

Preparation:

- Disconnect the negative battery terminal. Park the vehicle on level ground and set the emergency brake.
- We recommend reading through the installation instructions in whole before performing the work.
- When button head bolts are being used, install the supplied washer on the nut side. Then, hold the bolt stationary and only turn the nut to tighten. Do not turn the bolt to tighten hardware assembly, unless otherwise noted.
- Estimated Installation Time: **3 Hours for OEM Removal/Bumper Installation**

1 Additional Hour to Wire Lights

*****This installation requires 2 people for best results*****

*****Labor Rates are based on a vehicle with no pre-existing damage. Wiring labor is based on a standard wiring procedure with light switches installed in an easily accessible location. Custom light triggering or switch mounting location will result in a greater labor charge.*****

You will need the following tools:

- | | | |
|----------------|-----------------|------------------------|
| - Ratchet | - 7mm Socket | - 10mm Socket |
| - 15mm Socket | - 17mm Socket | - Tape Measure |
| - Cutoff Wheel | - T-15 Torx Bit | - 3/4" Socket & Wrench |

Included in Kit:

- | | |
|--|--|
| 6 - Hex Head Bolts (M10-1.5 x 30mm) | 4 - Flat Washers (M10) |
| 2 - Wide Washers (M10) | 8 - Button Head Bolts (1/2-13 x 1 1/2") |
| 8 - Flat Washers (1/2") | 8 - Nylon Lock Nuts (1/2"-13) |
| 1 - Universal Light Mount Kit | 1 - Winch Mounting Plate |

Removal:

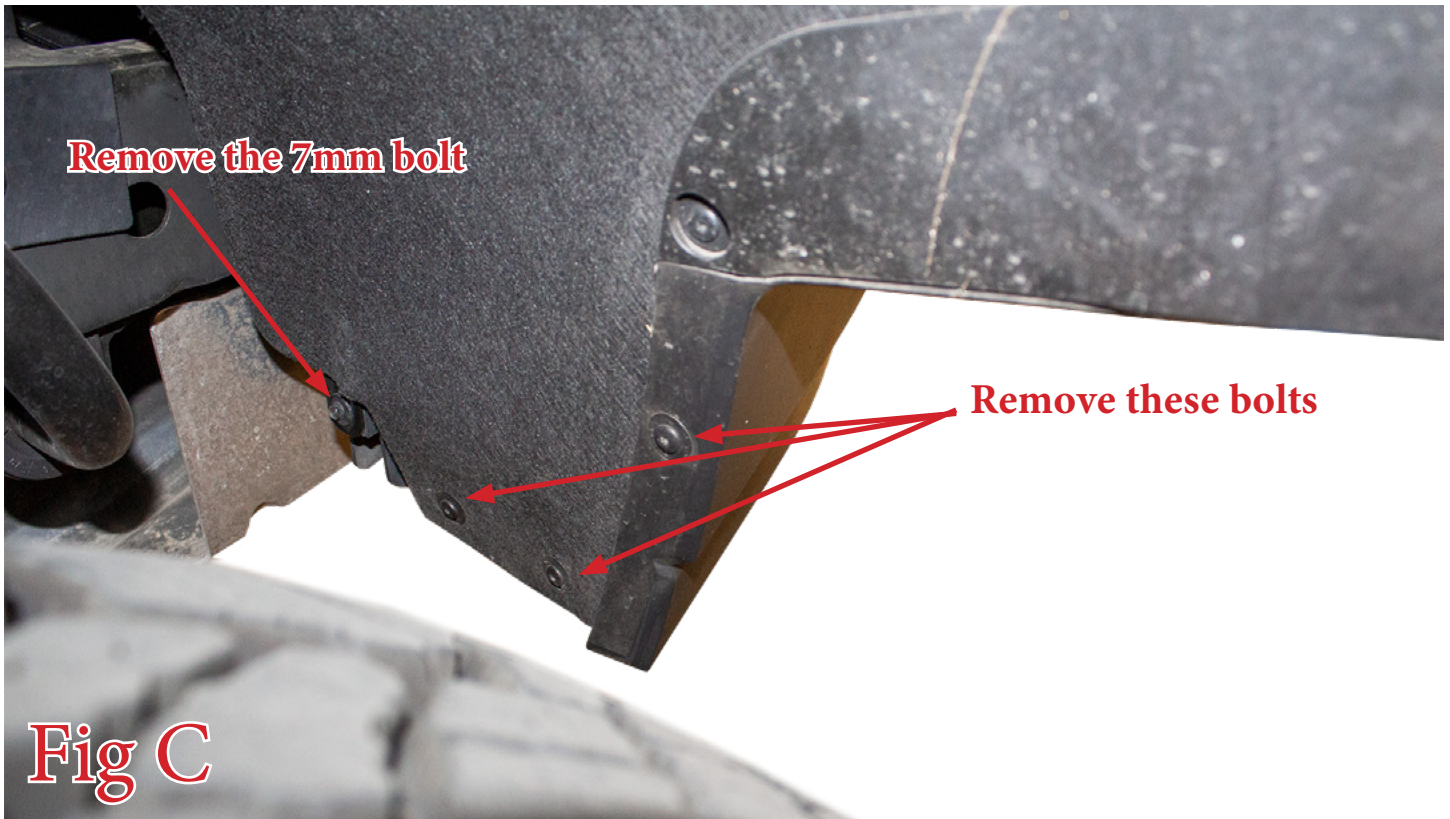
1. From underneath the vehicle, remove the 15mm (x4) bolts holding the skid plate to the vehicle. Remove the skid plate, then **reinstall the back two bolts**. (Fig A)



