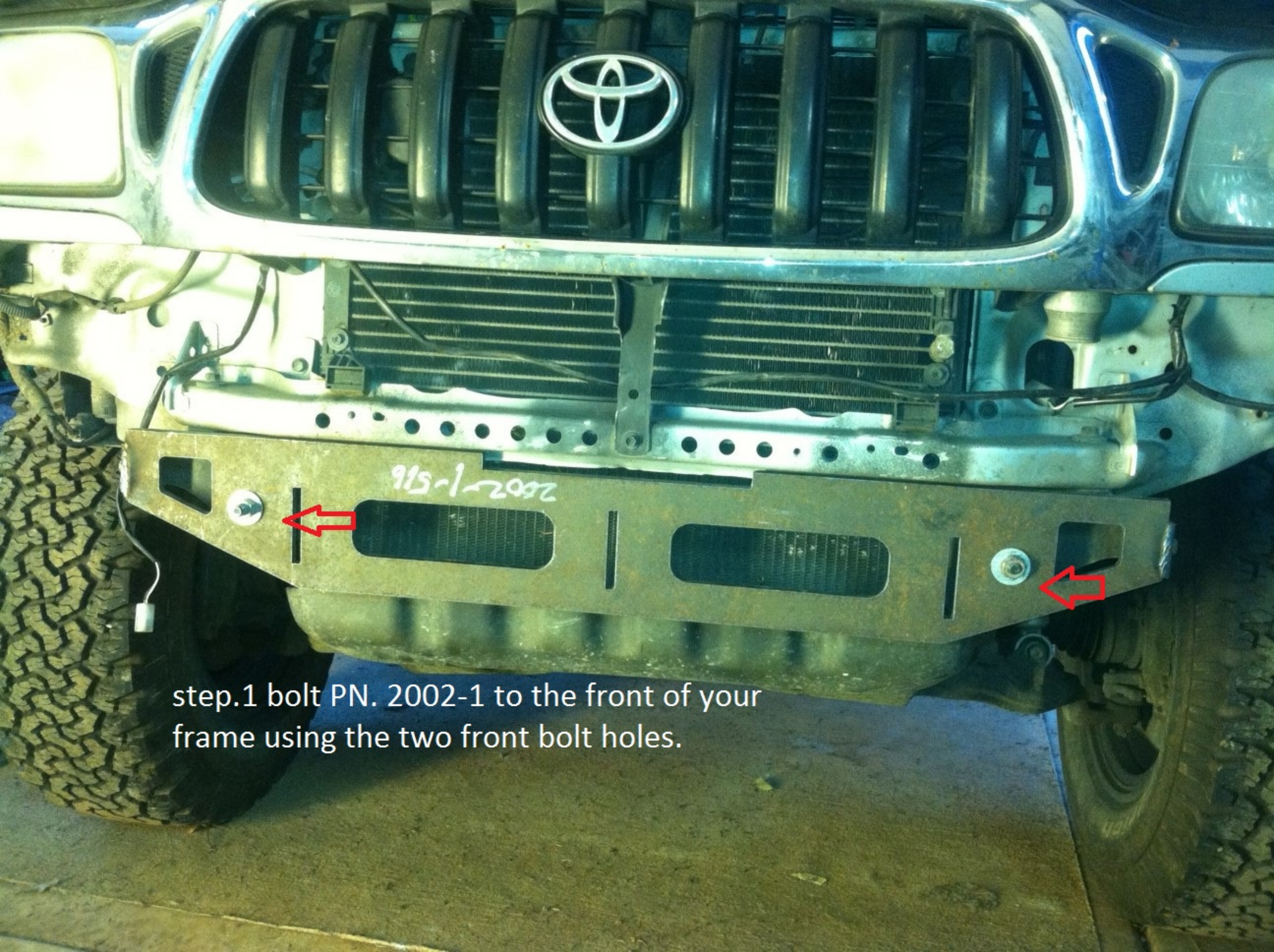
