

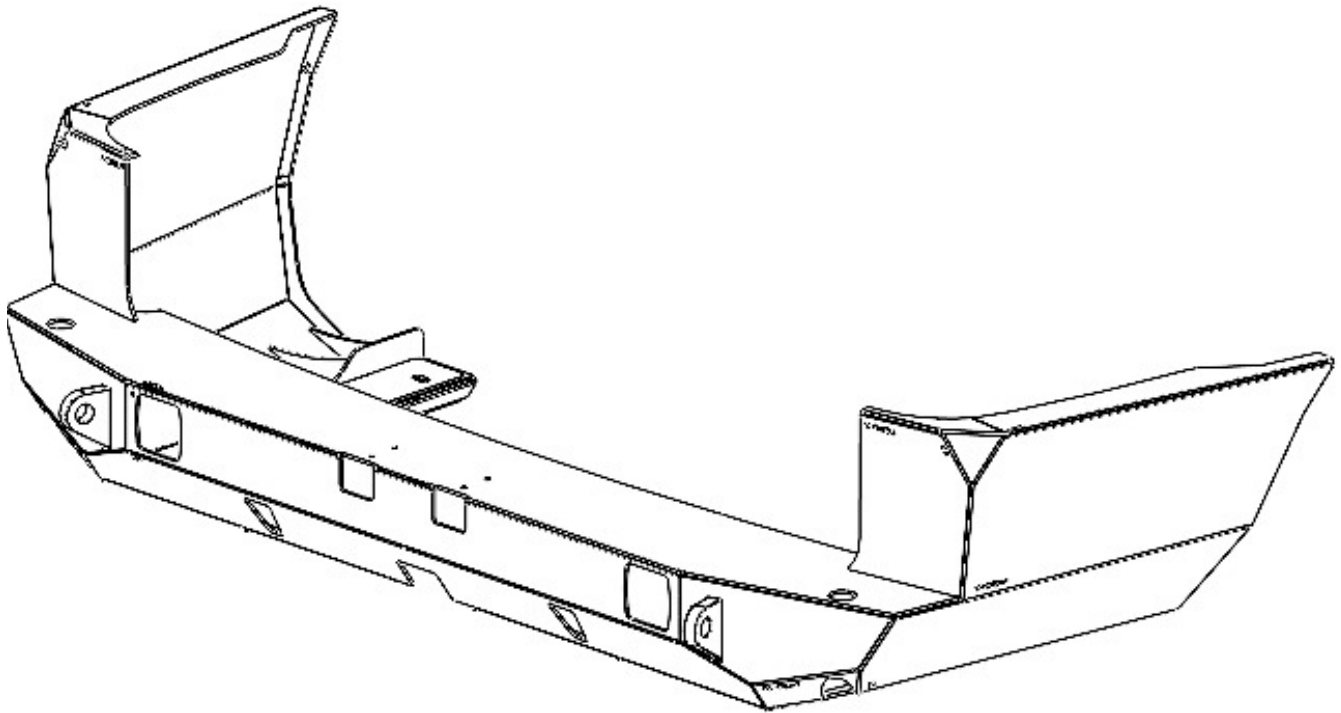


VICTORY4X4

03-09 GX 470

DIY REAR BUMPER

INSTALL INSTRUCTIONS



Please read the mounting instructions below carefully before attempting to install.

Be sure to check out the install video on the product page, if available.

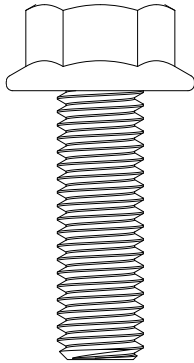
Thank you for purchasing from Victory 4x4! Checkout our website, victory4x4.com for other great off-road products. Be sure to rate and review our product online. If you have any questions or are missing parts, please don't hesitate to call us at 269-459-8447!

INCLUDED HARDWARE

INCLUDED BOLT PACK(S) 046-0179

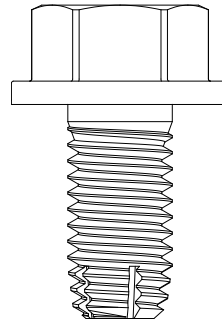
Note: Some Victory 4x4/JCR Offroad/SquatchProof products share hardware kits. Any extra hardware you may receive that is not listed below can be repurposed or discarded.

