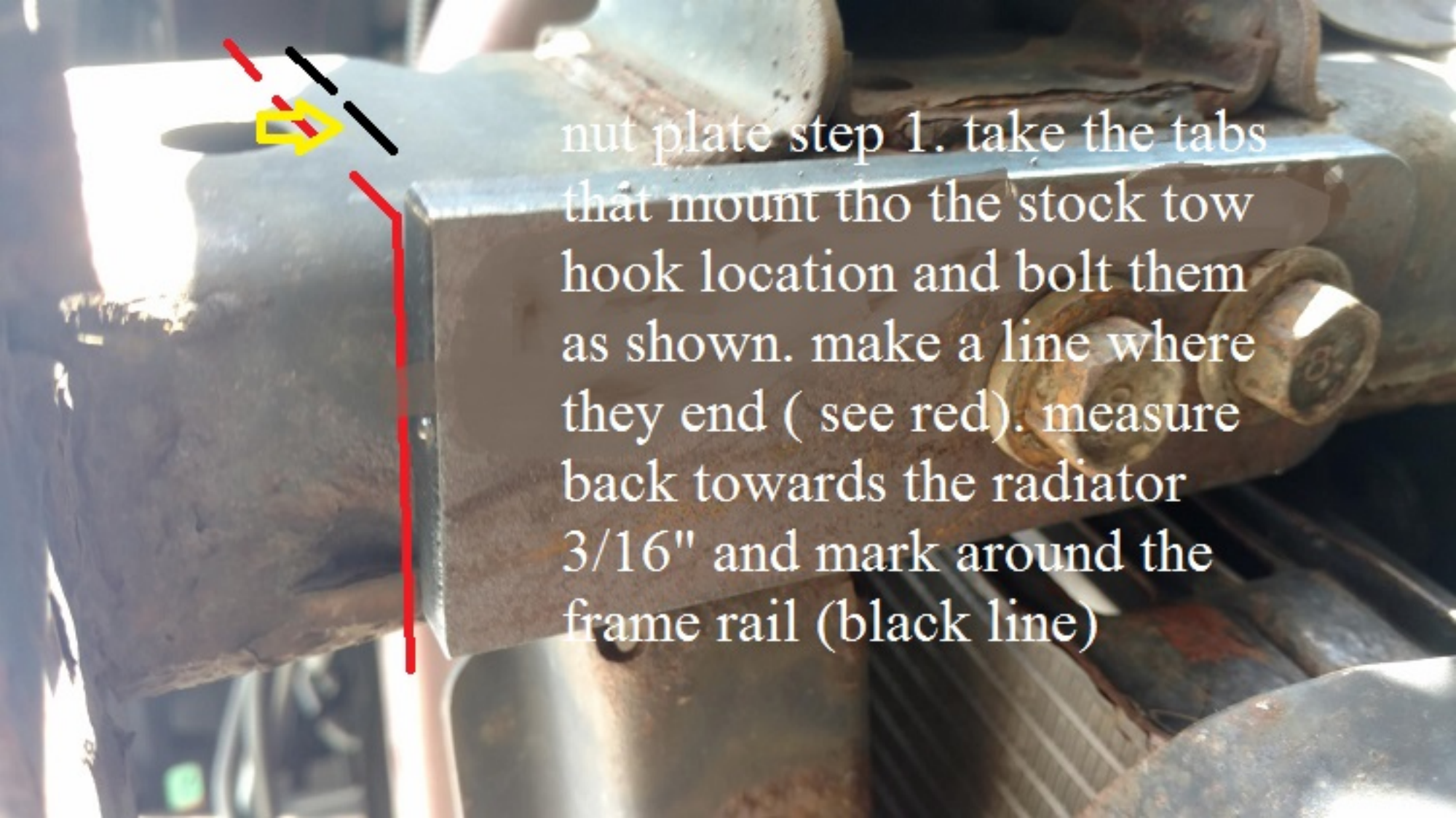




nut plate step 1. take the tabs
that mount tho the stock tow
hook location and bolt them
as shown. make a line where
they end (see red). measure
back towards the radiator
3/16" and mark around the
frame rail (black line)



