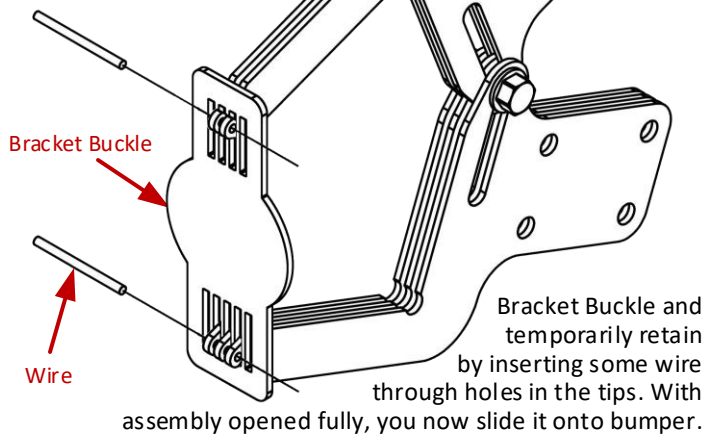


Instructions Continue on Next Page...

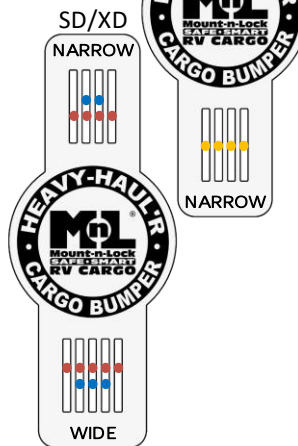
Visit www.mount-n-lock.com/installs for full-size instructions.

Step 9: Create mounting bracket assembly with 5, 7, or 9 L-Brackets, 1 Bracket Buckle, 1 Short Bolt and 1 Flanged Locknut. Interleave two inverted L-Brackets with 3 upright L-Brackets and put Short Bolt through overlapped slots and finger-tighten nut. Next, insert bracket tips through slots in the