4x



JIS High Strength Steel
Flanged Hex Heads

2x



1/2"-13 x 1" Long Zinc-
Plated Steel Thread Cutting
Screws

INCLUDED PARTS

1x #1 Center Section

2x #2 D-ring Brackets

2x #3 Mounting Brackets

2x #4 Wing Pieces

2x #5 Front Wing Pieces

2x #6 Tie-in Brackets

2x #7 Spindle Tie-in Brackets

2x #8 Cube Light Mounts

2x #9 Back Wing Pieces

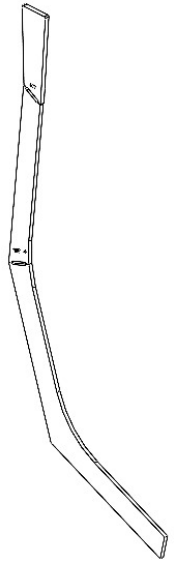
2x #10 Frame Spacer

2x D-Rings

2x Spindle Sleeve

ASSEMBLY

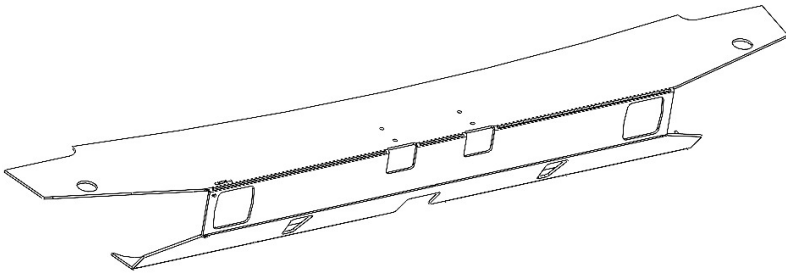
(L&R) 8



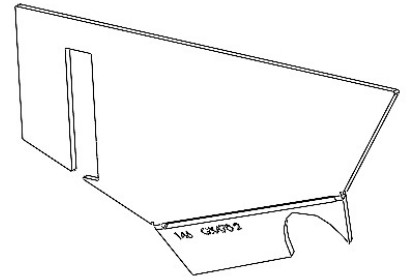
1. Before you start, **note that each of the bend angles are etched on the part along the slit lines.**

Start by bending all of your parts on the slit lines according to the angles called out. Below you will see each part and how they should look after they are bent. Note that there will be parts labeled as (L&R) which are lefts and rights, and will need to be mirror images of one another after being bent.

