



INSTALLATION INSTRUCTIONS FOR ACI
74 - 82 REAR BUMPERS
BCF010, BCF020, FCF010, FCF020

IMPORTANT!
READ INSTRUCTIONS BEFORE BEGINNING INSTALLATION

THE FOLLOWING INSTRUCTIONS INCLUDE 26 STEPS TO FACILITATE THE INSTALLATION OF THE PART NUMBERS LISTED. PLEASE BE AWARE OF THE "NOTE" AND "TIP" REFERENCES. YOU MAY CALL AMERICAN CUSTOM INDUSTRIES FOR TECHNICAL ADVICE, 8:00AM TO 5:00PM EASTERN, SHOULD YOU NEED ASSISTANCE AT 1-800-822-8020.

!!!NOTE!!!

DUE TO THE FACTORY QUARTER PANEL TOLERANCES, BUMPER INSTALLATION VERY LIKELY WILL NOT BE A "BOLT-ON" OPERATION. THE FOLLOWING INSTRUCTIONS TAKE INTO ACCOUNT FACTORY QUARTER PANEL DEVIATIONS. THESE INSTRUCTIONS WILL GUIDE YOU THROUGH THE INSTALLATION PROCESS ALLOWING YOU TO PERFORM A PERFECT REAR BUMPER COVER FIT.

1. REMOVE TAIL AND BACKUP LIGHT RETAINERS AND SET ASIDE FOR LATER INSTALLATION. ON 80 - 82 CARS... REMOVE TWO (2) 7 mm HEX HEAD SCREWS LOCATED IN BACKUP LIGHT BUCKET, VISIBLE ONCE THE BACKUP LIGHT IS REMOVED.
2. REMOVE LICENSE PLATE LIGHT AND RETAIN FOR LATER INSTALLATION.
3. ALL FASTENERS ATTACHING ORIGINAL BUMPER COVER IN THE LICENSE PLATE AREA MUST BE REMOVED AND RETAINED FOR LATER INSTALLATION.
4. REMOVE BUMPER COVER RETAINERS LOCATED ON INSIDE OF BODY PANELS ADJACENT BUMPER COVER. **NOTE... BUMPER RETAINERS ARE STRIPS OF METAL WITH PROTRUDING STUDS.** BEGIN BY REMOVING HEX HEAD NUTS FROM RETAINER STUDS.

!!!TIP!!!

RETAINER NUTS WILL MOST LIKELY BE FROZEN DUE TO RUST. IT IS OUR SUGGESTION TO OVER-TIGHTEN RUSTED NUTS CAUSING STUDS TO BREAK OFF AND TO SPOT-WELD IN NEW STUDS PURCHASED FROM A LOCAL HARDWARE STORE. BUMPER COVER INSTALLATION BOLT KITS ARE AVAILABLE (ACI PART # 601275) THROUGH ACI BY CALLING 1-800-822-8020. IT IS SUGGESTED THAT ALL RUSTED HARDWARE BE REPLACED.

5. ONCE BUMPER COVER RETAINERS ARE REMOVED, REMOVE BUMPER COVER FROM CAR.
6. FOR 75 - 79 CARS... REMOVE THE LEFT AND RIGHT BUMPERETTE REINFORCEMENT BRACKETS FROM IMPACT BAR (SEE FIG. 6).

7. **FOR 75 – 79 CARS...** REMOVE LEFT AND RIGHT TAIL LIGHT HOUSINGS FROM IMPACT BAR (SEE FIG. 7).
8. **FOR 75 – 79 CARS...** REMOVE LEFT AND RIGHT LOWER BRACE FROM IMPACT BAR (SEE FIG. 8). **FOR 80 – 82 CARS...** REMOVE ANY SUBSTRUCTURE AND BRACING CONNECTED TO THE IMPACT BAR. **NOTE... IT IS IMPORTANT THAT ALL SUBSTRUCTURE AND BRACING BE REMOVED FROM THE IMPACT BAR BEFORE INSTALLING NEW BUMPER COVER.**

!!!NOTE!!!

ALL BRACING THAT WAS REMOVED IN STEPS 6 - 8 WAS NEEDED TO SUPPORT THE ORIGINAL FACTORY URETHANE BUMPER COVER. THE BRACING IS NO LONGER NEEDED TO SUPPORT YOUR NEW FIBERGLASS BUMPER COVER.

