Step 1 GX460 DIY Front Bumper Install Instructions





Step by step on how to install the GX460 DIY Front Bumper. Please read all steps carefully before starting the install.

Questions or Support:
Phone: 269-353-1184
Email: info@victory4x4.com

Step 2 Included Parts



Check that you have all of the parts shown before starting.

Step 3 Included Hardware

046-0105 BOLT PACK

VGX46FS-BP • Bill of materials (per 1 bag)

PIECES / BAG 143

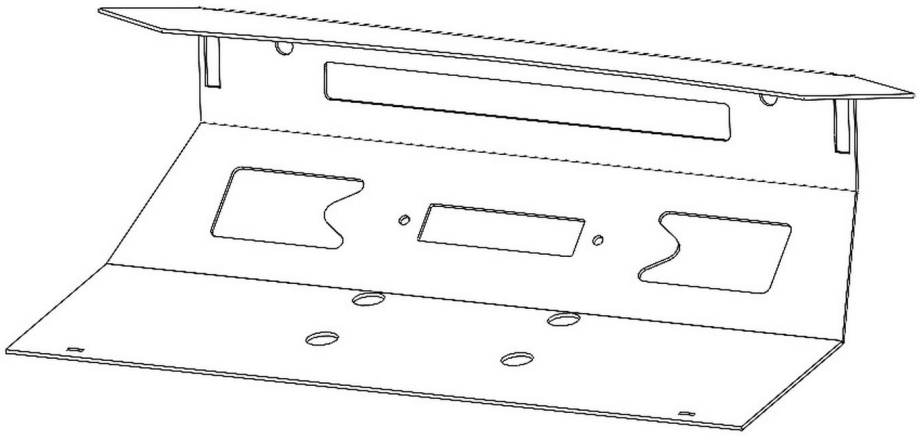
1	8	040-0163 M10-1.25 x 30 FLANGED HEX CAP	13	4	040-0019 1/2-13 SERR FLANGE NUT
2	8	040-0002 3/8 USS FLAT WASHER ZNC	14	4	040-0148 1/4-20 x 3/4 BUTTON HD SOC CAP 18-8 SS BLK
3	14	040-0278 3/8-16 x 1 BUTTON HD SOC CAP 18-8 SS BLK	15	4	040-0147 1/4 MIL-SPEC FLAT WASHER 18-8 SS BLK
4	8	040-0004 3/8-16 x 1 HEX CAP GR5 ZNC	16	4	040-0025 1/4-20 SERR FLANGE LOCKNUT GR5 ZNC
5	8	040-0014 5/16 USS FLAT WASHER ZNC	17	4	040-0194 8-32 x 1-1/2 BUTTON HD SOC CAP 18-8 SS BLK
6	22	040-0026 3/8-16 SERR FLANGE NUT HARD ZNC	18	4	040-0114 8-32 NYLON LOCKNUT ZNC
7	3	040-0199 5/16-18 x 1 BUTTON HD SOC CAP 18-8 SS BLK	19	4	040-0244 #8 x 3/8 NYLON SPACER
8	3	040-0020 5/16-18 SERR FLANGE NUT HARD ZNC	20	4	065-0041 7/8 RUBBER GROMMET
9	3	040-0200 5/16 SAE FLAT WASHER 18-8 SS BLK	21	4	035-0036 7/8 LOCKING PANEL PLUG BLK
10	2	040-0040 1/2-13 x 1-1/2 HEX CAP GR5 ZNC	22	14	040-0275 3/8 MIL-SPEC FLAT WASHER 18-8 SS BLK
11	2	040-0035 1/2 USS FLAT WASHER ZNC	23	2	065-0046 AMBER LED MARKER LIGHT
12	2	040-0127 1/2-13 x 1 BUTTON HD SOC CAP ZNC	24	8	040-0276 #8 MIL-SPEC FLAT WASHER 18-8 SS BLK

Set bins out in this order • One bag at a time • Gold = zinc • Black = black finish

