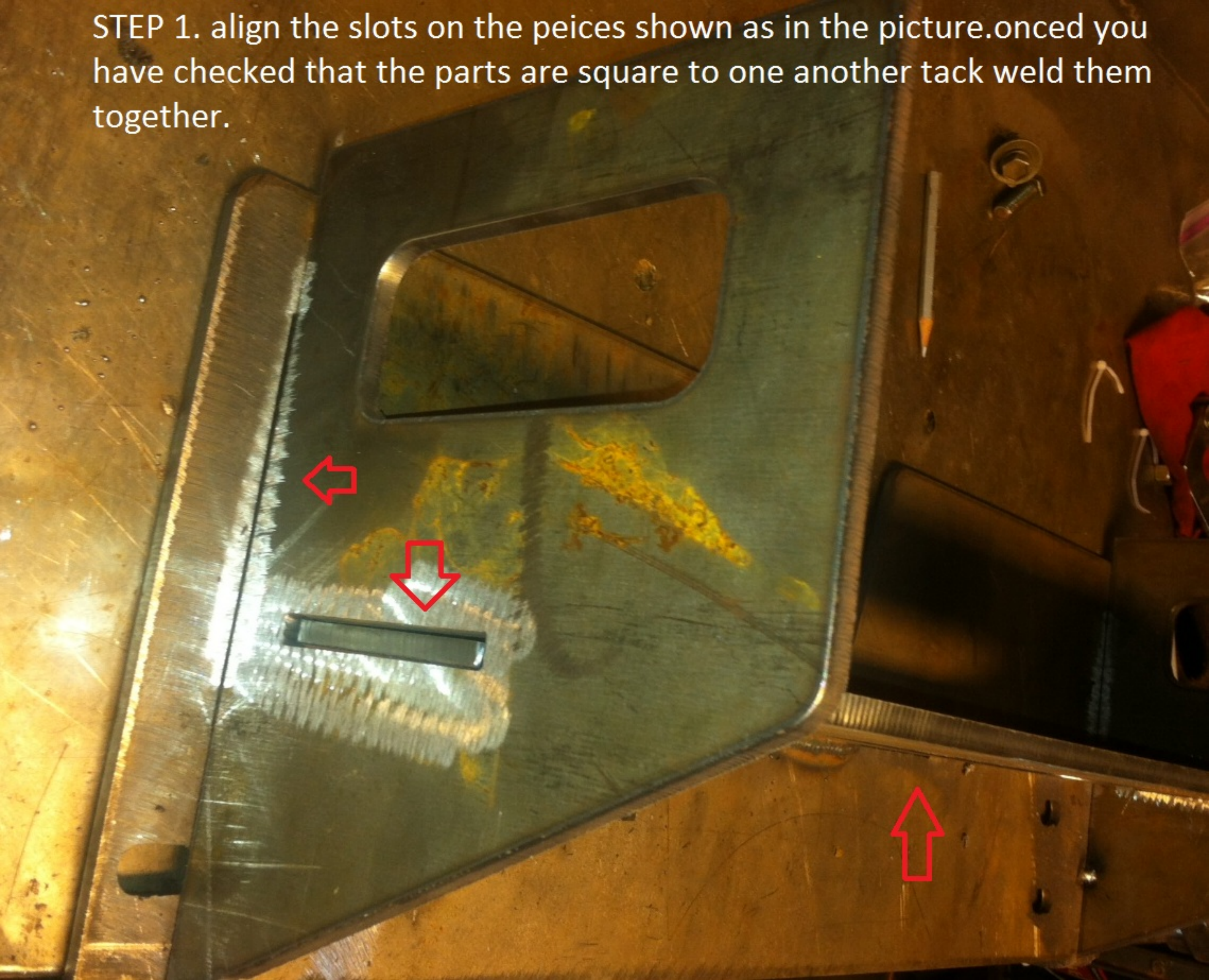


STEP 1. align the slots on the peices shown as in the picture. onced you have checked that the parts are square to one another tack weld them together.