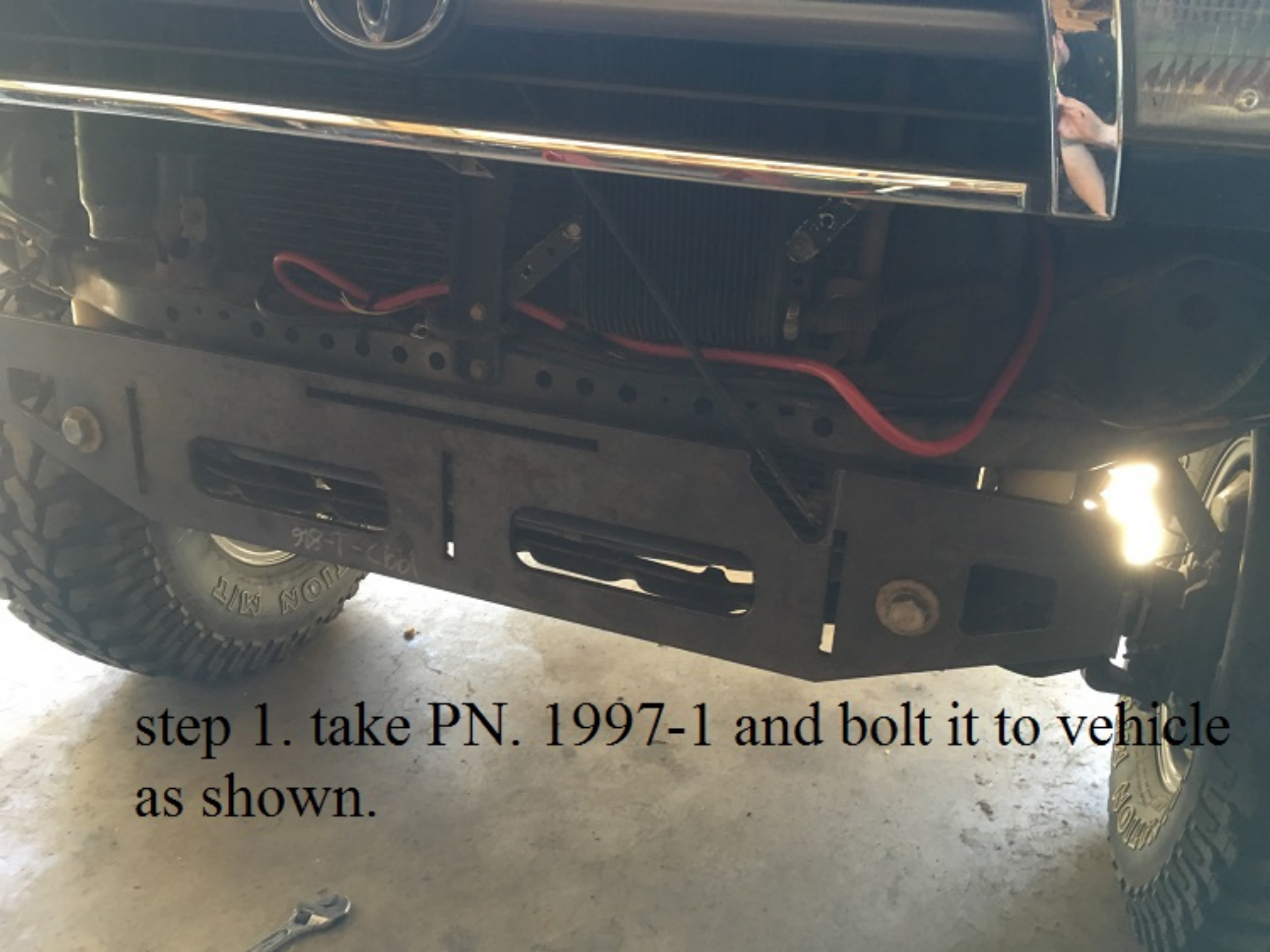
nut plate step 2. trim frame
rail back on the black line.

nut plate step 3. take the nut plate and weld
either a 1/2", 5/8" or M12 nut to one side of it.





nut plate step 4. weld nut plate onto
frame rail with the welded nut inside
the frame rail.