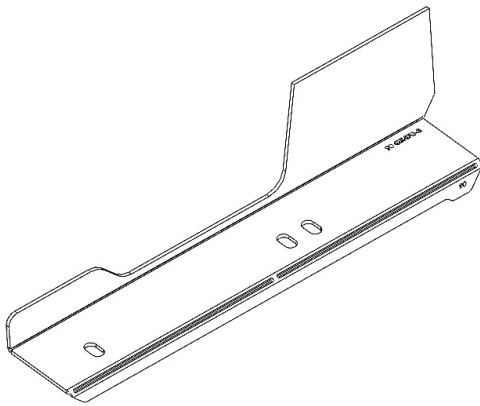
1



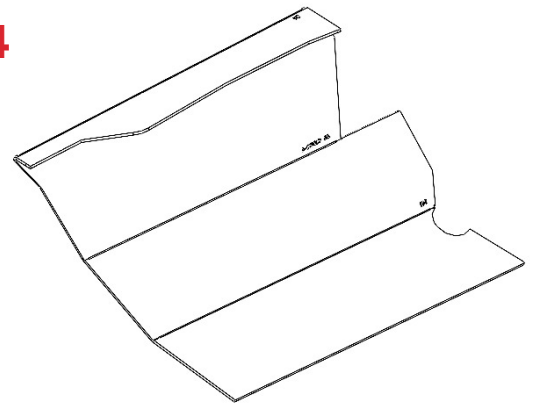
(L&R) 2



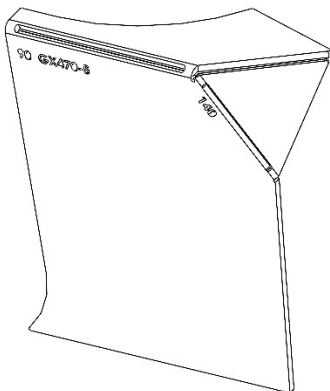
(L&R) 3



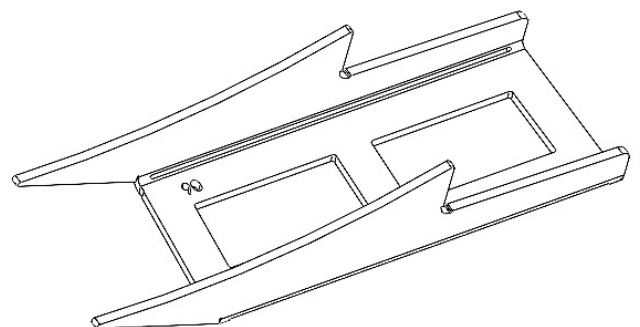
(L&R) 4



(L&R) 5

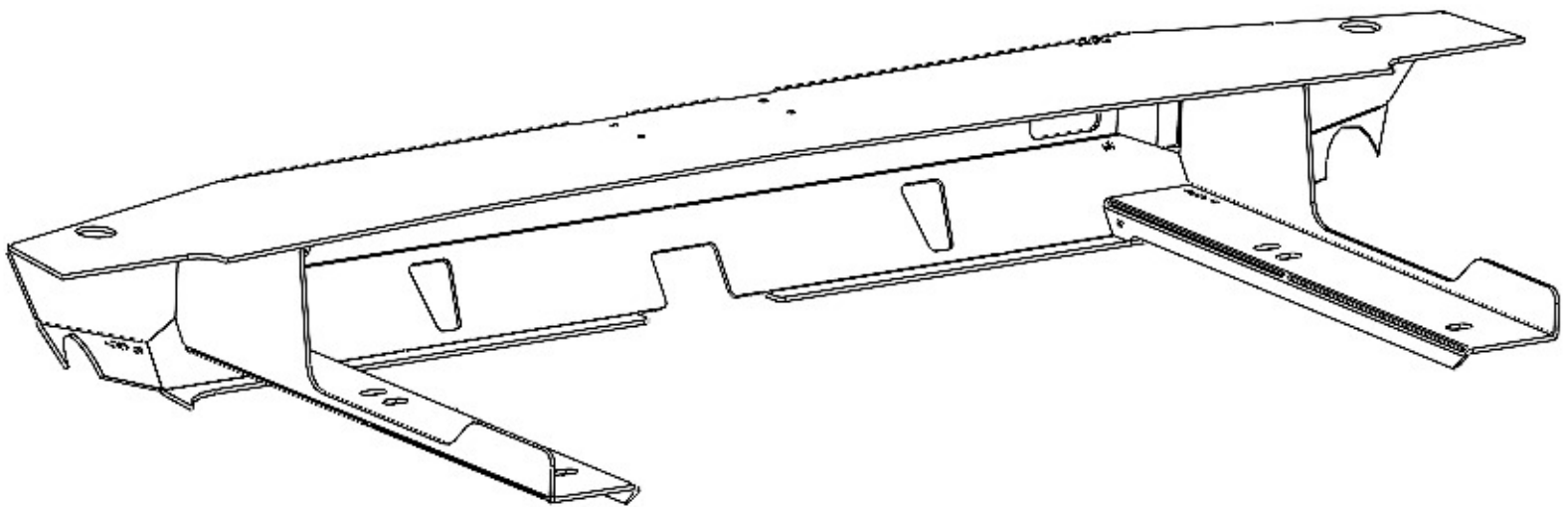
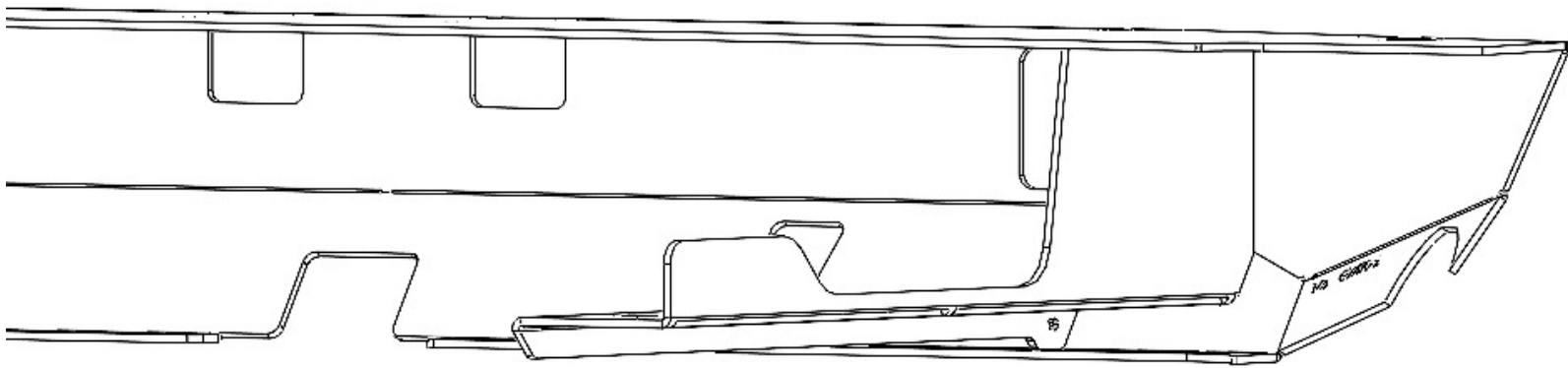


