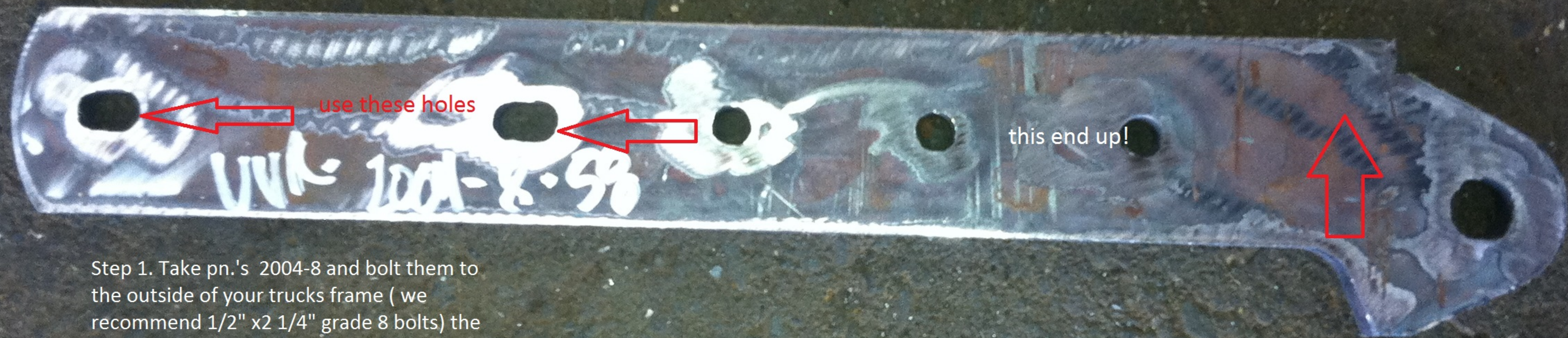




Step 1. Take pn.'s 2004-8 and bolt them to the outside of your trucks frame (we recommend 1/2" x2 1/4" grade 8 bolts) the same way the stock bumper was installed.