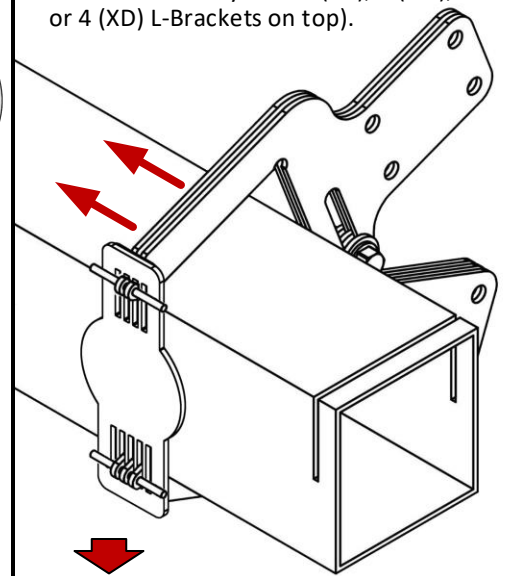


Buckle Slot Usage by Bracket Set

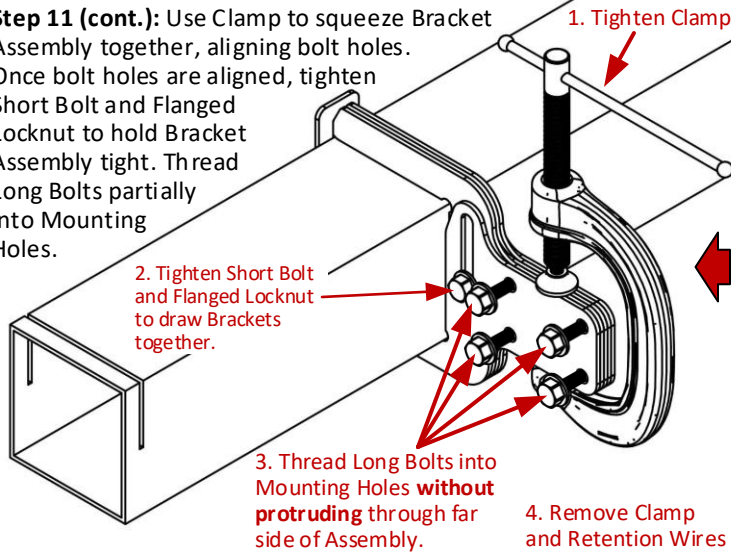
SD: 5
HD: 7
XD: 9



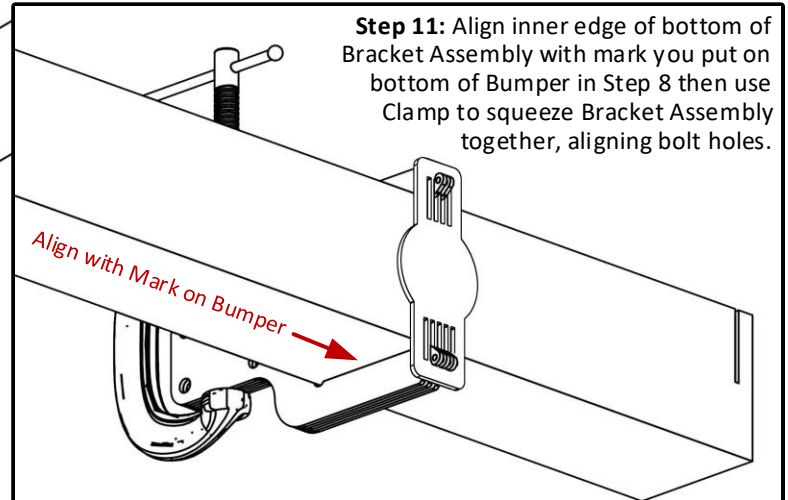
Step 10: Slide the Bracket Assembly over Bumper as shown. Pay attention to the relation of the orientation of the Bumper (slot on top) to the orientation of the Bracket Assembly with 2 (SD), 3 (HD), or 4 (XD) L-Brackets on top).



Step 11 (cont.): Use Clamp to squeeze Bracket Assembly together, aligning bolt holes. Once bolt holes are aligned, tighten Short Bolt and Flanged Locknut to hold Bracket Assembly tight. Thread Long Bolts partially into Mounting Holes.



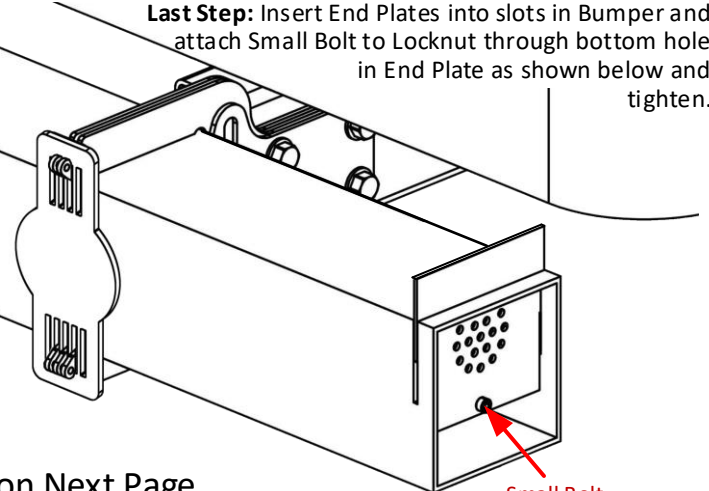
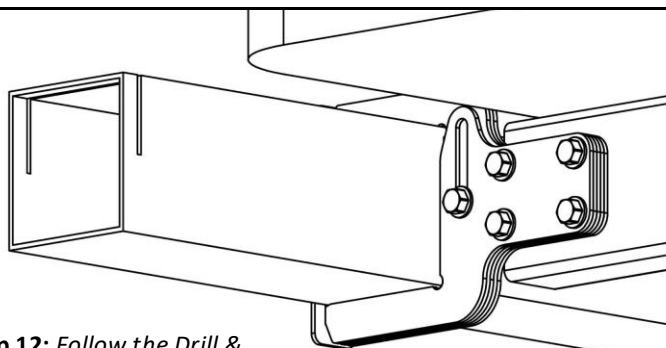
Step 11: Align inner edge of bottom of Bracket Assembly with mark you put on bottom of Bumper in Step 8 then use Clamp to squeeze Bracket Assembly together, aligning bolt holes.



