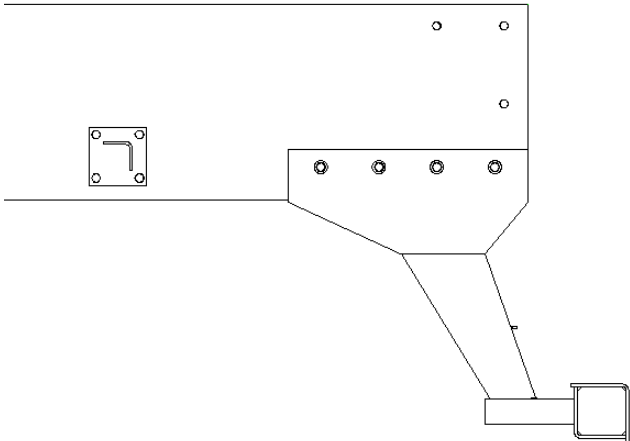
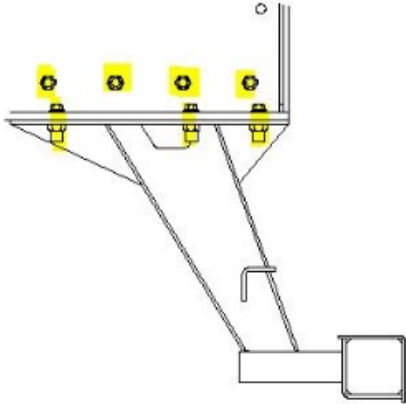
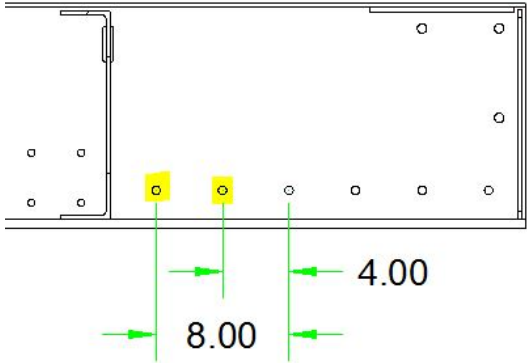
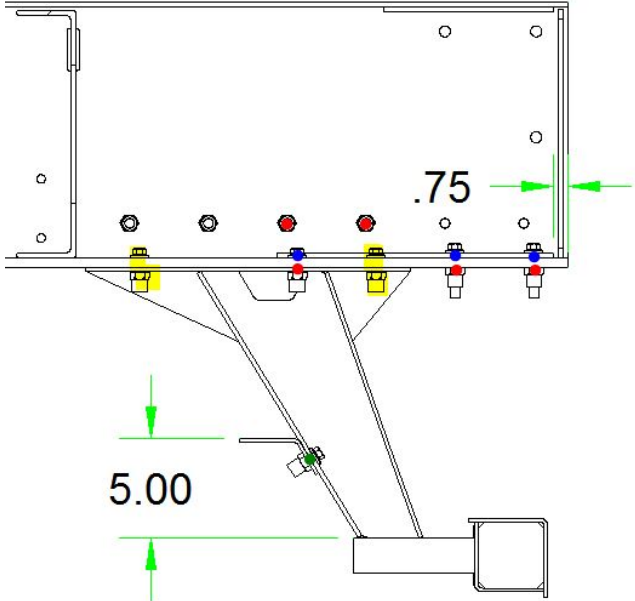
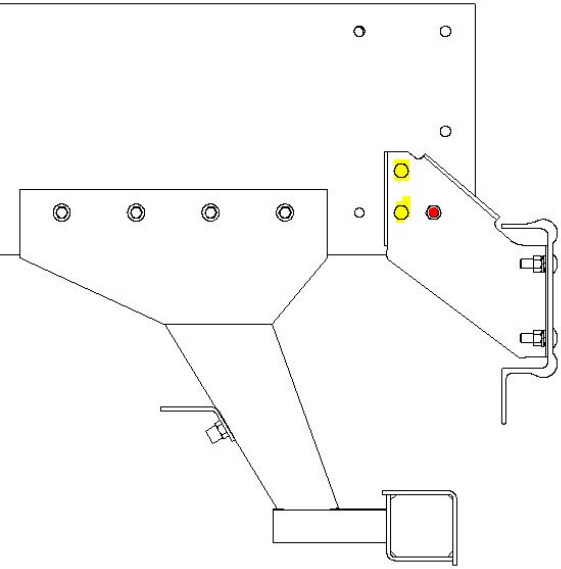
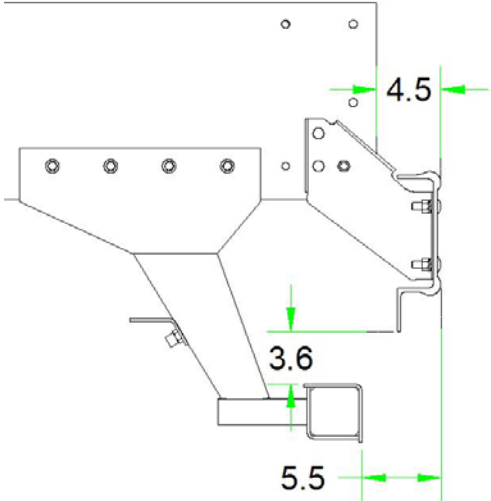
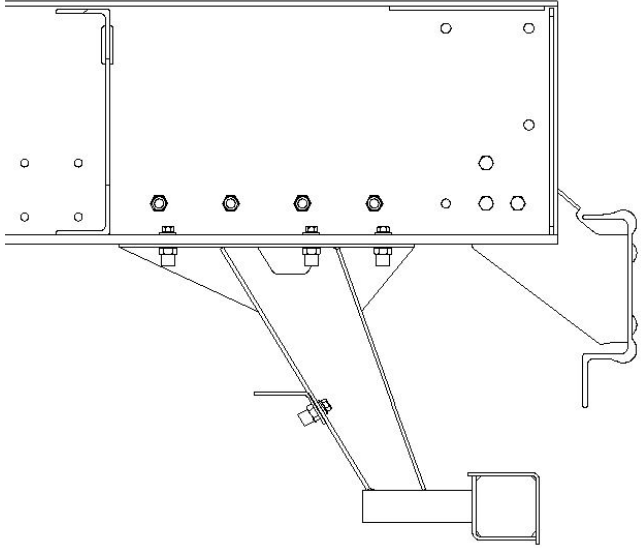