9. USING 2" MASKING TAPE, MASK BODY OF CAR ALONG TOP OF DECK AND DOWN BOTH QUARTER PANELS (SEE FIG. 9A & 9B). **TIP... TWO LAYERS OF TAPE WORKS BEST HERE.**
10. CLAMP NEW BUMPER COVER ONTO CAR, MAKING SURE CENTER OF BUMPER IS ALIGNED WITH CENTER OF REAR DECK (SEE FIG. 10A). MANIPULATE BUMPER IN THE QUARTER PANEL AREAS TO ATTAIN BEST POSSIBLE FIT WITHOUT MOVING BUMPER FROM CENTERED POSITION. **CAUTION MUST BE TAKEN NOT TO OVERSTRESS BUMPER COVER.** BUMPER COVER FIT TO QUARTER PANELS SHOULD BE FLUSH MINUS UP TO 1/4" PER SIDE. **ON 75 – 79 CARS...** IF BUMPER COVER IS HITTING REAR IMPACT BAR, SHIMS LOCATED BETWEEN IMPACT SHOCKS AND IMPACT BAR MAY BE REMOVED (SEE FIG. 10B). **NOTE... FOR SOME 75 – 79 CARS, IT MAY BE NECESSARY TO ALTER THE IMPACT BAR TO PROVIDE ADDITIONAL CLEARANCE FOR THE 80 – 82 STYLE BUMPER COVER (SEE FIG. 10C & 10D).**

!!!NOTE!!!

CENTERING OF BUMPER IS CRITICAL TO DETERMINE LEFT AND RIGHT QUARTER PANEL BODY TOLERANCES. THIS STEP IS USED TO DETERMINE IF BUMPER COVER WILL NEED TO BE FILLED TO PROPERLY FIT THE IRREGULARITIES IN THE BODY.

11. USING A 90 DEGREE SCRATCH AWL, MARK BUMPER COVER FOR RETAINER ACCESS HOLES BY REACHING INTO BODY AT QUARTER PANELS AND ALONG UPPER DECK AND MARKING BUMPER THROUGH RETAINER HOLES IN BODY (SEE FIG. 11).
12. USING ONE OF THE REAR LAMP REINFORCEMENTS AS A TEMPLATE, MARK HOLES NEEDED FOR INSTALLATION OF TAIL AND BACKUP LIGHTS (SEE FIG 12A). ONCE ALL HOLES ARE MARKED, DRILL USING A 3/8" DRILL BIT. **TIP... TEST FIT ALL REAR LIGHTS WITH INNER AND OUTER RETAINERS TO MAKE SURE ALL LIGHT ASSEMBLIES FIT CORRECTLY INTO BUMPER COVER.** **FOR 75 – 79 CARS...** USE THE TEMPLATE PROVIDED WITH THESE INSTRUCTIONS TO MARK OFF AREA TO BE CUT FOR INSTALLATION OF LICENSE PLATE LIGHT. **FOR 74 CARS...** USE ORIGINAL BUMPER COVER LICENSE PLATE LIGHT OPENINGS TO MAKE A TEMPLATE AND TRANSFER MARKINGS ONTO NEW FIBERGLASS BUMPER COVER. ONCE MARKED, PROCEED TO CUT OUT MARKED AREA. **TIP... A ROTARY CUTTING TOOL, SUCH AS A DREMEL, WORKS BEST FOR CUTTING FIBERGLASS. ONCE**

CUT, SWITCH TO A ROTARY SANDING BIT TO CLEAN UP ANY JAGGED EDGES OF OPENING (SEE FIG. 12B).

