



# INSTALLATION INSTRUCTIONS

## HD BUMPER

**Kit 66240 (BLACK), 74760 (BLACK) &  
74690 TUBELESS (TEXTURED BLK)  
For 03-Newer Chevy 3/4 Ton Trucks**

As you read these instructions, you will see **NOTES**, **CAUTIONS** and **WARNINGS**. Each message has a specific purpose. **NOTES** are additional information to help you complete a procedure. **CAUTIONS** are safety messages that indicate a potentially hazardous situation that, if not avoided, may result in minor or moderate injury. A **CAUTION** may also be used to alert against unsafe practice. **WARNINGS** are safety messages that indicate a potentially hazardous situation, which, if not avoided could result in serious injury. **CAUTIONS** and **WARNINGS** identify the hazard, indicate how to avoid the hazard, and advise of the probable consequence of not avoiding the hazard. **PLEASE WORK SAFELY!**

**NOTE:** This installation requires hole drilling. Make sure you have a drill motor and a sharp 7/16” and 1/2” drill bit available. Wear safety goggles.

**NOTE:** Follow the instructions step by step for the fastest and easiest installation. Do not securely tighten fasteners until directed to do so.

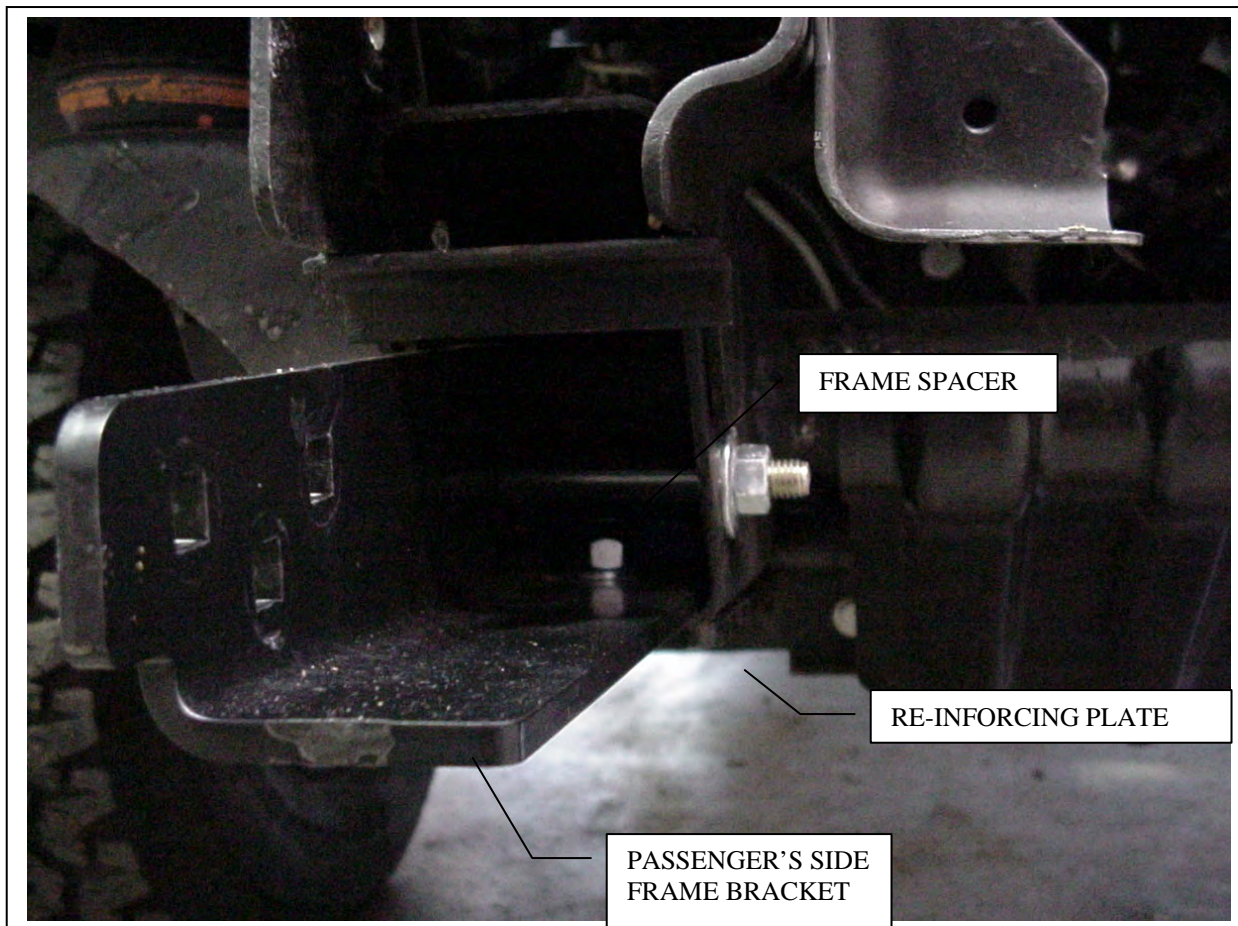
### PARTS LIST

PART NO.	QUANTITY	DESCRIPTION
66237	1	Bumper, Black
or 75157	1	Bumper, Tubeless
66242	1	Bracket Kit, Parts Below
66230	1	Frame Extension, RH.
66231	1	Frame Extension, LH.
66238	1	Bracket, Upper Frame Mount
64368	2	Reinforcing Plate
66249	6	Shim Plate, Top
66360	6	Shim Plate, Bottom
65277	2	Frame Straps
66239	1	Hardware Kit
74001	1	Light Port Backing Plate Kit (Tubeless Only)

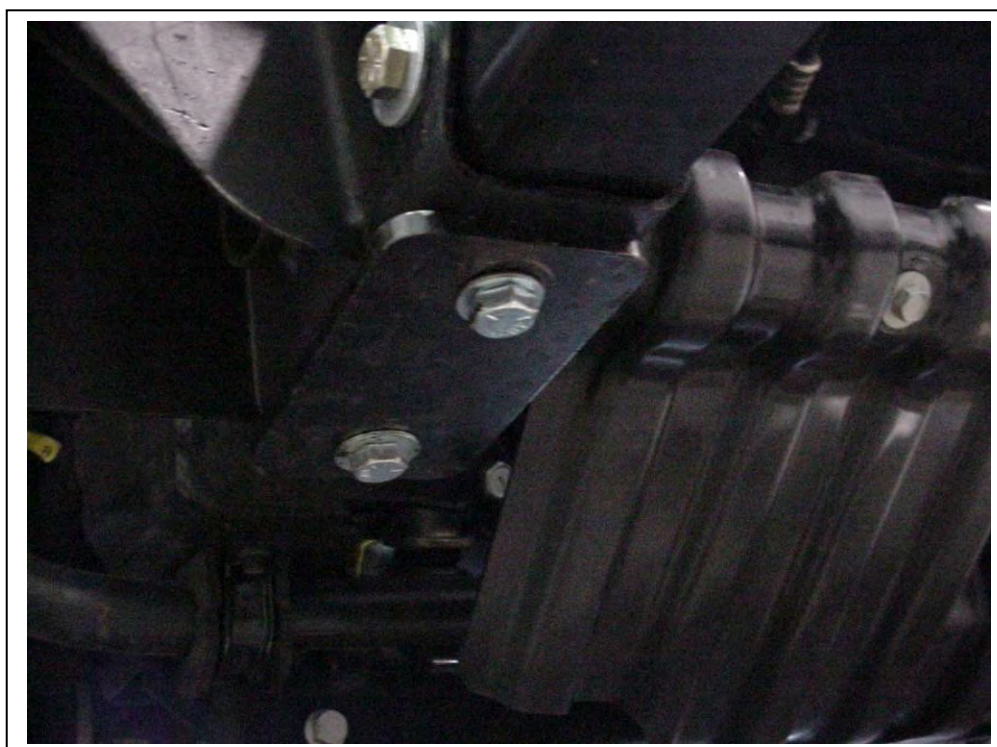
## TORQUE SPECIFICATIONS

BOLT SIZE	TORQUE
7/16 inch	50 lbs. ft. (67.8 N-m)
1/2 inch	75 lbs. ft. (101.7 N-m)
5/8 inch	110 lbs. Ft. (149.2 N-m)
OEM Bumper Bolts	55-60 lbs. Ft. (75-82 N-m)

