



INSTALLATION INSTRUCTIONS

FOR MODULAR OR ONE-PIECE BUMPERS
WITH HARDWARE KIT 25407

TO MOUNT A WARN WINCH ON
1972 & PRIOR CHEVROLET/GMC TRUCKS

NOTE: Please read these instructions thoroughly before starting the installation of this kit. Minor modifications may be required due to variations between vehicles.

1. Remove the bumper and bumper supports from the vehicle frame.
2. Align the hole indicated as #3 in frame extension with elongated hole in frame and attach with a 1/2-13 x 1-14 hex head capscrew, flat washer, lock washer and hex nut. Level the frame extension and using hole #2 as a guide, drill a 1/2" diameter hole through frame. Secure frame extension through this hole with a 1/2-13 x 1-1/4 hex capscrew, lock washers and hex nut. Leave bolts finger tight so kit be aligned later. Repeat for opposite side. (See Figure 1)
3. Attach the bumper brace to hole shown as #4 in frame extension with a 1/2-13 x 1-1/4 hex capscrew, lock washers and hex nut. (See Figure 1)

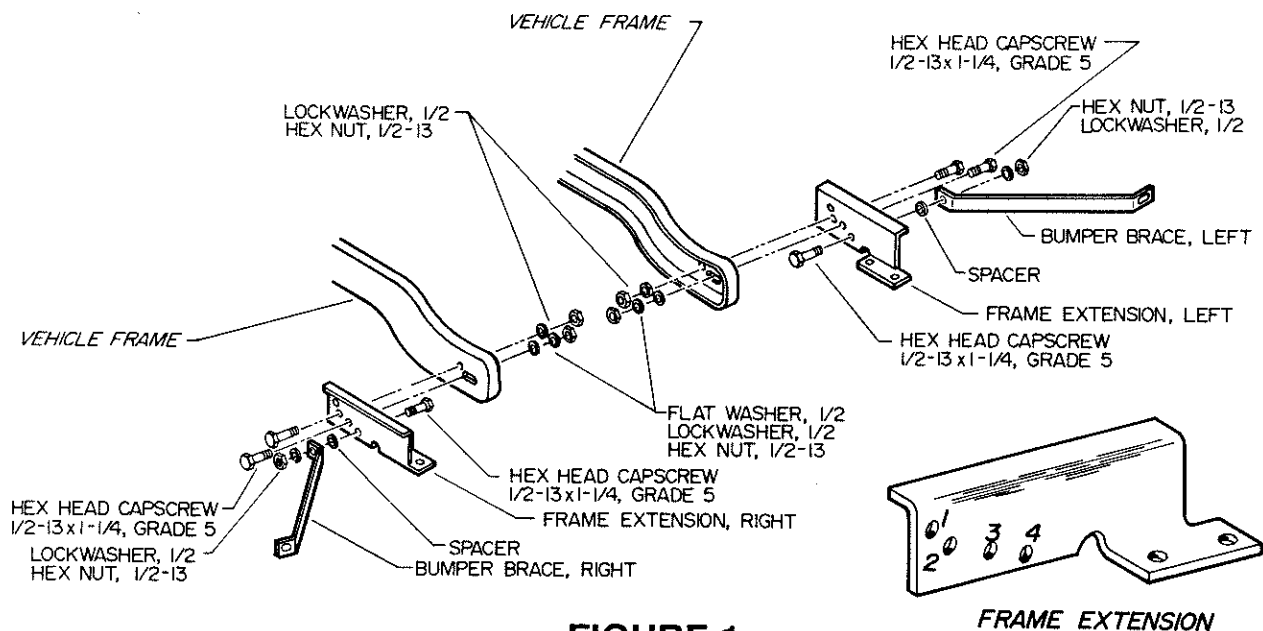


FIGURE 1

10. Attach bumper braces to bumper brace brackets with 1/2-13 x 1-1/4" hex head capscrews, flat washers, lock washers, and 1/2-13 hex nuts. Flat washers must be next to slots in bumper braces and bumper brace brackets. (See Figure 6).
11. Align bumper with vehicle and torque all loose fasteners to torque shown on page 6.
12. Two "Light Guard" brackets are furnished for use on certain models which have the original turn signal lights mounted in the bumper. The original light units and the brackets may be mounted on top of the rock guards with 1/4-20 x 3/4 round head machine screws, lock washers, and hex nuts. Holes must be drilled in the rock guards. (See Figure 7)

