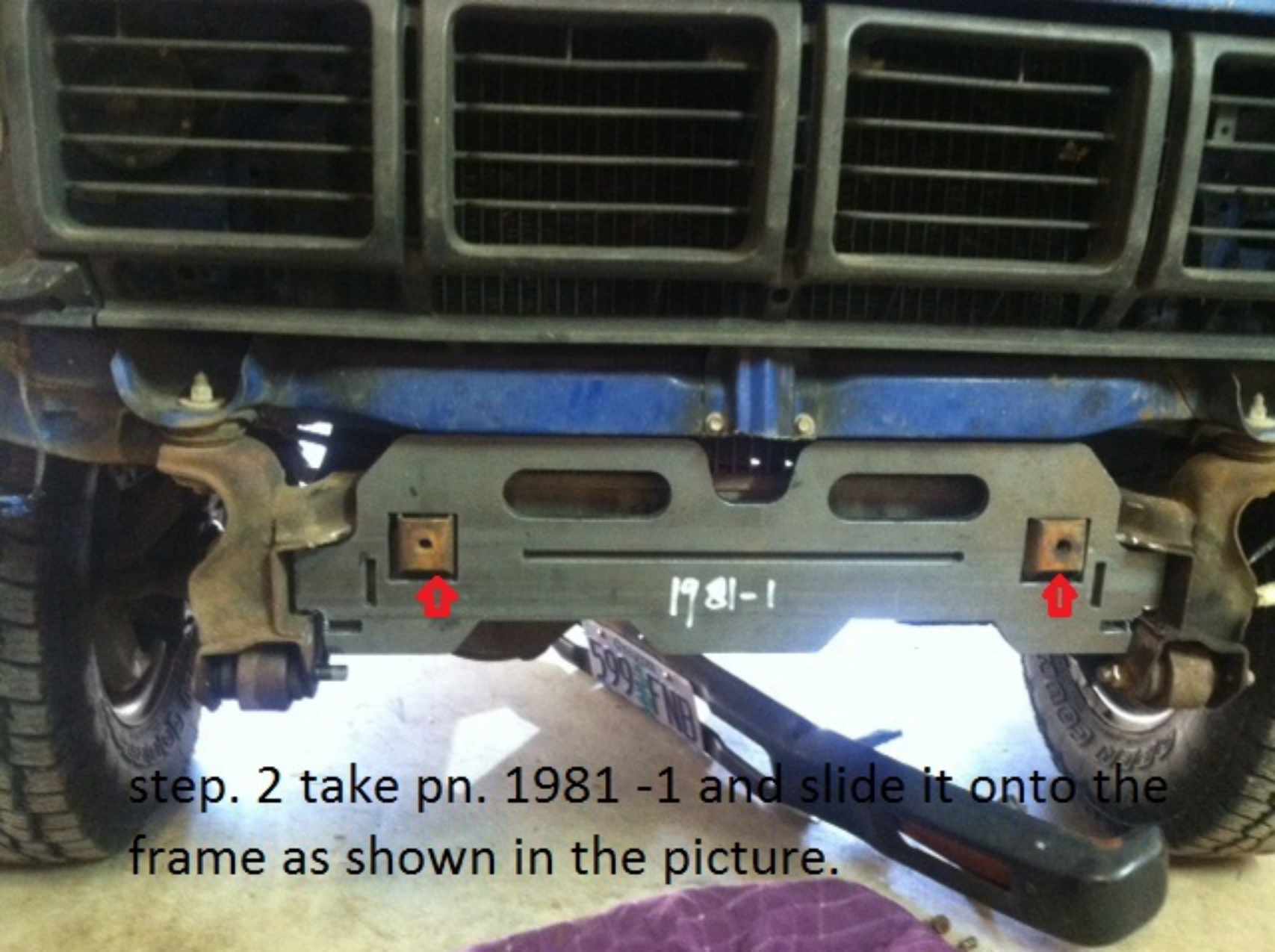




step 1. grind both sides of the frame as shown in the picture.



step. 2 take pn. 1981 -1 and slide it onto the frame as shown in the picture.

