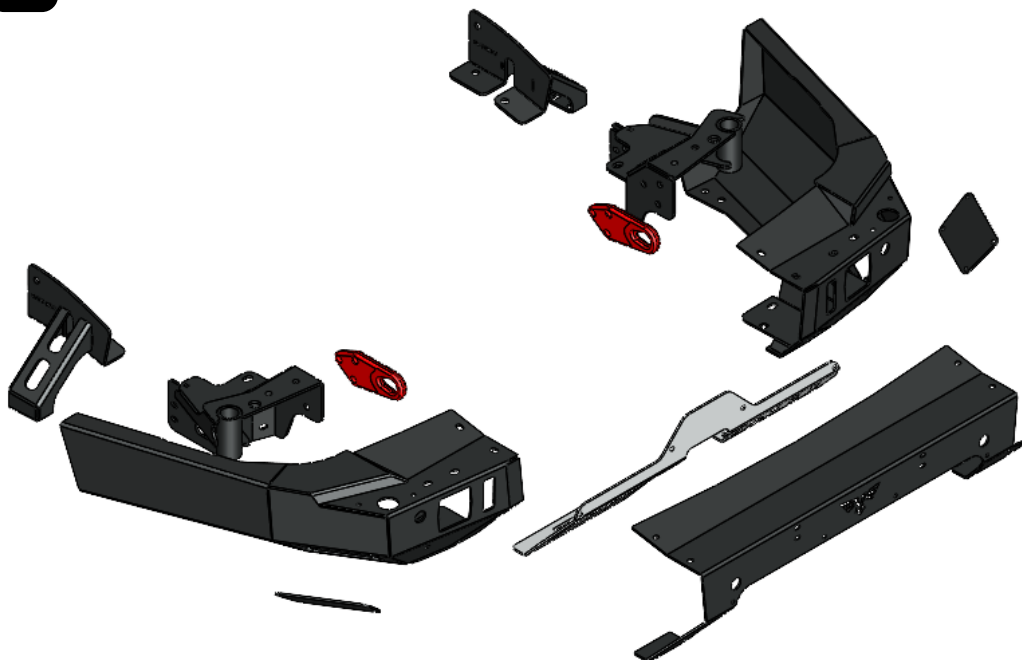


1



Included Parts:

2

Part	Description	Qty/Parent	Δ
040-0116	Zinc Plated Steel Flange Locknut 10-24 3/8" 7/32" 1/2" 0.07" part #94831A011	2.00000000	
040-0169	18-8 Stainless Steel Button Head Hex Drive Screw 10-24 Thread Size, 3/4" Long	2.00000000	
040-0174	Zinc Yellow-Chromate Plated Grade 8 Steel Washer for 1/2" Screw Size, 0.531" ID, 1.	2.00000000	
040-0186	18-8 S.S Nylon-Insert Locknut, 2-56 thread size	2.00000000	
040-0187	18-8 Stainless Steel Socket Head Screw	2.00000000	
040-0210	1/2"-13 Thread Size, 4-1/2" Long, Partially Threaded, Zinc-Plated, Medium-Strength	2.00000000	
040-0279	18-8 Stainless Steel Button Head Hex Drive Screws, Black-Oxide, 10-24 Thread Size,	2.00000000	
040-0280	Black-Oxide 18-8 Stainless Steel Mil. Spec. Washer, for Number 10 Screw Size, 0.20	2.00000000	
040-0281	Medium-Strength Grade 5 Steel Hex Head Screw, Zinc-Plated, 1/2"-13 Thread Size, 6	2.00000000	
035-0008	Rigid Plastic Locking Plug Fits 1-1/2" ID, 1-11/16" Head Diameter	4.00000000	
040-0123	Medium-Strength Steel Nylon-Insert Locknut, Grade 5, Zinc-Plated, 1/2"-13 Thread Si	4.00000000	
040-0264	Buna-N Rubber Grommets for 1-1/16" Hole Diameter and 3/16" Material Thickness, 3/	4.00000000	
040-0020	5/16-18 SERR FLANGE NUT HARD & TRV ZNC	6.00000000	
040-0035	1/2 USS FLAT WASHER TRIV ZNC	6.00000000	
040-0198	18-8 Stainless Steel Button Head Hex Drive Screws Black-Oxide, 5/16"-18 Thread Si	6.00000000	
040-0200	18-8 Stainless Steel SAE Washer	6.00000000	
040-0208	Zinc-Plated Steel Thread-Cutting Screws for Metal External Hex Drive, 1/2"-13 Threa	6.00000000	
040-0019	1/2-13 SERR FLANGE NUT	8.00000000	
040-0025	1/4"-20 Thread Size, Medium-Strength Steel Serrated Flange Locknut	8.00000000	
040-0026	3/8-16 SERR FLANGE NUT HARD & ZNC	8.00000000	
040-0127	Button Head Hex Drive Screws, Zinc-Plated Alloy Steel, 1/2"-13 Thread, 1" Long	8.00000000	
040-0178	18-8 Stainless Steel Button Head Hex Drive Screws Black-Oxide, 3/8"-16 Thread Siz	8.00000000	
040-0275	3/8" Mil. Spec. Washer, Black-Oxide 18-8 Stainless Steel, 0.406" ID, 0.812" OD	8.00000000	
040-0118	JIS High-Strength Steel Flanged Hex Head Screws	10.00000000	
040-0147	Black-Oxide 18-8 Stainless Steel Mil. Spec. Washer, Passivated, 1/4" Screw Size, MS	16.00000000	
040-0148	Black Oxide 18-8 Stainless Steel Button Head Hex Drive Screws, 1/4"-20 Thread Size	16.00000000	

