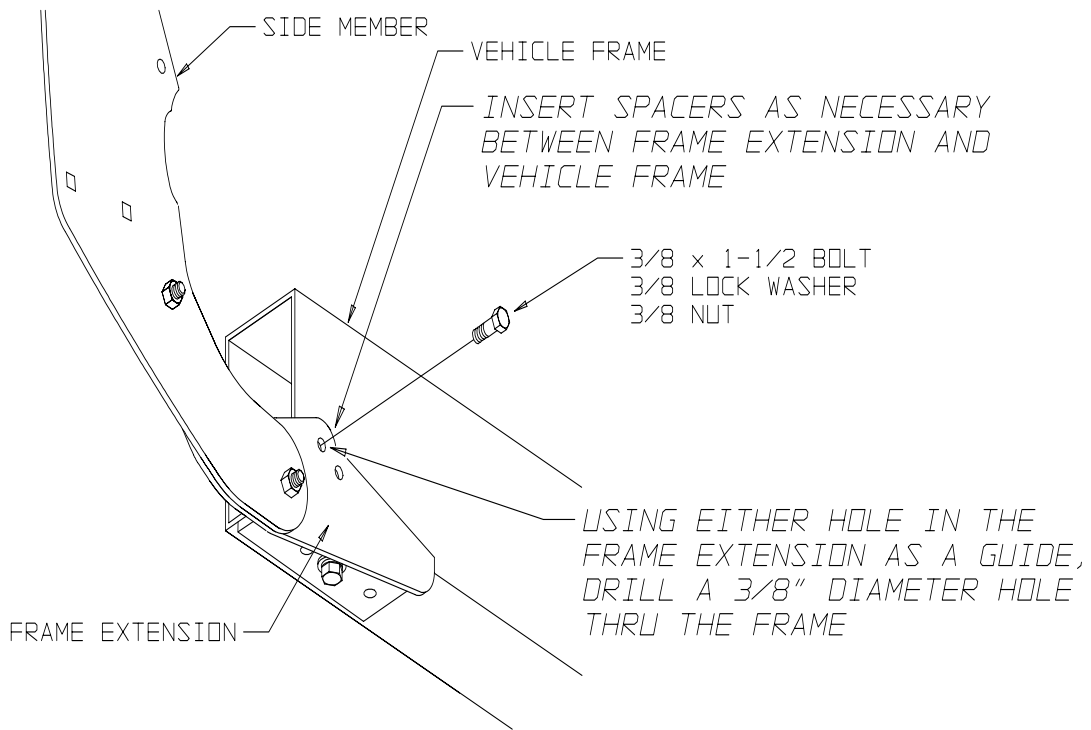


Figure 4

9. Fasten the air dam to the bumper.
10. Attach the upper brackets to the inside of the side members **as shown in Figure 5**. Adjust the brackets to lie flat against the vehicle bumper. Use the hole in the brackets to mark bumper. Remove brackets and drill a 3/8" hole through the bumper at each mark.