Odoo BOM link in description

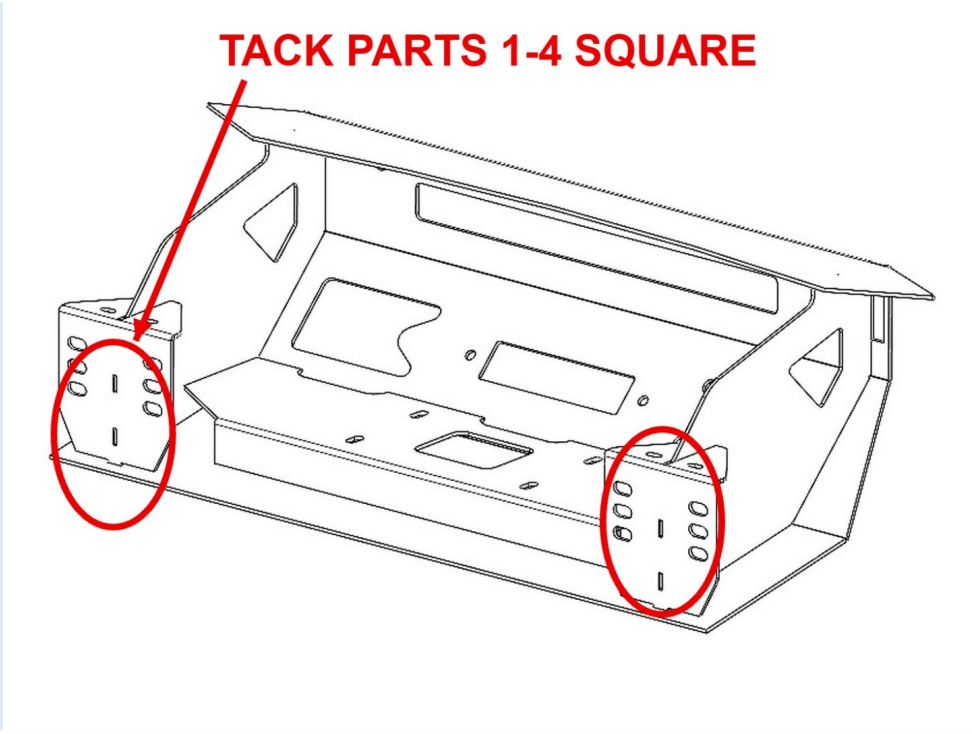
Check that you have all of the hardware shown before starting.

Step 4 Bend Parts



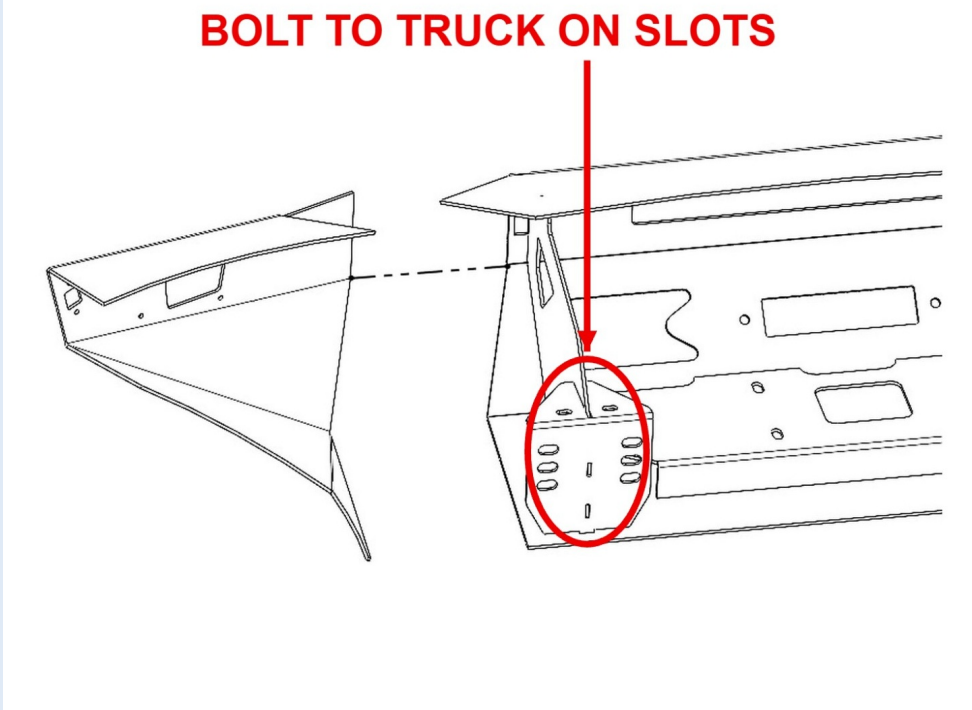
Each bend angle is etched on its part along the slit lines. Bend all parts to the called out angles. There are 2 part 5s and 2 part 6s, lefts and rights, which must end up as mirror images of each other.