Included Hardware:



INST: VGX55RS-PC

Feedback?



3

Link to camera relocation install guide.

<https://gembadocs.com/stdop/pdf/54dc17995-172f442ab4e2-1774874372>

4

NOTE: Check the video on the product page for the video detailing the dissassembly and cut of the factory bumper.



5



With the factory bumper cut and fastened back on the vehicle, bumper installation can begin. Start with the steel mounts labeled 1L and 1R. Place the mount onto the frame and loosely secure it in place using the provided M8 bolts as shown. Be sure to slip the spacer (labeled SP) between the outside of the frame and the inside of the mount and line the holes up. Repeat on the other side.

6



With the mounts loosely in place, use an angle finder to position the top of the mount so that it is parallel with the center of the frame. Tighten all bolts into place, making sure that the mount remains close to parallel throughout. This may require loosening and re-tightening some hardware to dial it in. Anything under half a degree will be fine.



7



Grab the mounts labelled 2L and 2R. Loosely install the first one onto the frame as shown. Use the 1/2"-13 x 4-1/2" bolt to pass through the existing hole frame. Make sure to use a washer between the bolt head and mount on the outside and a square washer followed by a washer followed by a flange nut on the inside of the frame, in that order. Repeat on the other side.

8



With the mounts in place, the wings can be installed. Slide the wing over the top of mount 1. Loosely secure it in place using the 1/2" button head down through the top.



9



Align the holes in the front of the wings with the holes in the mount 2 and loosely mount them together using more of the 1/2" button heads.

10



Insert the provided 1/2"-13 x 6-1/2" bolt up through the bottom of the wing and frame with a washer on the head. Pass it through the frame and fasten a washer and nylock nut on top.



11



A square hole is located near the mounting hole to help position the bump with, if necessary. A pry tool or screw driver can be inserted through that hole and into the frame to pry against and act as a guide to assist with installing the bolt.

12



With all hardware loosely in the wing, adjust the position until it is satisfactory and then tighten the hardware. The main thing to keep an eye on prior to tightening is that the hole in the wing for the spindle is aligned with the hole in the spindle sleeve on mount 1. Repeat on the other side.



13



With the wings in place slide the D-Ring through the slot from the inside and secure it using the 1/2"-13 x 2-1/4" bolts and nylock nuts. Use a yellow washer on the head side as well as the nut side of the bolt. Make sure the D-Ring is centered vertically in the slot and then tighten the hardware fully. Repeat on the other side.

14



Before installing the center section, mount the grey accent panel to the inside of the center shell as shown using the 5/16" hardware.



15



Install the rubber grommets into each of the large holes in the bumper. There are two in the center section and one in each wing.

16



Insert the back up sensors into the grommets on the center section as shown. Double check that each is on the correct side by comparing the connectors to the ones on the vehicle.