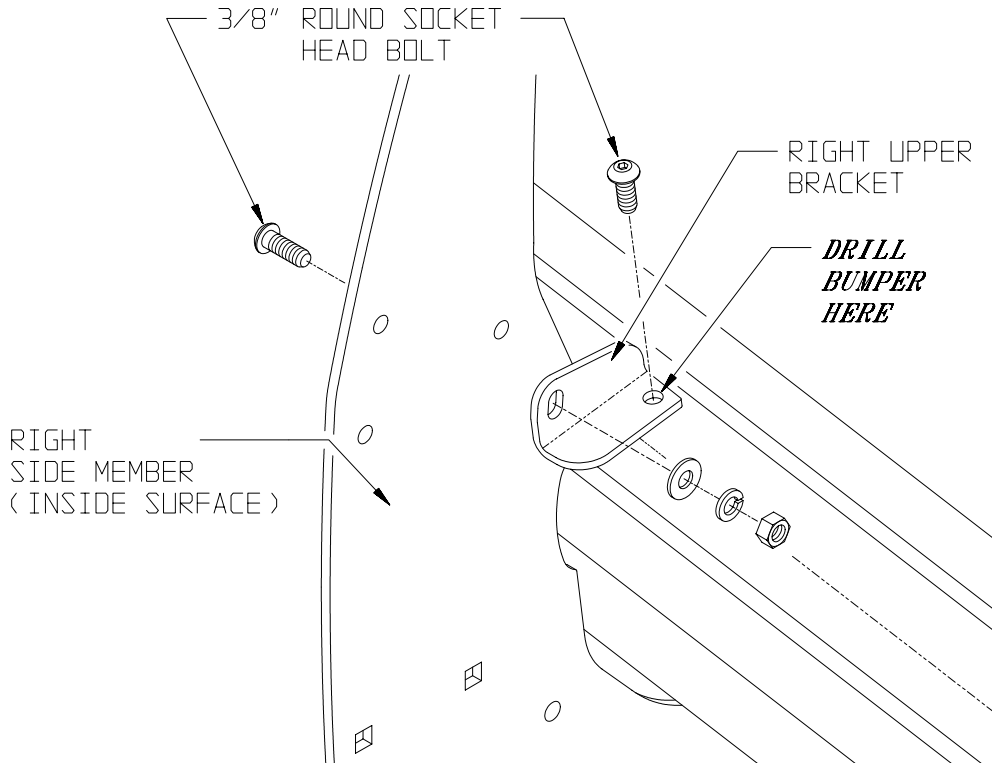


Figure 5

11. To seal the drilled hole against corrosion, insert the bolt into the bracket, apply a bead of the supplied sealer as shown in **Figure 6**, then install bolt with bracket into the drilled bumper hole.

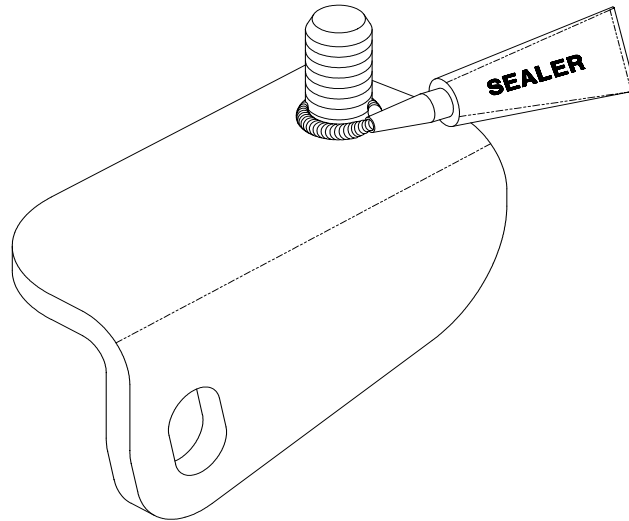


Figure 6

12. **If a Winch Carrier or Receiver Kit is being installed, it is mandatory that the braces shown in Figure 7 be installed.** Drill 5/16" holes in the braces to match the lower license housing holes in the bumper. Some minor bending of the brackets may be required to improve the fit. If a winch is not being mounted at this time, the braces are optional, but be sure to save them if a winch may be mounted at some future time.

NOTE: Four (4) stainless steel 7/16-14 x 1-1/2" button head bolts are included in the stainless kit. Replace the 7/16" carriage bolts in the Winch Carrier Kit with these when attaching the Winch Carrier to the Side Members.

