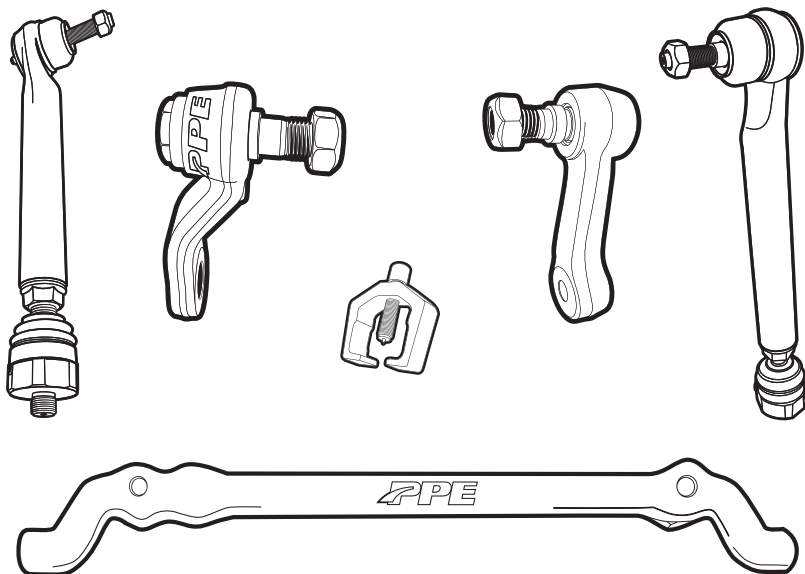




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Duramax Extreme-Duty Forged Steering Assembly

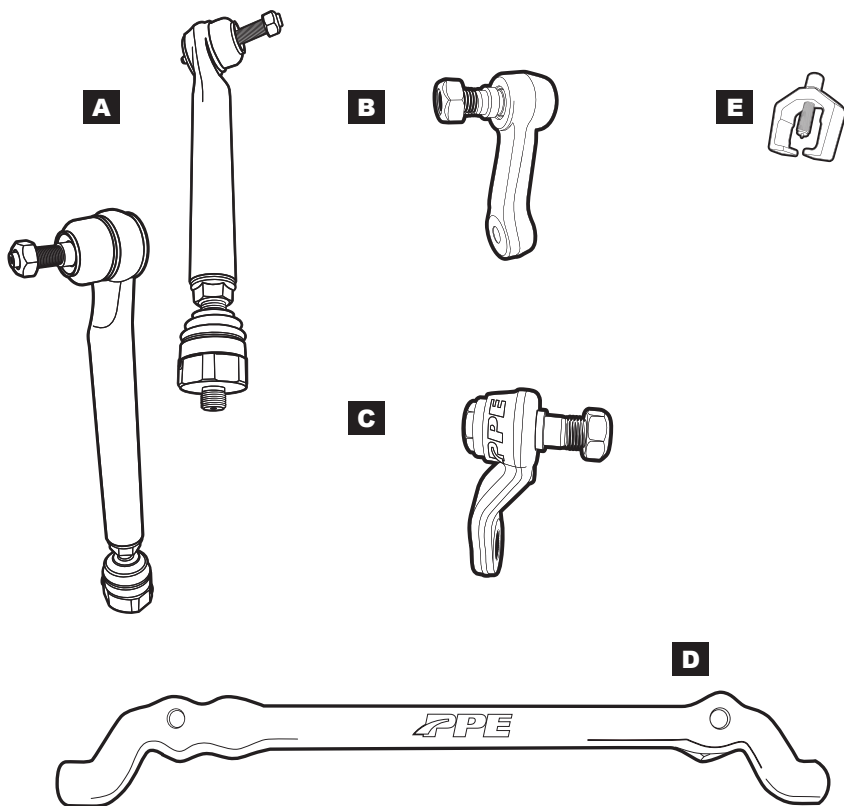
2001-2010 GM 2500/3500 HD
2011-2025 GM 2500/3500 HD

(158100110, 158101120)

Installation Guide



Duramax Extreme-Duty Forged Steering Assembly

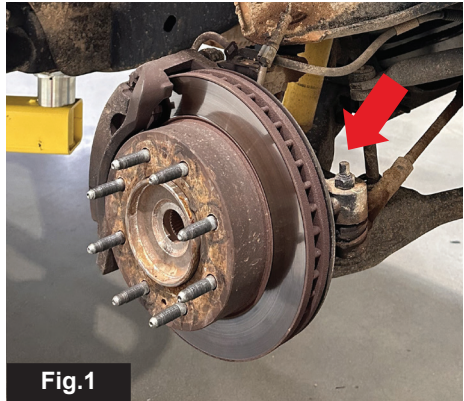


CONTENTS:

- A. (2) Forged Tie Rods
- B. (1) Forged Idler Arm
- C. (1) Forged Pitman Arm
- D. (1) Forged Center Link with 7/8" Holes
- E. (1) Heavy-Duty Pitman Arm Puller (Only in the 158100110 Kit)

INSTALLATION

1. Vehicle off and cool.
2. Remove both passenger and driver side front wheels and fender liners.
3. Remove the outer tie rod nut and separate the outer tie rod from the wheel spindle for both sides. **(Fig. 1)**



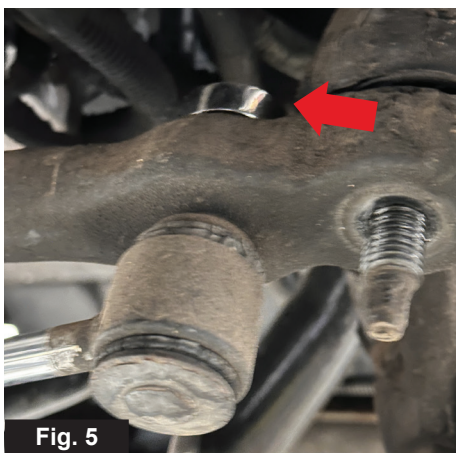
4. Remove the splash guard from under the vehicle. **(Fig. 2)**



5. Remove the nuts securing the idler and pitman arm from the bottom of the center link. **(Fig. 3 & 4)**



6. Remove the nut securing the steering stabilizer from the top of the center link. **(Fig. 5)**



7. Use the supplied Pitman Arm Puller (**E**) to separate the idler arm and pitman arm from the center link. (**Fig. 6**)
8. Separate the steering stabilizer from the center link then remove the center link from the vehicle.
9. Separate the splined end of the pitman arm from the steering box.
10. Loosen the bolts and remove the idler pivot assembly.
11. Separate the factory idler arm from the idler pivot assembly. Clean the shaft and regrease.
12. Install the PPE Idler Arm (**B**) into the idler pivot assembly. Torque nut to 73 lb-ft. (**Fig. 7**)
13. Install the idler pivot assembly back into the vehicle. Tighten the bolts.
14. Install the splined end of the PPE Pitman Arm (**C**) to the steering box. Torque nut to 185 lb-ft.



15. Install the PPE Center Link (D) to the PPE Idler and Pitman Arms (B & C) with the supplied spacers and bolts. The idler arm spacer must be installed between the Idler Arm and the center link, the pitman arm spacer must be installed between the Pitman Arm and the center link. Torque both nuts to 65 lb-ft. **(Fig. 8 & 9)** Install steering stabilizer back in place. Tighten nut to 30 lb-ft.



16. Remove factory tie rods from factory center link. Adjust the PPE Tie Rod **(A)** to the same length as the factory tie rod for each side. **(Fig. 10)** It is recommended to install the tie rods one side at a time to avoid confusion. Apply red thread locker to the inner tie rod threads then install into the PPE center link end. Torque to 73 lb-ft. **(Fig. 11)**



17. Install the outer tie rod to the tapered hole of the wheel spindle. Torque nut to 48 lb-ft. **(Fig. 12)**
18. Reinstall the splash guard, front wheels and fender liners.

Installation Complete



DISCLAIMER OF LIABILITY

Performance products can increase horsepower above and beyond factory specifications. Additional horsepower creates more stress on the drive-train components, which could result in drive-train failure.

Note regarding emissions-related, non-E.O.-legal products: THESE PRODUCTS ARE LEGAL IN CALIFORNIA ONLY FOR RACING VEHICLES THAT MAY NEVER BE USED, OR REGISTERED OR LICENSED FOR HIGHWAY OR OFF-ROAD USE.

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LIMITATION OF WARRANTY

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Limited lifetime warranty on all PPE cast aluminum products, and PPE VXZmission Coolers. Three (3) year limited warranty on PPE Manifolds and Up-Pipes Kits, and OEM-Length Up-Pipes. One (1) year limited warranty on all other PPE products from the date of sale to original buyer and limited solely to the parts contained within the products kit. All products that are in question of Warranty must be returned prepaid to the Seller and must be accompanied by a dated proof of purchase receipt. All Warranty claims are subject to approval by Seller. Under no circumstances will the Seller be liable for any labor charged or travel time incurred in diagnosis for defects, removal, or re-installation - of this product or any other contingent expenses. Under no circumstances will the Seller be liable for any damage or expenses incurred by reason of the use or sale of any such equipment. In the event that the buyer does not agree with this agreement: the buyer may promptly return this product, in a new and unused condition in its original packaging, with a dated proof of purchase to the place of purchase within ten (10) days from date of purchase for a full refund. The installation of this product indicates that the buyer has read and understands this agreement and accepts its terms and conditions.



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