2. Using a T-15 Torx Socket, remove the lower bumper valance bolts (x14) referenced in (Fig B).



3. Inside each wheel well, use a T-15 Torx Socket to remove the 3 lower inner fender liner bolts. Then remove the 7mm bolt referenced in (Fig C).



4. In the front/center of the bumper, find the straight body line underneath the grille. Measure down 5/16" from that body line at several points. Then, connect those points together to make a straight line. (Fig D)

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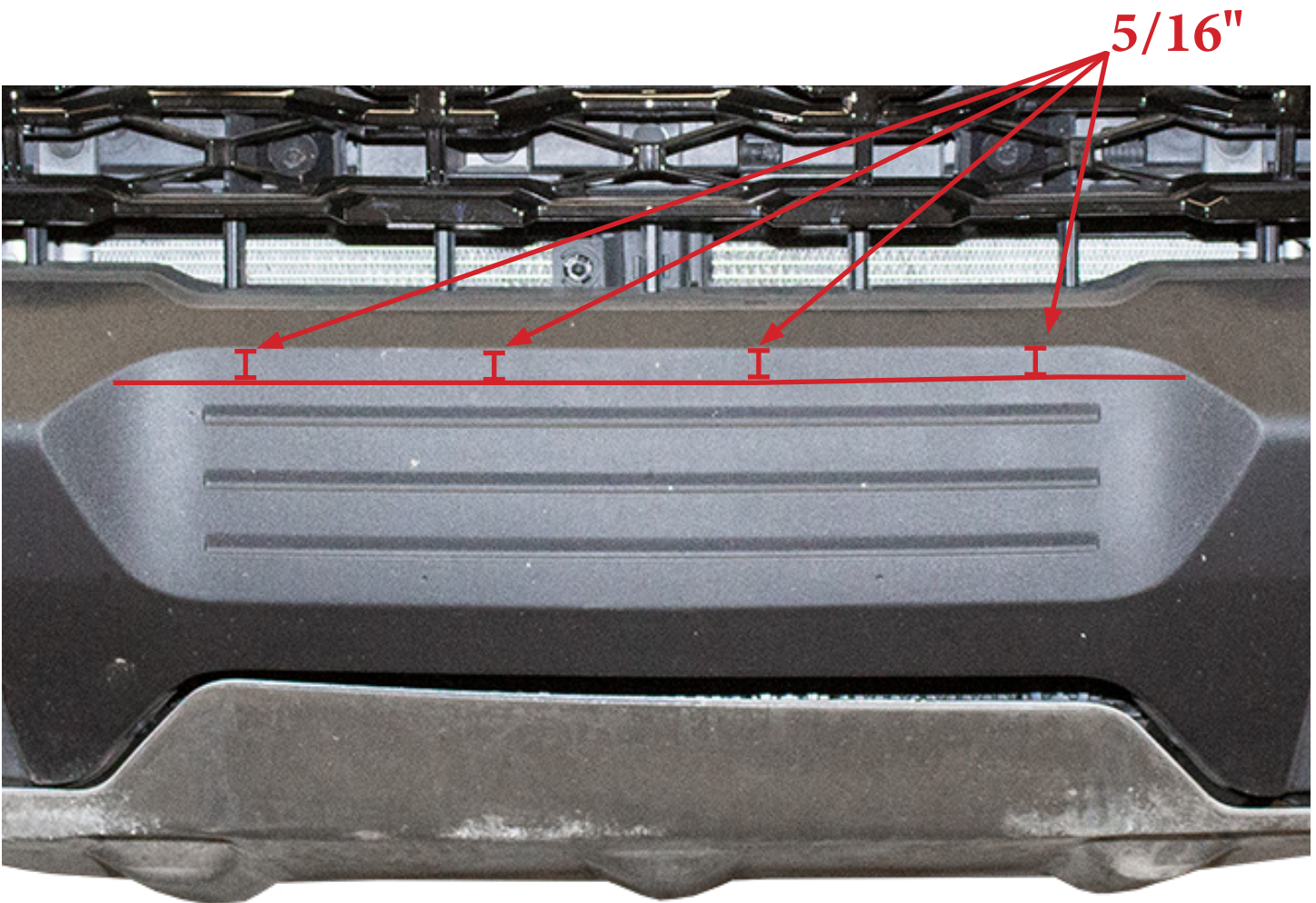