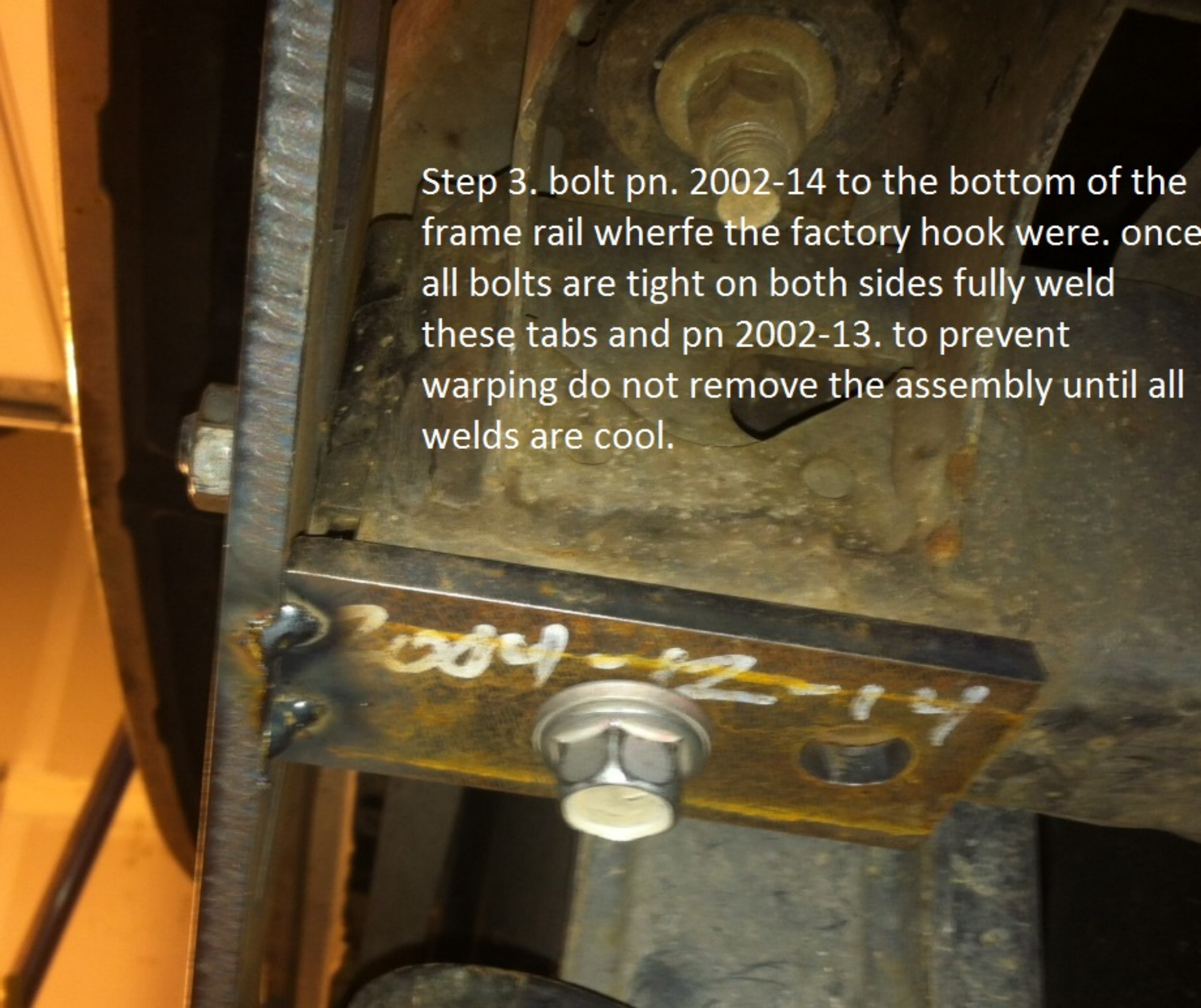




