

# TRUCK MASTER *Designs*<sup>™</sup>

## Air Dam Installation Instructions CK580-S/CK580-T '99-'02 GMC Sierra Truck & 2000-'05 Yukon & Yukon XL

*Warranty is void if Air Dam is not prefitted to factory bumper before painting and permanently installing.*

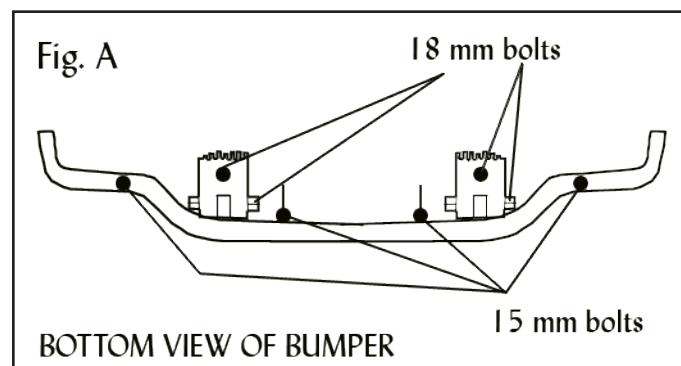
Tools needed: 6" flat screwdriver, 1 pair needle nose pliers, 2 7/16 open wrenches or 1/4 drive ratchet with 7/16 socket, 15mm wrench, 18 mm wrench, electric or battery operated drill and 1/4" drill bit

### REMOVING FACTORY AIR DAM

1. To remove factory Air Dam, use a 6" long flat blade screwdriver. The rivets are accessed through the bottom of the bumper behind the factory Air Dam.
2. It will be necessary to remove the factory driving lights by removing the two bolts that hold the plastic light brackets to the bumper. Also remove the nut clips from the bumper.
3. Insert the screwdriver blade into the rivet head slots and twist screwdriver to force rivet inserts downward. Once rivet inserts are 1/4" to 1/2" down, grab with fingers or pliers and pull down, completely removing inserts.
4. After all rivets and lights are removed, use the screwdriver from the front side of Air Dam and pry down on the Air Dam to remove it from the bumper.
5. Next remove the plastic rivet clips from the bottom of the bumper by squeezing the clips and pulling down.

### YOU MUST REMOVE TOW HOOKS TO MOUNT AIR DAM

1. To remove the tow hooks, remove the 4 - 15mm hex head bolts that hold the bumper to the frame brackets; two are at the outside of the bumper bottom with the bolt heads facing down and shaft threading up; the other two are on the inside of the frame rails with the bolt head facing up and the shaft threading down into a hex head frame clip. (see fig. A). **ALL FOUR BOLTS MUST BE REMOVED BEFORE NEXT STEP.**



2. Using an 18mm wrench or socket, remove the 4 - 18mm hex head bolts that screw upward into each tow hook.
3. Using an 18mm wrench and socket, remove the nut from the long bolt that goes through the frame and tow hook from side to side.
4. Due to the bumper design, the long bolt head will hit the bumper when being removed. Slide the tow hook bolt outward until the bolt head contacts the bumper curve. **IMPORTANT: SLIDE THE WASHER THAT IS ON THE BOLT BACK TOWARD THE FRAME.**
5. Then using a large screwdriver or medium size pry bar, stick the end of the prying device into one of the square holes closest to the bottom of the bumper curve. Pry the bumper outward just enough so that the bolt head will clear the edge of the bumper - then remove the bolt. **BE CAREFUL NOT TO BEND THE BOTTOM FLANGE OF THE BUMPER.**
6. Once the tow hooks are removed, replace the 15mm bolts and proceed with Air Dam installation.

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**\*\*\*IF YOU ORDERED PART # CK580-T SO YOU CAN KEEP THE TOW HOOKS. FOLLOW INSTRUCTIONS ON BACK TO REINSTALL TOW HOOKS IN OPPOSITE OPENINGS.\*\*\*  
OTHERWISE SKIP TO REINSTALL THE LIGHTS & AIR DAM AS DESCRIBED ON BACK.**