Step 5 Tack Center Section



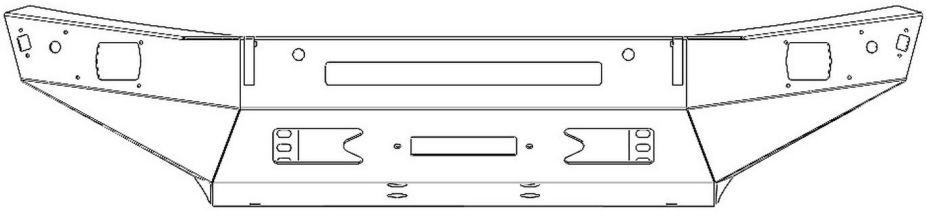
Tack weld and assemble parts 1, 2, 3, and 4 using the tabs, keeping everything square to one another. This forms the center section shell.

Step 6 Test Fit Center



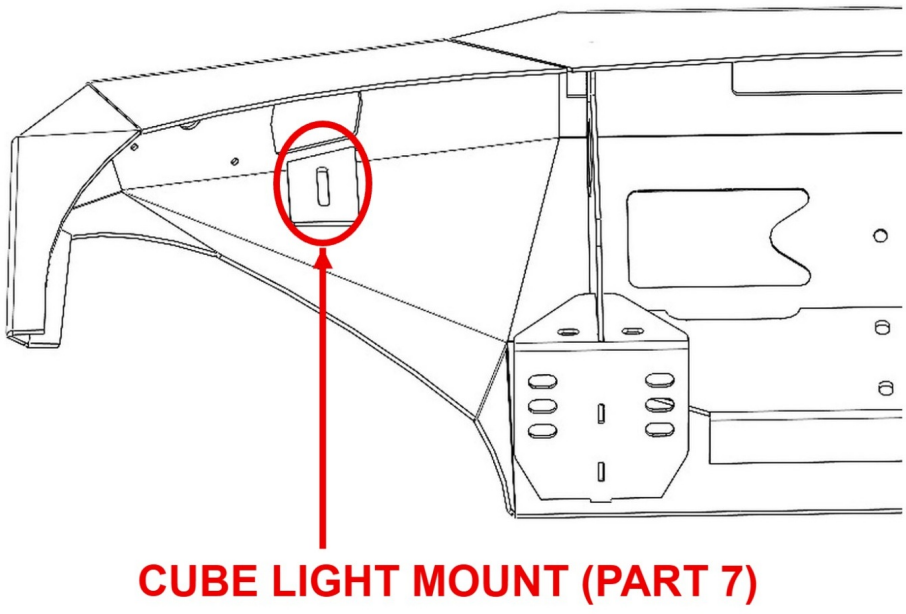
Loosely bolt the tacked center section onto the truck, centered on the slots, and snug the bolts. Using the headlights, grille, and fenders as reference, tack on parts 5 and 6 on both sides, working from the center out. Keep a uniform 3/8 to 5/8 inch gap to the body.

Step 7 Weld Seams



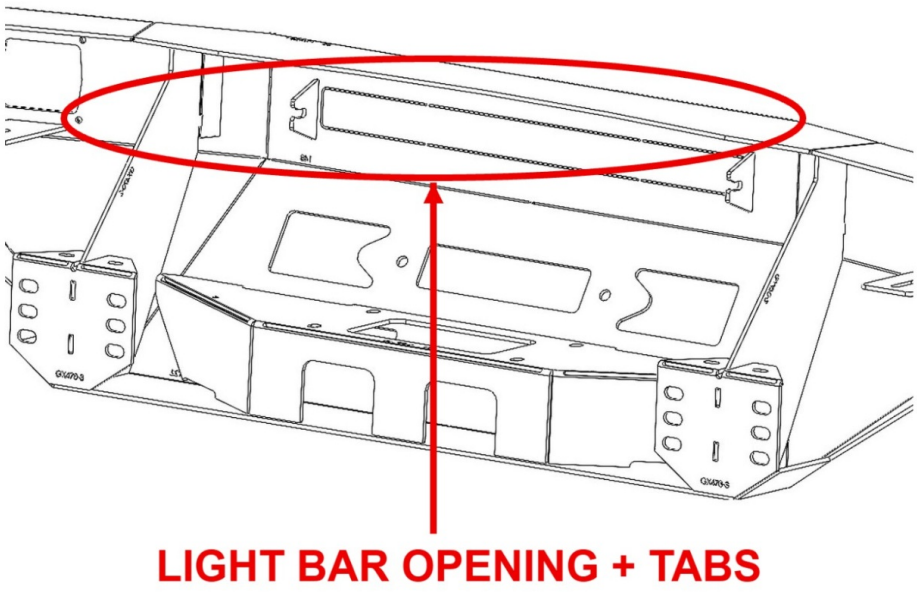
Fully weld the seams. Heat can warp the bumper, so weld some of it while mounted on the vehicle. If you remove it, jump between locations to spread the heat, and clamp a rigid straight edge across the top of the wings to resist warping.