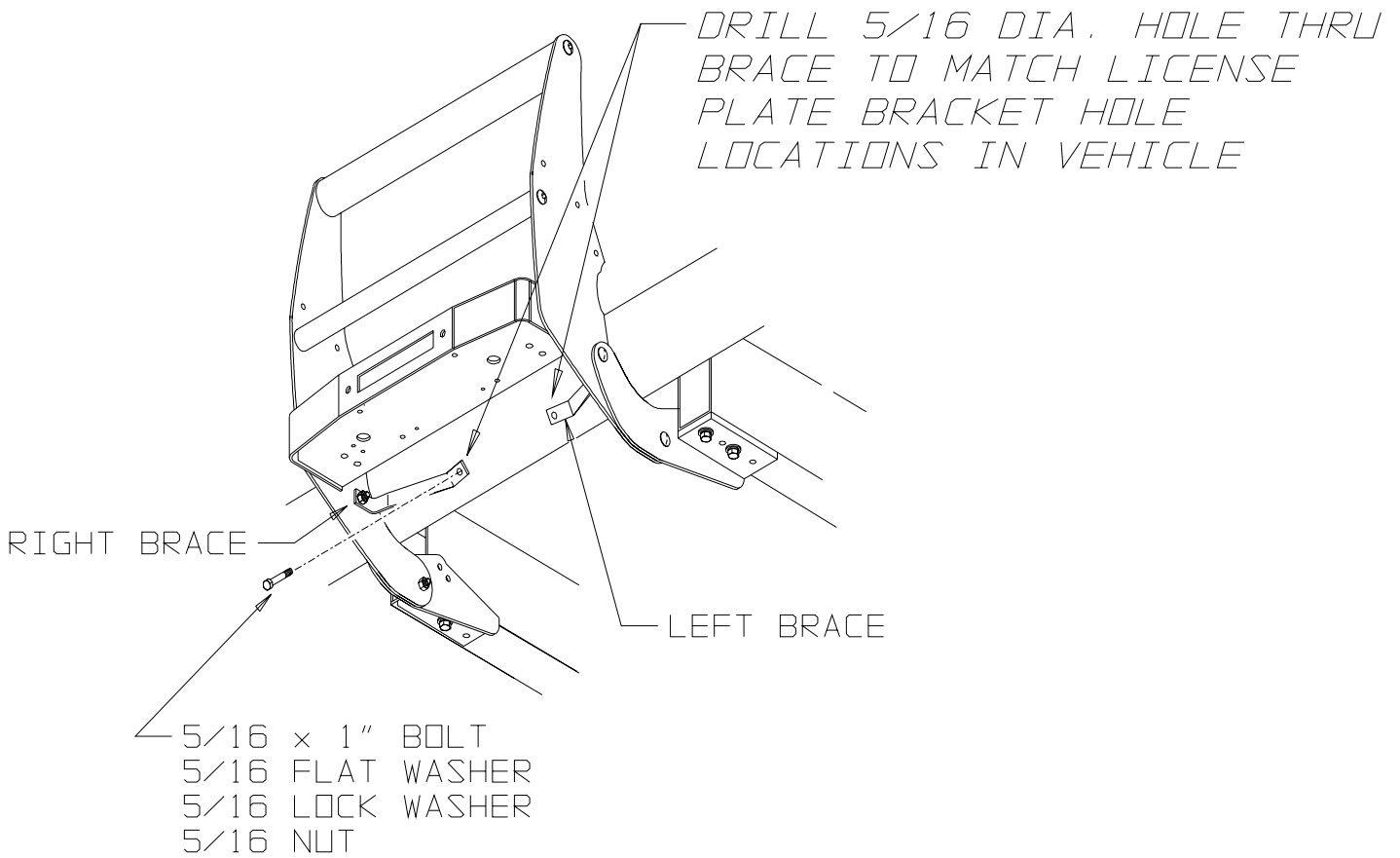


Figure 7

13. When connecting winch electrical cables to a GM side terminal battery, use the fasteners provided as shown in **Figure 8**.

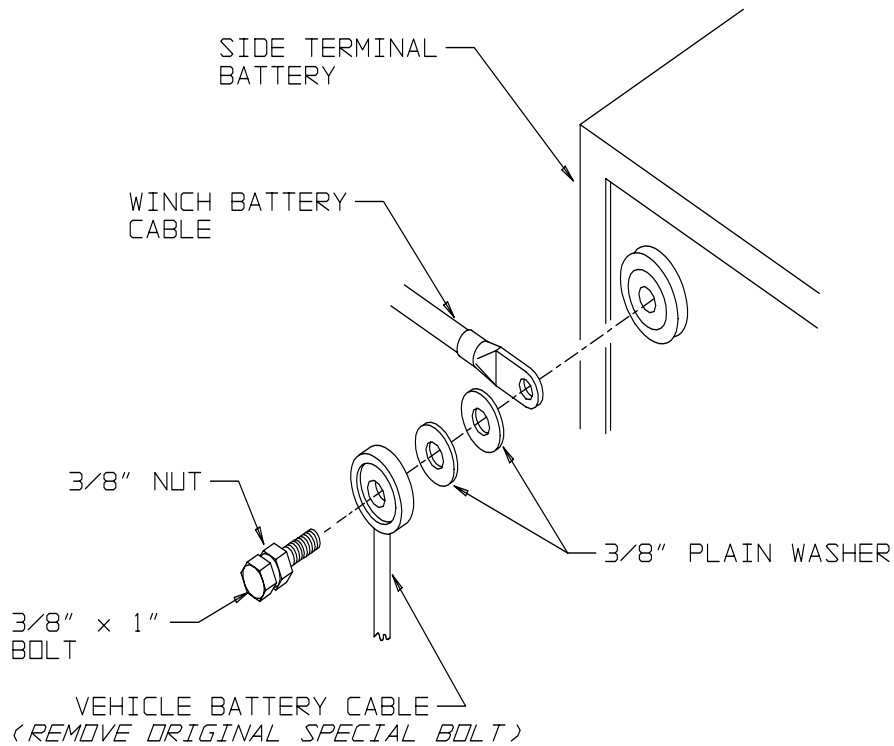


Figure 8

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.