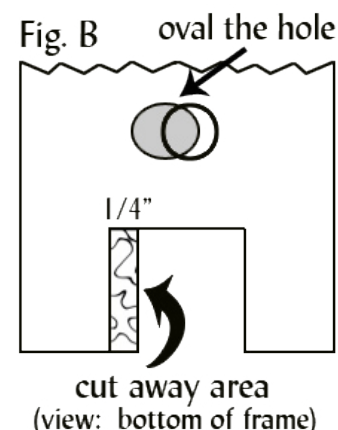
*CONTINUED ON BACK...*

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IF YOU DON'T HAVE AIR DAM CK580-T AND ARE NOT REINSTALLING THE TOW HOOKS, SKIP TO NEXT STEP TO REINSTALL THE LIGHTS AND AIR DAM

## REINSTALLING THE TOW HOOKS

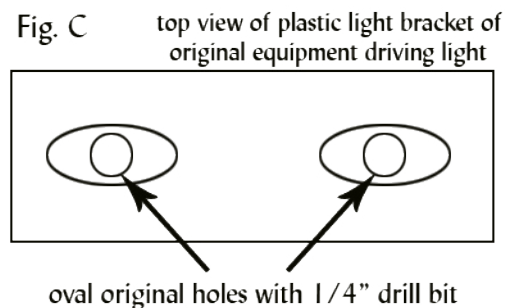
1. **To reuse tow hooks, you must have Air Dam part # CK580-T.**
2. After the tow hooks are removed, it is necessary to install the right tow hook into the left frame rail, and the left tow hook into the right frame rail.
3. To do this, you must make two modifications to each frame rail. First, cut or grind approximately 1/4" off material from the notch in the frame rail (see fig. B). Next slide the tow hook into the frame rail, aligning the side holes. While keeping the tow hook and frame side holes aligned, mark the area adjoining the bottom frame hole that needs to be enlarged.
4. Drill or grind this area so that the bottom tow hook bolt can be reinstalled.
5. To reinstall the long bolts, it will be necessary to pry the bumper forward as was done to remove the tow hooks.
6. Once tow hooks are reinstalled, replace the 15mm bolts and proceed with Air Dam installation



## REINSTALLING THE LIGHTS AND INSTALLING THE AIR DAM

DO NOT INSTALL THE LIGHTS IN THE ORIGINAL FACTORY POSITION - FOR PROPER FIT AND AIR DAM WARRANTY THEY MUST BE REINSTALLED TO THE BOTTOM SIDE OF THE BUMPER.

1. Use a 1/4" drill bit and redrill the two mounting holes in the top of the plastic light bracket. We recommend that you oval the holes from side to side 1/4" to allow for more adjustment (see fig. C).
2. Reinstall the driving lights to the **BOTTOM** side of the bumper using supplied bolts and flat washers (do not reuse the factory hardware). Use a small silver flat washer on bolt head and nut side when assembling.
3. Snug bolts but do not tighten yet as the lights will need to be adjusted.
4. Install the Air Dam by sliding it over the driving lights and align with the bumper holes.
5. Install 3 bolts using large silver flat washers on bumper side and small silver flat washers on Air Dam side.
6. Slightly snug one center bolt and 2 end bolts to hold Air Dam in place. Adjust driving lights from side to side until centered in light pocket hole.
7. Tighten driving light bolts.
8. Now install the balance of Air Dam bolts. Tighten starting from center of Air Dam and working towards each end of bumper.



## IMPORTANT INSTRUCTIONS FOR PAINTING ABS

It is imperative that the parts you plan to refinish be thoroughly cleaned with the correct products to ensure that all mold release agents, greases and oils are removed. Failure to clean a substrate properly can easily cause an otherwise good system to turn out poorly.

The products and methods described here are supplied by DuPont Automotive Finishes. Other paint manufacturers have their own recommended systems for painting plastics.

### CLEANING & PAINTING ABS

All parts should be thoroughly cleaned before painting.

1. Wash both sides of product with liquid dish or commercial grade soap and water.
2. Wipe with 2319S Plastic-Prep to remove mold release agents, greases and oils. Wipe a few times to maximize cleaning. (Note: 2319S is made for cleaning plastic parts. Do not Use this as a wiping solvent over bare metal or freshly primed areas. 2319S works well over OEM and aftermarket parts. It can be aggressive over remanufactured parts).
3. Hand sand with gray scuff pad or 800 grit sandpaper. Sanding is essential when painting over plastics and is always beneficial in promoting adhesion. If the part comes pre-primed, scuff the primer without breaking through the substrate.
4. Apply Plas-Stic 2330S or A-2330S (one coat).
5. Apply your choice of topcoat: ChromaSystem Activated Basecoat with Flexibilized Clearcoat or ChromaSystem Flexibilized Single-Stage or Dupont Vinyl Color



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