

Southern Style Speed

FRONT STEEL BUMPER INSTALLATION INSTRUCTIONS

2003-2009 Lexus GX470

Version 3.1.1 - 2014

Thank you for purchasing the Southern Style Speed Lexus GX470 steel winch bumper. This bumper was designed as a complete bolt on solution, with the ability to easily go back to stock should you choose to do so later. However, it may be necessary to make small adjustments to the vehicle to ensure proper fitment and strength.

Included Content:

- 1-piece steel bumper with/without driving light cut outs.
- Front aluminum skid plate
- Lower steel skid plate
- (Optional) – bolt on side splash guards
- Hardware
 - 8 – 7/16" hex bolts and 11/16" flange nuts w/ washers
 - 13 - 3/8" button head bolts w/ washers
 - i. 13 - 3/4" length for front skid plates
 - 10 - 1/4" button head bolts and nuts w/ washers
 - 2 - m12 bolts w/ washer and lock washers
 - 4 - m8 bolts w/ washer and lock washers
- Optional Accessories

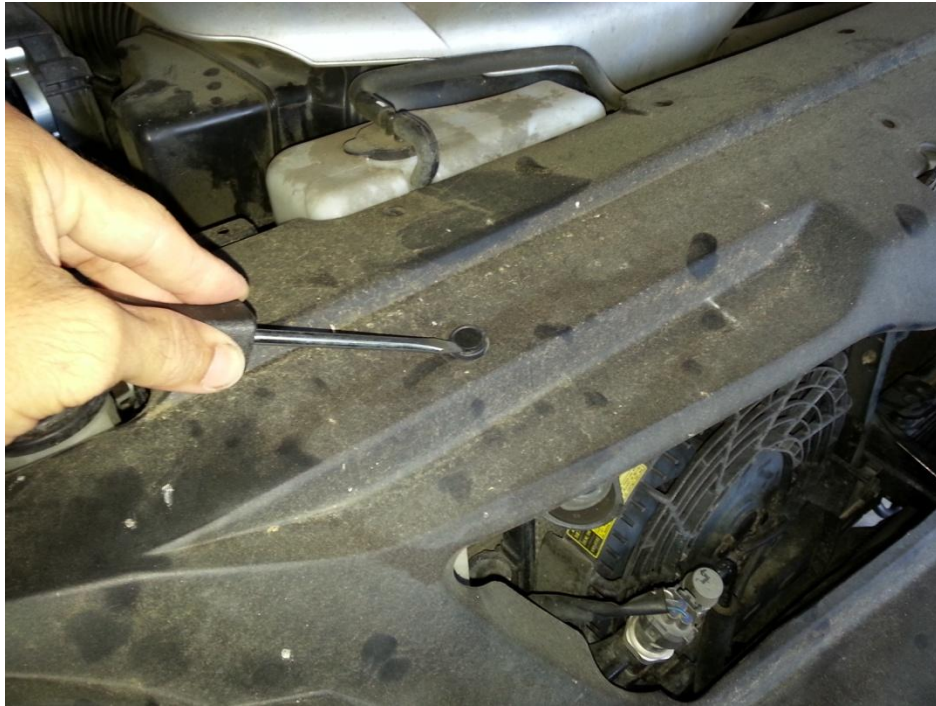
Additional tools required:

- 5/8", 11/16" socket/impact
- 5/8" wrench
- 17,14,13,12,10 mm socket/impact
- 1/2" and 3/8" drive ratchet wrench
- Flat and Phillips screwdriver
- Grinder (depending on irregularity of OEM welds on frame)
- Electric drill with 1/2" metal bit
- Ratchet strap
- 2-3lb hammer



Begin installation by carefully unpacking the bumper from the pallet and protective materials. Verify all required hardware and optional accessories are included.

It is best to leave about 6" of the protective material on the tips of the wings to protect your vehicle during installation. This installation procedure can be done with only 2 people, but 3 is optimal.