Repeat Steps 9-11 with other Bracket Assembly at other end of Bumper.

Step 12: Follow the Drill & Bolt Instructions on Page 3 of this document to mount the Bumper and Bracket Assemblies to your vehicle's frame using the Long bolts and the holes you've already drilled.

Last Step: Insert End Plates into slots in Bumper and attach Small Bolt to Locknut through bottom hole in End Plate as shown below and tighten.



Instructions Continue on Next Page...

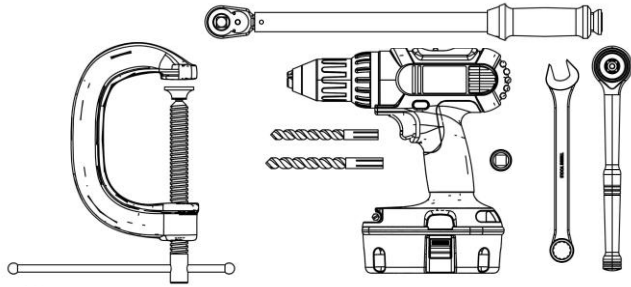
Visit www.mount-n-lock.com/installs for full-size instructions.

Universal Drill & Bolt Instructions

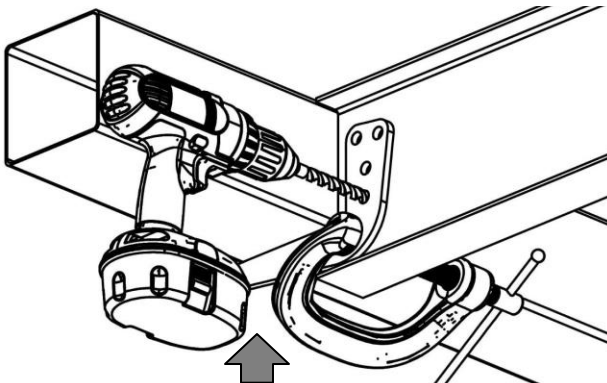
Part shown in drawings may differ from your part.

RECOMMENDED TOOLS

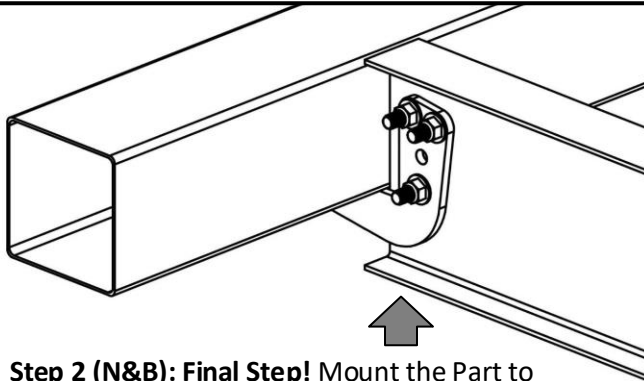
9/16" wrench, torque wrench with 9/16" socket, power drill with 3/8" bit, and a C-Clamp. If using bolts as self-tappers, add 11/32" bit and a ratchet.



HOW TO FASTEN PARTS USING NUTS AND BOLTS (N&B)*



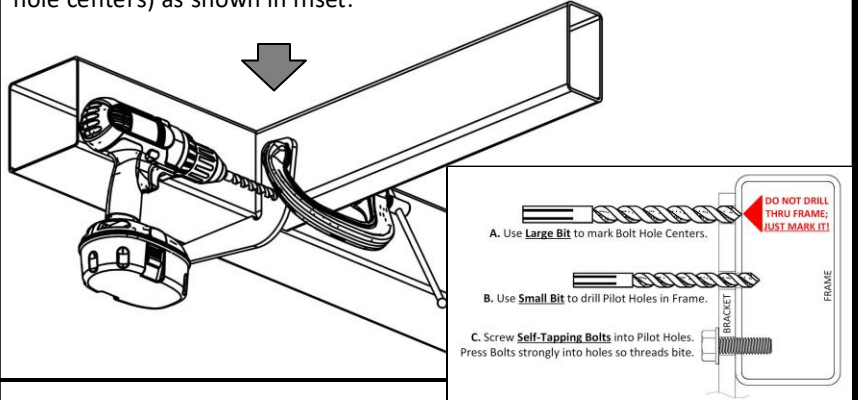
Step 1 (N&B): With your Part clamped in place and using the Part's bolt holes as a guide, use the 3/8" bit to drill *completely* through the wall of the frame member.



