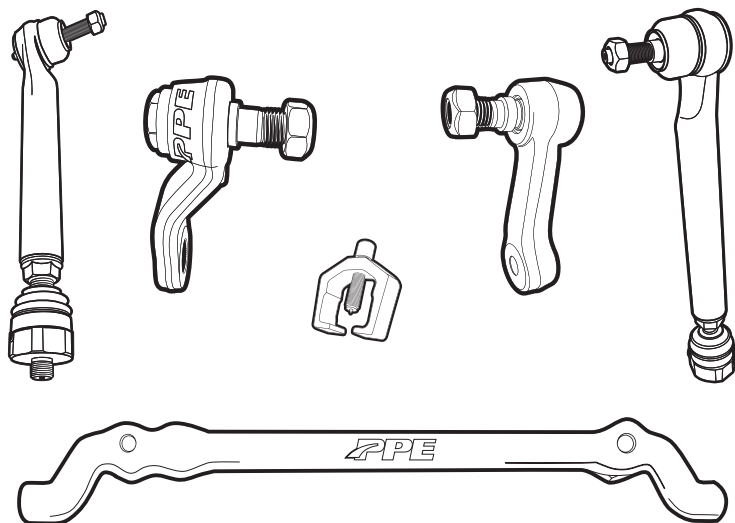




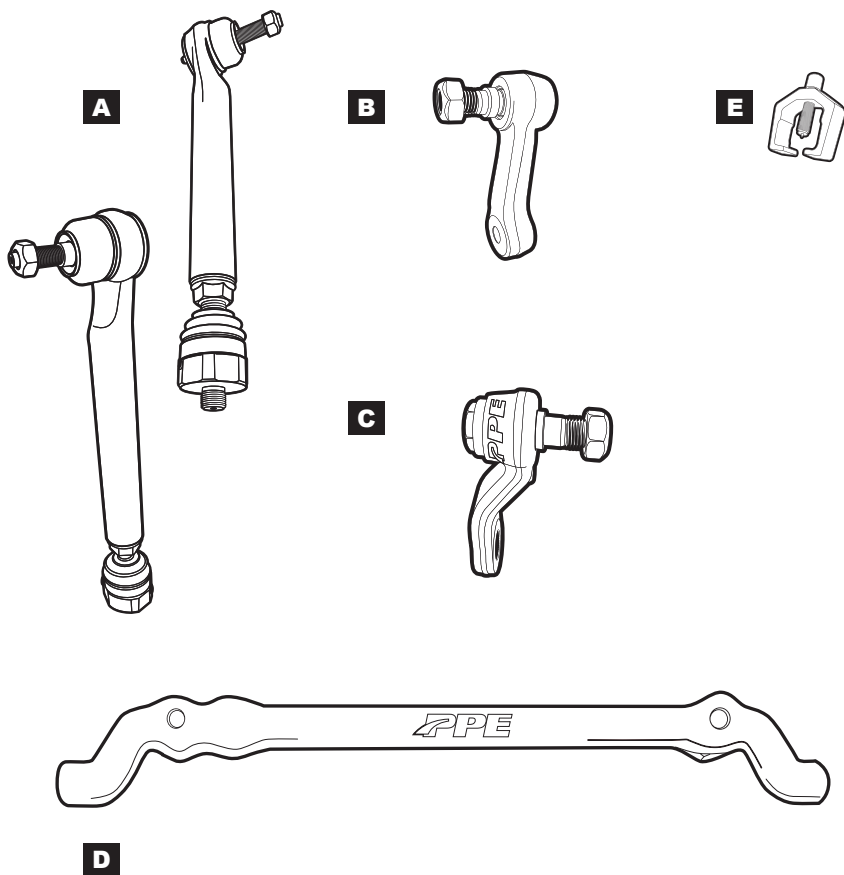
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2001-2025 GM 6.6L Duramax Extreme-Duty, Forged 7/8" Drilled Steering Assembly Kit

(158100110, 158101120)

Installation Guide

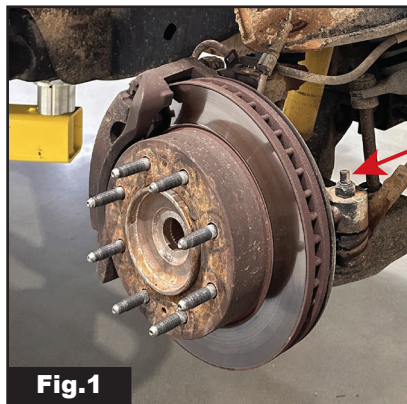


CONTENTS:

- A.** (2) *PPE Tie Rod Kit*
- 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 NOTES

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



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

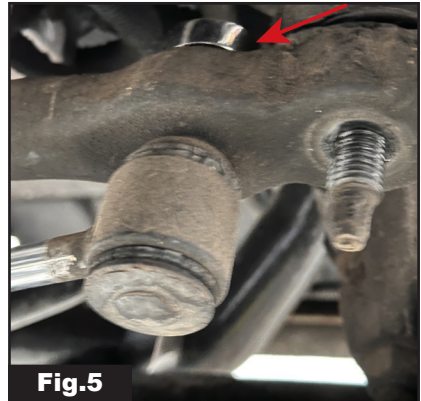


- Step 5.** Remove the nuts securing the idler and pitman arm from the bottom of the center link (**Fig. 3 & 4**).





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



- Step 7. Use the supplied **Pitman Arm Puller (E)** to separate the idler arm and pitman arm from the center link (**Fig. 6**).

- Step 8. Separate the steering stabilizer from the center link then remove the center link from the vehicle.

- Step 9. Separate the spline end of the pitman arm from the steering box.



PPE Extreme-Duty, Forged 7/8" Drilled Steering Assembly Kit - GM

Step 10. Loosen the bolts and remove the idler pivot assembly.

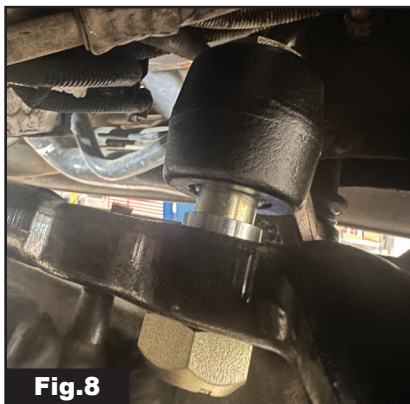
Step 11. Separate the factory idler arm from the idler pivot assembly. Clean the shaft and regrease.

Step 12. Install the **PPE Idler Arm (B)** into the idler pivot assembly. Torque nut to 73 lb-ft (**Fig. 7**).

Step 13. Install the idler pivot assembly back into the vehicle. Tighten the bolts.

Step 14. Install the spline end of the **PPE Pitman Arm (C)** to the steering box. Torque nut to 185 lb-ft.

Step 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**).





Step 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. 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. 10**).



Step 17. Install the outer tie rod to the tapered hole of the wheel spindle. Torque nut to 48 lb-ft (**Fig. 11**).

Step 18. Reinstall the splash guard, front wheels and fender liners.

Installation Complete



PPE Extreme-Duty, Forged 7/8" Drilled Steering Assembly Kit - GM

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.

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