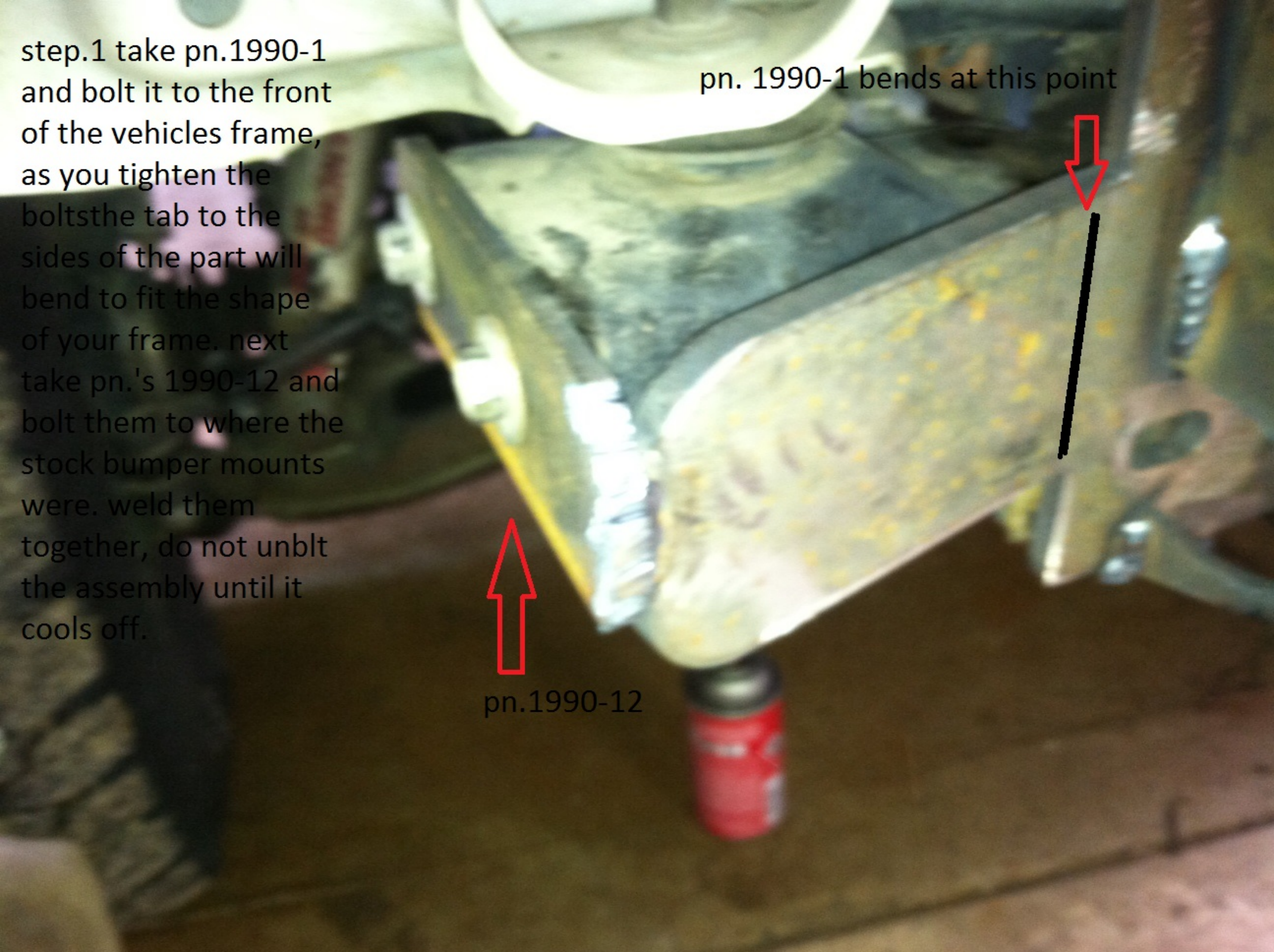


step.1 take pn.1990-1 and bolt it to the front of the vehicles frame, as you tighten the bolts the tab to the sides of the part will bend to fit the shape of your frame. next take pn.'s 1990-12 and bolt them to where the stock bumper mounts were. weld them together, do not unbolt the assembly until it cools off.