1. Remove the grille and bumper. The grille must be removed first to gain access to the bumper bolts. These are easy to remove if the following procedure is followed, follow steps “a through e”.
  - a. Open the hood. Remove the plastic fasteners that attach the plastic shroud to the top of the grille. Pry up the center pin with a screwdriver, and then pry out the collar.
  - b. Gently pull out on the grille to release. At extreme outer ends of grille, where grille attaches to the fender, give a sharp pull to release the clips. Remove grille.
  - c. Unplug the wiring from the backside of the fog lights, if so equipped.
  - d. Remove the bolts from the outer bumper braces just forward of the wheels (15mm head). Remove the outer braces from the vehicle frame.
  - e. Remove the four remaining bumper bolts (15mm head) and remove bumper.
2. Remove the plastic splash pan/air deflector that’s below the engine.
3. Remove the factory tow hooks and install the Frame Extensions & Spacer Tubes inside the frame rails. Insert the 1/2” x 4-1/2” hex head bolt through vehicle frame, Frame Extension, Spacer Tube, Spacer Washers (as needed) and Brace Assembly. **See Figure 1. Do not tighten fasteners too tight. You should be able to move parts to adjust.**
4. Install the Reinforcing Plates to the bottom of the Frame rails, using the supplied 1/2” x 1-1/2” hex head bolts, 1/2” flat washers (over slots) & 1/2” nut welded to a 7” long stick. Install rear fastener first using the 7” Long nut on stick for the back holes. Make sure the Reinforcing plate is aligned with the Frame Extension. Using the front hole in the Reinforcing plate drill up through the frame. Install other 1/2” fasteners as before. **See FIGURE 1A and 1B. Tighten these fasteners to proper torque specification.**



