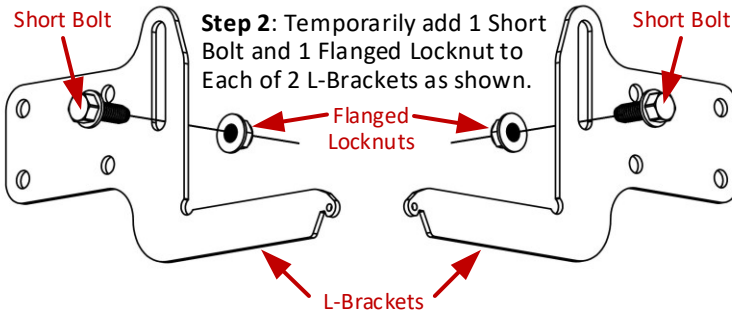
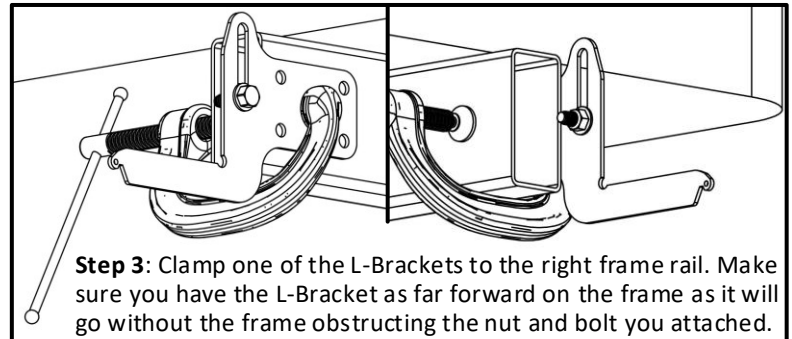


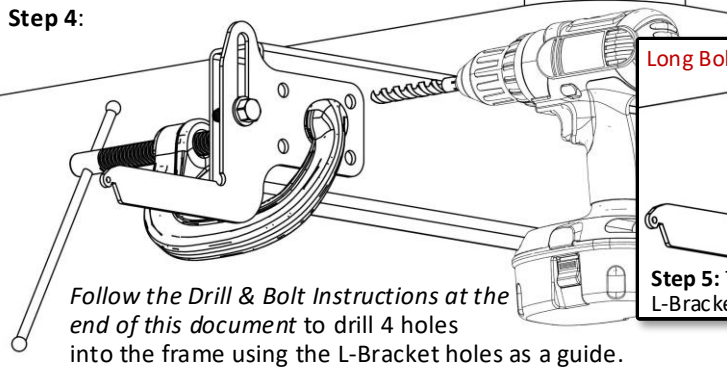
Step 1: Remove old bumper from frame (a reciprocating saw with a new steel-cutting blade works well) and deburr frame ends (red circles) to create flat sides for mounting brackets.



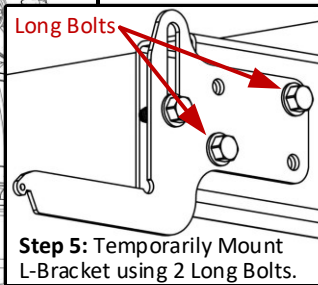
Step 2: Temporarily add 1 Short Bolt and 1 Flanged Locknut to Each of 2 L-Brackets as shown.



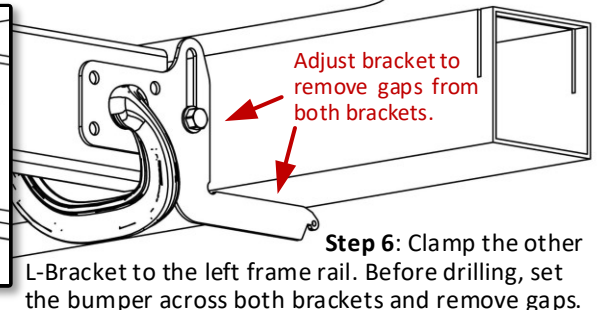
Step 3: Clamp one of the L-Brackets to the right frame rail. Make sure you have the L-Bracket as far forward on the frame as it will go without the frame obstructing the nut and bolt you attached.