(L&R) 6



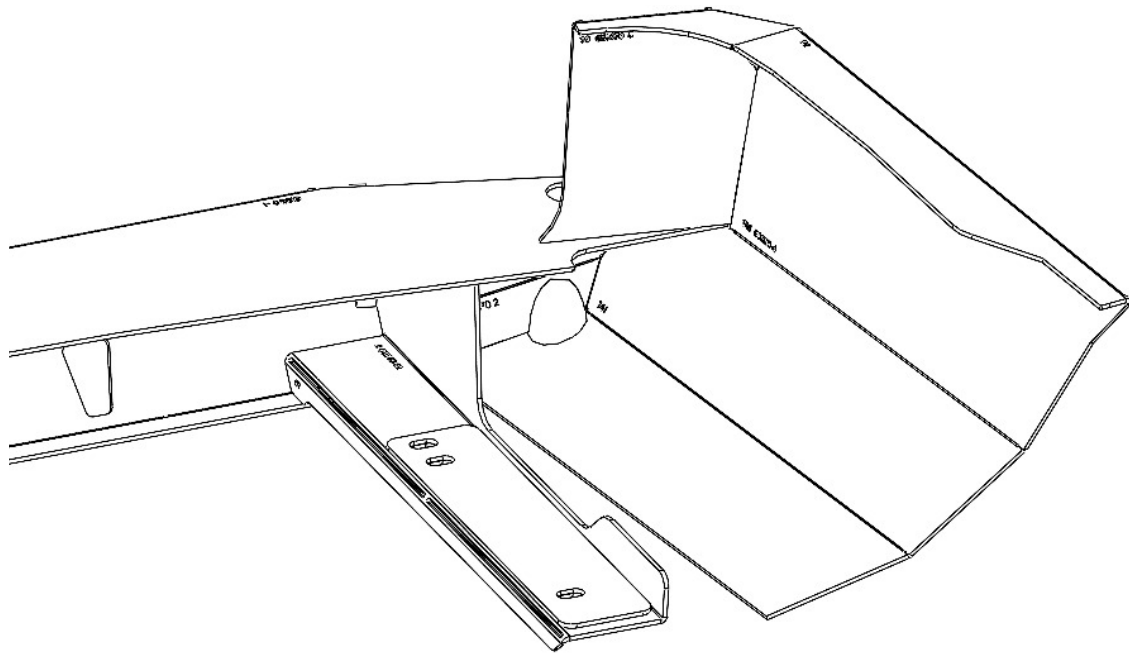
ASSEMBLY

2. Once all of your parts are bent to the correct angles, tack weld and assemble parts 1, 2 & 3 (on both sides) by aligning part 3 to the outside of the D-ring cut out, and making sure everything is square to one another. See reference picture below for an idea of what it should look like.

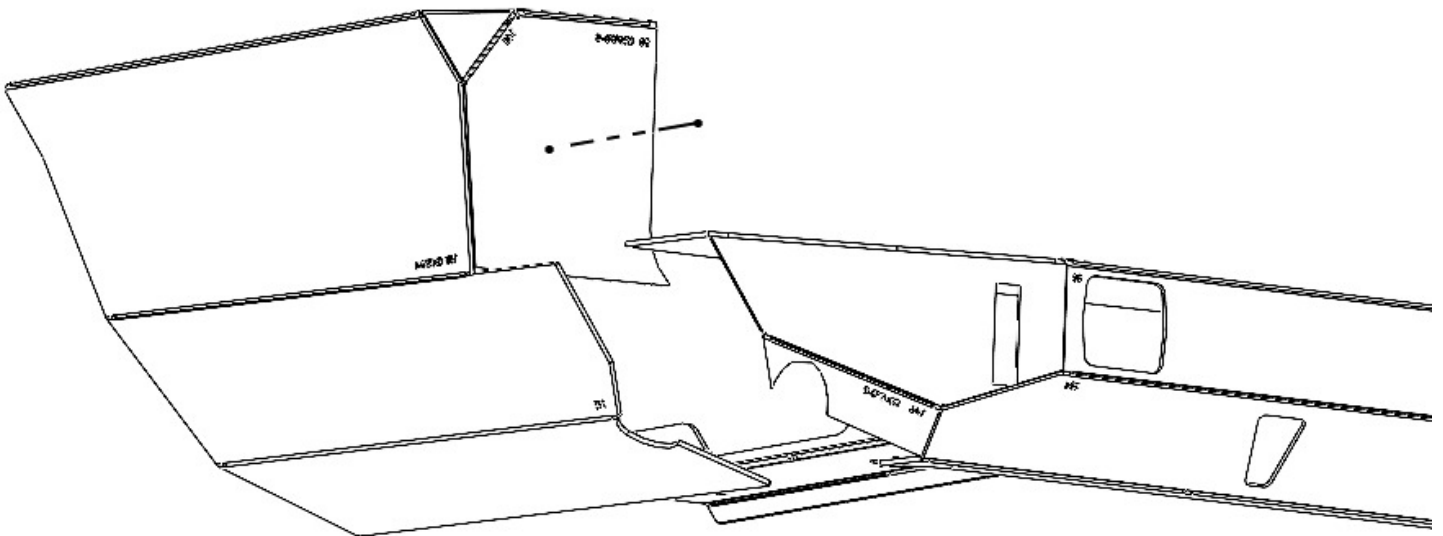


ASSEMBLY

3. Now that your center section shell is tacked together, loosey bolt it onto the truck with the frame spacers (as shown below) centered on the slots and snug the bolts down.

