



## 2003-2010 CHEVY REAR BUMPER INSTALLATION INSTRUCTIONS

### HARDWARE:

- 300196 STRAP SS, (2) Two 3/8" hole on one side and one 3/8" hole on the other.
- 70080 BOLT, SS, 1/2-13 x 2" Hex (4)
- 70035 WASHER, ZINC 1/2" (8)
- 70033 NUT, SS, 1/2" Nylock (4)
- 70029 BOLT, SS, 3/8-16 x 1 1/4" (2)
- 70028 WASHER, SS, 3/8" Flat (4)
- 70013 BOLT, SS, 1/4-20 x 1" Flat Socket Cap (4)
- 70009 WASHER, SS, 1/4" Flat (4)
- 70008 NUT, SS, 1/4-20 Nylock (4)
- 400503.4 KEYS



### NOTES:

The hardware is mostly Stainless Steel and will bind to the nut if you do not put some kind of lubricant on the threads (wax, never cease, etc.)

This procedure requires 2 people.

- Remove stock bumper
- Enlarge Frame Holes for 1/2" bolts. They are slightly under size. A file will do.
- Remove rear taillights on van – remove exposed 10mm nuts from tail light and upper plastic panel.
  - Plastic panel must be removed to access taillight nut.
- 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" Znc washer on both sides.
    - Each bolt should be held on with a 3/8" Nylock Nut.

### NOTE:

**The swing arms must be closed and latched to properly install the bumper.**

**The straps from the door hinge to the standing pivot pole must be installed with the swing arms latched.**

**The straps keep the swing arms in alignment.**

- Strap Installation
  - With the rear bumper bolted to the frame and the tail light removed place the straps on top of the standing pivot pole and on top of the door hinge.



- Install the 3/8-16 x 1 1/4" bolts through the strap and into the pole. (See picture below)
  - 3/8" Flat Washers should be between the head of the bolt and the strap, and the strap and the bumper pole.
- Provide some outward pressure to the pole when marking the door hinge holes.
  - This step preloads the swing arm for the weight of the spare tire & box.
- Drill two 1/4" holes through the door hinge AND the already existing holes in the strap.
- Mount the strap to the bottom side of the hinge so it will not interfere with the taillight.
- Install the 1/4-20 x 1" bolts from the bottom up i.e. upside down so the nuts are on the top.
  - The head of the bolts should have no washers on them.
  - The nut side should have a 1/4" flat washer and a 1/4" nylock nut.
- Replace the tail light.
- This process is required for both sides.

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**The straps keep the swing arms in alignment.**