17



Slide the center section onto the wings and install the 3/8" hardware to secure them together. Be careful to not clamp the harnesses for the back up sensors between the pieces of the shell. Center it on the vehicle and then tighten all hardware into place.

18

The hardware through the top of the shell can be accessed from under the vehicle, over the top of the frame. The hardware through the access holes in the side of the bumper.



19



With everything in place, center punch the holes in the bottom of mount 2 and then drill them out to 7/16" to accept the 1/2 self tapping bolts. It is best to start with a smaller drill bit and work up to the 7/16". Repeat on both sides.

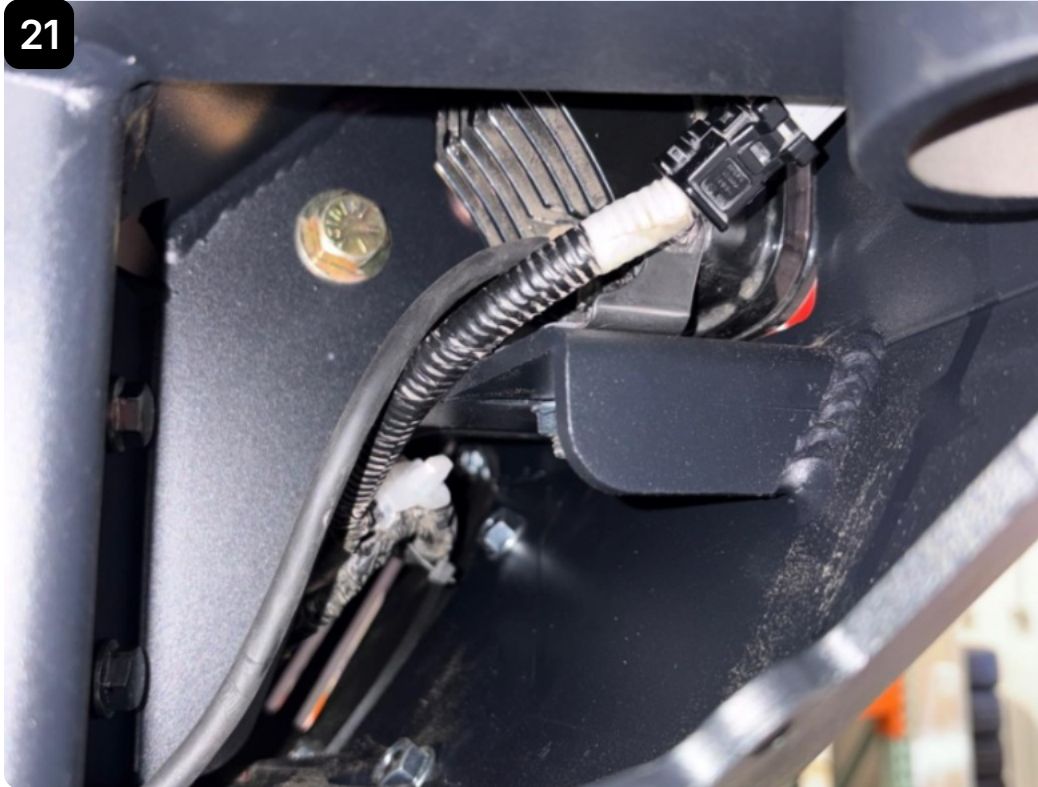
20



Once the holes are drilled, install the 1/2" self tapping bolts and tighten them fully.



21



Route the backup sensor under mount 1 and insert it into the grommet in the wing through the access hole as shown.

22



With the bumper installed, now is the best time to install lights if doing so. Slide the light in through the back and mount it to the tab inside the bumper. The holes in the bumper are sized so that the majority of lights can be installed this way but it may be more difficult with some than others.



23



Once all hardware is tight and access to the inside of the bumper is no longer required, install the cover panels from the inside of the bumper using the 1/4" hardware as shown.

24



If not installing carriers, pop the plastic caps into the top and bottom of the spindle sleeve. It is best to put some RTV sealant on the caps prior to popping them in. This helps to protect the spindle sleeve from corrosion in case carriers are desired in the future.



INST: VGX55RS-PC

Feedback?



25

**Thank you for supporting
American-made. We hope you
enjoy your new product!**

If you have any questions or concerns
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