STEP	PROCEDURE	INSTRUCTIONS	GRAPHIC
1	Confirm correct parts are available before starting.	See parts list on last page.	
2	Review bumper installation as original built		 <p>A line drawing of a bumper assembly. On the left, a square mounting bracket with four holes is attached to a horizontal line representing the trailer frame. The bumper itself is a trapezoidal shape with four holes along its top edge. It is connected to a vertical support post, which is further attached to a horizontal bar with a rectangular end piece.</p>
3	Cut-off existing Huck bolts	Each side is secured with (7) seven Huck bolts. The recommended method to remove them is using an abrasive cutoff wheel and cutting thru the collar and then removing the bolt.	 <p>A line drawing of a bumper assembly, similar to the one in step 2. Seven yellow circles are placed along the top edge of the bumper, indicating the locations of Huck bolts. The bumper is attached to a vertical support post, which is connected to a horizontal bar with a rectangular end piece.</p>

STEP	PROCEDURE	INSTRUCTIONS	GRAPHIC
4	Drill (2) two holes each side	The (2) two ½” holes are located inline of the existing (4) four holes.	
5	Install the supplied Rear Impact Guard.  RIM Bumper PN's RIM0000223 RIM0000224 ANG0000069  Plate PN PLT0001005  Bolt, nut and washer PN's BLTZP00302 BLTZP00301 NUTZP00129 WSH0400237	<ul style="list-style-type: none"> <li>• Locate the plate as shown.</li> <li>• Reuse the (5) five bolt holes shown in red.</li> <li>• Install mylar film or equal between SS brackets and aluminum frame.</li> <li>• Match drill the (2) two vertical bolt holes shown in yellow each side.</li> <li>• Match drill the (3) three vertical bolt holes in plate as shown in blue each side.</li> <li>• Install (9) nine bolts (7/16” - 2” long) each side.</li> <li>• Torque to 63 ft-lbs.</li> <li>• Attach lower bumper tube to brackets. Level bumper as needed. Use MIG welder with XXX weld wire.</li> <li>• Install bolt-on angle. Match drill and bolt (7/16” - 1-1/2” long) (2) two places shown in green.</li> <li>• Torque to 63 ft-lbs.</li> </ul>	