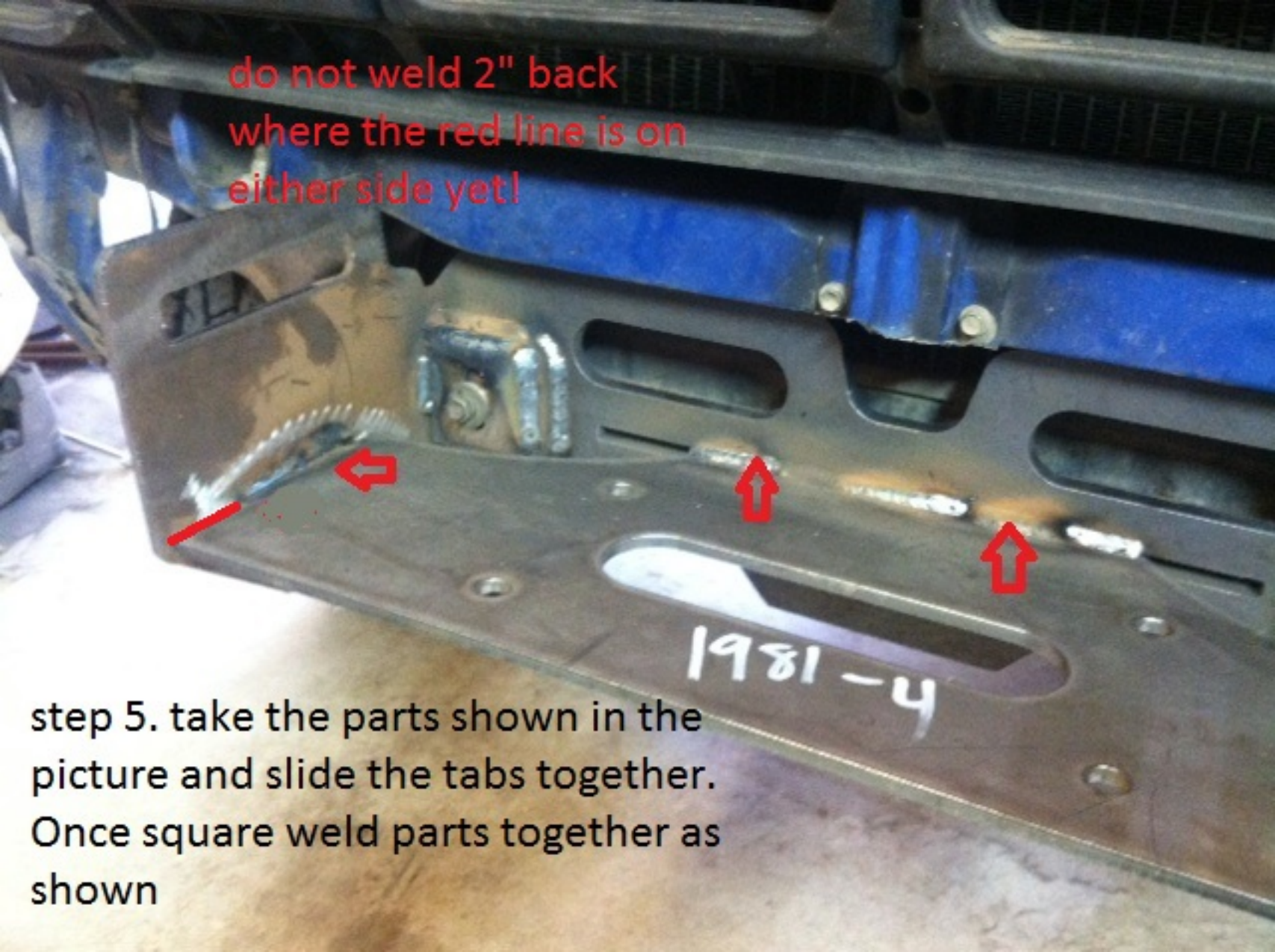


step 3. place the 1/2" spacers
over the stock bumper mounts
as shown and tack weld them.



step 4. take the part shown above and use a bolt to pinch it in place over the 1/2" spacer. make sure you have good clearance around the stock mount and tack weld in place.

do not weld 2" back
where the red line is on
either side yet!



step 5. take the parts shown in the
picture and slide the tabs together.
Once square weld parts together as
shown

step 6. loosen the front spring hanger nuts on both sides. Slide in the part as shown in the picture and tighten the nuts. weld the this part to main bumper mount shown in step 1.