STEP 2. Take the supplied shackle mounts and place them inside the winch tray as shown, the shackle should hang 2 1/2" past the winch cradle you assembled in STEP 1. tack weld





STEP 3. Weld the winch mount assembly together







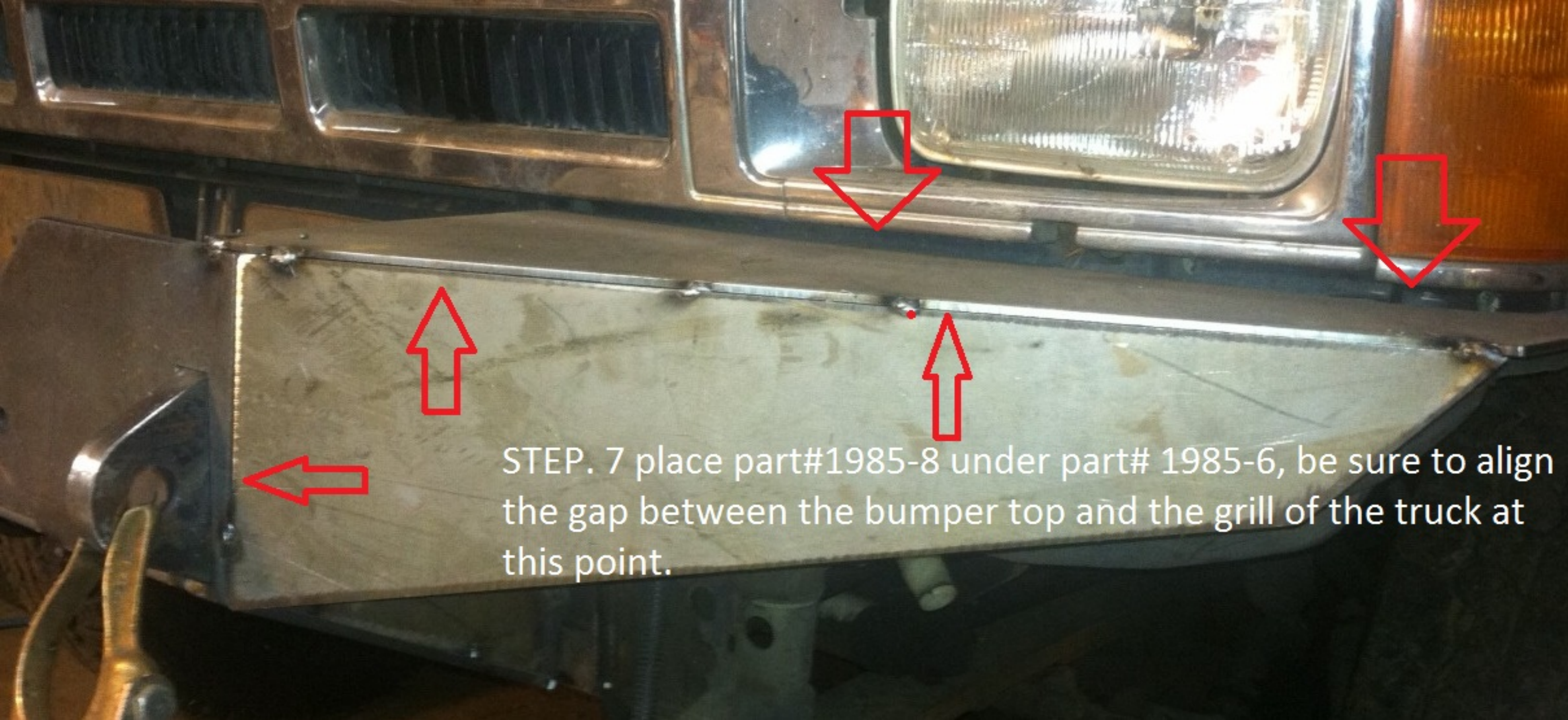
STEP.4 place part# 1985-4 onto the front of the winch mount assembly, align and tack weld. place part#1985-5 against the bottom of 1985-4 align and tack weld.



STEP 5. bolt assembly to the front of your vehicle using all the available mounting points.



