



## #C9919 Installation Instructions 1992-1998 Chevy/GM SUV 1500/2500 2/4wd Rear 3" Bumper Bracket Kit

### **Read and understand all instructions and warnings prior to installation of product and operation of vehicle.**

Zone Offroad Products recommends this system be installed by a professional technician. In addition to these instructions, professional knowledge of disassembly/ reassembly procedures and post installation checks must be known. Minimum tool requirements include the following: Assorted metric and standard wrenches, hammer, hydraulic floor jack and a set of jack stands. See the "Special Tools Required" section for additional tools needed to complete this installation properly and safely.

---

#### » **PRODUCT SAFETY WARNING**

Certain Zone Suspension Products are intended to improve off-road performance. Modifying your vehicle for off-road use may result in the vehicle handling differently than a factory equipped vehicle. Extreme care must be used to prevent loss of control or vehicle rollover. Failure to drive your modified vehicle safely may result in serious injury or death. Zone Offroad Products does not recommend the combined use of suspension lifts, body lifts, or other lifting devices.

You should never operate your modified vehicle under the influence of alcohol or drugs. Always drive your modified vehicle at reduced speeds to ensure your ability to control your vehicle under all driving conditions. Always wear your seat belt.

#### **Difficulty Level**

easy 1 (2) 3 4 5 difficult

Estimated installation: 1 hour

#### **Special Tools Required**

Reciprocating Saw or Equivalent

---

#### » **PRE-INSTALLATION NOTES**

1. Special literature required: OE Service Manual for model/year of vehicle. Refer to manual for proper disassembly/reassembly procedures of OE and related components.
  2. Adhere to recommendations when replacement fasteners, retainers and keepers are called out in the OE manual.
  3. Larger rim and tire combinations may increase leverage on suspension, steering, and related components. When selecting combinations larger than OE, consider the additional stress you could be inducing on the OE and related components.
  4. Post suspension system vehicles may experience drive line vibrations. Angles may require tuning, slider on shaft may require replacement, shafts may need to be lengthened or trued, and U-joints may need to be replaced.
  5. Secure and properly block vehicle prior to installation of Zone Offroad Products. Always wear safety glasses when using power tools.
  6. If installation is to be performed without a hoist, Zone Offroad Products recommends rear alterations first.
  7. Due to payload options and initial ride height variances, the amount of lift is a base figure. Final ride height dimensions may vary in accordance to original vehicle attitude. Always measure the attitude prior to beginning installation.
-

## Kit Contents

Qty	Part
1	Rear Bumper Bracket (drv)
1	Rear Bumper Bracket (pass)
2	1/4" Thick Spacer
2	Rear Bumper Support Bracket
2	7/16" Nut Tab
1	Bolt Pack



## » INSTALLATION INSTRUCTIONS

1. Disconnect license plate lights and any other existing wires from rear bumper.
2. Disconnect the outer support brackets from the bumper **Figure 1**.



Figure 1

3. Support the rear bumper so that it does not fall when the mounting bolts are removed. Remove the four bolts on each that attach the bumper to the vehicle. **Figure 2**. Remove the bumper from the vehicle. Save hardware.



Figure 2

4. Remove rear-most body mount bolts, washers and bushings. Save hardware.
5. Make a vertical cut mark that is in-line with the vertical edge of the bottom notch in the frame rail. This mark should be approximately 3-7/8" from the rear-most edge of the frame rail **Figure 3**.