Fig D

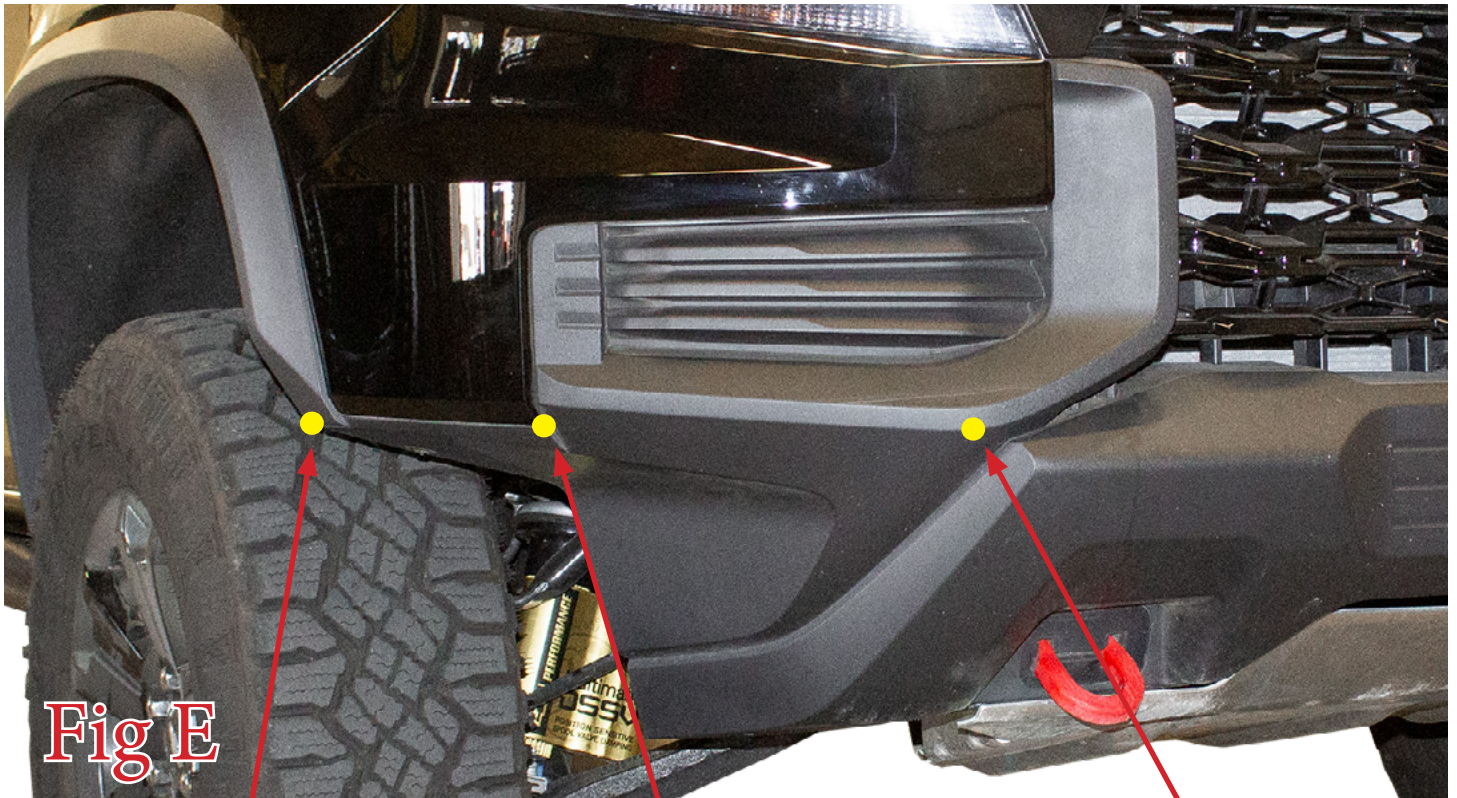
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5. Make a point at the 3 spots shown in (Fig E).

