



1994-Up Chevy Phantom Grille

PART # 40401 - 40402 - 40403



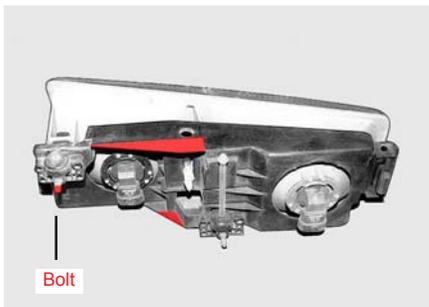
Hardware



1. Remove the four screws attaching each parking light assembly to the grille. Remove the assemblies and unplug the lights from the back.



4. The next step involves removing the headlight units so they can be recessed approximately 1". To do this, remove the four factory bolts on each side holding the headlight assemblies to the radiator support. Unplug lights and remove assemblies from truck.



7. Cut the tabs shown in red, on the back of the headlight assembly flush with the rounded boss they are attached to allowing the unit to line up with mounting holes on the new brackets. These pieces are all molded plastic so they are easy to cut with the cut-off disc or hack saw. **Cut off bolt to required length before re-installing so it will not rub against radiator.**



3. Remove the vertical rods on outside and near the center holding the headlamp assemblies to the plastic mounting plates. These pieces will be replaced by metal brackets supplied with the Carriage Works Inc. grille, which allows you to position the headlights about 1" further back so the grille bars can go in front of them.

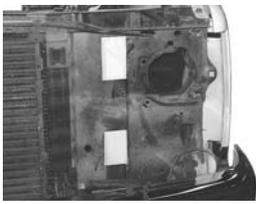


5. Pre-fit the Carriage Works Inc. shell & grille assembly to the truck by first attaching the two top tabs with the factory screws. With the vertical line of grille aligned with the edge of the fender, you can then drill holes in the exterior piece on fender. Close hood and check line.

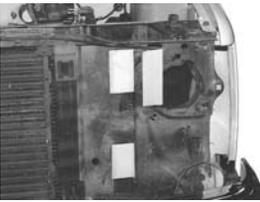
6. With the grille shell pre-fitted to the truck, remove it. The shell can then be painted.

8. The most complicated procedure is finding and cutting off a washer in back of each headlight unit. With a 90-degree torx wrench, loosen the bolt at the top center holding the lens unit until the unit is nearly detached and the washer on the top center bolt is accessible.

9. Working carefully with a cut-off disc, cut off this washer. Then retighten the adjusting screws, again in sequence, alternating a few turns at a time. Tighten the top center screw until it touches the vertical adjusting rod.



1988 with quad headlights

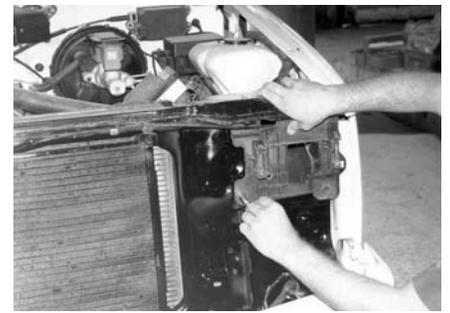


1990-95 with composite headlights

10. Sections shown in white have to be cut out of the radiator support panel to allow the headlights to move back.

11. Sections of the radiator support must be cut out using a die grinder with a very thin cut off wheel. The areas to be cut out are shown on the enclosed drawing. (See Figure 1A).

NOTE: On some models with large radiators, be careful not to cut into the radiator, the tolerances are quite close.