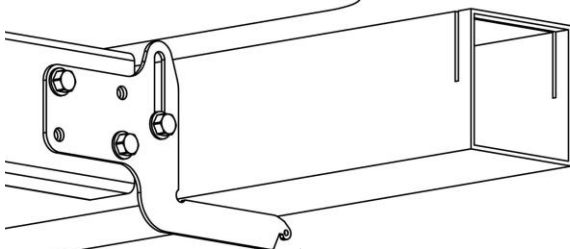
Step 4: Follow the Drill & Bolt Instructions at the end of this document to drill 4 holes into the frame using the L-Bracket holes as a guide.



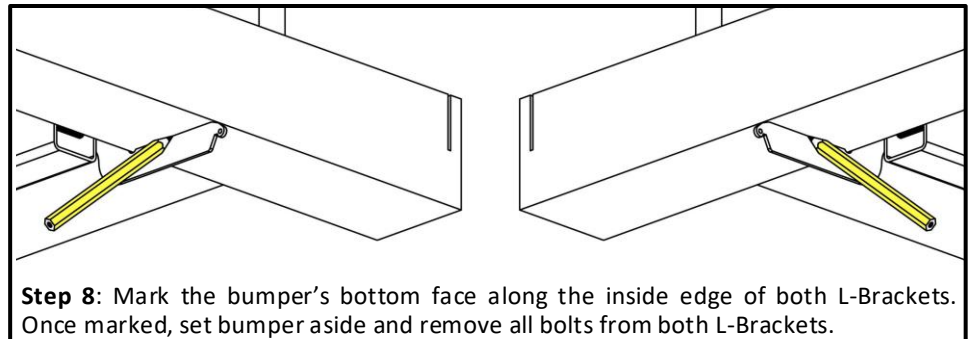
Step 5: Temporarily Mount L-Bracket using 2 Long Bolts.



Step 6: Clamp the other L-Bracket to the left frame rail. Before drilling, set the bumper across both brackets and remove gaps.



Step 7: Drill and mount 2nd L-Bracket as you did the first. Center bumper across both L-Brackets.



Step 8: Mark the bumper's bottom face along the inside edge of both L-Brackets. Once marked, set bumper aside and remove all bolts from both L-Brackets.

Instructions Continue on Next Page...

Visit www.mount-n-lock.com/installs for full-size instructions.

Step 9: Create mounting bracket assembly with 5 L-Brackets, 1 Bracket Buckle, 1 Short Bolt and 1 Flanged Locknut. Interleave two inverted L-Brackets with 3 upright L-Brackets and put Short Bolt through overlapped slots and finger-tighten nut. Next, insert bracket tips through slots in the

Bracket Buckle

Wire

Bracket Buckle and temporarily retain by inserting some wire through holes in the tips. With assembly opened fully, you now slide it onto bumper.

Step 10:

Slide the Bracket Assembly over Bumper as shown. Pay attention to the relation of the orientation of the Bumper (slot on top) to the orientation of the Bracket Assembly (2 L-Brackets on top).

Step 11 (cont.): Use Clamp to squeeze Bracket Assembly together, aligning bolt holes. Once bolt holes are aligned, tighten Short Bolt and Flanged Locknut to hold Bracket Assembly tight. Now remove Clamp and Retention wires.

1. Tighten Clamp

2. Tighten Short Bolt and Flanged Locknut.

3. Remove Clamp and Retention Wires

Step 11: Align inner edge of bottom of Bracket Assembly with mark you put on bottom of Bumper in Step 8 then use Clamp to squeeze Bracket Assembly together, aligning bolt holes.

Align with Mark on Bumper

Repeat Steps 9-11 with other Bracket Assembly at other end of Bumper.

Last Step: Insert End Plates into slots in Bumper and attach Nylon Nut and Bolt through bottom hole in End Plate as shown below.