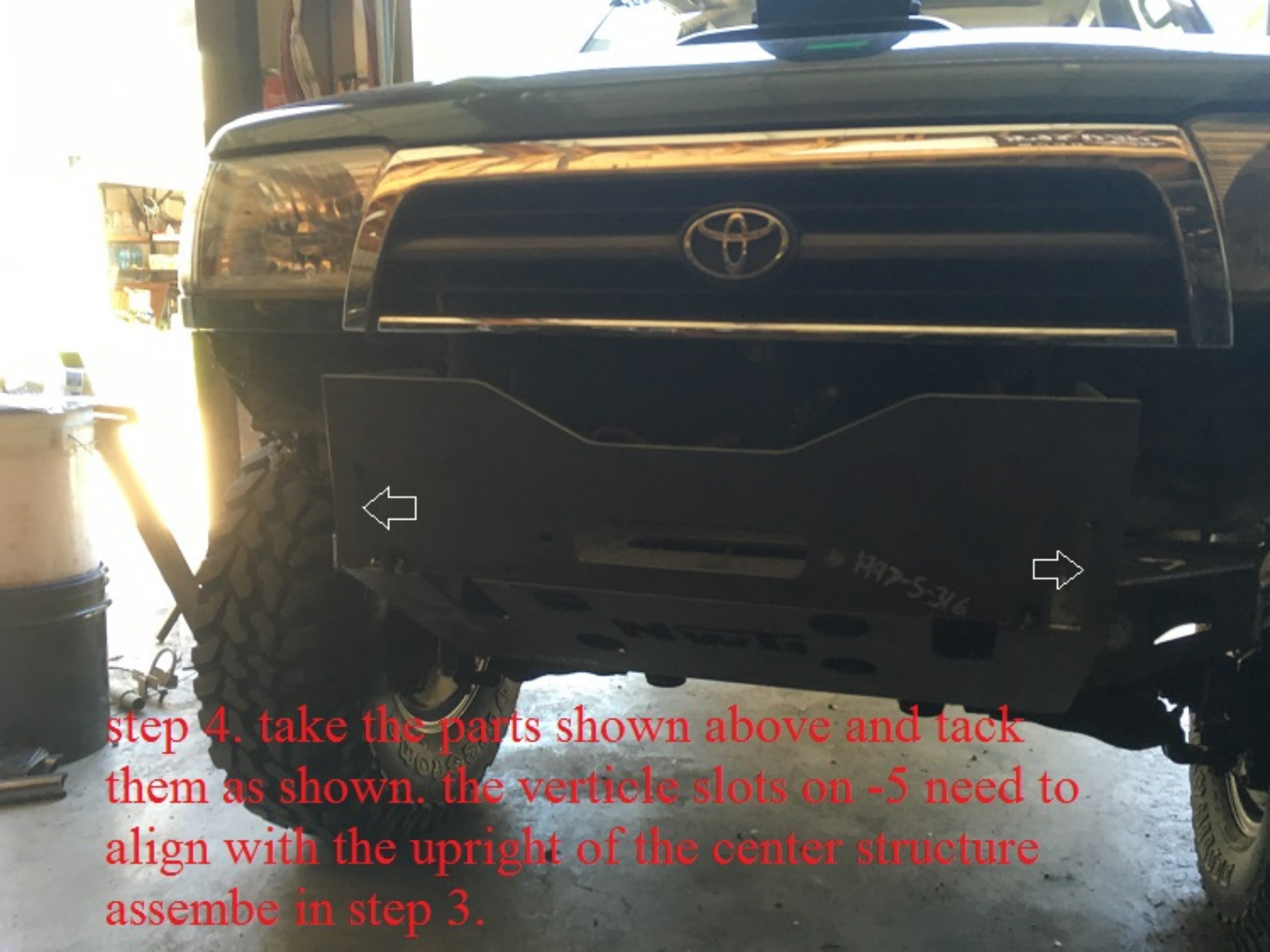
step 1. take PN. 1997-1 and bolt it to vehicle as shown.



step 2. bolt the
mounting tabs as
shown in the
picture. tack weld.



step 3. take the parts shown in the picture and align the slots to fit together. tack weld