**Figure 1A, Frame Bracket, Re-Inforcing Plate, Spacer**



**Figure 1B, Frame Re-inforcing plates.**



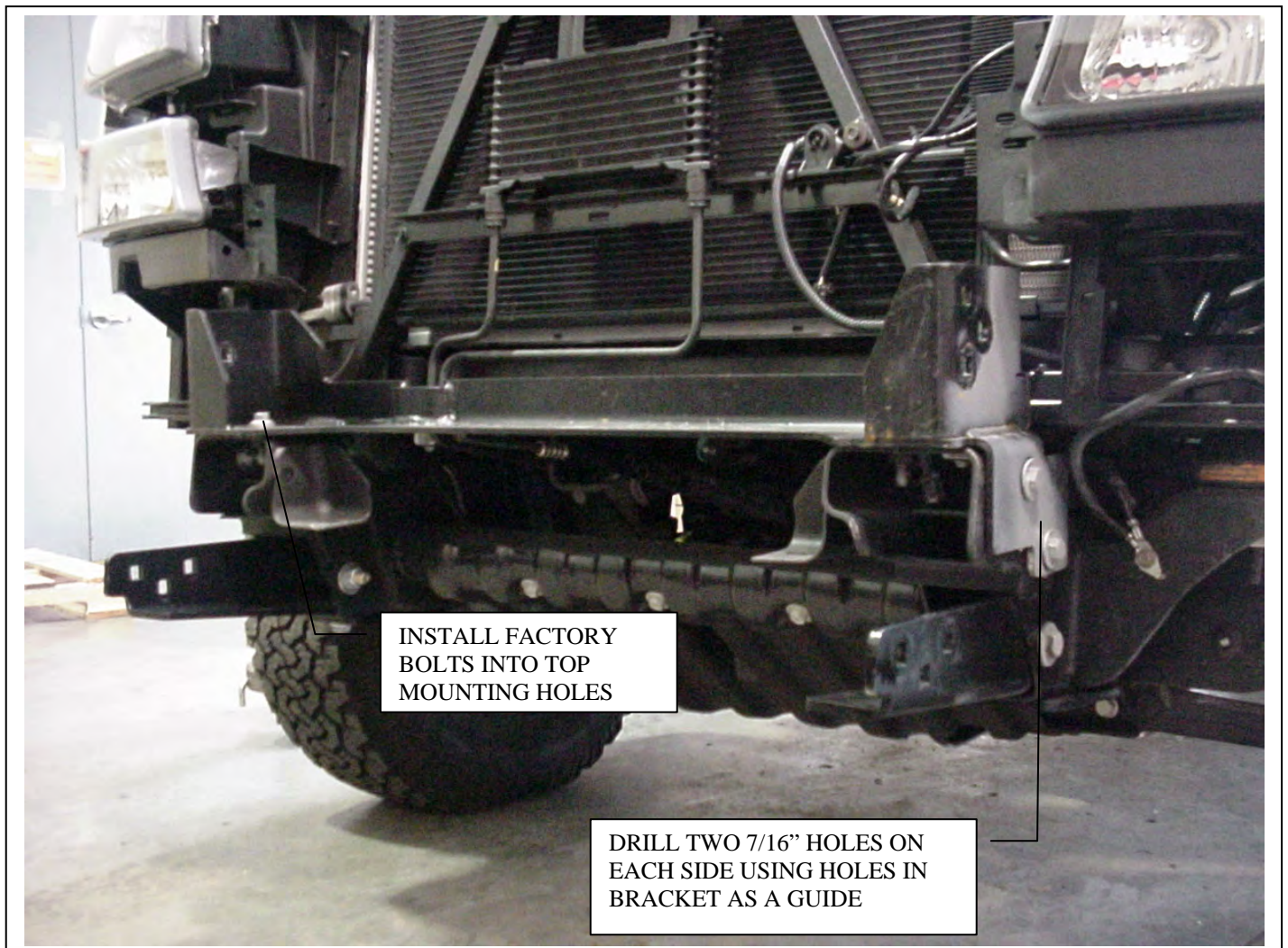


### **WARNING**



Drilling operations can cause flying metal chips. **WEAR SAFETY GOGGLES.**  
Flying metal chips can cause eye injury.

5. Install the upper frame bracket. Place the upper frame bracket over the top of the original bumper mounting holes. **See Figure 2.** Use the factory bumper bolts in the top mounting holes. Tighten but do not torque these bolts at this time. Using the upper bracket as a guide drill two 7/16" holes in each side of the frame tower.