13. TAKE NOTICE ALONG ENTIRE BUMPER AND MARK AREAS WHERE ANY FILLING IS NEEDED TO MAKE UP FOR ANY BODY TOLERANCES.
14. REMOVE BUMPER COVER FROM CAR. OPEN RETAINER ACCESS HOLES PREVIOUSLY MARKED IN STEP 11. **TIP... A ROTARY CUTTING TOOL, SUCH AS A DREMEL, WORKS BEST FOR CUTTING FIBERGLASS (SEE FIG. 14A). NOTE... HOLES ACROSS THE TOP OF BUMPER ADJACENT TO THE REAR DECK SHOULD BE ELONGATED (SEE FIG. 14B). RETAINER ACCESS HOLES ALONG SIDES OF BUMPER ADJACENT TO QUARTER PANELS SHOULD BE SLOTTED (SEE FIG. 14C). THE ELONGATED AND SLOTTED HOLES ARE NEEDED FOR EASE OF INSTALLATION OF STOCK AND REPLACEMENT RETAINERS.**
15. IF REUSING STOCK BUMPER COVER RETAINERS, MODIFY OUTSIDE QUARTER PANEL RETAINERS BY REMOVING TOP SECTION OF RETAINER (SEE FIG. 15). INSTALL RETAINERS OR REPLACEMENT STUD KIT INTO BUMPER BY DRILLING AND POP-RIVETING INTO BUMPER. **TIP... COUNTER-SINK HEADS OF POP-RIVETS INTO BUMPER COVER SO HEADS ARE FLUSH WITH BUMPER COVER.**
16. BEFORE ANY SANDING BEGINS, WASH BUMPER DOWN WITH A STRONG DETERGENT, SUCH AS DISH SOAP, TO REMOVE ANY MOLD RELEASE AGENTS PRESENT FROM THE MANUFACTURING PROCESS.
17. USING 150 GRIT SAND PAPER, SAND AREAS OF BUMPER COVER MARKED IN STEP 13 (SEE FIG. 17). **NOTE... THIS STEP IS IMPORTANT TO ENSURE ADEQUATE ADHESION OF FILLER MATERIAL TO BUMPER.**
18. WITH RETAINERS INSTALLED, CLAMP BUMPER COVER ONTO CAR. MAKE SURE BUMPER IS CENTERED WITH THE CENTER OF THE REAR DECK.
19. THIS STEP IS USED TO APPLY THE FILLER MATERIAL TO THE BUMPER COVER TO MAKE UP FOR FACTORY BODY TOLERANCES. THE FILLER MATERIAL IS APPLIED TO THE BUMPER COVER ON THE AREAS SANDED IN STEP 16 EXTENDING ONTO THE REAR BODY PANELS OVER THE MASKING TAPE PREVIOUSLY APPLIED IN STEP 8 (SEE FIG. 19). **TIP... WHEN APPLYING FILLER, PACK FILLER TIGHTLY IN SEAM BETWEEN BUMPER COVER RETURN LIP AND REAR BODY OF CAR TO FILL ANY IRREGULARITIES. CAUTION MUST BE TAKEN NOT TO HAVE FILLER MATERIAL COME INTO CONTACT WITH UNPROTECTED PAINTED SURFACES. NOTE... IF AMOUNT OF FILLER NEEDED IS 3/16" OR LESS, "BONDO" OR A POLYESTER BASED BODY FILLER WORKS FINE. FOR THOSE APPLICATIONS THAT WARRANT MORE THAN 3/16" OF FILLER, WE SUGGEST USING "EVERCOAT 880 : VETTE PANEL ADHESIVE". TIP... USE ONLY AMOUNT OF FILLER NEEDED. USING EXCESS AMOUNTS OF FILLER CAUSES A LONGER CURE TIME.**

20. ONCE FILLER MATERIAL HAS COMPLETELY CURED, SAND FILLER ACROSS SEAM OF REAR BUMPER COVER AND REAR BODY PANELS. SAND UNTIL THE MASKING TAPE BECOMES VISIBLE ON REAR BODY PANELS. WHEN MASKING TAPE IS VISIBLE, BUMPER COVER AND BODY PANELS ARE ALIGNED WITH EACH OTHER.
21. ONCE SANDING IS COMPLETE, GENTLY REMOVE BUMPER COVER FROM CAR. **NOTE... CARE MUST BE TAKEN WHEN SEPARATING BUMPER FROM CAR BY BREAKING THE "BRIDGE" CREATED BY THE FILLER BETWEEN BUMPER COVER AND BODY. WITH BUMPER COVER REMOVED, SAND ANY JAGGED FILLER EDGES ON BUMPER (SEE FIG. 21).**
22. ONCE SANDED SMOOTH, FIT BUMPER BACK UP TO BODY TO MAKE SURE THE FIT IS ADEQUATE (SEE FIG. 22). **NOTE... ADDITIONAL FILLER MAY BE ADDED AT THIS TIME IF NEEDED.**
23. WHEN YOU ARE SATISFIED WITH THE FIT, REMOVE BUMPER COVER AND COMPLETE ALL NECESSARY PREP AND PAINT WORK.
24. INSTALL TAIL LIGHTS, BACKUP LIGHTS, AND LICENSE PLATE LIGHTS INTO BUMPER COVER.
25. INSTALL "CORVETTE" SCRIPT OR INDIVIDUAL "CORVETTE" LETTERS INTO BUMPER.
26. INSTALL AND ALIGN BUMPER COVER ONTO BODY.