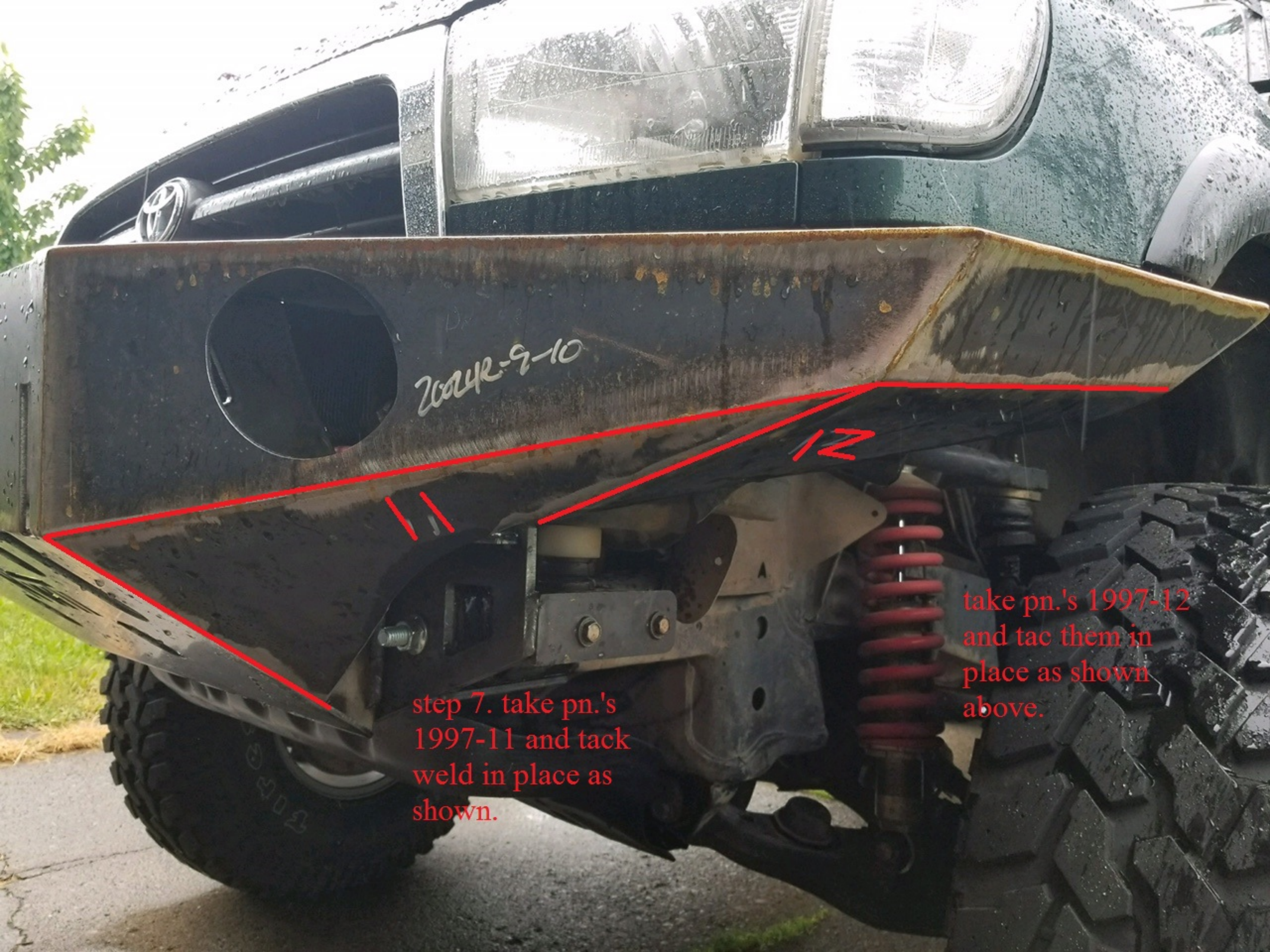
step 4. take the parts shown above and tack them as shown. the verticle slots on -5 need to align with the upright of the center structure assembe in step 3.



step 5. take pn.'s
1997-8 and tack
weld them as shown
in the picture. make
sure they are level
first.



step 6. take pn.'s -9 and -10
and tack them in place as
shown.



2004R-9-10

12

step 7. take pn.'s
1997-11 and tack
weld in place as
shown.

take pn.'s 1997-12
and tac them in
place as shown
above.

Step 8. take pn.'s
1997-13 and weld
in place as shown.