WELD HERE

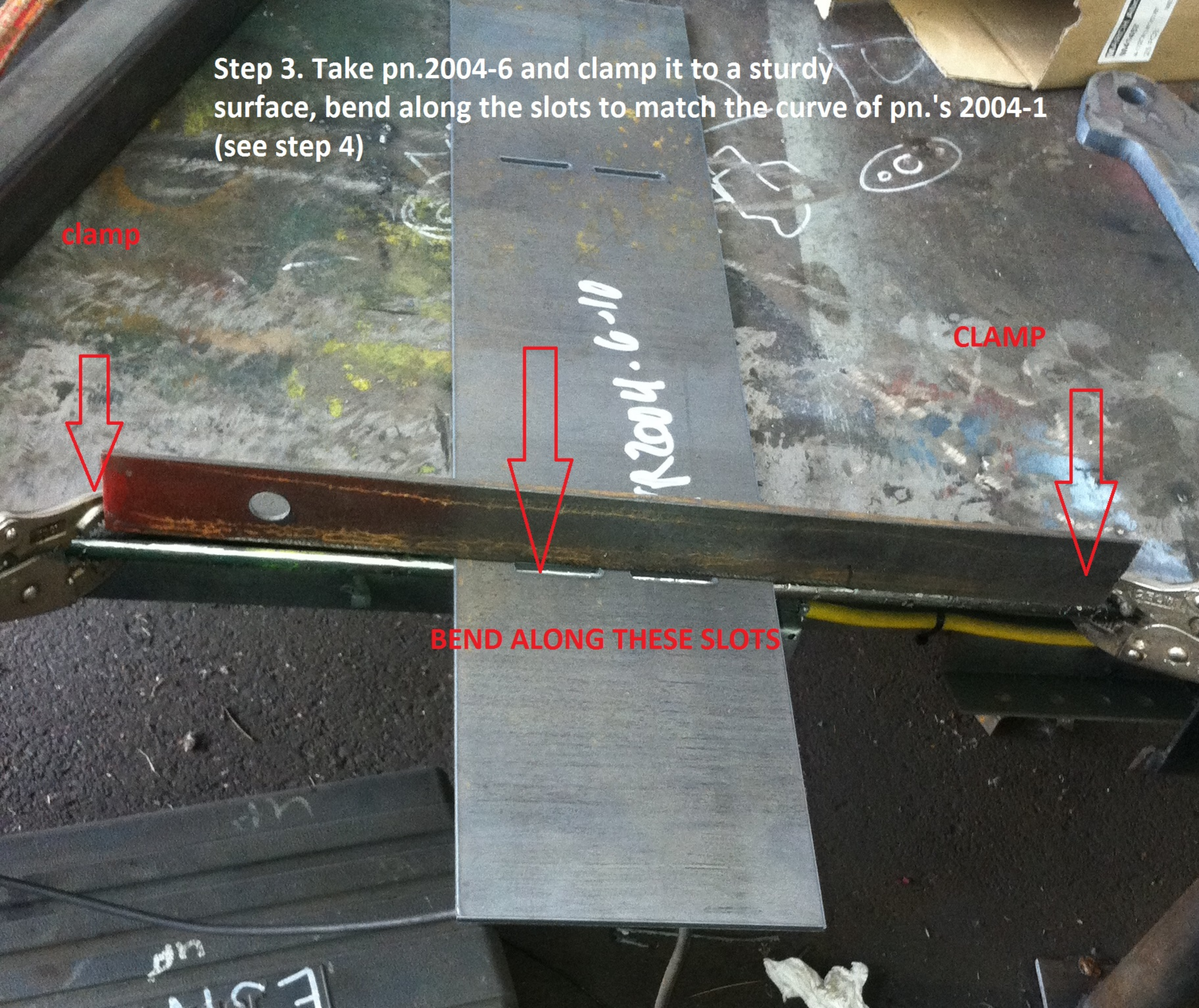
Step 2. take pn.'s and place them against a straight edge or angle iron, clamp them in place and tac them together weld together.

Step 3. Take pn.2004-6 and clamp it to a sturdy surface, bend along the slots to match the curve of pn.'s 2004-1 (see step 4)