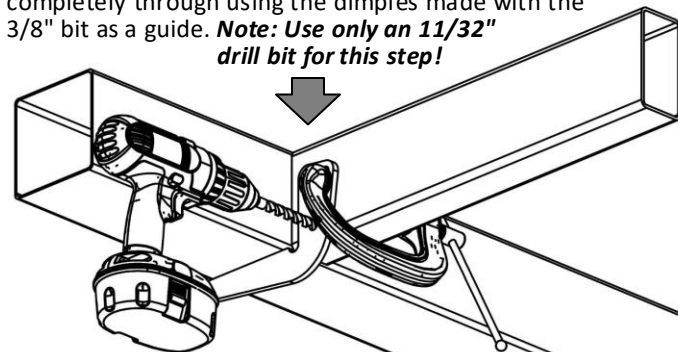
Step 2 (N&B): Final Step! Mount the Part to your vehicle's frame using the supplied Nuts and Bolts. Use a torque wrench on the Nuts to slowly tighten the assembly to **25-30 ft. lbs.**

HOW TO FASTEN PARTS USING ONLY SELF-TAPPING BOLTS (STB)*

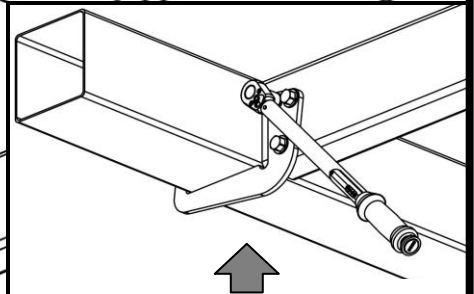
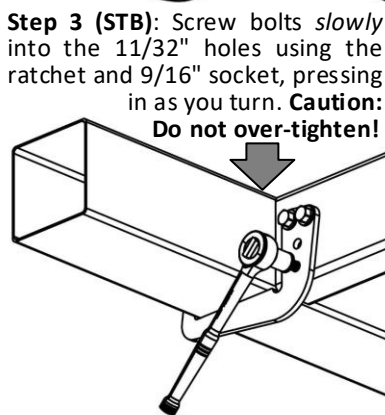
Step 1 (STB): With your Part clamped in place and using the Part's bolt holes as a guide, use the 3/8" bit to drill *slightly* into the steel (just to mark the hole centers) as shown in inset.



Step 2 (STB): Using the 11/32" bit, drill the holes completely through using the dimples made with the 3/8" bit as a guide. **Note: Use only an 11/32" drill bit for this step!**



Step 3 (STB): Screw bolts *slowly* into the 11/32" holes using the ratchet and 9/16" socket, pressing in as you turn. **Caution: Do not over-tighten!**



Step 4 (STB): Final Step! Using the torque wrench, slowly tighten bolts to **15-20 ft. lbs.** Tighten carefully! Over-torquing will strip threads.

*** Note:** The mounting bolts (Long Bolts) supplied with your order are self-tapping bolts, meaning that they can form their own threads into metal, yet they work equally well with the nuts that were also supplied. *Use what works best for your application.*

Self-Tapping Bolts (STB) work best on 0.120" (~1/8") or thicker steel. To use **Nuts and Bolts (N&B)**, frame steel thickness should be 0.188" (3/16") or less; thicker steel may require longer Bolts. *Most frames are 0.120" thick.*

Visit www.mount-n-lock.com/installs for full-size instructions.

