

# 20025

88-93 CHEVY  
PHANTOM  
BILLET INSERT



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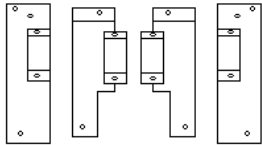
**88-93 Chevy Truck, 92-93 Suburban / Tahoe / Dually Truck**  
**(Requires composite style headlamps)**

**Tools Required:**

- Die Grinder w/ Cut-Off Wheel or Dremel
- Drill & Drill Bit (1/8" & 1/4")
- Files or Sand Paper
- Phillip Screw Driver
- Ratchet & Sockets (to remove grille shell)
- Torque Drive (to remove lower turn signals)

**Parts list:**

- 1 Upper Billet Insert (9 bars)
- 1 Lower Billet Insert (9 bars)
- 20 #8 x 3/4 Phillip Screws
- 20 #8 Flat Nuts
- 8 1/4-20 x 3/4" Bolts
- 8 1/4-20 Nuts
- 8 1/4-20 Washers
- 4 Headlight Relocation Brackets



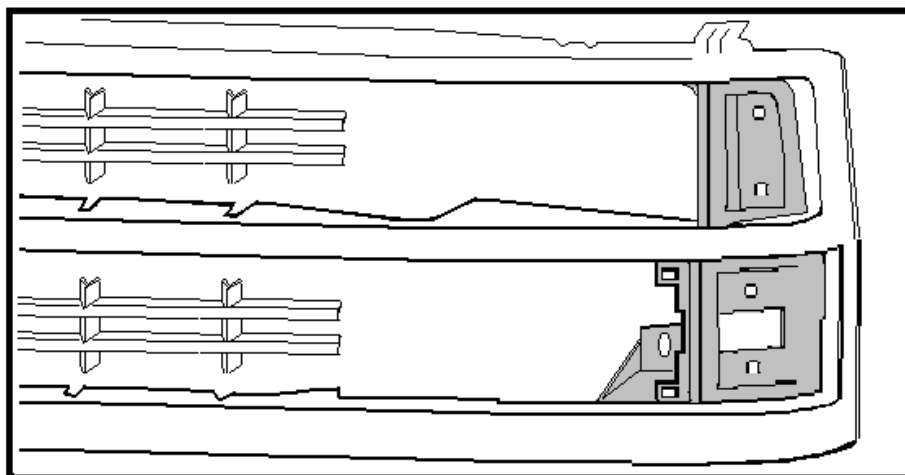
Headlight Relocation Brackets

**Read and understand instructions before attempting installation**

**NOTE: This grille assembly will require 90-93 style composite 1 piece headlamps.**

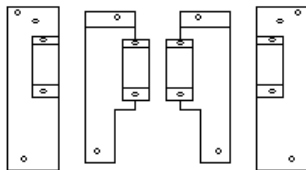
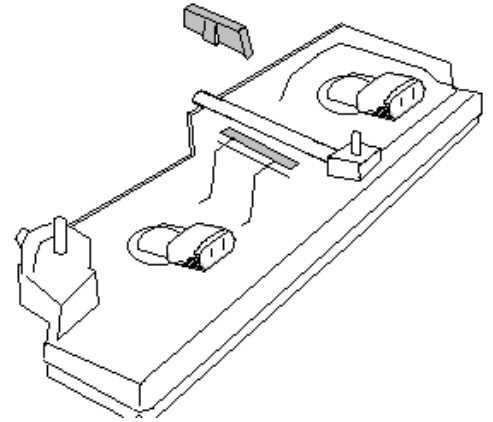
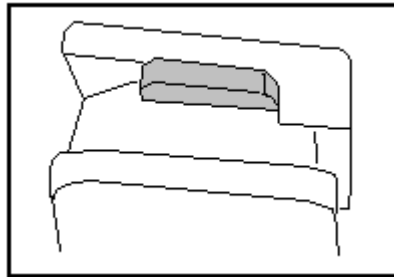
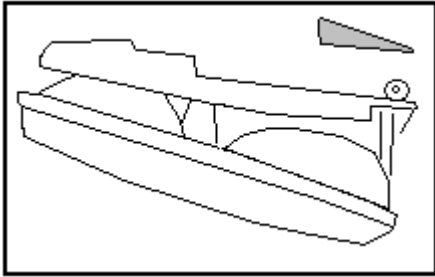
**Step 1.**