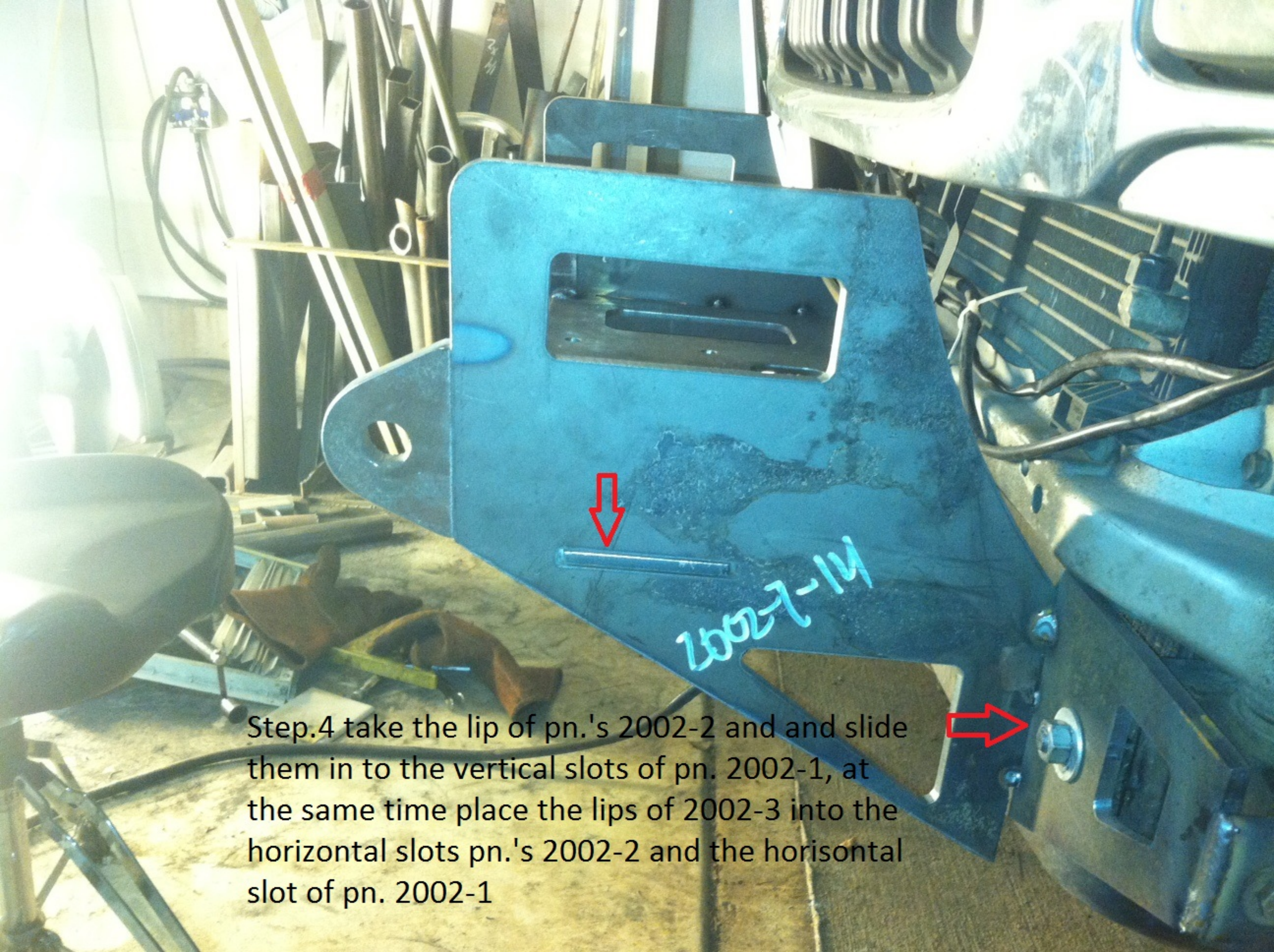
step.1 bolt PN. 2002-1 to the front of your frame using the two front bolt holes.