Step 12: Follow the Drill & Bolt Instructions at the end of this document to mount the Bumper and Bracket Assemblies to your vehicle's frame using the Long bolts and the holes you've already drilled.

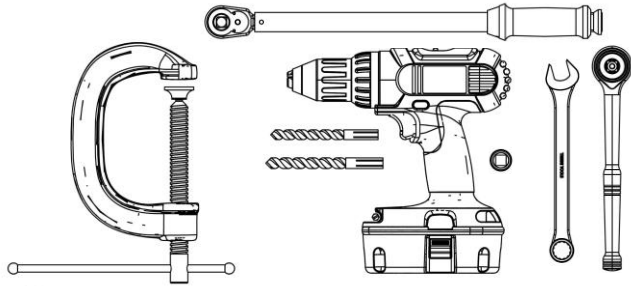
Instructions Continue on Next Page...

Visit www.mount-n-lock.com/installs for full-size instructions.

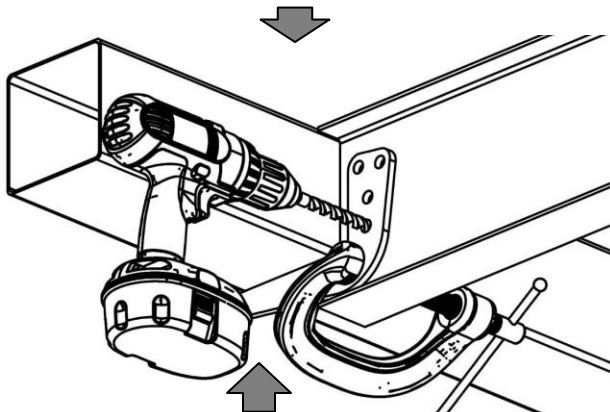
Universal Drill & Bolt Instructions

RECOMMENDED TOOLS

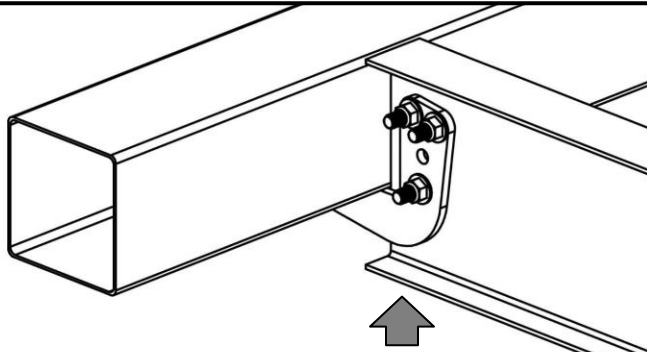
9/16" wrench, torque wrench with 9/16" socket, power drill with 3/8" bit, and a C-Clamp. If using bolts as self-tappers, add 11/32" bit and a ratchet.



HOW TO FASTEN PARTS USING NUTS AND BOLTS (N&B)*



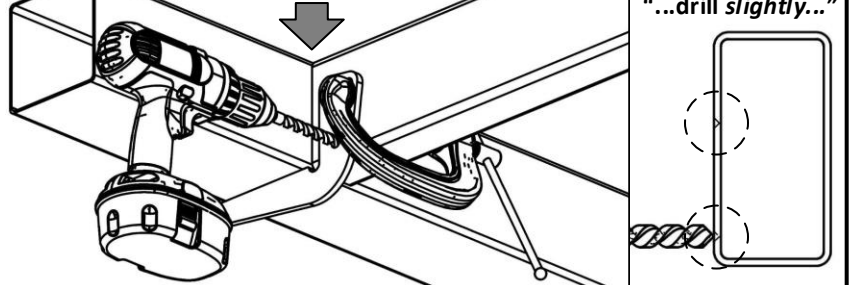
Step 1 (N&B): With your Part clamped in place and using the Part's bolt holes as a guide, use the 3/8" bit to drill *completely* through the wall of the frame member.