Remove the lower turn signals and unplug the lights. Remove all the factory bolts retaining the grille shell (Four along the top, one bottom center and one behind each parking light). Now remove the grille shell from the vehicle. Remove the corner lights. Apply masking tape to the chrome or painted areas. Place the grille face down on a table and cut the plastic cross bars out of the center of the grille shell. Make your cuts at the base of the bars. Now sand or file any rough edges smooth. The diagram illustrates how the bars will be cut.



**Step 2.**

Remove the four bolts and nuts securing the plastic headlight mounting buckets to the headlamps. Some areas on the headlights must be removed to attach the headlight relocating brackets. Cut the shaded areas off of the headlamp assemblies as shown here. Align the brackets as they will mount to see what areas will need to be trimmed.

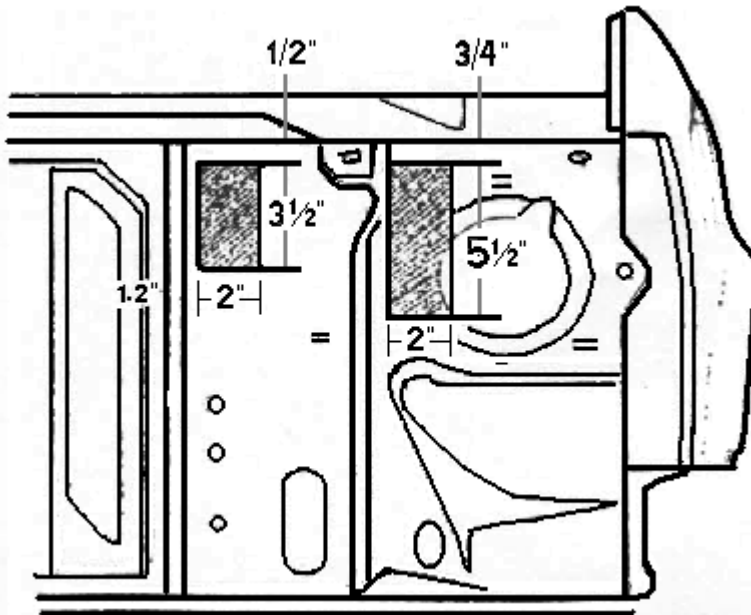


Passenger side

Driver side

Note the three bumps molded to the headlamps lenses. Use a file or die grinder to file these off each headlamp. Now bolt the headlight relocation brackets to the headlamps using the factory hardware (see above diagram).

Driver side view of core support from front of vehicle



**Step 3.**

A portion of material must be cut from the core support to mount the headlamps. Use this diagram on the left to cut the area needed to recess the headlights. Make your cuts as indicated by the shaded areas. Repeat the cuts on the other side of the vehicle. Test fit each headlight assembly on the vehicle. Mark the 1/4" mounting holes in the relocation brackets to the core support. Drill a 1/4" hole at each mark. Bolt the headlight assemblies back onto the vehicle using the 1/4" hardware.

**Step 4.**

Center the billets into the grille shell (The lower billet has mounting brackets on the back to hold the signals lights). Hold the billets firmly in place. Make sure they are flush; Drill a 1/8" hole at each mounting tab. Use the #8 screws and flat nuts to secure the billet in place.

**Step 5.**

Re-install the 4 piece corner lights. Center the grille assembly on the vehicle; slide the signal lights onto the lower billet insert. Attach the wiring harness to the lights. Install the remaining grille hardware. Use two of the factory signal light screws to secure the signals. *Thank you for purchasing a T-Rex billet grille. 9/13/05*