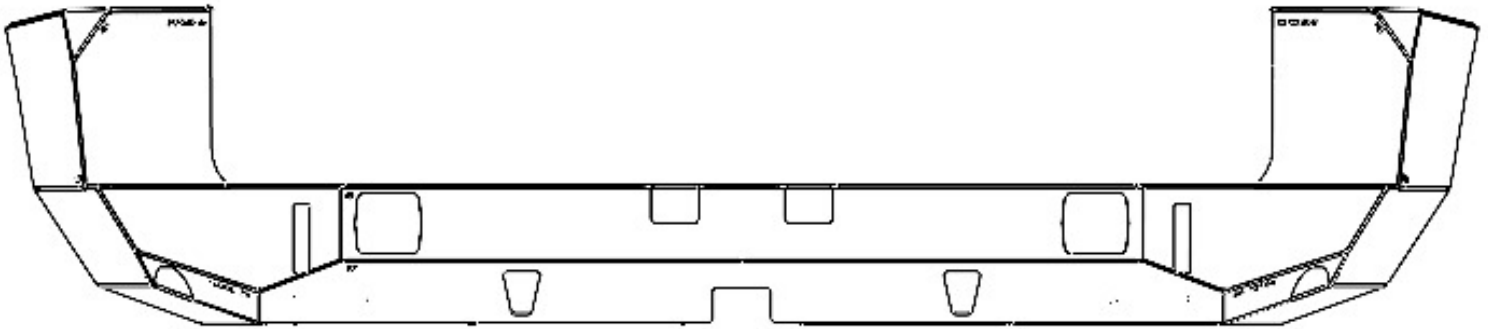


- 4a. Now, tack both sets of parts 4 & 5 together before tacking them to the shell. Once the parts are together, tack them to the shell on the truck, as shown below.



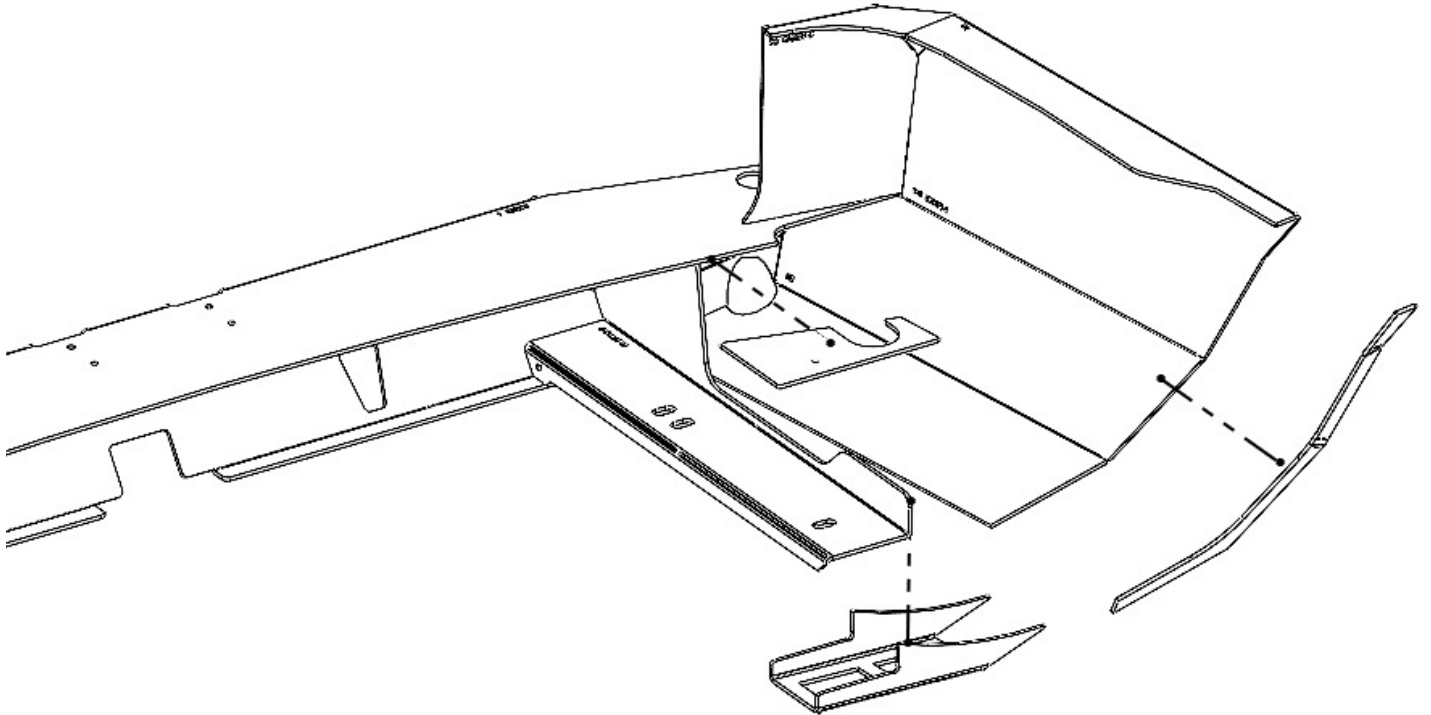
ASSEMBLY

4b. How it should look after both parts are tacked onto the shell.