**Figure 2, Upper Frame Bracket**

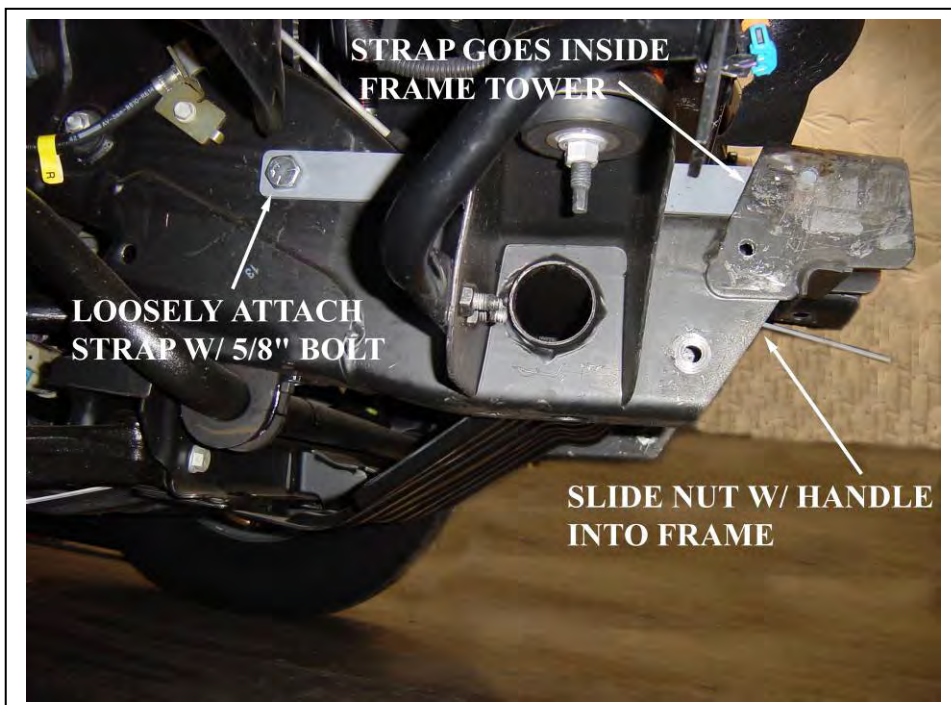


### **WARNING**



Drilling operations can cause flying metal chips. **WEAR SAFETY GOGGLES.**  
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6. Install the frame straps with the 5/8" x 1-1/2" bolts and nuts with long handle. The strap slides inside the frame tower and on the outside of the frame rail. The front hole of the strap will line up with the upper 7/16" hole drilled in step 3. The nut with handle slides inside the frame rail. See **Figure 3**.



**Figure 3, Frame Straps**

7. Once the brackets are installed, torque all of the fasteners to the proper torque spec.
8. Reinstall the grille.
9. If installing a winch, do it now. Use the hardware supplied with the winch to mount the winch to the inside of the front face of the bumper and the bottom winch plate inside the bumper. Bolt the winch to the front face first and hand tighten the bolts. If there is a gap between the winch and the bottom winch mounting plate, place a washer from winch hardware kit. Install the bottom winch bolts and tighten. See **Figure 4**.

