

THUREN BUMPER INSTALL



- Install center section on to truck, set bumper height and make sure it is level with the body lines. If the frame fit is tight, pushing the bumper up from the bottom with a floor jack works very well.
- Snug mounting bolts but do not tighten yet.
- Install outsides of bumper on to center section, align bumper with body lines and other parts of the bumper. Some bolt locations may not have enough room for the washer; on these bolts put the bolt head up against the bumper.
- IF YOUR TRUCK DOES NOT HAVE PLOW MOUNT HOLES THEN YOU WILL NEED TO DRILL HOLES IN THE FRAME, IT IS CRITICAL THESE HOLES ARE DRILLED PERFECTLY CENTERED IN THE MOUNTING HOLES ON THE BUMPER. MEASURE THE HOLES THEN USE A SCRIBE AND CENTER PUNCH TO MARK THE CENTER OF THE MOUNTING HOLE; START WITH A PILOT HOLE THAT GOES THROUGH THE **OUTSIDE AND INSIDE** OF THE FRAME RAIL, THE PILOT HOLE MUST BE PERFECTLY PARALLEL THROUGH THE FRAME. ONCE PILOT HOLES ARE MADE DRILL HOLES TO $\frac{1}{2}$ ", BE CAREFUL NOT TO LET THE DRILL BIT POP THROUGH THE FRAME AND PUT A HOLE IN THE RADIATOR!!! LASTLY DRILL THE **OUTSIDE AND ONLY THE OUTSIDE** OF THE FRAME RAIL TO $\frac{3}{4}$ " AND INSTALL A CRUSH SLEEVE INTO THE $\frac{3}{4}$ " HOLE ON OUTSIDE OF FRAME THROUGH HOLES IN BUMPER.
- Torque $\frac{1}{2}$ bolts to 110 ft/lbs.
- Torque stock 18mm plow mount bolts or $\frac{3}{4}$ " replacement bolts to 200 ft/lbs.