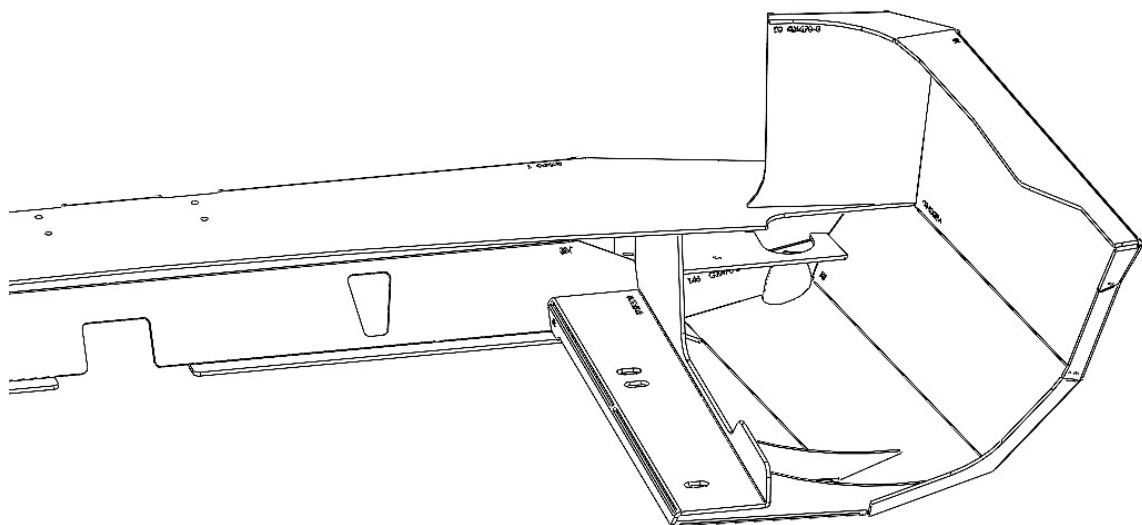


ASSEMBLY

5. With the shell fully tacked together, take the bumper back off of the truck and then take parts 6,7 & 8 and tack them into place on the inside of the bumper on both sides, as shown below.