clamp

CLAMP

BEND ALONG THESE SLOTS



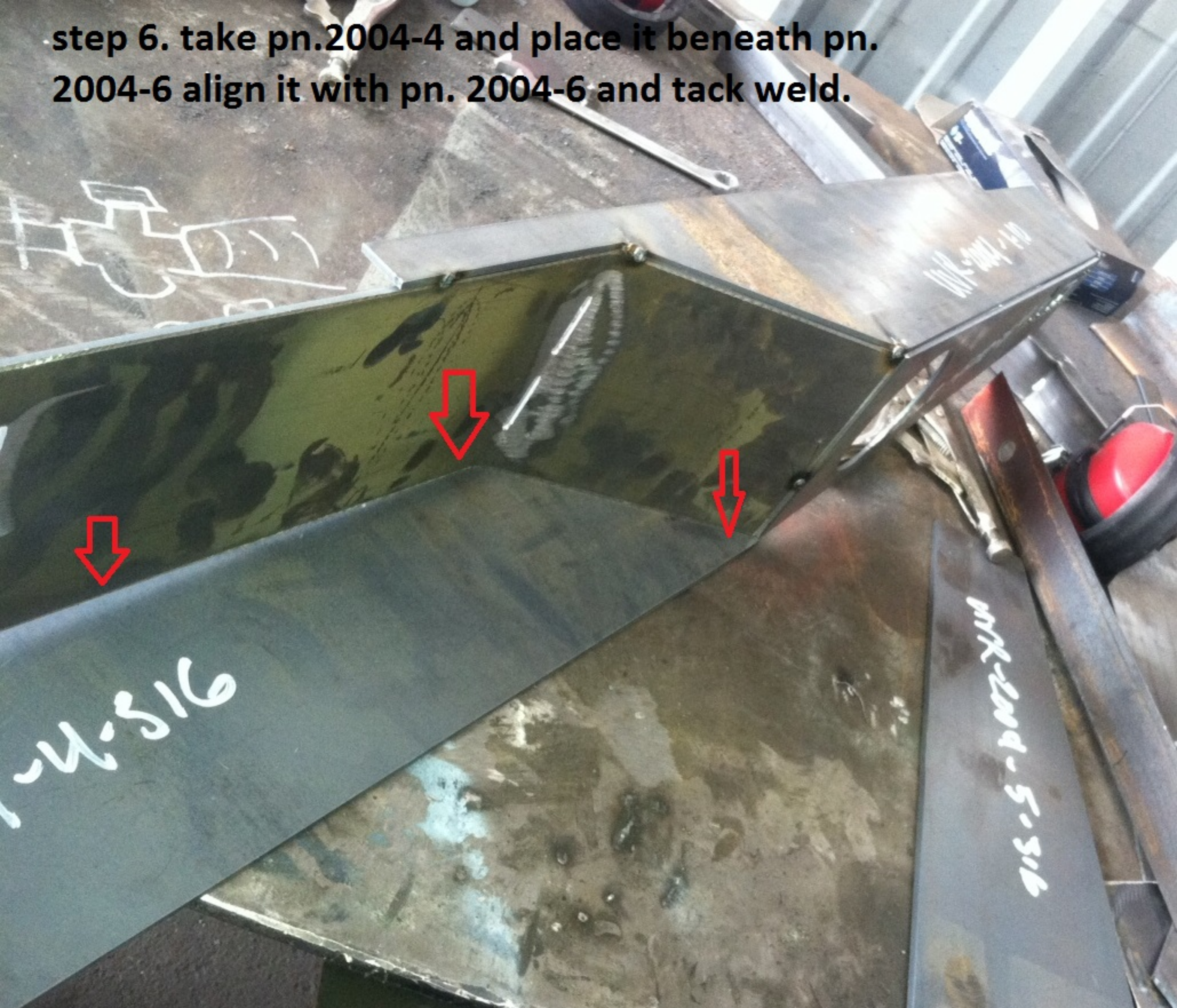


Step 4. Take pn. 2004-6 and bend it until it fits the the profile of 2004-1. tac weld in place.



