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## Bolt In Steering Box Brace Kit for '67-'87 ('91) Chevy

<u>Application</u>	<u>Part Number</u>	
'67-'72 Chevy 4WD	GU29001	
'73-'80 Chevy 4WD	GU39001-E	
'81-'87 ('91) 4WD	GU39001-L	
'73-'87 Chevy 2WD	GU39001-2WD	

The '67-'87 ('91) straight axle GM's are notorious for frame problems behind the steering box, even with stock height tires. Large tires and lockers only make the flex problems worse and flex eventually leads to cracks. This steering box brace goes to the source of the problem by stopping the flex before cracks can start.



'73-'80 Bracket shown, the others are similar

1. For 4WD trucks: remove the bolt and spacer from the forward most, top steering box bolt (this is the only one that's in front of the crossmember).

### **'67-'72 4WD Chevy trucks**

The small bracket goes on the front of the crossmember. It has one large hole and the matching hole on the frame is usually already drilled in the crossmember, but don't be surprised if you have to enlarge or oval that hole to make our bracket fit. A die grinder or rat tail file may be handy to get the holes to line up. Apply Loctite or similar to new 7/16" bolt, snug bolt into the steering box first (while holding the bracket up against the crossmember), then tighten the bolt through the crossmember to 25 ft. lbs. Finally tighten the bolt in the steering box to 80 ft. lbs.

**'73-'80 4WD Chevy trucks**

The small bracket goes on the front of the crossmember. It has one large hole and the matching hole on the frame is usually already drilled in the crossmember, but don't be surprised if you have to enlarge or oval that hole to make our bracket fit. A die grinder or rat tail file may be handy to get the holes to line up. Apply Loctite or similar to new 7/16" bolt, snug bolt into the steering box first (while holding the bracket up against the crossmember), then tighten the bolt through the crossmember to 100 ft. lbs. Finally tighten the bolt in the steering box to 80 ft. lbs.

**'81-'87 ('91) 4WD Chevy trucks**

The small bracket goes on the front of the crossmember. To install it, you'll have to remove the factory bracket in this location and sandwich ours underneath. A die grinder or rat tail file may be handy to get the holes to line up. Apply Loctite or similar to new 7/16" bolt, snug bolt into the steering box first (while holding the bracket up against the crossmember), then tighten the bolt through the crossmember to 25 ft. lbs. using the stock bolts. Finally tighten the bolt in the steering box to 80 ft. lbs.

**'73-'87 ('91) 2WD Chevy trucks**

The steering box brace for 2WD trucks fits on the front of the crossmember, it does not use any brace on the back of the crossmember.

2. Remove the two rearward steering box bolts and sleeves.

3. Install the two remaining 7/16” bolts through the main steering box brace bracket and snug them up into the steering box. Starting in the early 80’s many GM trucks came with oil coolers that may interfere with the larger brace. If you run into that, you can re-route or move the lines, notch our brace, or remove the cooler entirely. If there is a gap between the brace and crossmember, it is ok to use a washer.



4. Mark the crossmember by pushing a marker or punch through the end of the steering box brace. Remove the larger steering box brace from the truck.
5. Drill 1/2” hole through the crossmember, make sure to watch out for brakelines and hoses.
6. Re-install the steering box brace with all three bolts loose.
7. Torque the bolts into the steering box to 80 ft. lbs.
8. Torque the bolt through the crossmember to 75 ft. lbs.

Steering box bolts are a periodic maintenance point, especially with hard off road use. Make sure they stay tight, check them often.