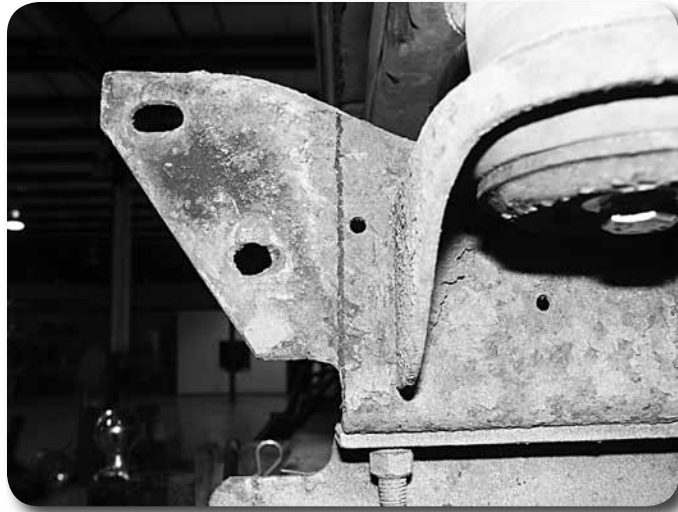


Figure 3

6. Cut the end of the frame rail off along the line with a reciprocating saw or cut-off wheel **Figure 4**. Paint any exposed metal to prevent rust. There may be a ground wire(s) running to the driver's side frame near the cut line. Disconnect the wire(s) before making the cut **Figure 5**.

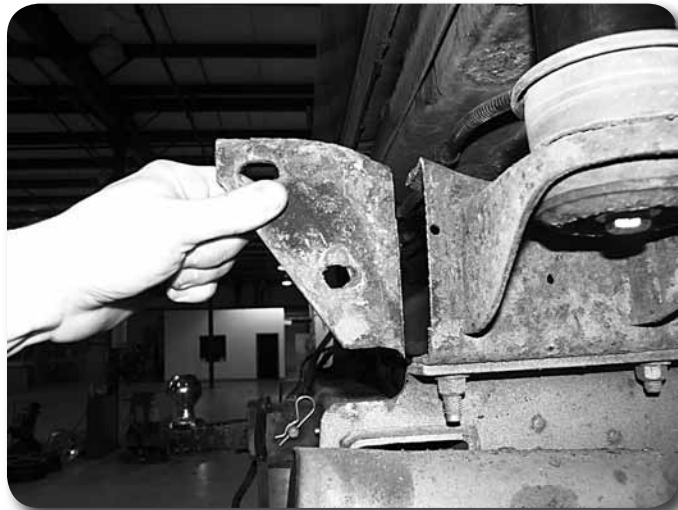


Figure 4

7. Locate the existing hole in the rear surface of the body mount **Figure 5**. Drill hole out with a 5/16" bit.

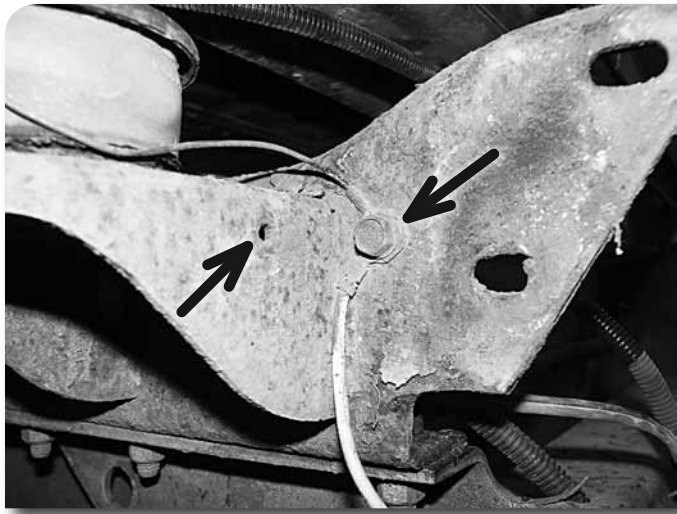


Figure 5

8. Locate a similar hole in the frame rail just to the front of the body mount **Figure 6**. Drill hole to 7/16". There may be a ground wire attached at this hole location on the driver's side of the vehicle. If this is the case, disconnect the wire. It will be relocated later.