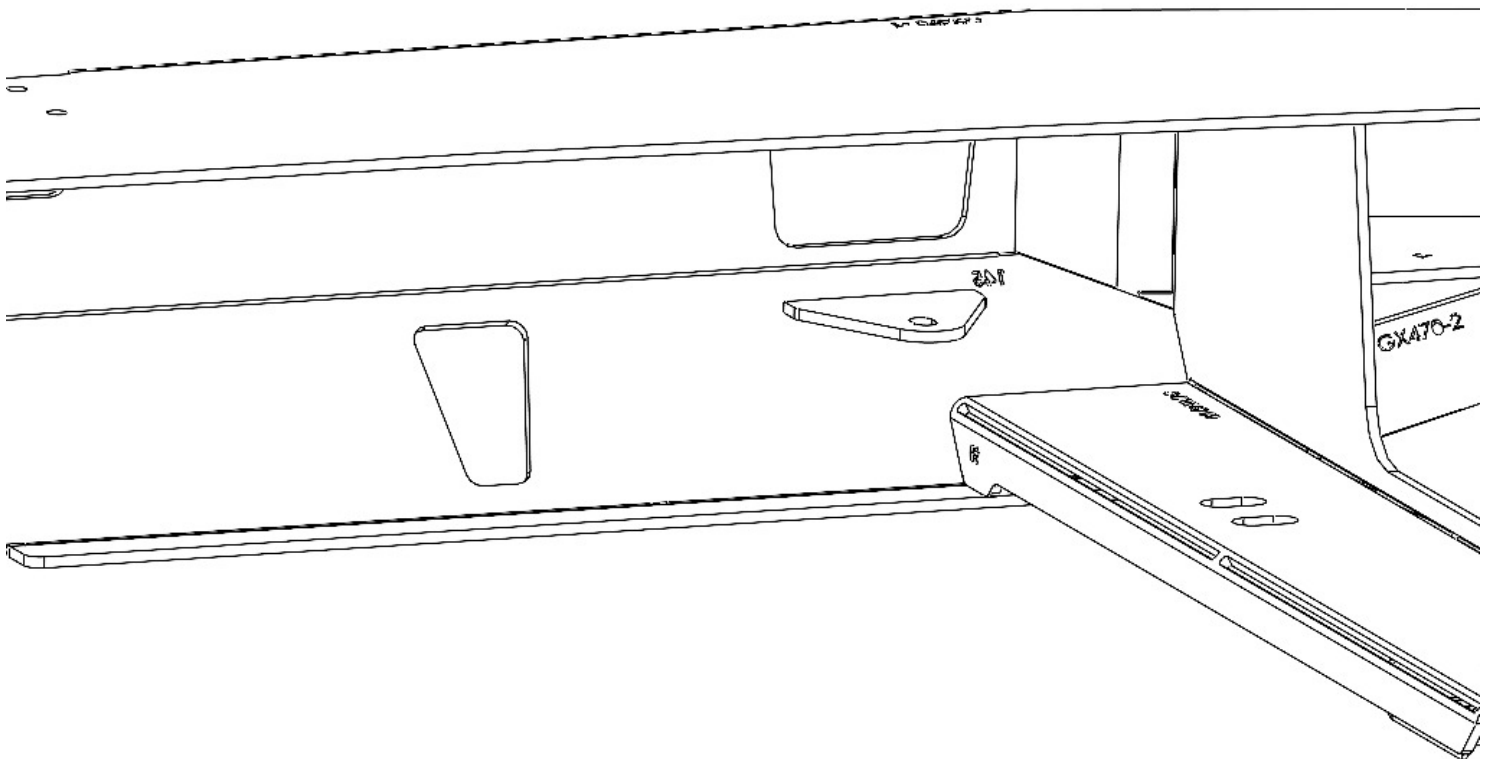


How it should look after the parts are tacked into the shell.



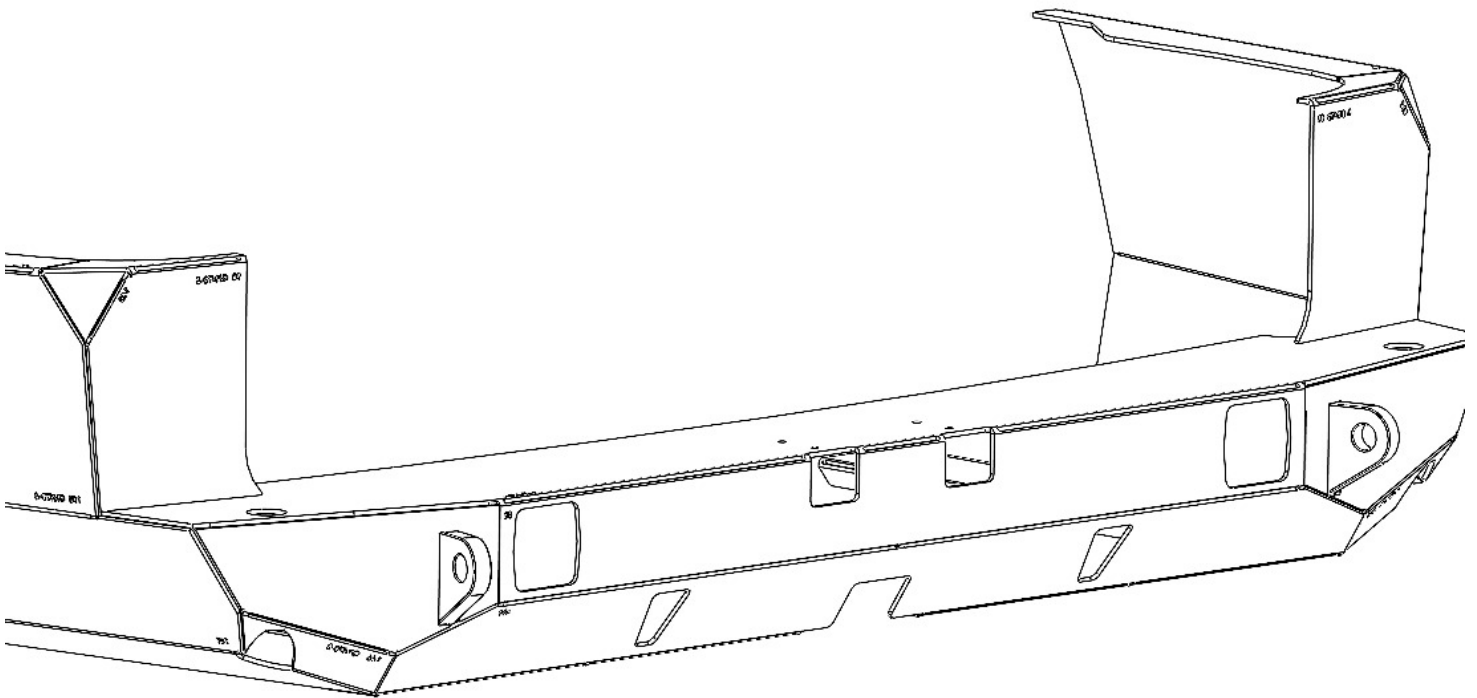
ASSEMBLY

6. Now that the bumper is fully tacked together on the truck, it is time to fully weld the seams. Keep in mind, with all of the heat produced by fully welding this bumper, you may experience some deformation or warping when welding. To avoid this, you may choose to do some of the welding with the bumper still mounted to the vehicle, to ensure it holds its desired shape. If you do remove the bumper to weld it fully, we recommend jumping around to different locations to avoid concentrating heat in one area. Clamping a rigid straight edge to the top of the wings can help prevent warping as well.
7. After the whole bumper has been fully welded together, using the cube lights of your choosing to set the height of your mounts, take the mounts and weld them centered under the cube light cutouts on each side of the bumper, as shown below.