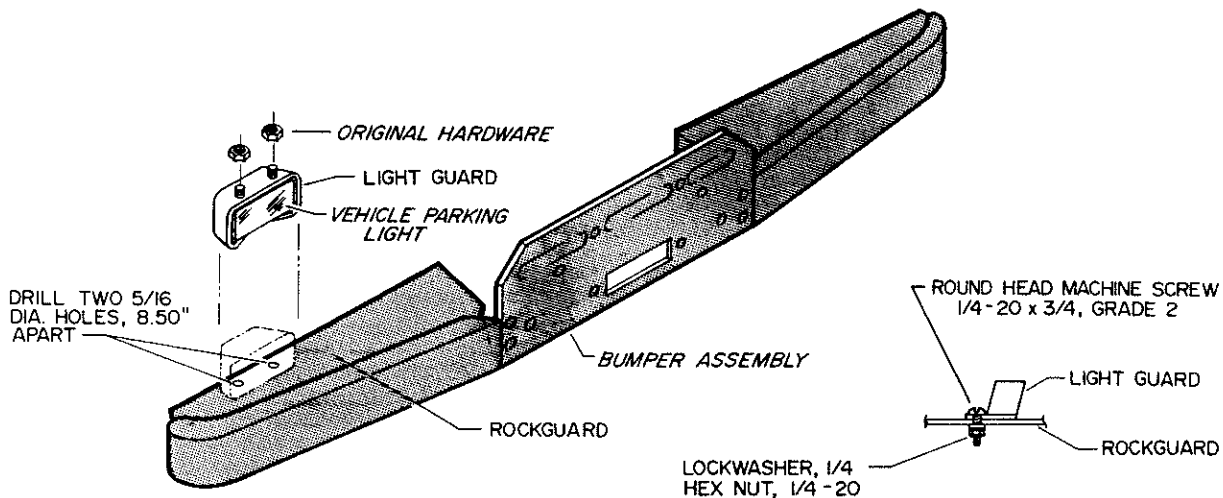


FIGURE 7

13. Install the M8274 as directed in the winch installation instructions. Refer to **Figure 10** for attachment of winch battery cables to a side terminal battery.

NOTE: For other winch installation, omit the previous step and proceed with the following.

14. Install the solenoid bracket on the bumper with 7/16-14 x 1-1/4 capscrews, lock washers, and nuts as shown in **Figure 8**.
15. Install the winch and solenoid unit as directed in the winch installation instructions.

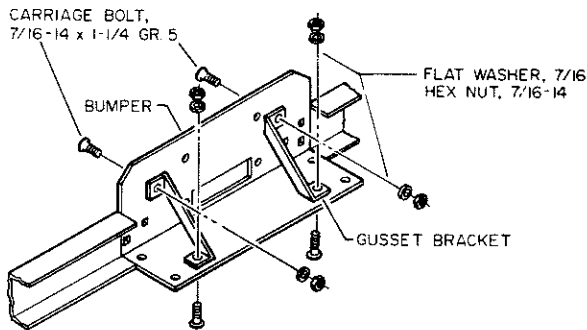


FIGURE 3

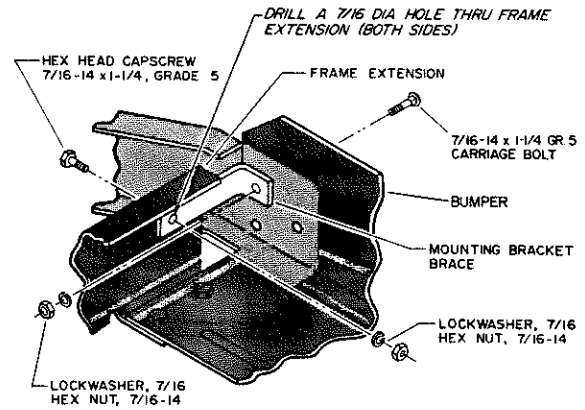


FIGURE 4

9. Align the bumper brace bracket with the holes in the bumper and rock guard. (See Figure 6 for orientation of bracket.) Secure top and bottom of bracket with 5/16-18 x 1 round head machine screws, lock washers, and hex nuts. Follow same procedure for opposite end of bumper.