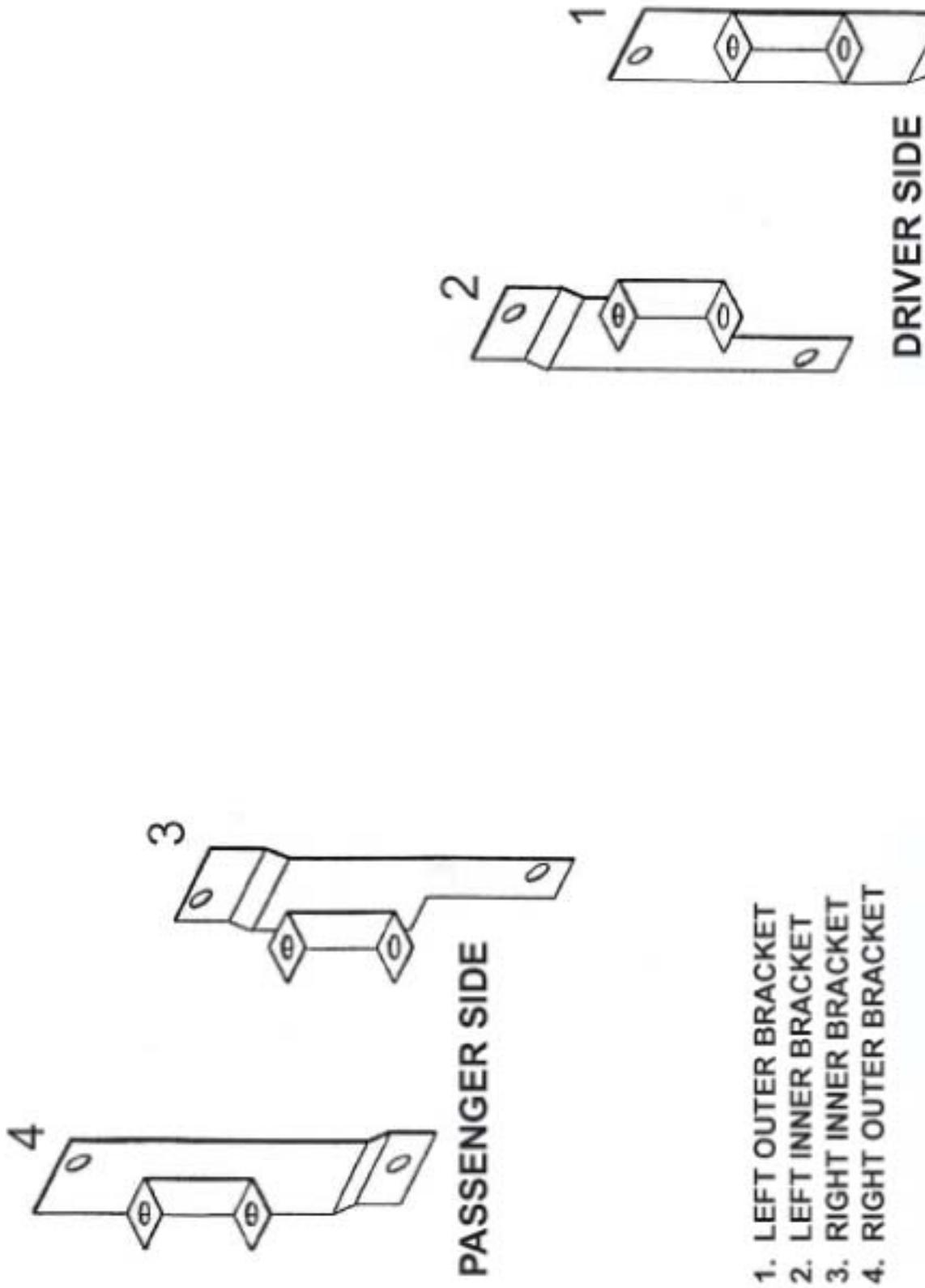
12. Mount the new brackets supplied into the original holes with original bolts. Refer to enclosed drawing to determine which of the four brackets go to the proper sides. (See Figure 2A).

13. Plug in the headlight wires before installing the unit with the two original long mounting bolts. **NOTE:** Insert the mounting bolts from the bottom this time, instead of the top as originally. You'll have to hold the nuts in place on top with needle-nose pliers.

