

For installation of billet grilles that require cutting of the stock shell, proper tools, knowledge and skill are needed. Carriage Works is not responsible for care & accuracy of the installation, only for Fit & Finish of its products. Use a qualified installer or contact original vendor for references to complete all instructions.

PART# 4034	1969-72 CHEVY PHANTOM BILLET GRILLE		
Grille Installation			
STEP: 1 Remove the Bumper, Turn Signals, and Head Light assembly			
STEP: 2 Remove the Grille by taking out the Four ½” hex head bolts from each bracket at the end of the grille, and remove all hood latch and center brace bolts that are attached to the grille.			
STEP: 3 Lay Grille face down on protected surface so not to harm finish of the shell. Now remove all screws and clips that attach center grille section.			
STEP: 4 Now cut away a section of each grille bracket to allow clearance for billet grille (see Ref. #1 or picture #1). After cutting remove the two rivets at the bottom of bracket (Ref. #2&3).			
STEP: 5 Turn Grille shell over to view the front. Take notice where the body line and edge of black paint is around headlight (Ref. #4). This is your finish cut line. Cut just inside of this line so you can finish trimming with a file (Ref. #5). Your Grille shell is ready to install Billet Grille (Ref #6).			
STEP: 6 Turn Grille shell back over (facedown). Now raise both braces on back of shell (Ref. #3) and put Grille in under braces with tabs to the top of the grille shell. (Ref. #7)			
STEP: 7 Being careful not to scratch front of Billet Grille. Center grille in shell and mark the location of each vertical rod at bottom of Grille (Ref #8). Remove grille and drill 1/8” hole at each marked location so that a screw will go through and into hole in vertical rod end. Replace Billet Grille and insert screws.			
STEP: 8 Assemble top brackets with out screw clips to grille tabs as show in (Ref. #9). Tighten ¼-20 hex bolts and nuts with bracket in line with tab. Push down on grille, to assure tight fit. Clamp the two center brackets to shell (Ref. #10). Drill 1/8” hole through shell.			
STEP: 9 Put screw clips on tab and fasten with screw from top. Repeat on outer brackets			
STEP: 10 Pop rivet bottom of mounting brackets to bottom of grille shell.			
Truck Modifications			
STEP: 1 (Recess Headlight) First remove headlight adjustment nut & bolts from mount. Now put a mark on core support through these holes. Remove mount from core support by drilling out spot welds (Ref. #11). Put a 3 rd mark where headlight spring is. Now drill a 5/16 hole at each spot. Hook spring into its hole. Insert (1 ½ x ¼ -20 cap screw) bolt through other 2 holes from back of core support. Hook spring to light housing then with one nut on each bolt force bolt into adjusting slot in housing. Adjust light then pinch with jam nut (Ref. #12).			
STEP: 2 After doing headlights you must now cut fenders and center support for clearance. Cut off the front of center support on white line (Ref# 13).			
STEP: 3 Cut off the front of both fenders leaving about ¾” of flange for grille shell to overlap half way down side before cutting inward (Ref# 14 & 15)			
STEP: 4 After market turn signals on core support are recommended.			
STEP: 5 Mount Grille Shell & bumper on truck. Installation is complete!			
4034 GRILLE HARDWARE: <ul style="list-style-type: none"> • Qty-4 1 ½” x ¼ -20 Allen head bolts • Qty-8 ¼ -20 Nuts • Qty-4 3/16” x ½” Pop rivets Aluminum • Qty-4 Brackets (powder coated black) • Qty-4 ¼-20 hex head bolts • Qty-4 ¼-20 bolts • Qty-4 clips • Qty-4 #8 x 5/8” Phil Pan head screw • Qty-4 #8 x 3/8” Phil Pan head screw 			