step 7. take part no 1981-6 align and tack it to the front of the winch tray assembly you built in earlier steps. Take part no 1981-7 and place it below 1981-6 as shown and tack weld in place. take 1981-8 and tack weld it below 1981-7 as shown in the picture.

take the 3/4" shackle mounts and weld them into the slots marked by the yellow arrows

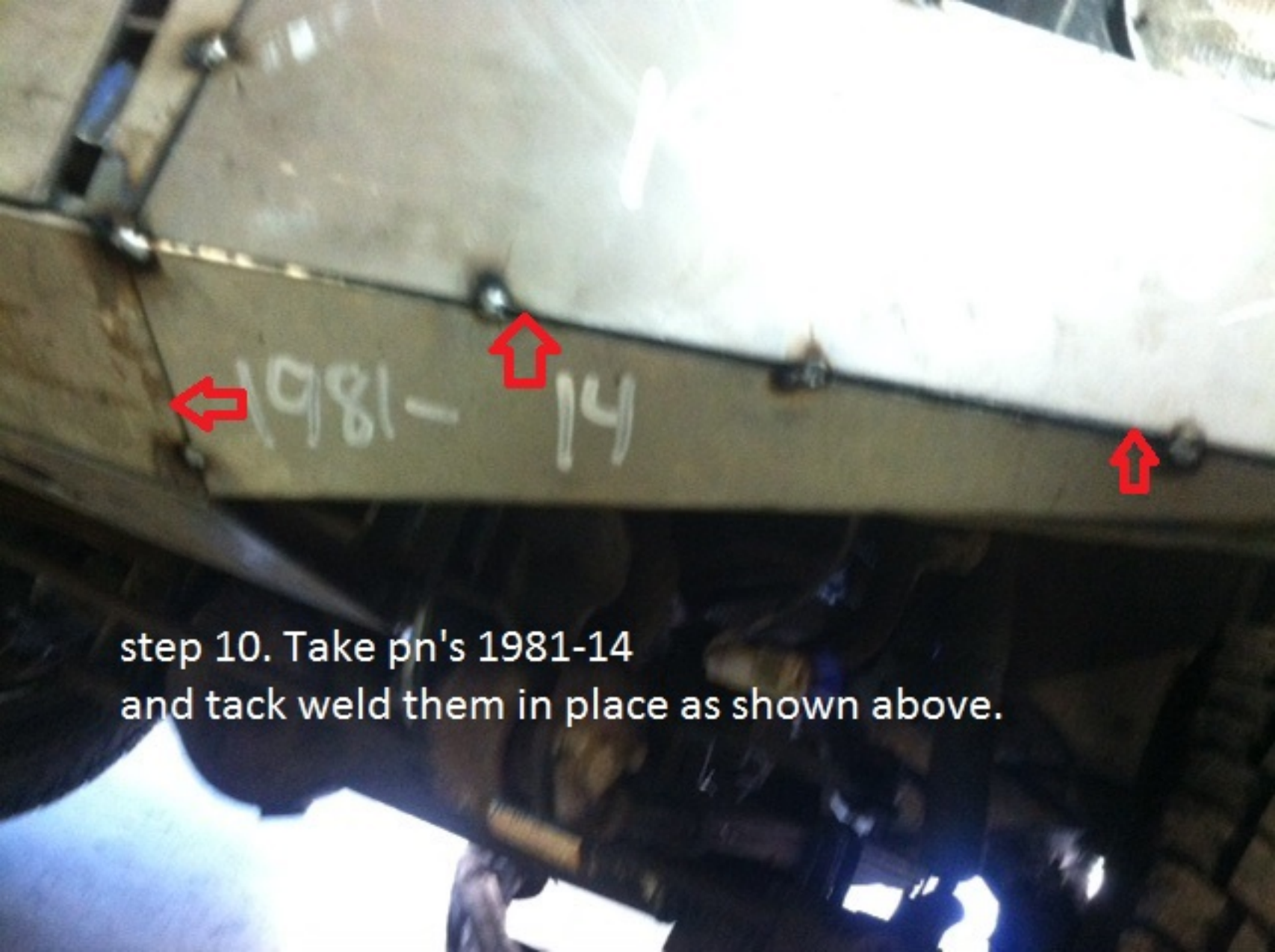




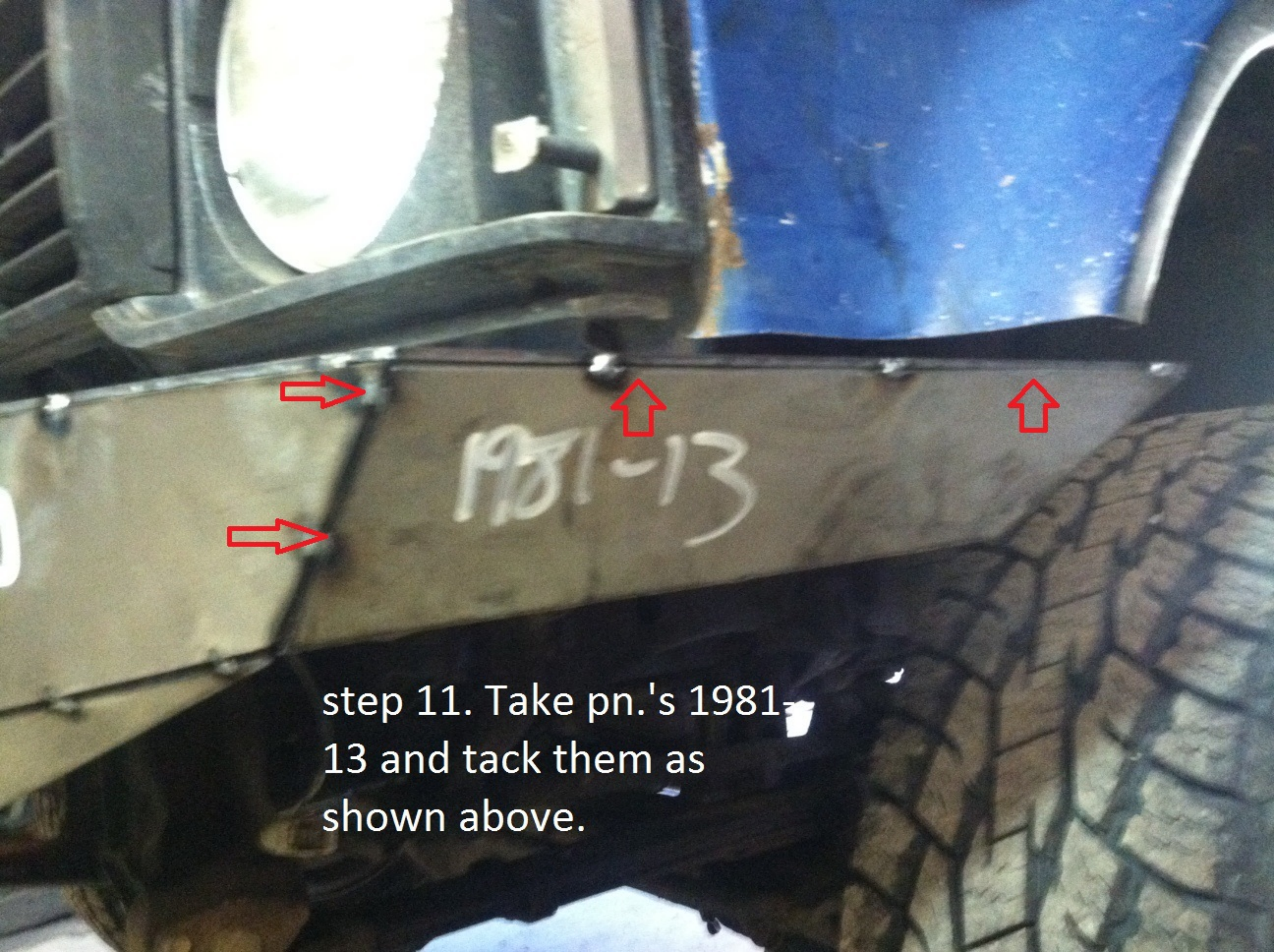
step 8. take part no.'s 1981-11 and place them as shown in the picture. this bumper kit requires trimming the lower corner of the fenders before assembly.

Step 9. Take pn's 1981-12
place and tack them as
shown in the picture.