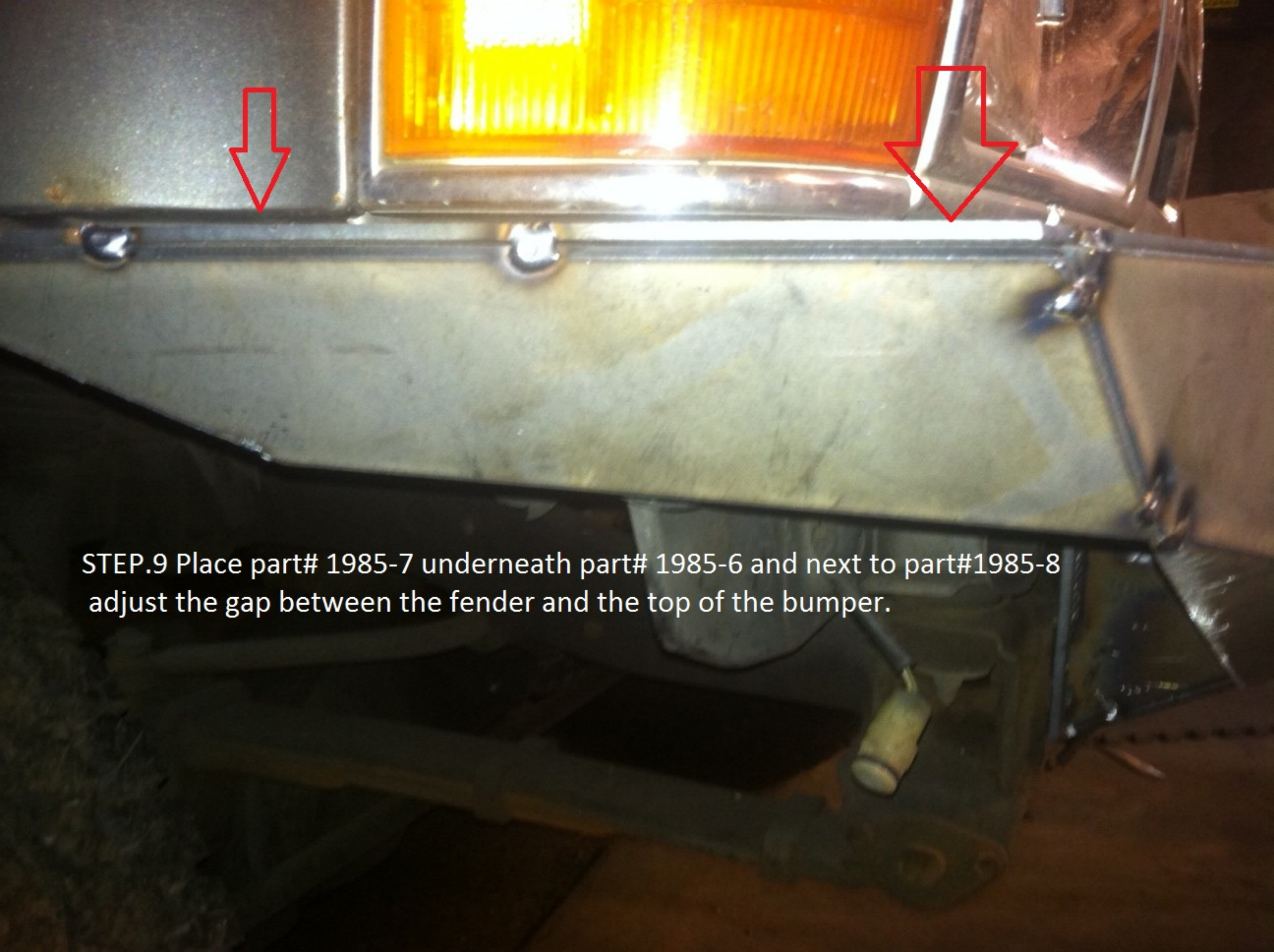
STEP 6. Place part# 1985-6 on top of the winch mount assembly, and tack weld as shown



STEP. 7 place part#1985-8 under part# 1985-6, be sure to align the gap between the bumper top and the grill of the truck at this point.



STEP.8 place part#1985-9 underneath part# 1985-8 and next to 1985-5 tack weld.



STEP.9 Place part# 1985-7 underneath part# 1985-6 and next to part#1985-8
adjust the gap between the fender and the top of the bumper.

A large, rectangular metal plate, likely aluminum, is being positioned in a workshop. The plate has a grid of welds or rivets along its edges and internal lines. It is being held by a yellow lifting device. The background shows a workshop environment with various tools and equipment.

STEP.10 place part#1985-10 underneath part#1985-7 and next to part# 1985-9 tack weld.

STEP 11. Place part# 1985-11 next to part# 1985-10 and 1985-7 tack weld. Once all peices are tacked together, go back and tack weld the seams on the bumper every 2", once it is completely tacked remove the bumper from the vehicle and weld all seams. Once the seams are welded grind them all, after grinding I recommend using a 80grit zirconia flapper sander and then a 80 grit belt sander to finish the edges.