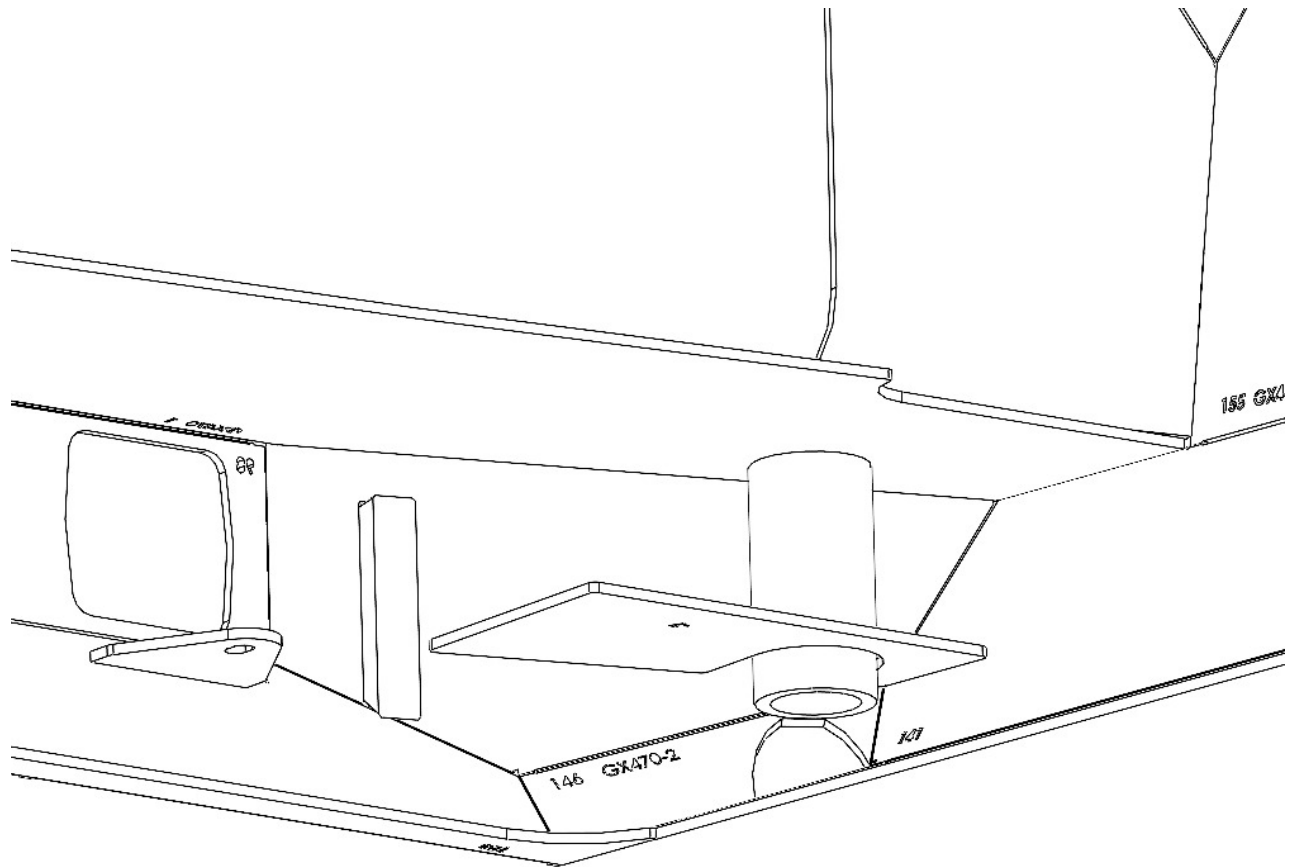
ASSEMBLY

8. With the bumper still off of the truck, it is now a good time to weld your D-rings into place. Insert your D-ring shackles through the back of the bumper and squaring them up. Once the D-rings are square on each side, tack them to the bumper before fully welding them down to make you are happy with the look and fit. Below is an example of how they should look.



ASSEMBLY

9. You can choose to do this earlier if you please, but if you plan on running a carrier you will need to weld in your spindle sleeves on both sides of the bumper. Weld the top face of the sleeve flush to the bottom side of the bumper with the hole concentric to the spindle hole cut out in the bumper, as shown below (some parts have been hidden to show the sleeve more clear).



ASSEMBLY

10. Once the sleeves are welded into place, you are now finished building your DIY bumper. At this time you are free to wire the cube lights of your choosing if you please, and any other customizing you may choose. Also be sure to check out Victory4x4.com for our DIY carrier to go with your bumper and other GX470 product.