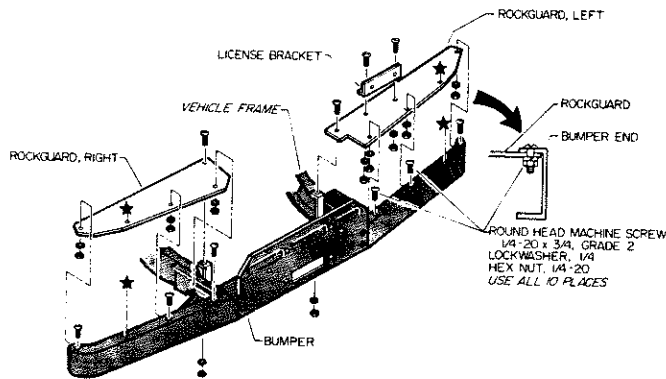


FIGURE 5

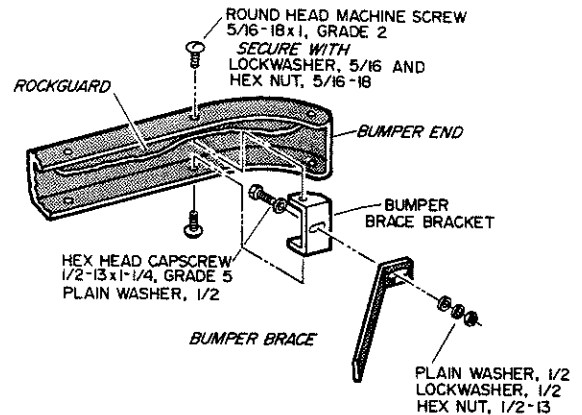


FIGURE 6

- Place the bumper on the frame extensions and secure with 1/2-14x1-1/4" hex head capscrews, lock washers and hex nuts. Rock guard brackets must be attached at rear holes of winch mounting plate. (See Figure 2)

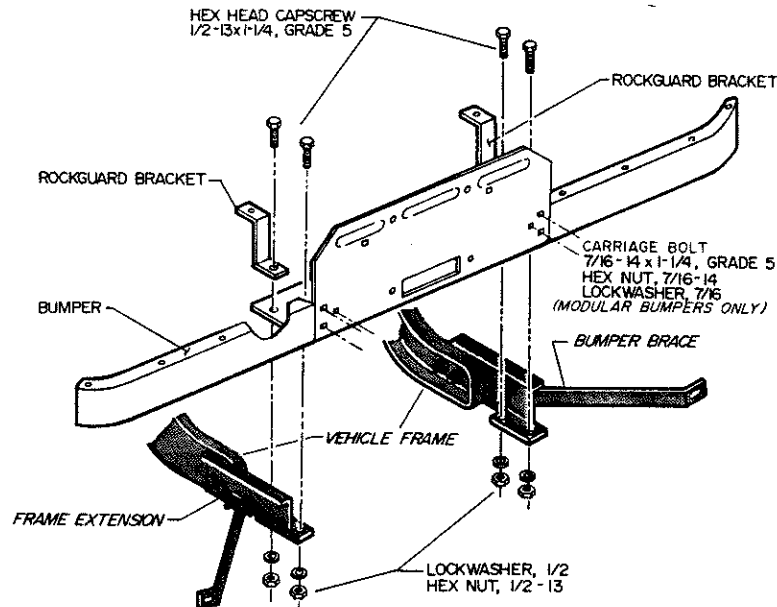


FIGURE 2

- THIS STEP APPLIES TO MODULAR BUMPERS ONLY:**
Attach bumper ends to winch mounting brackets with 7/16-14x11-1/4" carriage bolts, lock washers and hex nuts. (See Figure 2)
- M8274 ONLY:**
Attach gussets to bumper with 7/16-14 x 1-1/4" carriage bolts, flat washers and hex nuts. (See Figure 3)
- ALL EXCEPT M8274:**
Install the right and left mounting bracket braces onto the bumper as shown in Figure 4. Using the hole in the rear end of the braces as guides, drill a 7/16 diameter hole through each frame extension. Install fasteners.
- Attach rock guards to the bumper and rock guard brackets with four 1/4-20 x 3/4" round head machine screws, lock washers, and hex nuts on each side. (See Figure 5)
NOTE: License bracket is attached as shown with 1/4-20 x 3/4" machine screws, lock washers and hex nuts.
NOTE: A longer left hand rock guard is available for installations using a M8274 winch.