The first point is at the lowest point of the bodyline under the headlight.

The second point is where the painted part of the body meets the plastic in the lower part of the headlight bezel.

The third point is a the bottom/rear corner of the fender flare.



Point 3

Point 2

Point 1

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6. Take the line from Step 4 and continue it to both sides of the truck so that it intersects with the points made in Step 5. When you are done, your line will look like the line made in (Fig F).



Fig F

7. Cut along this line. (Fig G)

****WHEN YOU MAKE THE CUT, MAKE IT ABOUT 1/2" BELOW THE DRAWN LINE SO THAT AFTER THE CUT YOU CAN USE YOUR BUMPER TO FINE TUNE WHERE THE FINAL CUT WILL BE. AFTER THE INTIAL CUT, INSTALL YOUR BUMPER AND BRING THE LINE UP UNTIL IT LINES UP EVENLY WITH YOUR BUMPER.****



Fig G

8. Use a 15mm Socket to remove the bolts (x4) that hold on the bumper bar. Then, remove that bar. (Fig H)



Fig H

9. Cut off the bottom portion of the plastic shroud referenced in (Fig I).

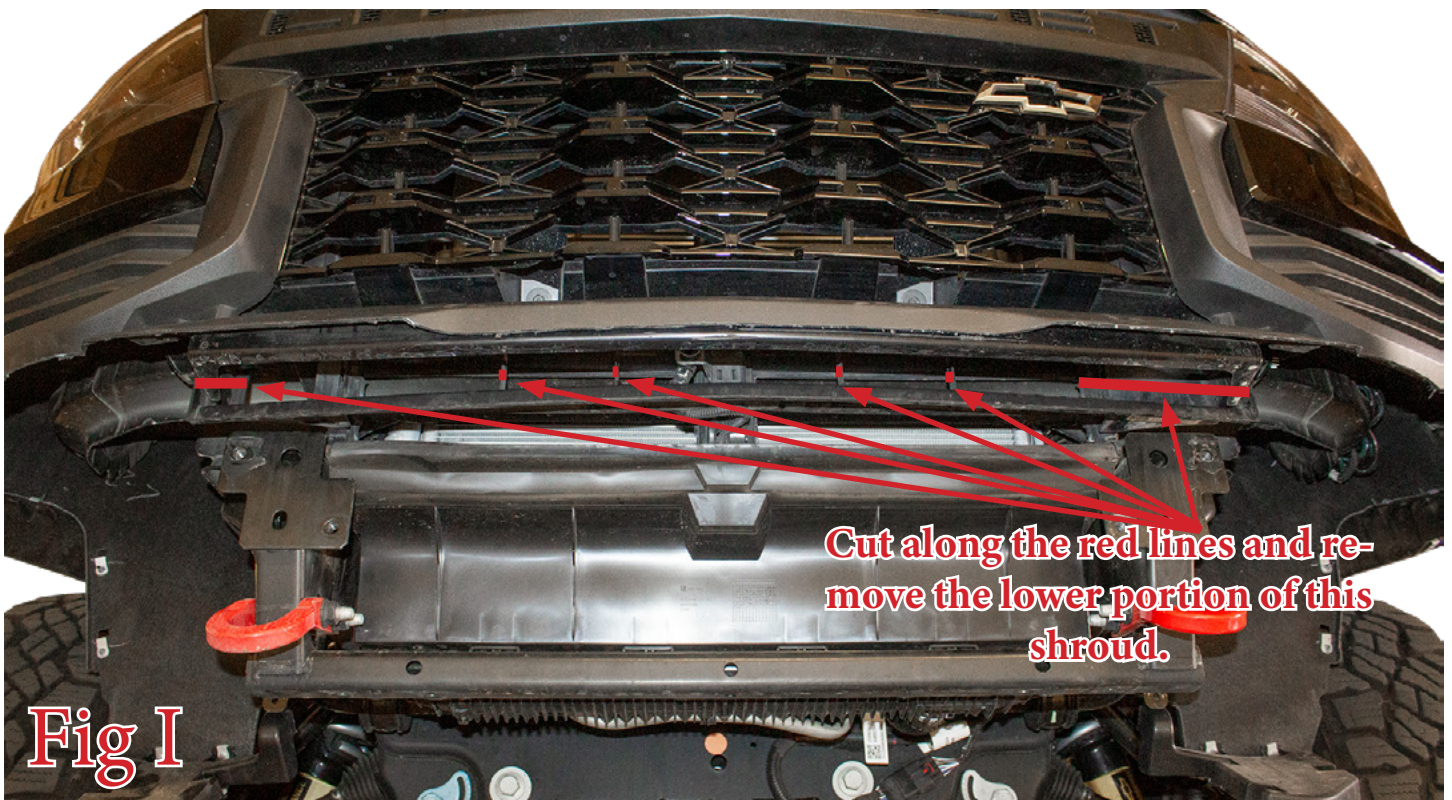
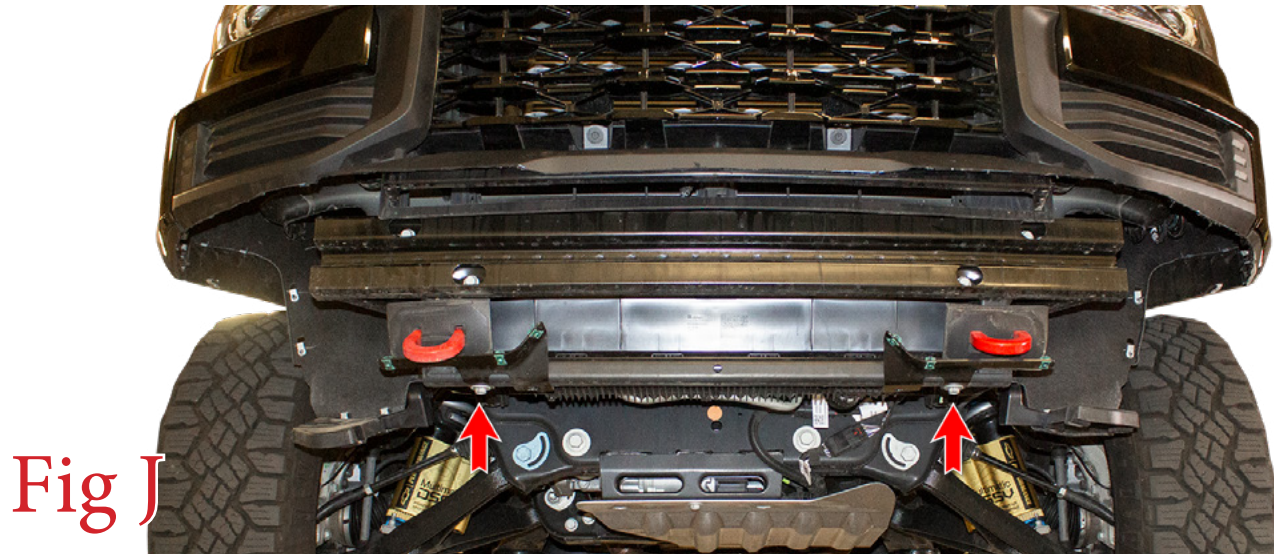


Fig I

10. Using a 15mm Socket, remove the two bolts referenced in (Fig J). Then, remove those brackets from the vehicle.



Installation:

11. If you have lights to install on your bumper, do so now. For light bars, use the supplied universal light mount kit to mount the light to the bumper.