A close-up photograph of a metal bumper assembly. On the left is a large, rusted metal plate with a rectangular cutout and a bolt. To its right is a smaller, rectangular metal bracket, also rusted, which is welded to the main plate. This bracket has two bolts. The entire assembly is mounted on a dark, curved metal surface, likely the underside of a vehicle bumper. The text 'step 2. bolt pn 2002--13 to the side mounts that tnhe stock bumper cover was bolted to' is overlaid on the bottom right of the image.

step 2. bolt pn 2002--13 to the side mounts that
tnhe stock bumper cover was bolted to



Step 3. bolt pn. 2002-14 to the bottom of the frame rail where the factory hook were. once all bolts are tight on both sides fully weld these tabs and pn 2002-13. to prevent warping do not remove the assembly until all welds are cool.



Step.4 take the lip of pn.'s 2002-2 and and slide them in to the vertical slots of pn. 2002-1, at the same time place the lips of 2002-3 into the horizontal slots pn.'s 2002-2 and the horisontal slot of pn. 2002-1



Step 5. Place the lips of 2004-4 into the vertical slot on 2002-1 and the slot on the bottom side of 2002-3 tack weld. Next take pn. SM34 and place it as indicated above by the yellow arrow the shackle should stick out 2 1/4 inches at the top from the front of 2002-2. tack weld.

At this point you need to remove the assembly form your truck, clamp it to a solid surface and fully weld, do not unclamp until all welds cool.

Step 6. Reinstall the welded assembly to your truck, Place pn. 2002-6 on the front of the assembly over the shackle mounts, sometimes slight trimming is required to slides of over the shackle mounts. once in place tack weld. do not fully the shackle mounts till the end of the bumper build!





Step.7 place pn. 2002-5 underneath pn. 2002-6
once alignment looks good tack weld it in place.

Step 8. Align pn. 2002-7 with the top of 2002-2 make sure the alignment between the grill and fenders is satisfactory, tackweld, dont worry about the final height as this will be set in the next step. repeat for both sides.

tack weld



Step 9. Place pn. 2002-9 underneath pn. 2002 7 and next to pn. 2002-6, at this point you can align the top of pn.2002-7 with your grill and fender by adding a bit of a gap where it requires.



Step 10. take pn. 2002-10 and place it below pn. 2002-9 and next to pn 2002-5 tack weld in place, repeat for the other side.



Step 11. take pn. 2002-8 and place it next to pn. 2002-9 and underneath pn.2002-7 check alignment between the bumper top and the fender, tackweld



step 12. place pn 2002-11 underneath pn 2002-8
and next to pn. 2002-10, tack weld repeat for
other side of bumper.

