UNIT PREPARATION AND INSTALLATION PROCEDURE

NOTE: THE FOLLOWING INSTRUCTIONS ARE FOR INSTALLING BUMPER INTO A MOUNTED TRAILER UNIT.

1.0 REMOVE UPPER SURROUND/GRILLE ASSY FROM UNIT. RETAIN CENTER MOUNTING SCREW FOR INSTALLATION.

2.0 DISCARD SCREWS THAT WERE FOR MOUNTING NEW BUMPER. USE A 3/8" DRILL BIT TO DRILL ALL Holes ON EACH END. FOLLOW UP WITH AN APPROPRIATE BIT TO DRILL THE TOP END Holes TO .540 DIA FOR A 3/8"-16 RIV NUT. INSTALL 3/8"-16 RIV NUT (IT. 15) EACH END.

3.0 REMOVE TOP BUMPER HOLES (0.69 DIA) IF PRE-EXISTING IN FRAME. IF Holes ARE NOT PRESENT SEE DETAIL "A" FOR DIMENSIONS TO LOCATE AND DRILL REQUIRED Holes.

4.0 DISCARD SURROUND PLUGS FROM TOP REAR FRAME POSTS. DISCARD PLUGS.

5.0 REMOVE SCREWS AND RIV NUTS FOR ATTACHING UPPER SIDE SURROUND MOUNTING AS INDICATED. USE A 3/8" DRILL BIT TO DRILL ALL Holes ON EACH SIDE. FOLLOW UP WITH A 1/2" DRILL BIT TO ENSURE ADEQUATE CLEARANCE WHEN HARDWARE ARE INSTALLED.

6.0 REMOVE UPPER UNIT MOUNTING NUTS AND WASHERS FROM EACH SIDE OF VERTICAL FRAME TUBES. RETAIN FOR RE-INSTALLATION.

7.0 REMOVE (3) 1/4" SCREWS FROM THE VERTICAL BUMPER SUPPORT CHANNELS.

8.0 INSTALL VERTICAL BUMPER CHANNELS INTO TOP OF VERTICAL FRAME TUBES UNTIL THEY CONTACT THE VERTICAL FRAME STUDS. VERIFY THAT BUMPER IS FULLY SEATED ON MOUNTING STUDS. INSTALL UNIT MOUNTING WASHERS AND NUTS. DO NOT TIGHTEN COMPLETELY.

9.0 ASSEMBLE BRACKET ROAD SIDE (IT. 25) TO FRAME. HOLD LOOSELY WITH ORIGINAL FENDER WASHER, OLD WASHER (IT. 10), AND NEW SCREW (IT. 3).

10.0 ASSEMBLE BRACKET CURB SIDE (IT. 30) TO FRAME. HOLD LOOSELY WITH ORIGINAL FENDER WASHER, NEW WASHER (IT. 10), AND NEW SCREW (IT. 3).

11.0 INSTALL SPACERS (ITEM 18) QTY OF 2, BETWEEN BOTTOM OF BUMPER ASSY AND TOP OF EACH BUMPER BRACKET INSTALLED IN NOTES 9 & 10.

12.0 INSTALL SCREWS (ITEM 6) QTY OF 2 (ONE EACH SIDE), WASHER (ITEM 10) QTY OF 4 (TWO EACH SIDE) TO TOP OF BUMPER ASSY THRU SPACER AND BUMPER BRACKETS. INSTALL WASHERS ON TOP OF SCREW (ITEM 10) QTY OF 4 (TWO EACH SIDE) AND LOCK NUT (ITEM 8) QTY OF 2 (ONE EACH SIDE) UNDER NUTS.

13.0 TIGHTEN UNIT MOUNTING NUTS AND 1/2" SCREWS. REMOVE ALL 1/4" SCREWS ON SIDE OF FRAME AND ON BUMPER FOR INVOLVED ASSY.

14.0 REINSTALL SURROUND USING ORIGINAL CENTER TOP HARDWARE AND 3 SETS OF ORIGINAL BOTTOM HARDWARE. DO NOT TIGHTEN COMPLETELY.

15.0 FULLY TIGHTEN ALL BUMPER AND SURROUND HARDWARE.