First, remove all the plastic clips holding the engine covers in place so that you may remove the covers for now. To do this, use a flat head screwdriver to pop the center section up. Once you have accomplished this, hold the clip at its base and pull it out of the mounting hole.



After removing the engine covers, you will also need to remove the remaining clips holding the front bumper cover onto the truck. You will find these clips between the headlights near the grill area.



Remove every 10mm bolt on the underside of the OEM bumper cover. This will help to free up the plastic fender liners for removal in the next step.



Remove the remaining clips and fasteners connecting the fender liner to the front bumper cover. You will want to wait until after the OEM bumper cover is removed before attempting to cut your fender liners out. This can be done with a sturdy pair of scissors. Carefully cut a straight line in the area highlighted below in the bright green circle. If done carefully, reinstallation of fender liners can be achieved by using industrial strips of Velcro or similar locking fasteners for a clean look.



Before continuing, be certain that all plastic clips, screws, and bolts holding the OEM bumper cover onto the truck have been removed. To get started, pull down and out at the corner indicated in the picture. This may take more force than anticipated. The OEM bumper is designed to latch to the fender even without any hardware holding it. Stop once you have achieved this on both sides.



Next, stand in front of the vehicle on the same side that you just started removing the bumper cover. By pulling downward and towards you, disengage the large plastic latches located in the circled area.



After disengaging these latches the bumper should start to easily “peel” off.

WARNING: If the bumper does not start to easily come off of the truck at this point, STOP and be certain that absolutely no clips or bolts were left impeding removal.

When the OEM bumper has been removed, you'll expose the cross beam that joins the frame rails together. Using a ratchet strap, apply slight tension around crash horn sections as shown. Remove the 8 - 14mm flange nuts holding this section to the frame rails.



You will find it necessary to increase the tension on the crash horns until the center section starts to loosen on the bolts. Under the correct tension, it should be easy to remove and reinstall the center section.

Remove this center section from the truck.



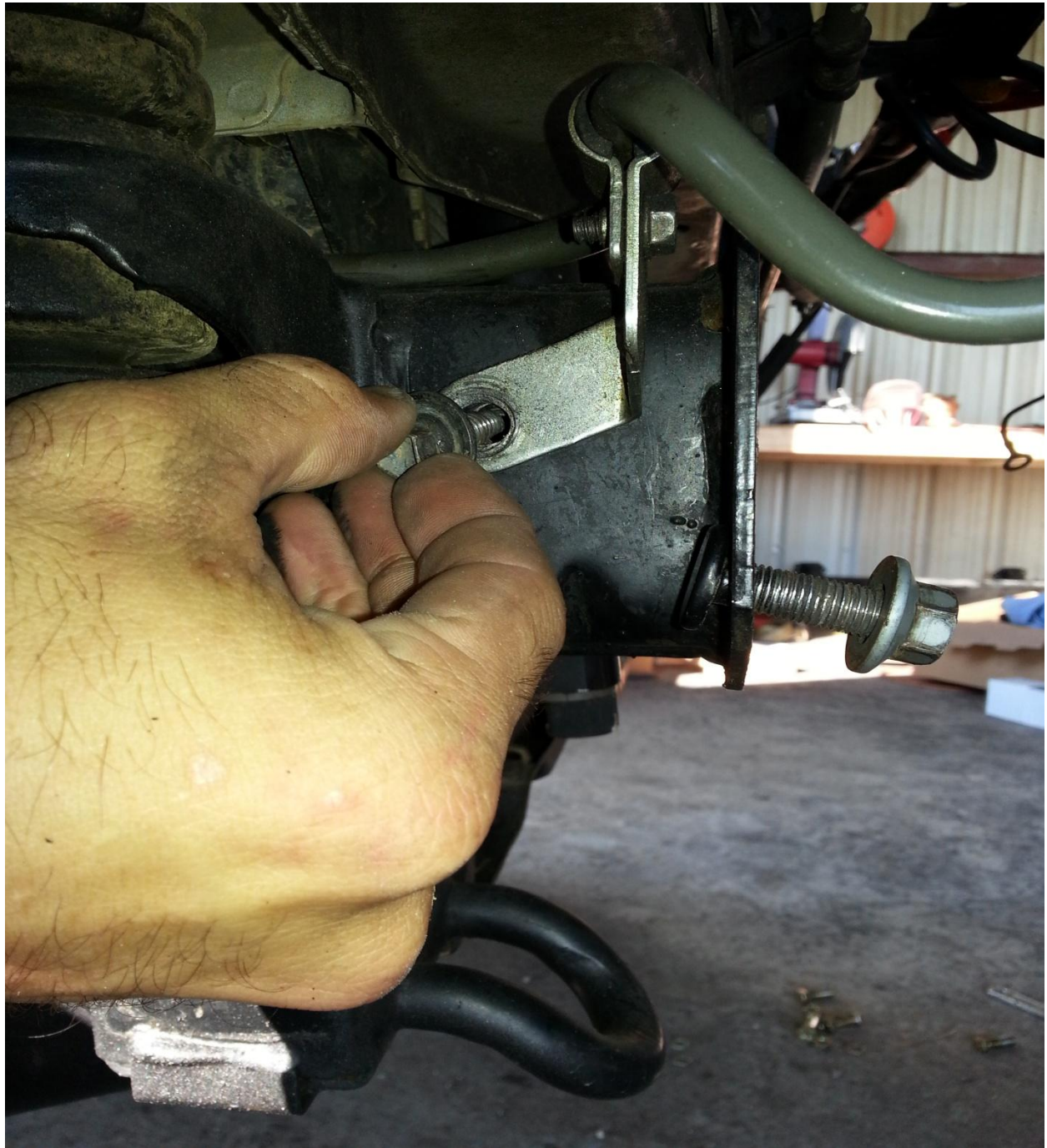
Reinstall the removed 14mm nuts without exposing any threads. Using a heavy hammer or light maul, tap the nut protecting the threads with a sideways motion until the three small tack welds break on the backside of the bolt. Do this for all frame rail bolts.



