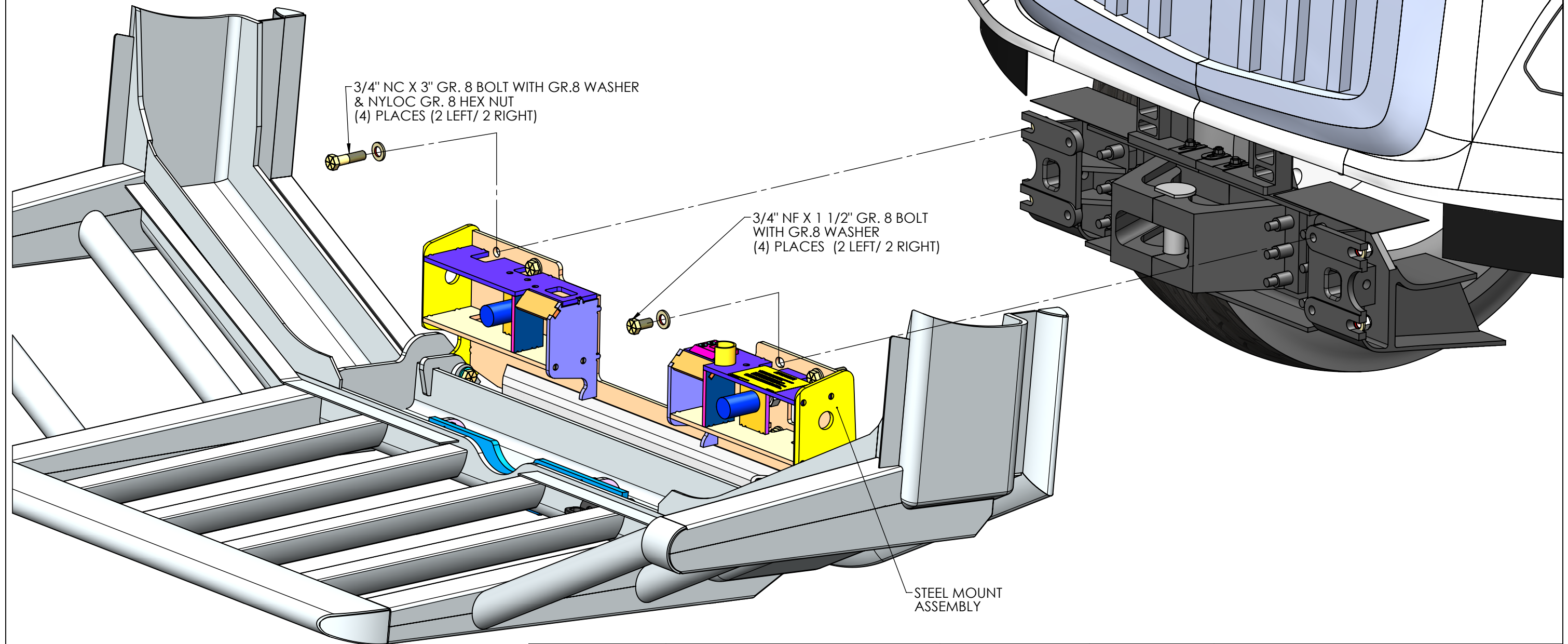


1. REMOVE FACTORY BUMPER FROM TRUCK.
2. PLACE STEEL MOUNT ASSEMBLY ON FRONT OF TRUCK.
3. INSERT (4) 3/4" NC X 3" BOLTS WITH WASHERS & NUTS THROUGH HOLES IN STEEL MOUNT & TRUCK. DO NOT FULLY TIGHTEN THESE BOLTS TO ALLOW MOVEMENT OF THE STEEL ASSEMBLY.
4. INSERT 3/4" NF X 1 1/2" GR. 8 CAPSCREWS THROUGH HOLES IN STEEL MOUNT & TRUCK WITH WASHERS STACKED.
5. POSITION THE STEEL MOUNT ASSEMBLY INTO A CENTERED POSITION ON THE TRUCK AND TIGHTEN THE (4) 3/4" NF X 1 1/2" BOLTS. TIGHTEN FIRMLY, BUT NOT TO FULL TORQUE AT THIS TIME AS SOME ADJUSTMENT OF THE POSITION WILL LIKELY BE REQUIRED.
6. IF BUMPER ALIGNMENT WAS OK TIGHTEN ALL FASTENERS AT THIS TIME. SEE TORQUE VALUES BELOW.
7. VERIFY BUMPER ALIGNMENT - INSTALLATION IS COMPLETE



FASTENER TORQUE SPECIFICATION	
FASTENERS: GR. 8	TORQUE FT/LB
3/4" NC WITH STOVER NUT	200
3/4" NF INTO TAPPED THREADS	180



FRACTIONS CHART							
1/32	.03125	9/32	.28125	17/32	.53125	25/32	.78125
1/16	.0625	5/16	.3125	9/16	.5625	13/16	.8125
3/32	.09375	11/32	.34375	19/32	.59375	27/32	.84375
1/8	.125	3/8	.375	5/8	.625	7/8	.875
5/32	.15625	13/32	.40625	21/32	.65625	29/32	.90625
3/16	.1875	7/16	.4375	11/16	.6875	15/16	.9375
7/32	.21875	15/32	.46875	23/32	.71875	31/32	.96875
1/4	.25	1/2	.5	3/4	.75		

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE:  
 FRACTIONS +/- 1/16"  
 ANGLES +/- 1°  
 .XX" +/- 0.03"  
 .XXX" +/- 0.005"  
 DIMENSIONS TO SHARP POINTS

SHEET NAME	TITLE		
INSTALL STEP 1	17232 BUMPER ON 2017 INTERNATIONAL HX620 SBA		
CURRENT CUSTOMER	STOCK NUMBER	VENDOR NUMBER	WEIGHT - LB.
WO#	DRAWN BY	DRAWN DATE	REV.
	LS	11/3/2017	
SCALE	MODELLER	DRAWING NUMBER	NUMBER OF SHEETS
1:8	HM	AB-45126	1