A Note About Mill Finish Appearance

Thank you for your purchase of a HeavyHaul'r™ bumper! Every precaution has been taken to ensure that you receive a bumper in top condition, though some imperfections are to be expected. As with all aluminum extrusions, your Mill Finish bumper may have traffic, handling, runout & carbon marks. Despite being extruded from one of the strongest alloys (6061) and hardened to the maximum possible (T6), aluminum is inherently a soft metal and susceptible to minor scratches and dings during the manufacturing and handling of each item. Bare aluminum will also oxidize slightly, losing its mirror finish for more of a matte finish.

Some normal imperfections are below. If you discover significantly worse damage (possibly caused by shipping), let us know and we'll work with you to make it right!



Dings

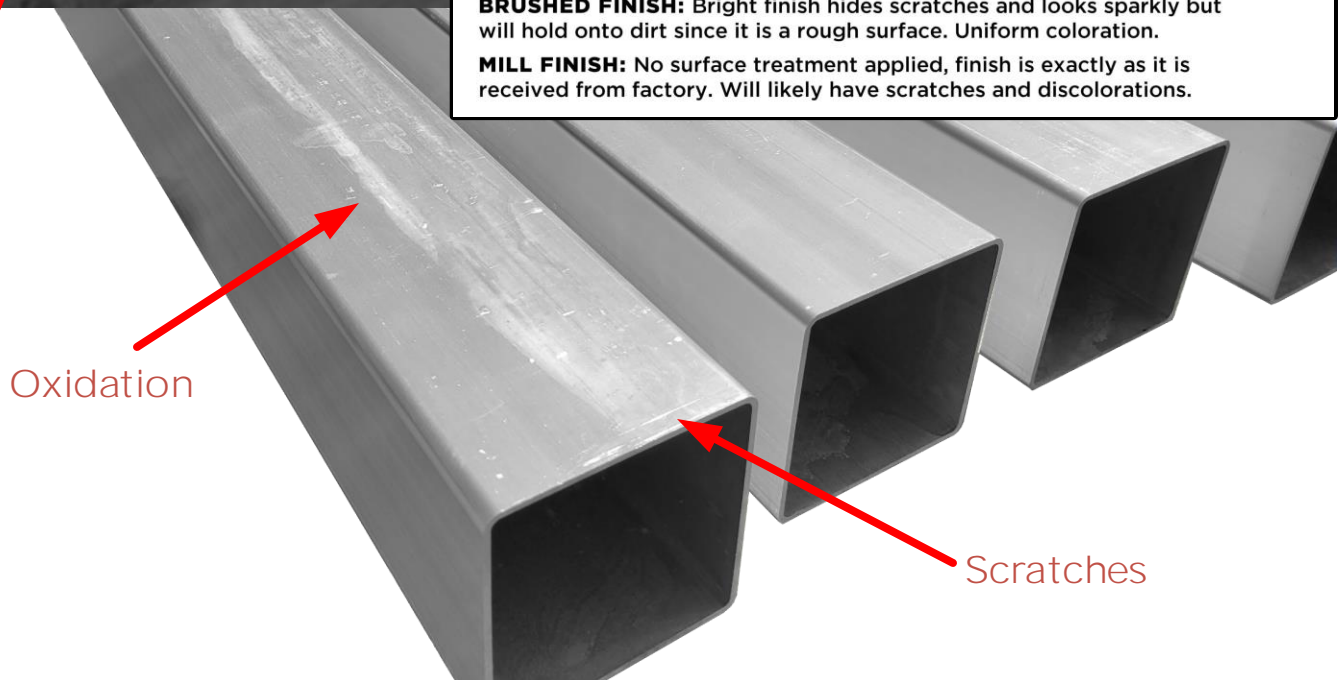


BUMPER TUBE EXTERIOR FINISH

POWDER COATED: Glossy black, mirror-like finish. Beautiful addition to any RV or camper. Aluminum tube won't rust from hose!

BRUSHED FINISH: Bright finish hides scratches and looks sparkly but will hold onto dirt since it is a rough surface. Uniform coloration.

MILL FINISH: No surface treatment applied, finish is exactly as it is received from factory. Will likely have scratches and discolorations.



Oxidation

Scratches

Visit www.mount-n-lock.com/installs for full-size instructions.