STEP	PROCEDURE	INSTRUCTIONS	GRAPHIC
6	<p>Install the supplied upper bumper</p> <p>Upper Bumper PN's BPR0000111 BPR0000112 EXT0070650</p> <p>Bolt, nut and washer PN's BLTZP00198 BLT0400044 NUTZP00078 NUT0400014 WSH0400010 WSH0400011</p>	<ul style="list-style-type: none"> <li>• Use the existing bolt hole, shown in red, to position and level the bumper brackets on the frame.</li> <li>• Install mylar film or equal between SS brackets and aluminum frame.</li> <li>• Match drill the (2) two other bolt holes shown in yellow.</li> <li>• Install (3) three bolts (1/2" - 2" long) each side.</li> <li>• Torque to 96 ft-lbs.</li> <li>• Level the bumper to the brackets. Match drill (4) four holes.</li> <li>• Install (4) four carriage bolts.</li> <li>• Torque to 43 ft-lbs.</li> </ul>	
7	<p>Review bumper installation after modifications.</p>	<p>Dimensions shown are reference.</p>	

STEP	PROCEDURE	INSTRUCTIONS	GRAPHIC
8	Inspect upper inside corner of the last suspension cross member on both sides of the trailer	Check for any cracks in the weld.	
8a		Example of cracks in the weld.	
9	Repair any cracks that are found.	Gouge out crack and weld. Use MIG welder with XXX weld wire.	

<u>STEP</u>	<u>PROCEDURE</u>	<u>INSTRUCTIONS</u>	<u>GRAPHIC</u>
10		Completed bumper modification.	

Parts List

<u>PN</u>	<u>DESC</u>	1 trailer <u>QTY</u>	<u>Changes</u>
<b>RIM0000224</b>	<b>RIM AS DS</b>	1	Was RIM0000141
<b>RIM0000223</b>	<b>RIM AS CBS</b>	1	Was RIM0000140
<b>ANG0000069</b>	<b>ANG .19x2x3x37.75 120°</b>	1	Revised; holes added
<b>PLT0001005</b>	<b>PLT RECT .235x14.0x36.0 SB209 5052-H32</b>	1	Revised; holes added
BPR0000111	BRC FORM .250x4.19x8.75x8.75 2B 1L DS	1	
BPR0000112	BRC FORM .250x4.19x8.75x8.75 2B 1L CBS	1	
EXT0070650	BPR 95.75 6061-T6	1	
BLT0400044	\$1/2-13x1.75 CARRIAGE 18-8	4	
NUT0400014	\$1/2-13 HEX 18-8	4	
WSH0400010	\$1/2 LK 18-8	4	
<b>BLTZP00302</b>	<b>7/16-14x2.00 HEX GRD8 CS ZP</b>	18	new
<b>BLTZP00301</b>	<b>7/16-14x1.50 HEX GRD8 CS ZP</b>	2	new
<b>NUTZP00129</b>	<b>7/16-14 HEX NYL INSR LNUT GRD8 ZP</b>	20	new
<b>WSH0400237</b>	<b>7/16x1.12OD FLT 18-8</b>	40	new
<b>BLTZP00198</b>	<b>1/2-13x2.00 HEX GRD8 CS ZP</b>	6	Qty was 26
<b>NUTZP00078</b>	<b>\$ 1/2-13 HEX NYL INSR LNUT GRD8 ZP CS</b>	6	Qty was 26
<b>WSH0400011</b>	<b>\$1/2x1.250OD FLT 18-8</b>	20	Qty was 60

MYLAR FILM OR EQUAL  
REFLECTIVE TAPE

As needed:

<u>PN</u>	<u>DESC</u>	1 trailer <u>QTY</u>
RIM0000135	BPR .187x4.00x4.00x88.00 2B 1L AS	1