For wiring information, please follow the light manufacturer's installation instructions.

12. If you have a winch to install on your bumper, bolt that to the supplied winch mount now. Use the winch manufacturer's installation hardware. (Fig K)



Fig K

13. Take the winch/winch plate assembly and bolt it to the vehicle using the supplied M10 Bolts (x4) and M10 Washers (x4). Torque these bolts to 40 foot pounds. **We also recommend using loctite on these bolts.** (Fig L)

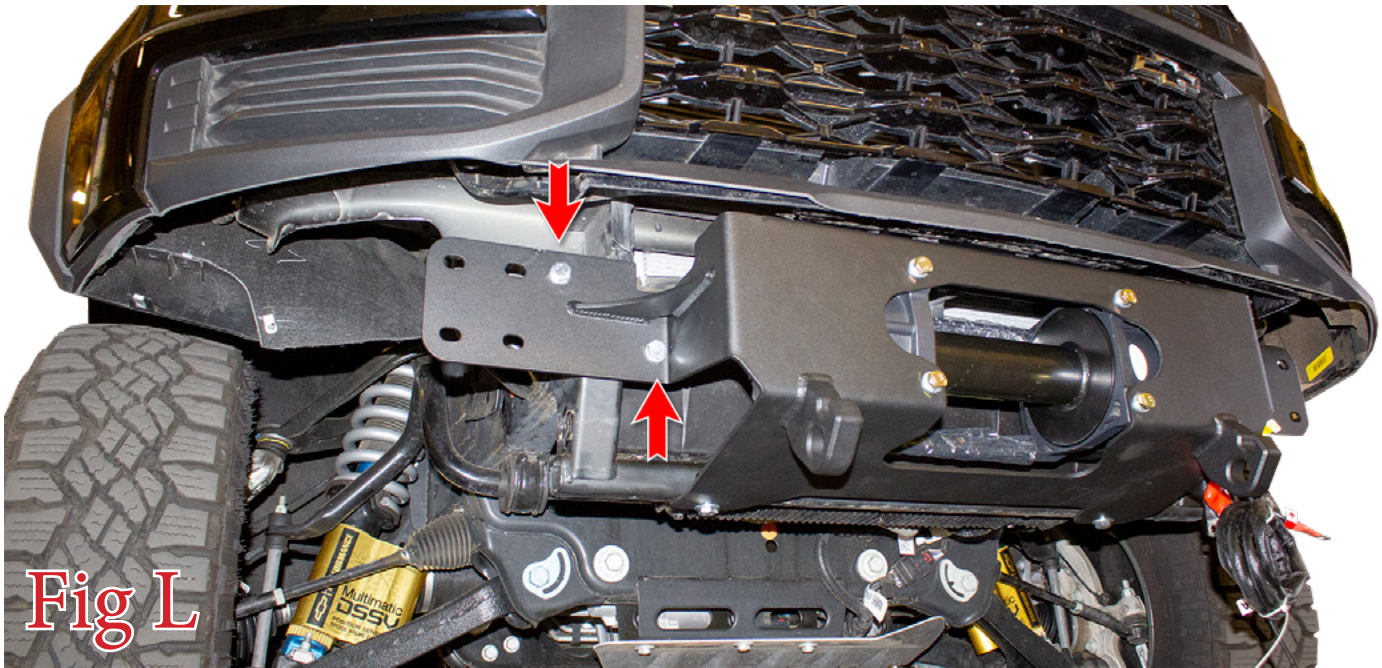


Fig L

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14. Set the bumper in place on the vehicle. Use the supplied 1/2" Bolts (x8), 1/2" Washers (x8), and 1/2" Lock Nuts (x8) to secure it. (Fig M)