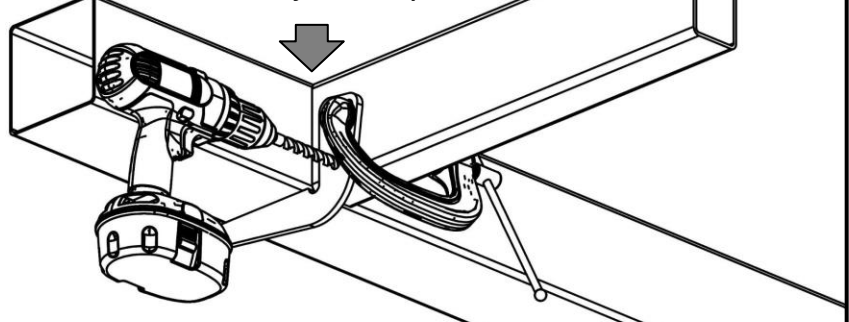
Step 2 (N&B): Final Step! Mount the Part to your vehicle's frame using the supplied Nuts and Bolts. Use a torque wrench on the Nuts to slowly tighten the assembly to **25-30 ft. lbs.**

HOW TO FASTEN PARTS USING ONLY SELF-TAPPING BOLTS (STB)*

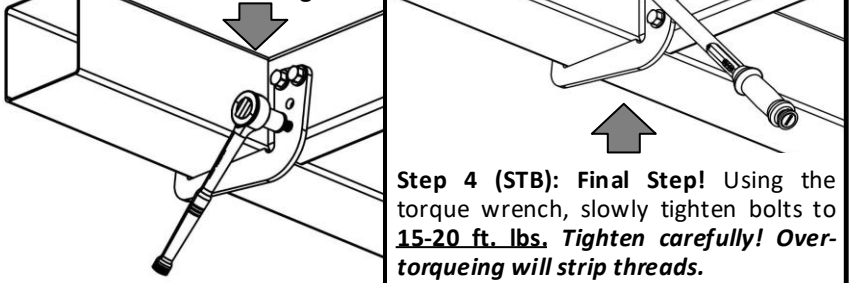
Step 1 (STB): With your Part clamped in place and using the Part's bolt holes as a guide, use the 3/8" bit to drill *slightly* into the steel (just to mark the hole centers) as shown in inset.



Step 2 (STB): Using the 11/32" bit, drill the holes completely through using the dimples made with the 3/8" bit as a guide. **Note: Use only an 11/32" drill bit for this step!**



Step 3 (STB): Screw bolts *slowly* into the 11/32" holes using the ratchet and 9/16" socket, pressing in as you turn. **Caution: Do not over-tighten!**



Step 4 (STB): Final Step! Using the torque wrench, slowly tighten bolts to **15-20 ft. lbs.** Tighten carefully! Over-torquing will strip threads.

*** Note:** The mounting bolts supplied with your order are self-tapping bolts, meaning that they can cut their own threads into metal, yet they work equally well with the nuts that were also supplied. *Use what works best for your application.*

