

We start assembly by welding Part 4 to the upper tab on the bench. The tube should be centered on the lower hole and perpendicular to the tab.

Parts 1,2,3 & 5 can be assembled off the vehicle if desired. Slot and tabs should locate 1 & 2 together. Part 3 & 5 label should be toward Part 2 for proper orientation. End caps are provided for the tube ends. Ensure all debris is removed from the tubes.

Bolt the tabs to the vehicle in the proper location and then use 4 to space the assembly off the vehicle the desired amount by rotating it on the tabs to 1. There is some adjustment here. Weld the upper gusset on last as it will make access to other weld areas difficult. Enjoy!