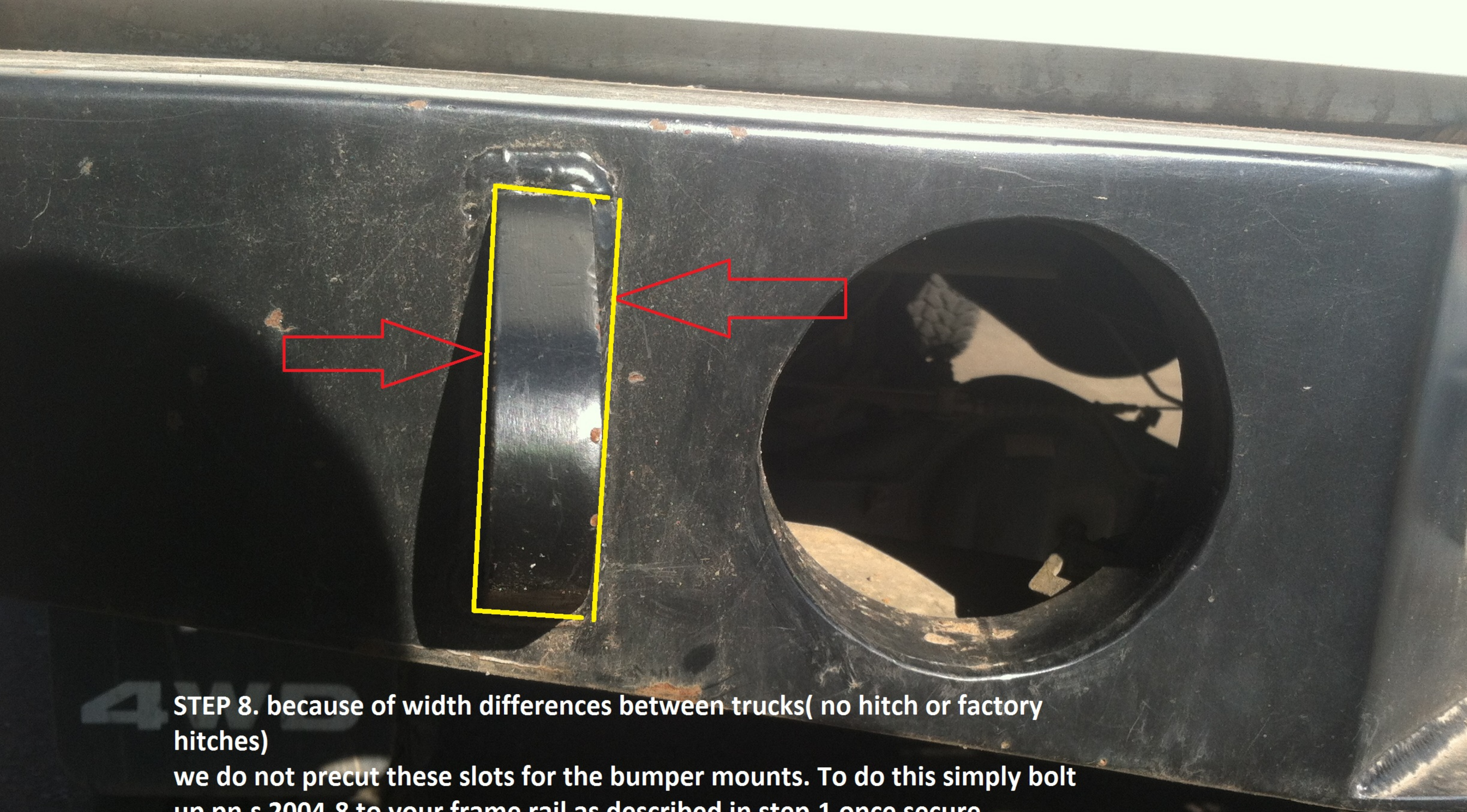
Step 5. take pn.'s 2004-2 and place them underneath pn.'s 2004-1 and next to pn.2004-6 tack weld in place. make sure logo is the correct direction!

step 6. take pn.2004-4 and place it beneath pn.
2004-6 align it with pn. 2004-6 and tack weld.



Step 7. take pn 2004-5 and place it between pn.
pn.2004-2 and pn. 2004-4 tack weld in place.
take pn 2004-7 and cap the end as shown in the
picture.
repeat for both sides.





STEP 8. because of width differences between trucks(no hitch or factory hitches)

we do not precut these slots for the bumper mounts. To do this simply bolt up pn.s 2004-8 to your frame rail as described in step.1 once secure, measure the distance between them mark the bumper accordingly, next measure the outside and make a mark leave yourself a little extra room, it can always be filled with weld. next measure down about 5/8" and make the top mark for the slot. next measure the height of the shackle mounts height and make your bottom mark. cut the slot with a cut off wheel or a plasma cutter. slide the bumper on the mounts and tack weld once

Step 9. Once you have the bumper center and tackwelded to the mounts tack the whole bumper every 2 inches, let it cool. make sure you have heavily tacke the bumper to the bumper mounts. remove the bumper and fully weld the all the seams. if you have the recessed reverse light option take the tubing supplied and line it up with the whole from the inside of the bumper. weld in place. To finish the bumper we recommend starting with a grinding wheel then a 100 grit zirconia flapper sander, last you can use a belt sander with a zirconia or ceramic 100 grit belt to finsh the edges.

4WD