pn. 1990-1 bends at this point

pn.1990-12



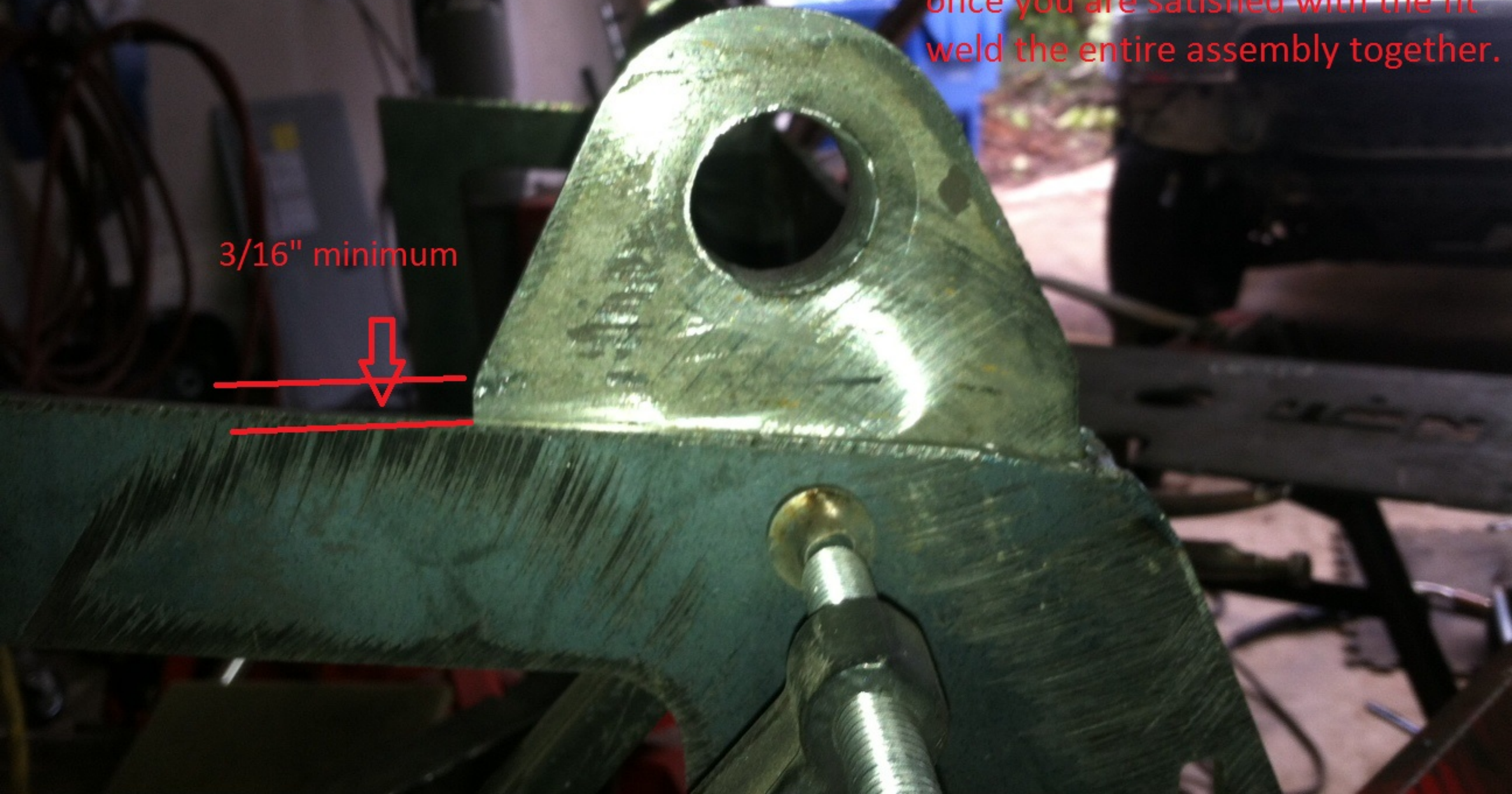


step.2 remove the parts from the vehicle that were welded in step 1. take pn 1990-2 (winch plate) and slide it into the highest slot on pn 1990-1, next take pn.'s 1990-3 and place against the sides of the winch plate and into the verticle slots on pn. 1990-1

step.3 take pn sm34 and place it in as shown in the picture (if better reference is needed please refer to the picture in step 2) sm 34 must sit flat against the winch plate. make sure 3/16" is sticking past on the high side of the sm34, once it looks correct tack weld.

once you are satisfied with the fit weld the entire assembly together.

3/16" minimum



step. 4 take the welded assembly and bolt it up to your vehicle, next take pn.1990-4 and slide it over the shackle mounts make sure the part does not sit higher than the tops of pn.'s 1990-3 once it looks good tack weld it.





step.5 take pn.'s 1990-6 and place them on top of pn.'s , 1990-3 this step is easier with a friend to hold it in place, level the part to match the grill at this point.

step 7. take pn. 1990-8 and place it as shown in the picture, make sure the gap between the fender looks even. tack weld, repeat for both sides.



step 8. take pn. 1990-5
and place it beneath
pn.1990-4 and tack weld.



step 9. take pn.'s 1990-9 and place them
underneath 1990-7 as shown in the picture. tack
weld.



1990-8-10

1990-10-10

step 10. take pn.'s 1990-10 and place them beneath
pn.'s 1990-8 and tack weld in place.

step 11. take pn.'s 1990-11 and place it on the end of the bumper corners as shown in the picture. next tack weld the entire bumper every few inches. pull the bumper off of the truck and fully weld the outside shell. next weld the inside of the bumper shell every few inches.

next grind all the outer welds with an angle grinder we like to use a belt sander with 80 grit zirconia or ceramic belts to finish the outer edges.