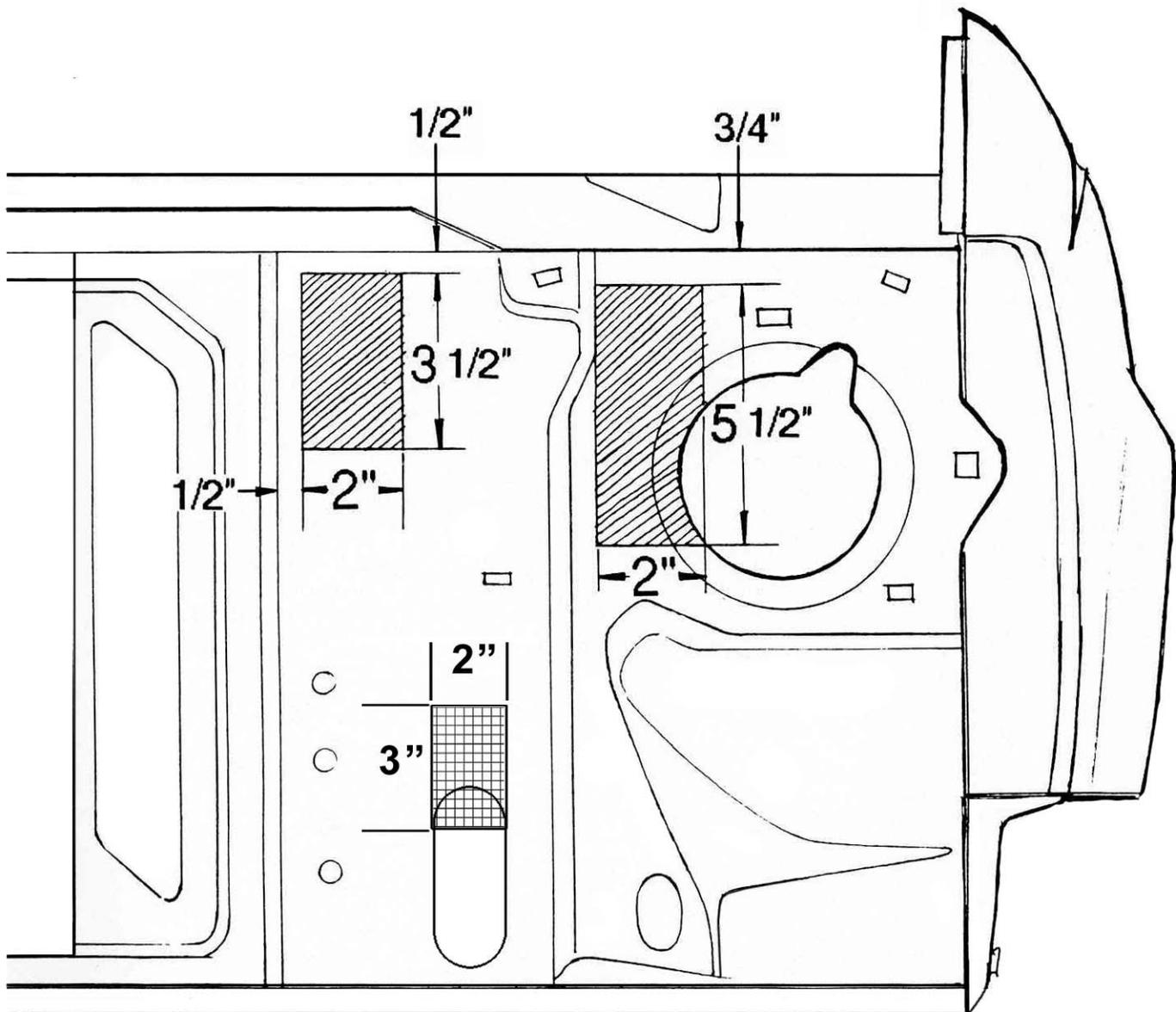
NOTE: Please adjust horizontal blades if irregular. This is the result of shipping and handling outside of Carriage Work's control.

Also Carriage Works Inc. recommends applying a high quality automotive wax to maintain the original appearance.

PHANTOM GRILLE LIGHT BRACKETS



BRACKETS SHOWN IN PROPER ORIENTATION FOR CLARITY.



CUT OFF SHADED AREAS
 RIGHT & LEFT SIDES ARE THE SAME
 1. LEFT OUTER BRKT. 2. LEFT INNER BRKT.
 3. RIGHT OUTER BRKT. 4. RIGHT INNER BRKT.

FIG. 1A