Using an electric drill with a ½" metal bit and GENEROUS amounts of WD-40, drill out the 8 bolt hole locations on the frame rail. This is necessary to fit the larger diameter grade 8 bolts provided.



Using a 12mm socket, remove the bolt holding the pressurized fluid line bracket on both driver and passenger frame rail.



At this point, you may find it necessary to smooth out the OEM frame welds to ensure the new bumper bracket fits flush against the side of the rail. This may not be necessary for all vehicles.



Install the supplied bumper bracket by slipping it behind the pressurized fluid line and loosely bolting it in using the supplied M12 bolt and M8 bolt on each side of the truck. Do not tighten the bracket down until you ensure that all 6 frame bolts slide through bumper bracket and OEM Frame plate.



You can see here that we only left a single bolt on the outside edge on both the driver and passenger side. We found it much easier to locate the holes on the bumper to only one bolt on each side. The other bolts can be installed after getting the bumper lined up.

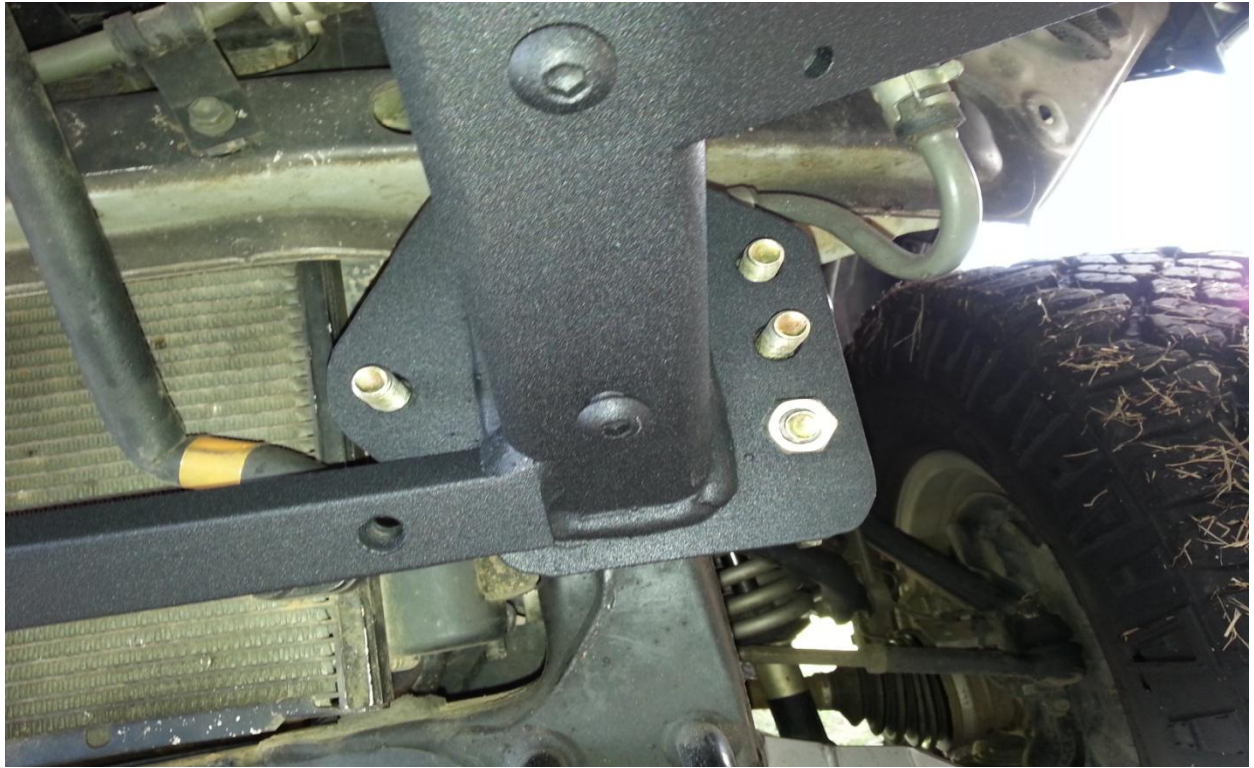


IMPORTANT: Install driving/fog lights before bolting the bumper to the truck. You will be able to adjust the angle of the beam output but will not be able to install any lights after the bumper is installed.

With a team of 2 or 3 people CAREFULLY install the bumper to the truck by first locating those single bolts to the appropriate bumper bolt hole. With 3 people, 2 will carry the weight of the bumper while the third has the job of ensuring bolt hole alignment, frame bolt tightening, and that the truck/bumper is not damaged during installation.

After the bumper has been slid into place, hand-tighten as many frame bolts as possible. If you secure a top and bottom frame bolt on each side, you will be able to begin releasing the bumper so that the truck is supporting all of the weight. Use this opportunity to adjust the bumper slightly so that all body lines match before tightening down.





Remove the two 12mm bolts securing the factory skid plate.



Install the supplied steel lower skid using 3/8" button head bolts (3/4" length) and 2 - M8 (13mm) metric bolts. The button head bolts install across the support bar between the two bumper legs. The M8 bolts install in the same two bolt holes that attach the lower skid.



****Install your winch before securing the front aluminum skid plate.****

Using the lower skid as a rest, install the front aluminum skid plate with the supplied 3/8" button head bolts ($\frac{3}{4}$ " length) and aluminum washers. It is advisable to apply a small amount of blue Loctite to the threads of these hex bolts. Be certain all winch connections and bolts are secure and operational before doing so.



If ordered, install the sheet metal splash guards with the supplied $\frac{1}{4}$ " button head bolts and washers. Also use a small amount of blue loctite on these threads to ensure no vibrations or bumps loosen the bolts.



CONGRATULATIONS! You've just successfully installed your Southern Style Speed GX470 steel winch bumper. Below are some included photographs of proper alignment and fitment to the body of the truck. There should be some gap between the bumper and the body of the truck to allow for flex during extreme trail riding. This is normal.