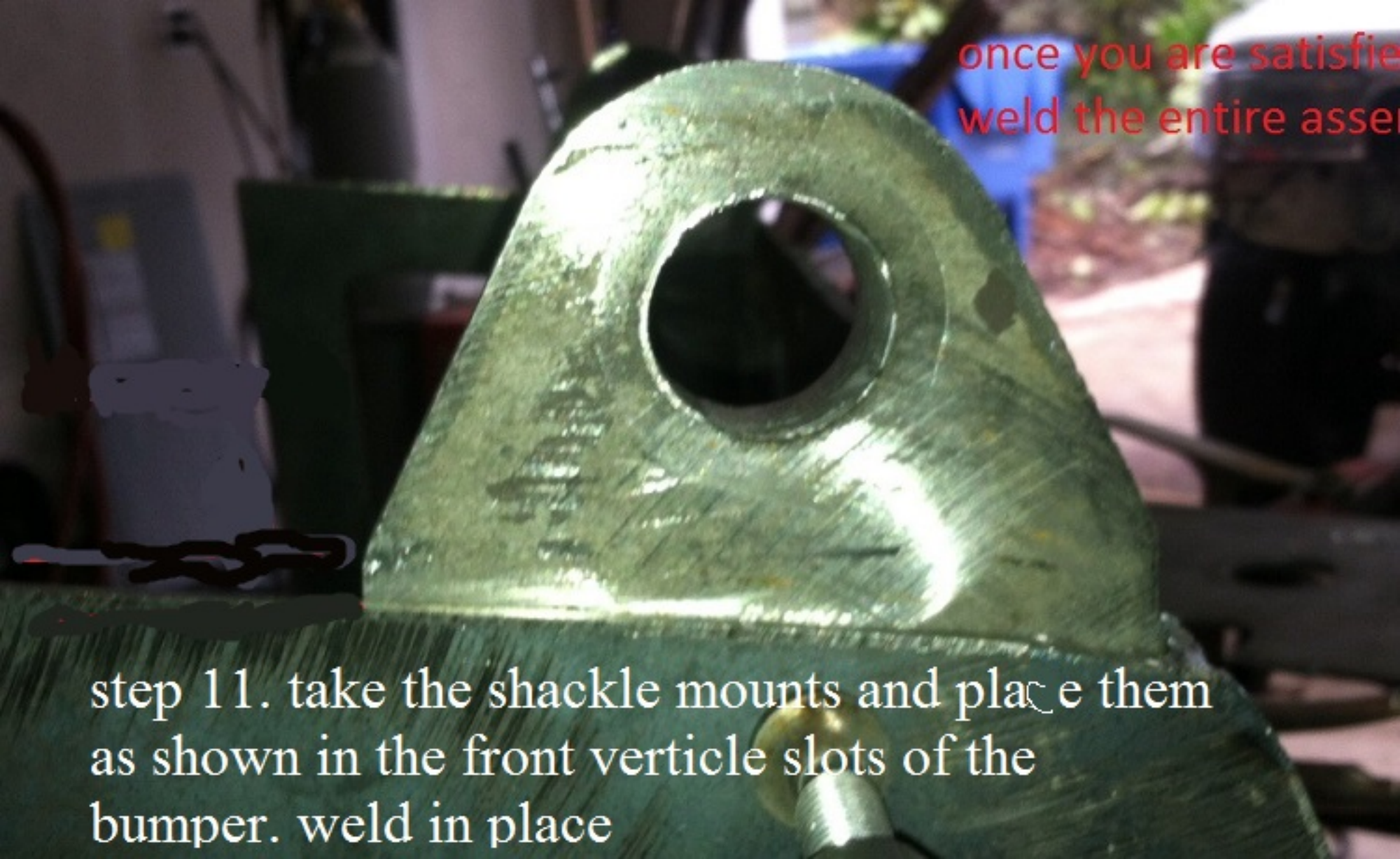


step 9. take pn.'s
1997-7 and weld
them as shown.





step 10. weld structural parts
center section. fully weld the
outer shell, stitch weld the
inner shell. grind all edges we
recommend using with 36 grit
zirconia sanding discs.



once you are satisfied
weld the entire assem

step 11. take the shackle mounts and place them
as shown in the front verticle slots of the
bumper. weld in place

step 12. if you ordered the recessed light mount option place the tubing as shown in the picture. rotate until the tubing aligns with the hole.