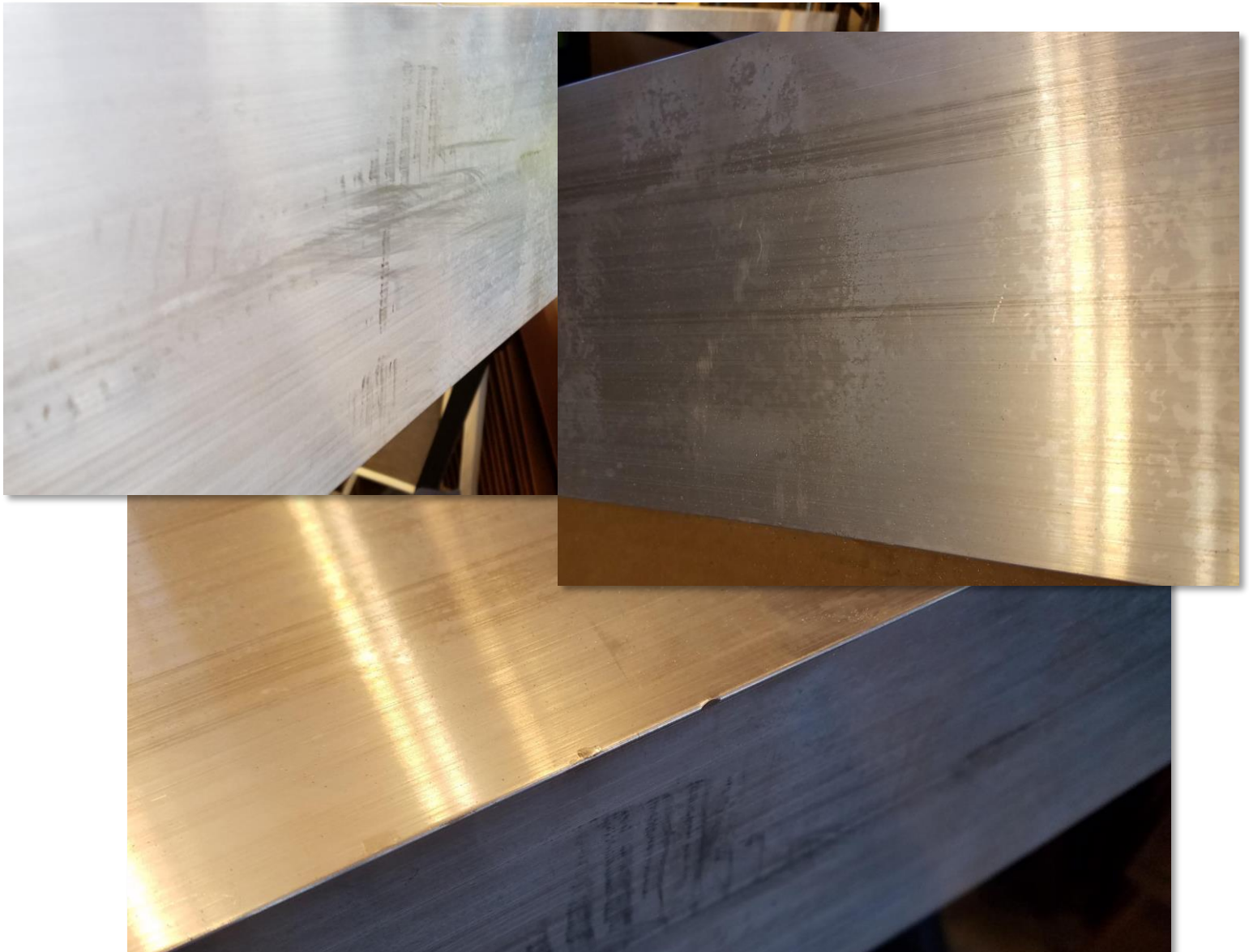
Self-Tapping Bolts (STB) work best on 0.120" (~1/8") or thicker steel. To use **Nuts and Bolts (N&B)**, frame steel thickness should be 0.188" (3/16") or less; thicker steel may require longer Bolts. *Most frames are 0.120" thick.*

Visit www.mount-n-lock.com/installs for full-size instructions.

A Note About Product Finish and Appearance

Thank you for your purchase from our HeavyHaul'r™ family of bumpers. Every precaution has been taken to ensure that you receive a bumper in top condition, though some imperfections are to be expected. As with all aluminum extrusions, your bumper may have traffic, handling, runout & and carbon marks. Despite being extruded from one of the strongest alloys (6061) and hardened to the maximum possible (T6), aluminum is inherently a soft metal and susceptible to minor scratches and dings during the manufacturing and handling of each item. Aluminum will also oxidize slightly, losing its mirror finish for more of a matte finish (slight discolorations are also possible but will typically “bleach out” once out in the sun).

Examples of acceptable imperfections are shown below. If you discover significantly worse damage (possibly caused by shipping), let us know and we'll work with you to make it right!



Visit www.mount-n-lock.com/installs for full-size instructions.