

Warrior Products, Inc.

INSTALLATION INSTRUCTIONS STEERING BOX FRAME SUPPORT **WARRIOR 899**

2 WHEEL DRIVE 1969 AND UP CHEVROLET FULL SIZE TRUCK WITH "OUTSIDE-OF-FRAME" STEERING BOX

IMPORTANT: The frame support brackets must be clamped into position on frame and welded to frame by a certified welder or front end frame specialist.

- 1) Support vehicle on Jack stands and remove drivers side tire, wheel, and all steering components, including steering box.. Completely remove steering box from frame.
- 2) If frame is cracked it must be repaired first. Make frame flat, grind groove along crack, weld its complete length, grind frame flat again. Clean all old paint or undercoating and all dirt away from all possible welding areas. Now the frame is ready for the support brackets.
- 3) Align large support plate with the four steering box holes on the inside of the frame, hold in place with four bolts, (not supplied). Use C-clamps to be sure support plate is consistently flat along frame. It may be necessary to heat the plate with a torch to help form it to the frame.
- 4) Weld plate to frame with 1 ½" weld passes. Move along approximately 1 ½" and begin welding another 1 ½" weld pass. **DO NOT WELD CONTINUOUS WELD PASSES.** Weld the top and two sides this way leaving the bottom with no weld until you install the bottom plate.
- 5) Place small plate on the underside of frame aligning the large hole over the rivet in the bottom of the frame. Clamp plate to frame and follow steps three and four above.
- 6) After cooling, remove small bolts, clean slag and apply two coats of paint.
- 7) Re-install all steering components, torque all bolts to manufactures suggested torque requirements. Install tire and wheel, torque lug nuts to manufacture recommended torque specifications.
- 8) After test driving your vehicle, check all bolts for tightness.

"Your Knight in Shining Armor!"

HAVE FUN WITH YOUR REPAIRED TRUCK