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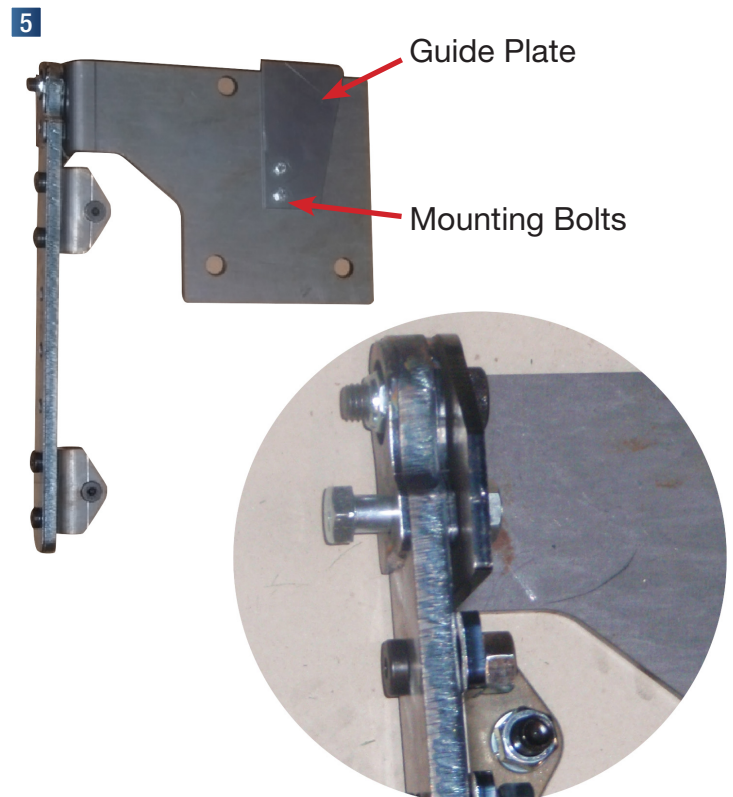
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12Ga

is committed to providing quality parts and welcomes product feedback. We use only a quality and the highest quality of metals. 12 Ga. Stainless is a 304 (nonmagnetic) with a #8 polish surface. We offer most products in stainless, satin coat steel, as well as aluminum.

379 FLIP BUMPER KIT INSTRUCTION

- 1 Remove rubber shrouds from front side of radiator.
- 2 Remove factory bumper.
- 3 Remove factory bumper support brackets from frame and reinstall 5/8 bolts in frame rail if removed.
- 4 Remove swing arm mechanisms from box and bolt to original bumper mounting holes using the factory bumper bolts (leaving bolts finger tight).
- 5 Making sure bumper plates are square to each other, snug the mounting bolts up. We will be tightening them up in our final check later on. (A good reference guide is to ensure the bolt in the centre of the arm is centre with the hood pin.)
- 6 Placing the half inch bolt in the hole below the pivot bolt will restrict the arm from travelling during bumper set up.
- 7 The new style of Flip Kit provides two guide plates to help keep the bumper square during set up. When the bumper set up is complete we will be removing them.
- 8 Please Install 5/8" washer between bracket and frame.



INSTRUCTION

9 Taking the cylinder mounting plates out of the box, ensure that the threaded side of the bolt is sticking away from the frame rails. Please note the rear hole in the cylinder mounting plate is large enough to go over a 5/8 bolt head. Use only the front hole to tighten the bracket to the truck frame.

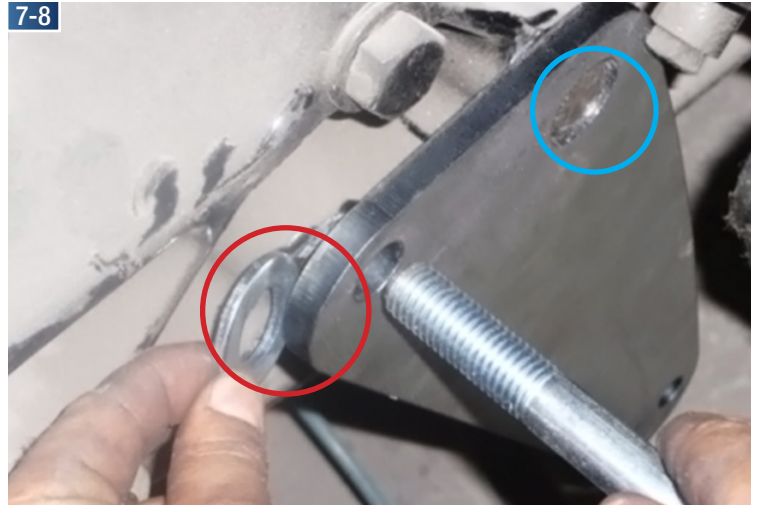
10 Once in place install the cylinder on the bracket with the clevis and cylinder mounting bracket in place. Use ½ inch nylock on cylinder stud and tighten nut just enough to ensure nylock is flush with the end of the bolt and cylinder can still pivot with ease.

11 Place bumper on truck allowing the bumper to rest on arms and guide plates. It's a good idea to have an extra person to keep pressure on the bumper for added safety.

