

## **PROCEDURE FOR CHANGING THE GALVANIZED / STAINLESS STEEL REAR IMPACT GUARD (BUMPER)**

### **Parts supplied:**

- (1) Galvanized or Stainless Steel Bumper Assembly**
- (4) ¾" dia. X 1 ¾" length grade 8 bolts**
- (4) ¾" grade 8 hex head lock nuts**
- (8) ¾" hardened washers**
- (2) 1 1/2" dia. X 3" length solid steel stop bars**

### **Step No. 1 Take off current galvanized /bumper**

- Remove bolts and nuts that hold the bumper to rear frame structure (retain fasteners for use in installing new bumper)
- Remove the bumper



**Step No. 2** – Inspect attachment connections free of any damage –If any damage is found, document with pictures and description of damage and send to OEM prior to repair

## Step No. 3 Remove rear stop bar

- Cut stop bar off inside of the "Z" slider rail on both sides
- Grind surface smooth inside slider rail free of burrs
- Keep remainder part of stop bar in place welded on external side of slider rail – (as shown)

Cut bar in  
this section



Keep stop bar welded  
in place on outside of  
"Z" rail

## Step No. 4 Attach new bumper to rear frame

- Attach the bumper to rear frame structure with fasteners removed (3/4" diameter, grade 8 bolt, 3/4" lock nut, grade C and (2) hardened washers per each bolt and nut).
- Torque of the bolts should be at 223 lb.-ft.



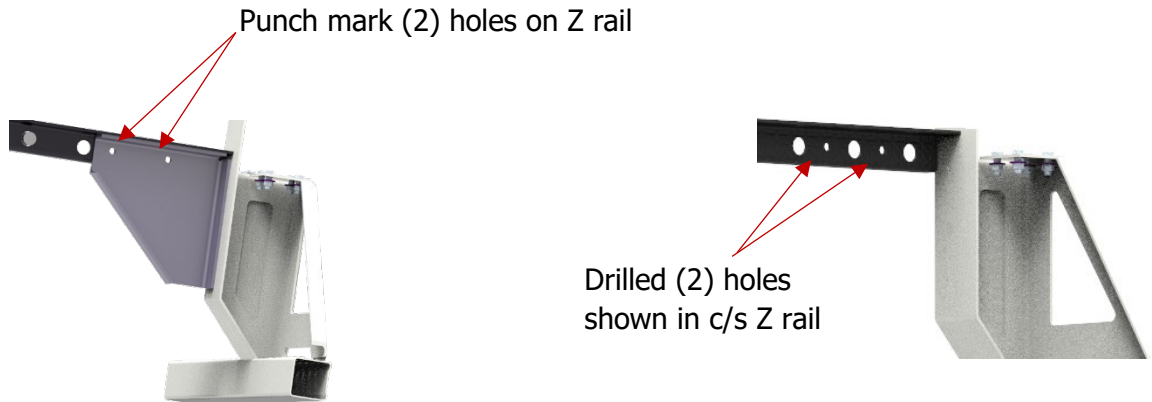
Bolt -3/4"  
Grade 8 and  
washer

Lock nut and  
washer



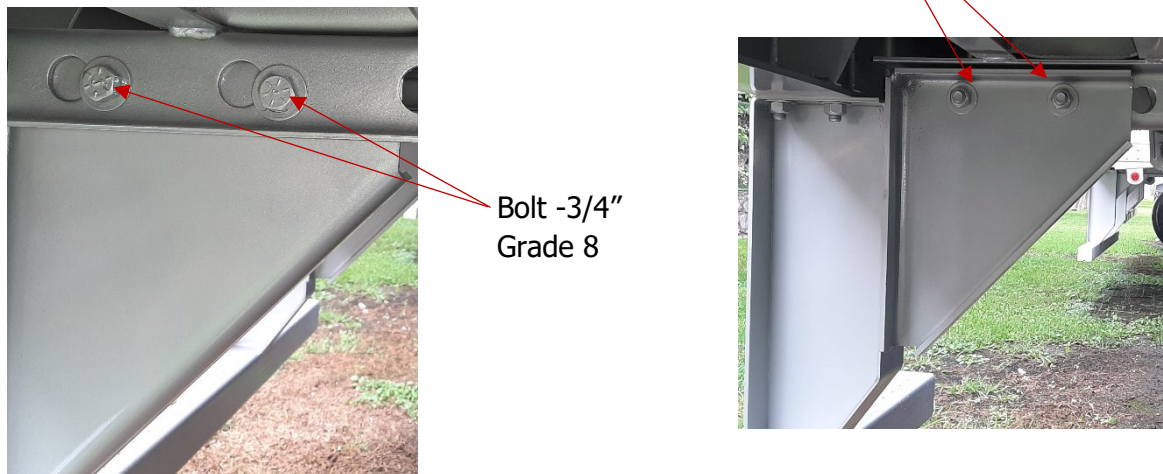
## Step No. 5 Drill (2) 13/16" diameter holes in each Z slider rail using reinforcement gusset as template.

- Use a reinforcement gusset as a template and punch mark inside of Z rail for hole locations
- Drill two 13/16" diameter holes per punch mark (both rails)



## Step No. 6 Attachment installation

- Attach the reinforcement gusset to each rail with a 3/4" diameter, grade 8 bolt, 3/4" lock nut, grade C and (2) hardened washers per each bolt and nut.
- Torque of the bolts should be at 223 lb.-ft.



Outside View

Inside view

## Step No. 7 Weld stop bar

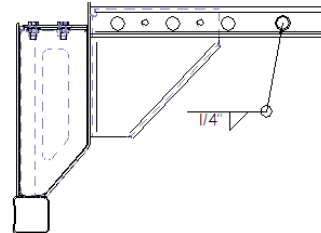
- Install the 1 ½" x 3" stop bar in the fourth hole from rear of the "Z rail" - each rail (see picture)



Stop bar

Weld all around the stop bar on outside of the "Z" rail

- Use steel welding ER-70S-6 or 7018



- Clean weld and surface and paint with polyurethane paint