



**2003-2016 CHEVY REAR BUMPER WITHOUT BRUSH GUARD
INSTALLATION INSTRUCTIONS**

Please read before beginning

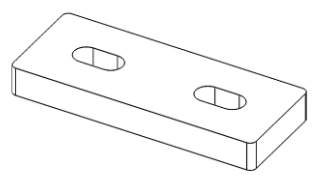
- *Stainless steel hardware may bind together when tightening—It is recommended that you apply an anti-seize assembly lubricant to the threads of each bolt before assembly*
- *This Installation requires 2 people*

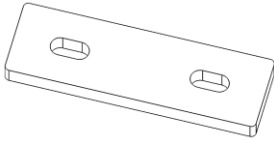


General Torque Values			
Size	Stainless Steel	Zinc	Grade 8
#6-32	10 lb-ft	--	--
#8-32	18.4 lb-ft	--	--
#10-32	26.6 lb-ft	--	--
1/4"-20	5.3 lb-ft	7.8 lb-ft	9 lb-ft
5/16"-18	10.9 lb-ft	16 lb-ft	18 lb-ft
3/8"-16	19.4 lb-ft	28.3 lb-ft	33 lb-ft
7/16"-14	31 lb-ft	45 lb-ft	52 lb-ft
1/2"-13	47 lb-ft	69 lb-ft	80 lb-ft
M6	4.7 lb-ft	5.8 lb-ft	--
M8	11.3 lb-ft	14.1 lb-ft	--
M10	22.3 lb-ft	27.9 lb-ft	--
M12	38.9 lb-ft	48.7 lb-ft	--

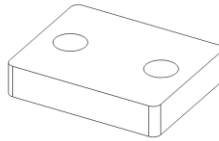
Included Hardware

- 70080 BOLT, SS, 1/2-13 x 2" Hex ----- 4
- 70035 WASHER, ZINC 1/2" ----- 8
- 70033 NUTS, SS, 1/2" Nylock ----- 4
- 70175 Bolt, Grade 8 – 7/16x2" ----- 8
- 70056 Nut Nylock Grade 8, 7/16 Nylock ----- 8
- 70057 Washer, 7/16 ----- 16
- 400503.4 KEYS ----- 1 (set)
- Hitch Spacers (large) ----- 2
- Hitch Spacers (medium) ----- 2
- Hitch Spacers (small) ----- 2





2X - Hitch Spacer (large)



2X - Hitch Spacer (medium)

2X - Hitch Spacer (small)

Installation Instructions

- Remove stock bumper
- Enlarge Frame Holes for 1/2" bolts. They are slightly under size. A file will do.
- Remove the 8 bolts holding on the hitch
- Place the 3/8" Spacers between the hitch and the frame and re-install using the 7/16" Hardware provided
- Mount the rear bumper:
 - Use the four 3/8-16 x 1 3/4" bolts to bolt the Aluminess bumper to the frame (two bolts per side).
 - Each bolt should have a 3/8" Zinc washer on both sides.
 - Each bolt should be held on with a 3/8" Nylock Nut.



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