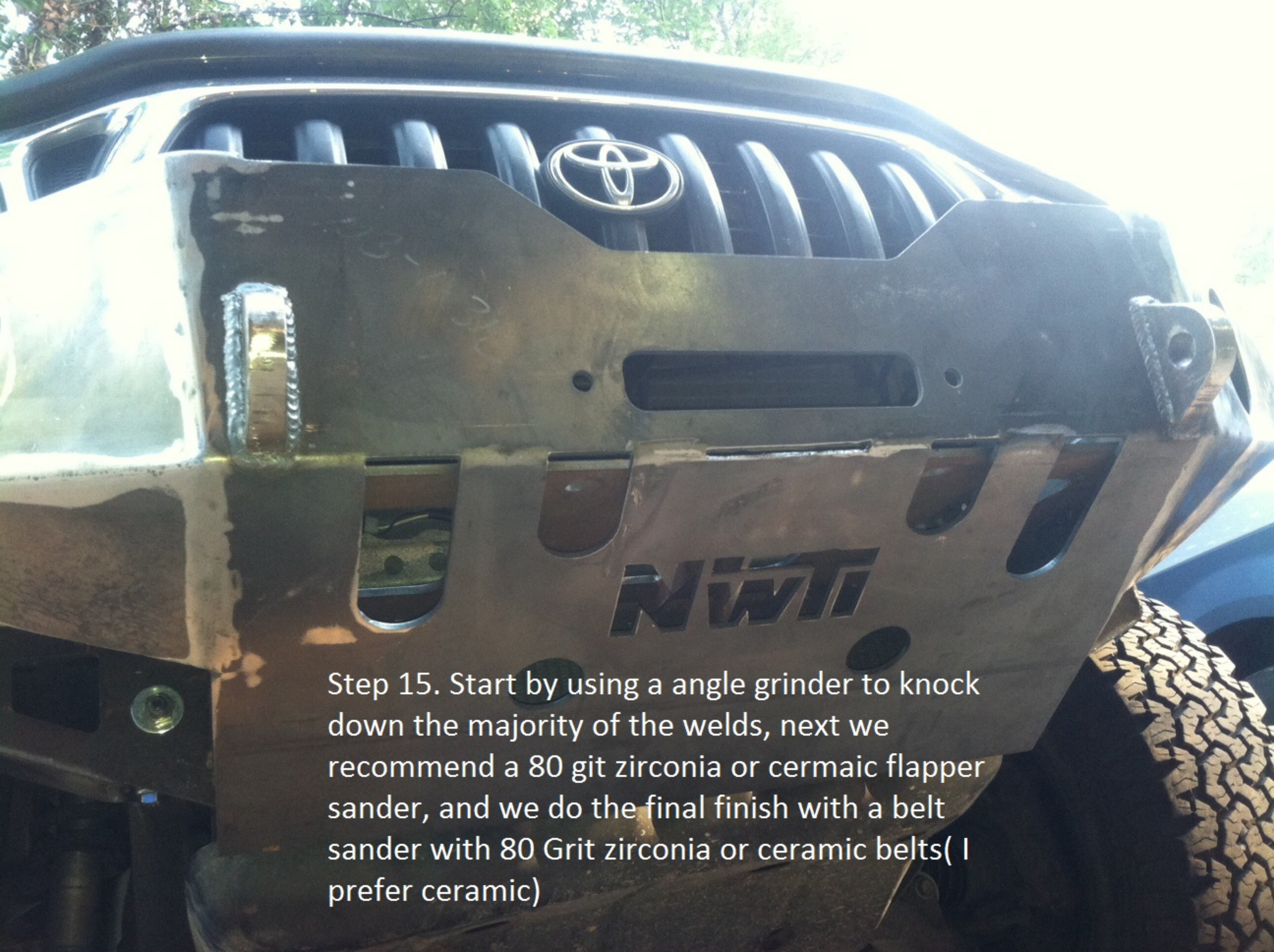


Step 13. take pn 2002-12 and place it underneath
pn 2002-7, next to pn. 2002-8 and above 2002-11
tack weld into place.





Step 14. tack weld along every joint every 2", make sure you have also tacked the bumper to the center section of the bumper. once the welds are cool remove the bumper and fully weld every edge. weld a 2" bead every 3" on the inside of the bumper.



Step 15. Start by using a angle grinder to knock down the majority of the welds, next we recommend a 80 git zirconia or cermaic flapper sander, and we do the final finish with a belt sander with 80 Grit zirconia or ceramic belts(I prefer ceramic)



Step 16 if you ordered the recessed light mount kit you will take the supplied pre cut tube and place it on the inside of the bumper. spin the tubing until aligns with the hole that is cut in the bumper.

next take your light that you wish to use and bolt it to the supplied light mount tab, align light against the tubing adjust the tab to the tubing and