Step 8 Weld Cube Light Mounts



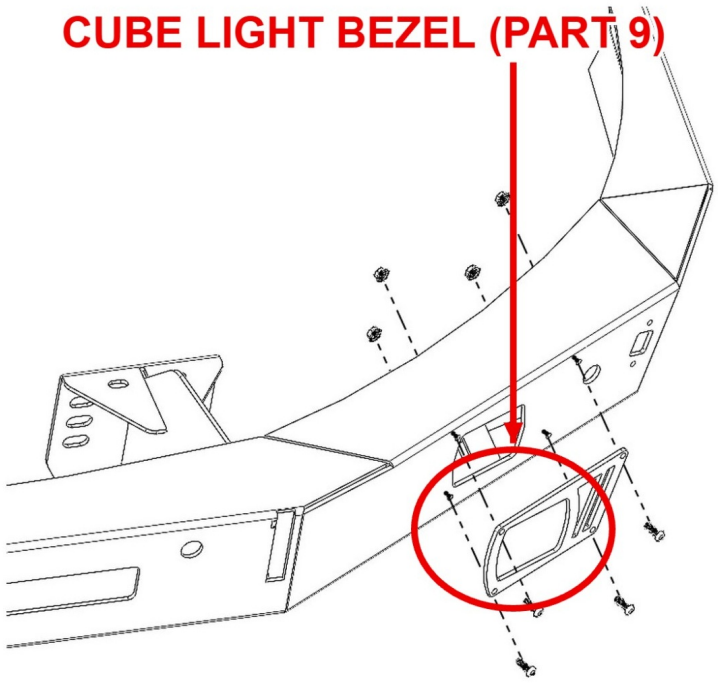
Pick your cube lights to set the mount height, then weld the cube light mounts (part 7) centered under the cube light cutouts on each side of the bumper.

Step 9 Light Bar Option



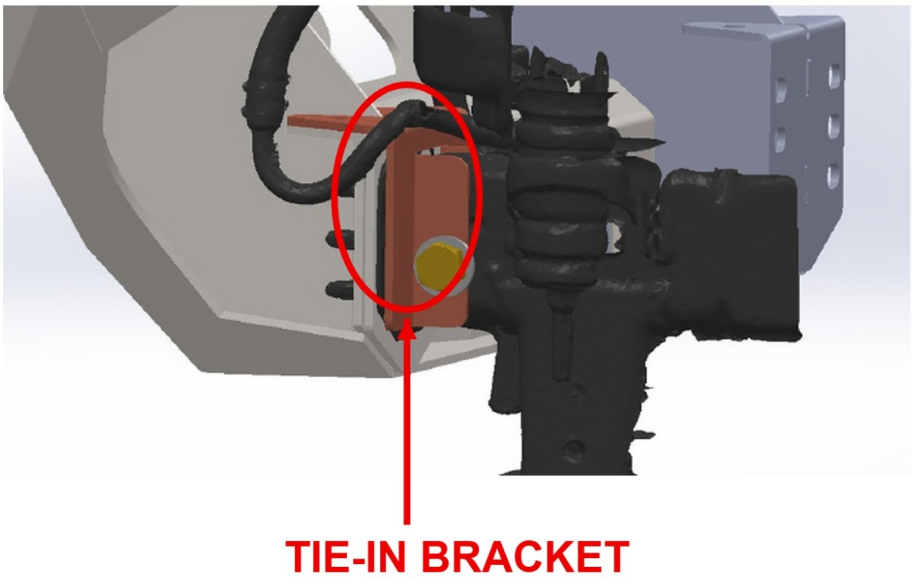
Running a light bar: cut out the rest of the opening, loosely assemble the tabs (part 8) to the light, center it, tack the tabs, then remove the light before fully welding them. No light bar? Weld and grind the cutout closed. Bolt the amber marker lights inside each side and tie them into the factory turn signals.

Step 10 Install Light Bezels



Bolt the two cube light bezel pieces (part 9) around the cube light cutouts using the provided hardware. This is also the time to put the parking sensors back into the small round cutouts, 4 per side.

Step 11 Install Tie-In Brackets



Weld the bend line, then place the tie-in brackets over the frame horns. With the bumper back on the vehicle, put the supplied bolts through the top of the brackets to locate them, drill a 5/8 hole through each bracket and frame rail, and touch up bare metal with paint.

Step 12 Install D-Rings



Insert the D-ring shackles through the back of the bumper and square them up. Tack them first to confirm the look and fit, then fully weld them down.

Step 13 Installation Complete



Confirm all hardware is tightened. Congrats! Your installation of the GX460 DIY Front Bumper is now complete. Enjoy!