



Rear Bumper Installation Instructions

P/N 210045: 2003-2010 Chevy Express Van

Before you begin:

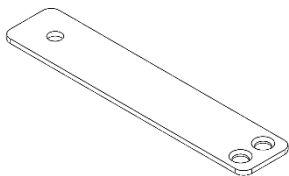
- *Stainless steel hardware may bind together when tightening – apply an anti-seize assembly lubricant to the thread of each bolt before assembly*
- *This installation requires two or more people*
- *Unless otherwise specified, refer to the general torque value at the end of the instructions for specified torque values.*



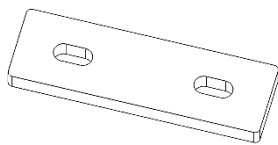
Included Hardware:

P/N	Description	Quantity
70008	Nut, Nylock, ¼”-20	4
70033	Nut, Nylock, ½”-13	12
70013	Bolt, ¼’-1 x 1”, Flat Head Socket Cap, SS	4
70029	Bolt, 3/8”-16 x 1-1/4”, Hex Head	2
70080	Bolt, ½”-13 x 2”, Hex Head	12
70009	Washer, ¼”, Stainless Steel	4
70028	Washer, 3/8”, Stainless Steel	4
70035	Washer, ½”, Stainless Steel	24
400503.4	Keys, Tool Box Lock Set	1
70246	Loctite Anti-Seize Packet, 2g	1

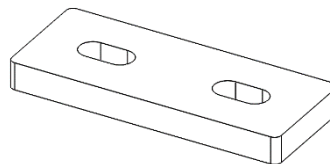
Included Parts:



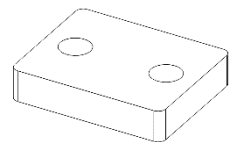
2X – Support Strap



2X - Hitch Spacer (Large)



2X – Hitch Spacer (Medium)



2X – Hitch Spacer (Small)



Installation Instructions:

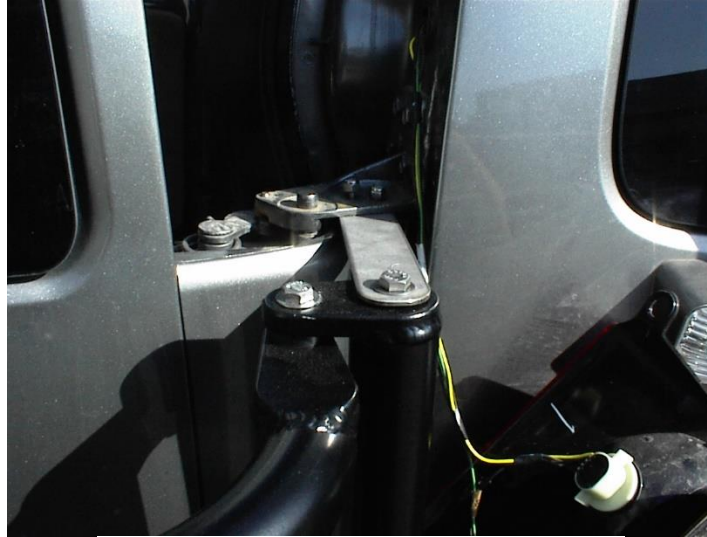
1. Remove stock bumper
2. Enlarge Frame Holes for ½” bolts. They are slightly under size. A file will do.
3. Remove the 8 bolts holding on the hitch
4. Place the 1/2” Spacers between the hitch and the frame and re-install using the ½-13 hardware provided. Depending on the year of the van and the make of the hitch (stock vs. aftermarket), use the provided spacers appropriately. There will be some left over after installation.
5. Remove rear taillights on van – remove exposed 10mm nuts from tail light and upper plastic panel.
 - a. Plastic panel must be removed to access taillight nut.
6. Mount the rear bumper:
 - a. Use four ½-13 X 2” bolts to bolt the Aluminess bumper to the frame (two bolts per side).
 - i. Each bolt should have a 1/2” Zinc washer on both sides.
 - ii. Each bolt should be held on with a 1/2” Nylock Nut.
7. **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.**
8. Strap Installation
 - a. 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.
 - b. Install the 3/8-16 x 1 ¼” bolts through the strap and into the pole. (See picture below)
 - i. 3/8” Flat Washers should be between the head of the bolt and the strap, and the strap and the bumper pole.
 - c. Provide some outward pressure to the pole when marking the door hinge holes.
 - i. This step preloads the swing arm for the weight of the spare tire & box.
 - d. Drill two ¼” holes through the door hinge AND the already existing holes in the strap.
 - e. Mount the strap to the bottom side of the hinge so it will not interfere with the taillight.
 - f. Install the ¼-20 x 1” bolts from the bottom up i.e. upside down so the nuts are on the top.
 - i. The head of the bolts should have no washers on them.
 - ii. The nut side should have a ¼” flat washer and a ¼” nylock nut.
 - g. Replace the tail light.
 - h. This process is required for both sides.

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.



General Torque Values			
Size	Stainless Steel	Zinc	Grade 8
#6-32	10 lb-ft	--	--
#8-32	18.4 lb-ft	--	--
#10-32	26.6 lb-ft	--	--
1/4"-20	5.3 lb-ft	7.8 lb-ft	9 lb-ft
5/16"-18	10.9 lb-ft	16 lb-ft	18 lb-ft
3/8"-16	19.4 lb-ft	28.3 lb-ft	33 lb-ft
7/16"-14	31 lb-ft	45 lb-ft	52 lb-ft
1/2"-13	47 lb-ft	69 lb-ft	80 lb-ft
M6	4.7 lb-ft	5.8 lb-ft	--
M8	11.3 lb-ft	14.1 lb-ft	--
M10	22.3 lb-ft	27.9 lb-ft	--
M12	38.9 lb-ft	48.7 lb-ft	--



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