****If your truck needs to be trimmed further for the bumper to fit right, now is the time to do so. Only go up a little bit at a time with the cut and use the bumper as a guide on how far up you should cut it****

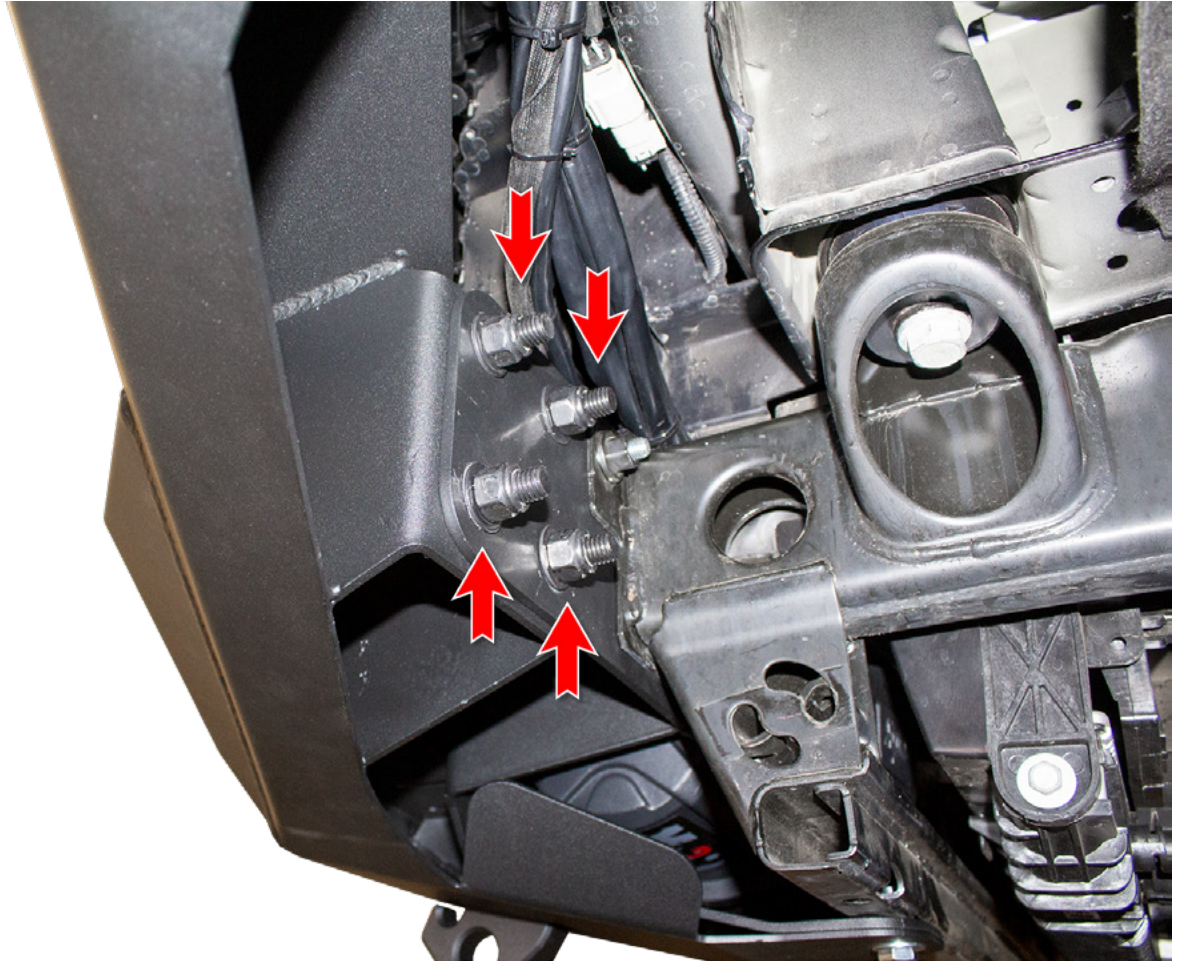


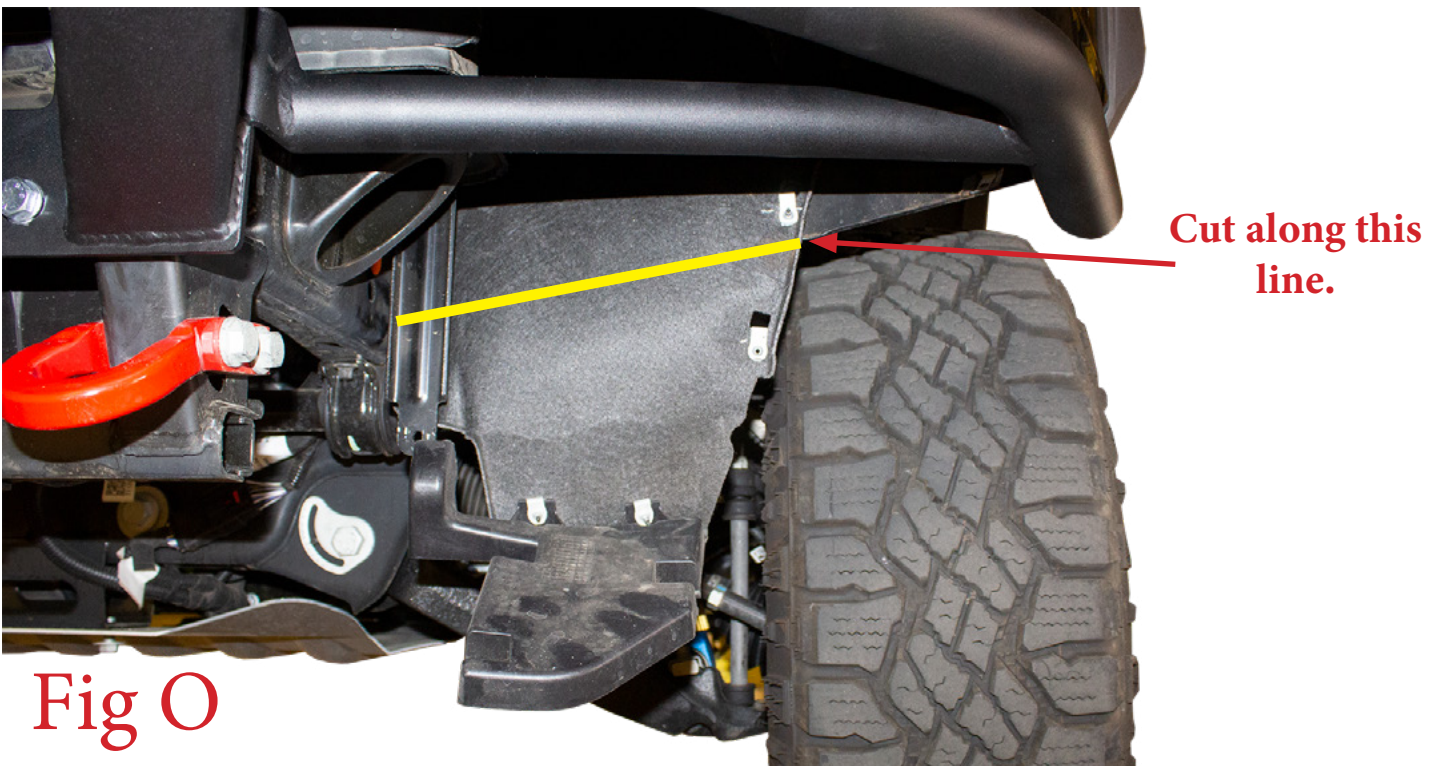
Fig M

15. Align your bumper so it is centered left to right and straight in relation to the grille. Then, torque the mounting bolts to 70 foot pounds.

16. Use a 10mm Socket to remove the inner fender liner bracket bolt (1 per side). **Set these bolts aside for reuse.** (Fig N)



17. Trim your inner fender liner along the line shown in (Fig O).



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18. Fold the inner corner of your liner up. Then, drill a hole where the liner meets up with the hole you removed the bolt from in Step 16. Once you've drilled the hole in your fender liner, reinstall the bolt from Step 16. (Fig P)



19. Stand back and enjoy your new Stealth Fighter™ Front Bumper.
20. Check and re-tighten, if needed, all mounting bolts after 100 miles and periodically thereafter.

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