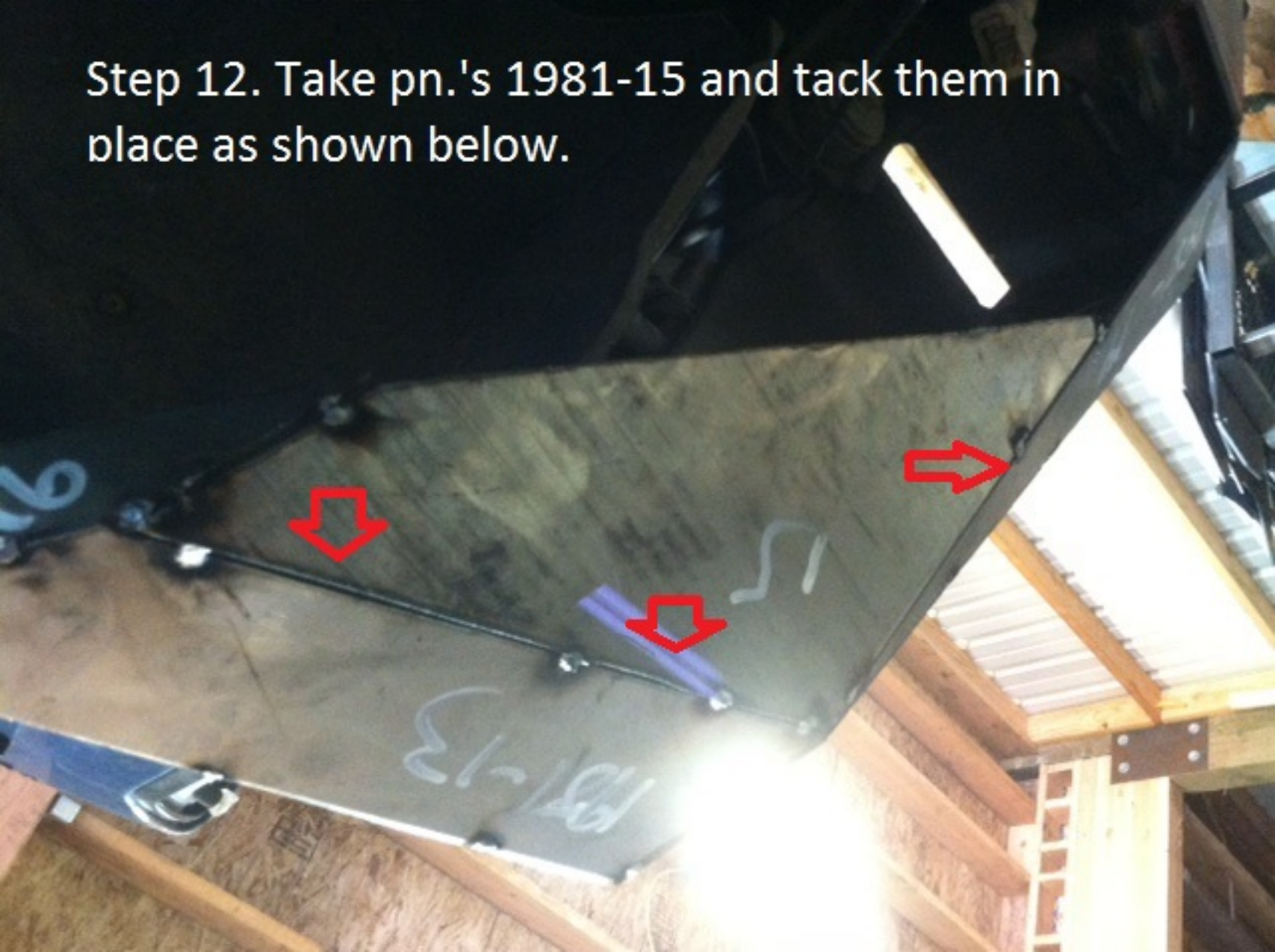


step 10. Take pn's 1981-14
and tack weld them in place as shown above.