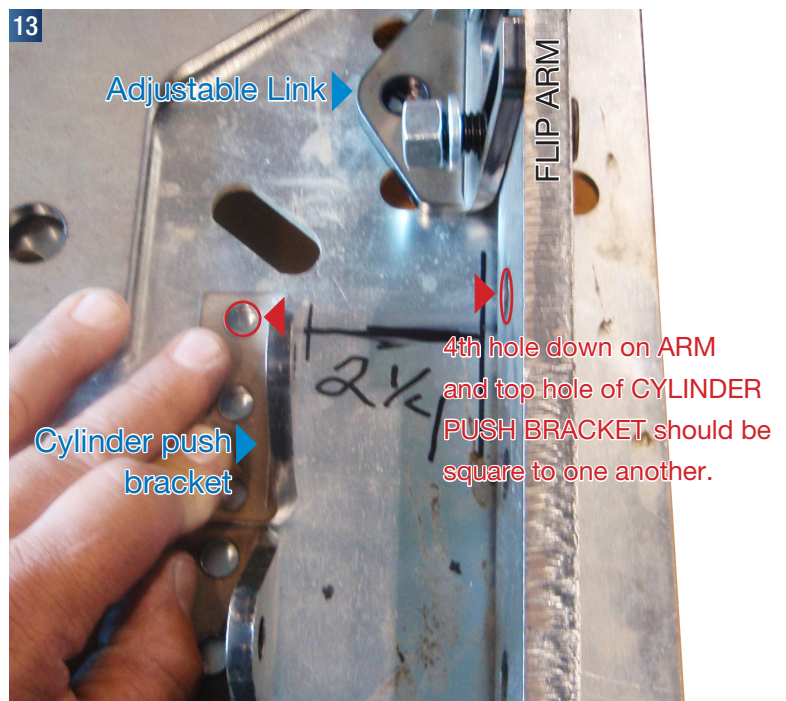
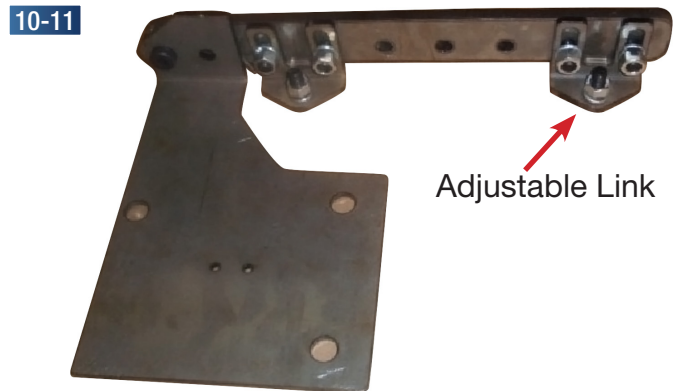
12 With bumper in place make sure bumper is squared on vehicle (side to side). Move the adjustable mounting links on arms until they contact the plate. Do this to all four of them marking the mounting holes on the bumper plate.

13 When the adjustable links have been marked on the bumper plates, measure 2 ¼" in from arm to mark holes for cylinder push bracket. For this, 3 bolts are required per side.

14 Remove the bumper from the vehicle, and take out the inner bumper plates to drill the newly marked holes. Drill ½" holes for the adjustable link brackets, and 3/8" holes for the cylinder push brackets.



Install washer between frame and air cylinder mounting bracket. Hole big enough to clear factory bolt head.



INSTRUCTION

- 15 Remove the guide plates from the swing arm assembly. Bolt bumper plates onto lift bracket assembly. Be sure that all bolts on entire assembly are tight at this point. Install bumper onto bumper plates.
- 16 Remove the ½ inch bolts that keep the swing arm stationary. This will allow the bumper to rest in it's bottomed out position.
- 17 Adjust the bumper taking advantage of the slots in the adjustable links ensuring that the top of the bumper is flush with the grill or even in 1/16th of an inch.
- 18 When the bumper is adjusted properly, tighten the adjustable link bolts. (If the bottom of the bumper appears that it is angled in, there is adjustment available on the plates that come with the bumper)
- 19 With the bumper in place and adjusted, open the hood slowly, and monitor the clearance between the hood and the bumper. If the hood opens with clearance the bumper will flip the same.
- 20 Swing bumper up and support with axle stand at the 75 degrees. Extend cylinders to max travel and swing cylinders up to bumper backing plates. Check that cylinder alignment is parallel with truck frame and mark locations of brackets to bumper backing plates. Remove axle stand and swing bumper back against frame. Bottom out air cylinders. Mount brackets should be ¼" away from marked location on backing plates if not, then lower the brackets ¼". Remove cylinder mounts from cylinders and bolt to backing plates by removing bumper from plates. Reassemble and lower bumper. Assemble air manifold sealing all fittings and plugs.
- 21 Mount electric valve in safe place. eg. Battery Box.
- 22 Route 12v power and ground from customer supplied dash control through plastic grommet and connect to top 2 terminals on solenoid.
- 23 Fill air system, turn up air pressure on regulator fitting then cycle control switch until air solenoid operates freely.
- 24 Turn down regulator clockwise until air supply is cut off. Connect air lines from "T" fittings to proper ports as in.
- 25 **CLOSE HOOD Check that no one is standing in front of unit then proceed.**
- 26 With the air system fully charged and the dash control turned on, turn up the air regulator until the bumper rises fully. Turn the regulator ½ extra turn up and check the operation. Adjust accordingly.

INSTRUCTION