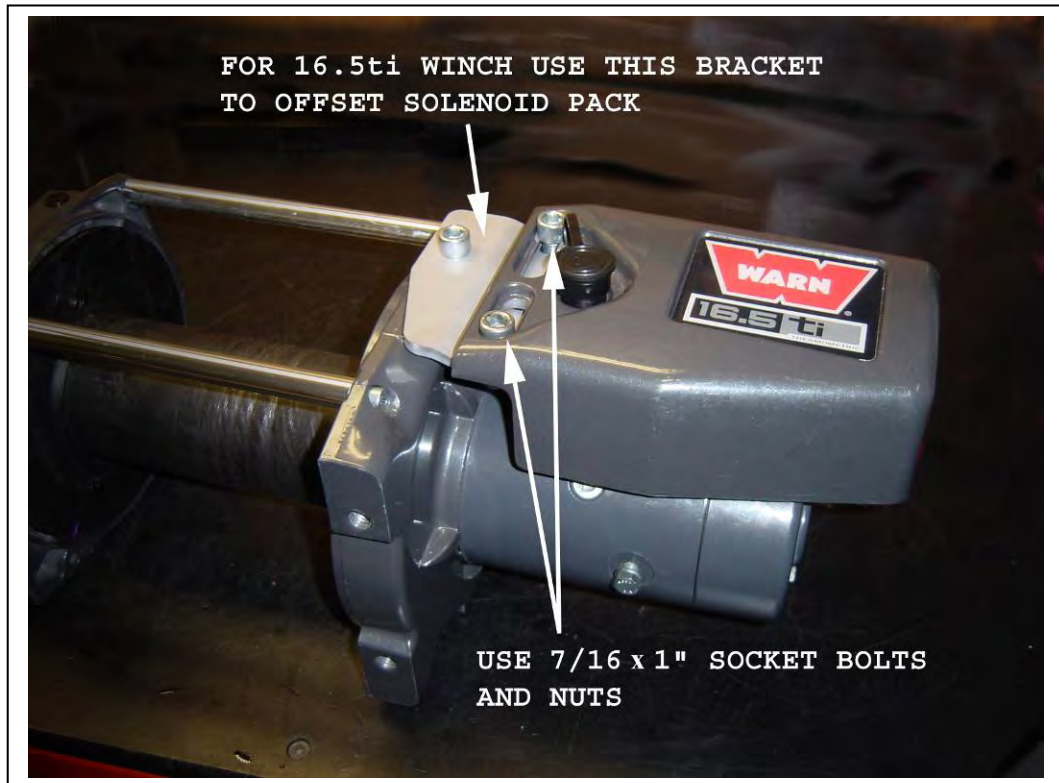


**Figure 4,  
Winch Mounting**



**Note:** If you are installing a 16.5ti winch, you must install the special solenoid pack bracket supplied in this kit. **Figure 4B**, follow the instructions supplied with the winch for correct installation. Tighten the control pack.

**Figure 4B,  
16.5ti with special  
Solenoid Pack  
Bracket installed.**



10. Install the bumper by carefully setting the bumper on the lower frame brackets. The frame brackets should be installed under the middle plate inside the bumper. Adjust the bumper from side to side to determine the shim placement. Nominal position should have three shims on each side. Check the gap between the headlight tubes and the body to properly align bumper from side to side. Once the side-to-side location is determined, install the bottom shims, carriage bolts, washers, and lock nuts. Once the lower bolts are installed, install the upper shims, carriage bolts, washers, and lock nuts. **See Figure 5.**



**Figure 5, Bumper, Shims, Carriage Bolts, Flat Washers, Lock Nuts**

11. Once the bumper bolts and shims are installed, snug up the bolts. Jack up the bottom of the bumper using a floor jack and a block of wood. Adjust the bumper height using the floor jack and tighten the bumper bolts after the desired height is determined. Torque the bumper bolts to the proper spec. **See Figure 5.**

**NOTE: The tubeless bumper does not include lights. If lights are not being installed, light port backing plates are included with the tubeless version and should be installed.**

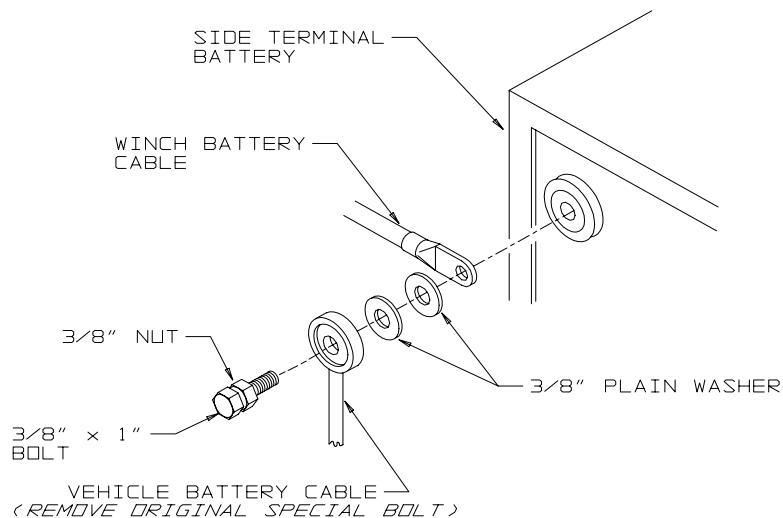
12. Install lights according to instructions provided with light kit. If lights are not being used, install the light backing plates using hardware provided in kit. Leave approximately 1/16" to 1/8" gap between backing plate and light port.



**Figure 5, Vertical Gap**

13. Route winch power cables so they do not come in contact with any hot, sharp or moving parts.

14. To connect the battery cables to the side terminal battery, use the supplied fasteners as shown in **Figure 6**.



**Figure 6**