**Step 8 Note**  
Check inside frame rail for wires, etc before drilling

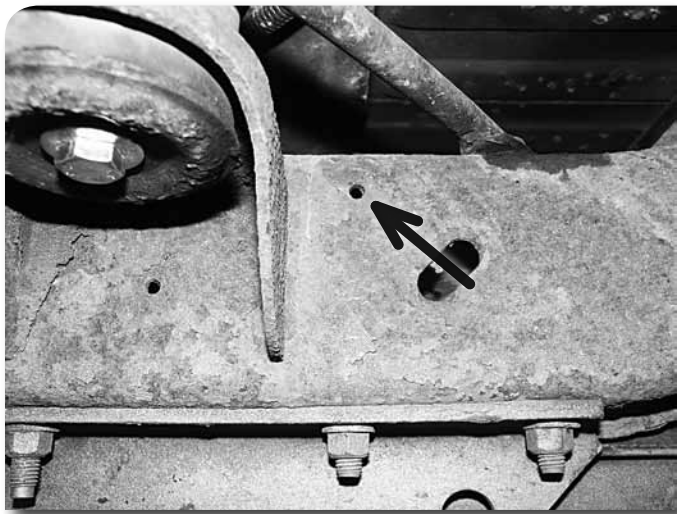


Figure 6

9. Cut out the provided drill template at the back of this instruction sheet. Place the template inside the rear frame mount as instructed on the template and mark the hole location. Drill a 1/2" hole at the mark..
10. Position the new driver's and passenger's side bumper brackets on the frame (over the body mount) so that the holes that were just drilled line up with the slots in the new brackets.
11. Install a 3/8" x 1" self-tapping bolt and 3/8" USS washer in the top hole (on the back edge of the body mount) that was just drilled to 5/16". Leave bolt loose.
12. Install a 7/16" x 1-1/4" bolt and 3/8" washer in the 7/16" hole drilled in the frame. Before installing the bolt, place a provided 1/4" thick spacer washer between the bumper bracket and the frame. Fasten the bolt with the provided 7/16" nut tab. Leave bolt loose.
13. Install a 7/16" x 1-1/4" bolt, nut and 3/8" USS washers in the 1/2" hole that was drilled in the body mount. Leave bolt loose.

14. Adjust the bracket so that the 3/8" self-tapping bolt is centered in the slot. Using the bracket as a template, mark the center of the slot just below the one with the self-tapping bolt. Drill a 3/8" hole at the mark and install a 3/8" x 1" bolt, nut and 3/8" USS washer. Leave hardware loose **Figure 7**.



Figure 7

15. Repeat the bumper bracket installation on the opposite side of the vehicle.
16. Note which end is the bottom on the factory bumper side supports and remove them from the frame. Save mounting hardware.
17. Cut bottom mount (end with welded nut) from side support within 1/4" of connecting rod **Figure 8**.



Figure 8

18. Install the provided outside bumper bracket inside the bumper with 7/16" x 1-1/4" bolts, nuts and 3/8" USS washers at the upper and lower mounting positions **Figure 9**. Repeat for other side.



Figure 9

19. Reinstall side supports to the frame with the sides reversed, such that the passenger's side is on the driver's side. The brackets will need to be flipped over (cut is pointing up). Loosely attach the brackets to the frame rail with the factory bolts.
20. Install the bumper on the vehicle so that the new bumper brackets mount to the outside of the inner bumper frame. Attach the bumper to the brackets with the factory hardware. Leave hardware loose.
21. Attach the factory side supports to the new support bracket 7/16" x 1-1/4" bolts, nuts and 3/8" USS washers. Leave hardware loose.
22. Adjust the bumper using the measurements noted earlier and tighten all hardware beginning with the bumper bracket-to-frame hardware. Torque 3/8" hardware to 35 ft-lbs, 7/16" and factory hardware to 50 ft-lbs.
23. Reattach all ground wires. If the driver's side had ground wires that were disconnected, relocate them elsewhere on the frame using the provided 5/16" x 1" self-tapping bolt. Drill a 1/4" hole in an appropriate location and fasten the wire(s) securely with the 5/16" bolt.
24. Reinstall the rear body mount bolts, bushings and washers. Torque body bolts to 65 ft-lbs.
25. Check all hardware for proper torque.
26. Check hardware after 500 miles.

**Step 23 Note**  
 Check inside frame rail for wires, etc before drilling