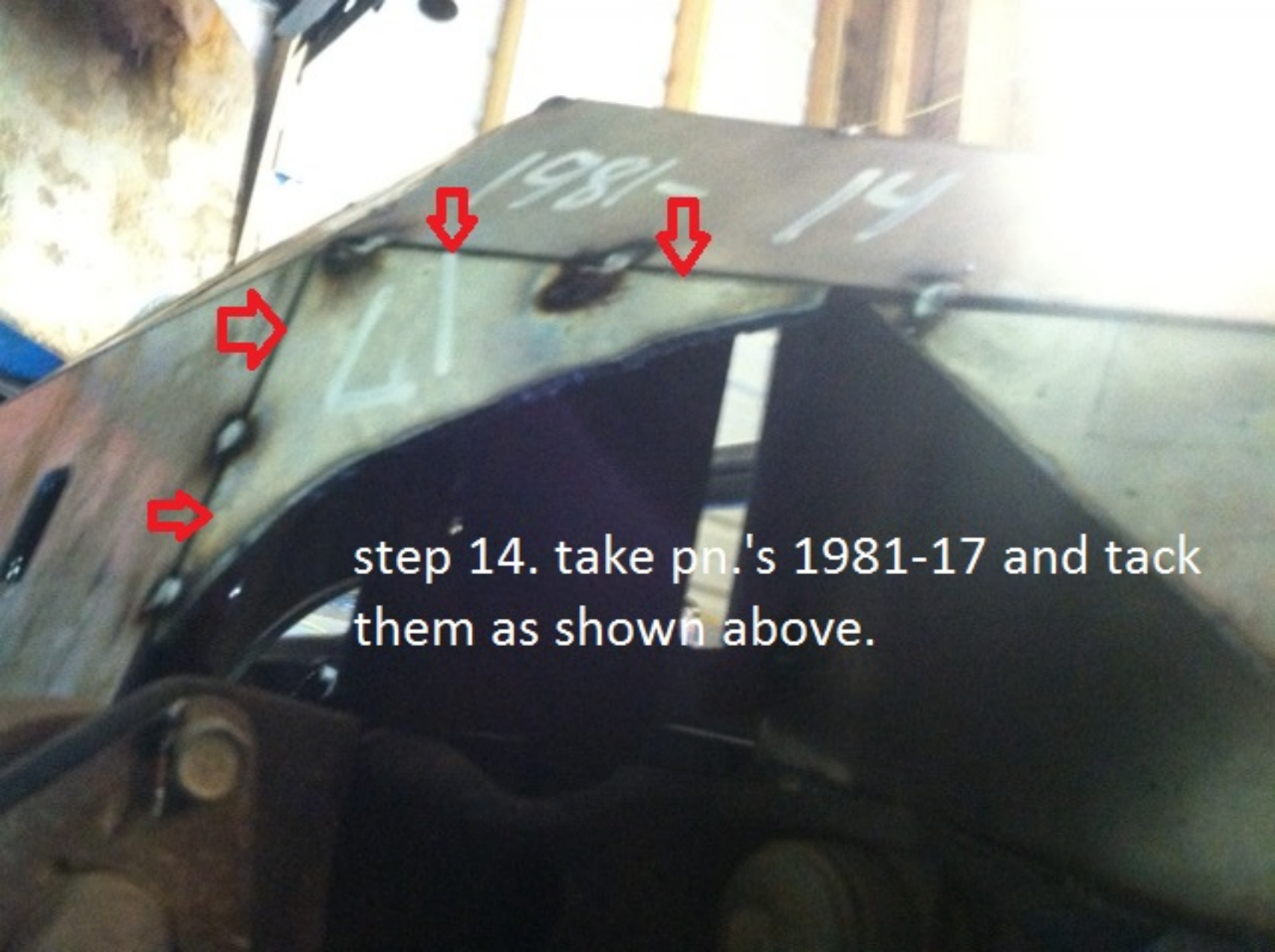
step 11. Take pn.'s 1981-13 and tack them as shown above.

Step 12. Take pn.'s 1981-15 and tack them in place as shown below.



step 13. take pn.'s
1981-16 and tack them as shown below.





step 14. take pn.'s 1981-17 and tack them as shown above.

step 15. take the part shown in the picture and weld 1/2" nuts on the top side of the part shown. weld between the frame rails as shown in below.



step 16. bolt take the part shown below and match it up with the part you welded into the frame in the previous step. tighten all the bolt you intend to use. once the bolts are tight weld to the bumper as shown by the arrows.



Step 17.

Weld all outside edges first then weld the inside shell with 2-3" beads every 3". Take a grinder and smooth the outside welds. Next use a 80 grit zirconia or ceramic sanding disc to even out the grinded edges. We recomend finishing with a belt sander with zirconia or ceramic belts