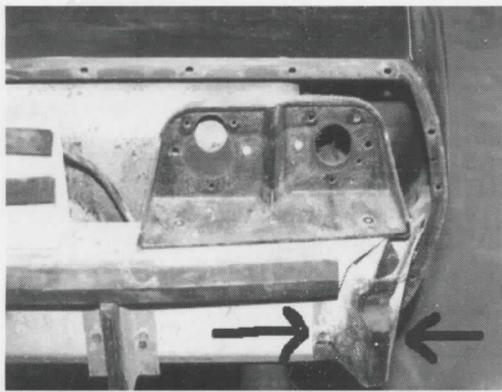


FIG. 6

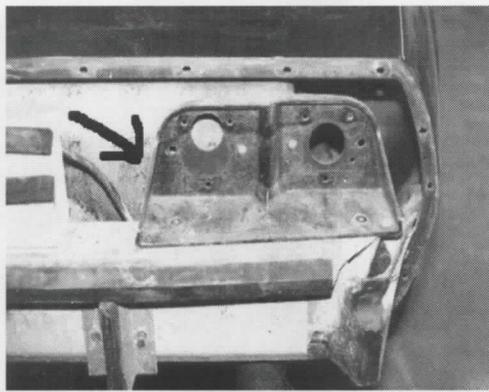


FIG. 7

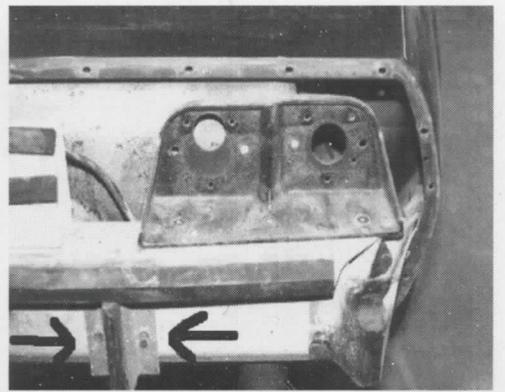


FIG. 8



FIG. 9A

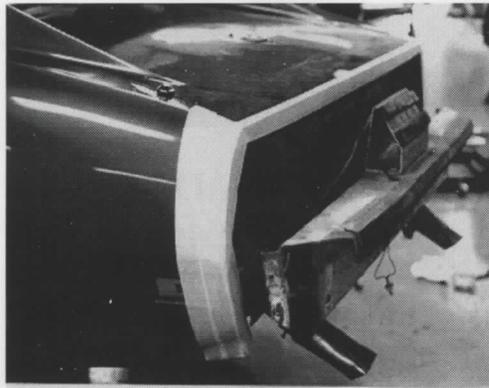


FIG. 9B

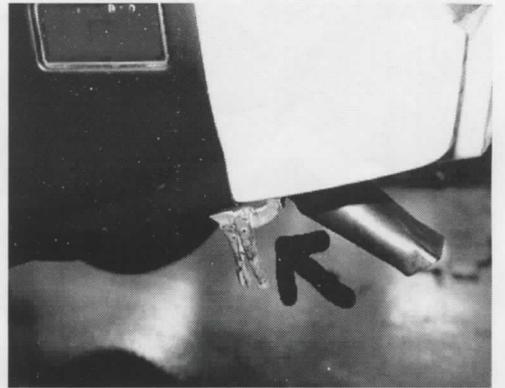


FIG. 10A

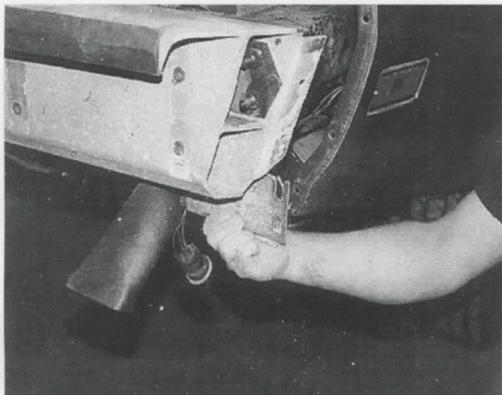


FIG. 10B

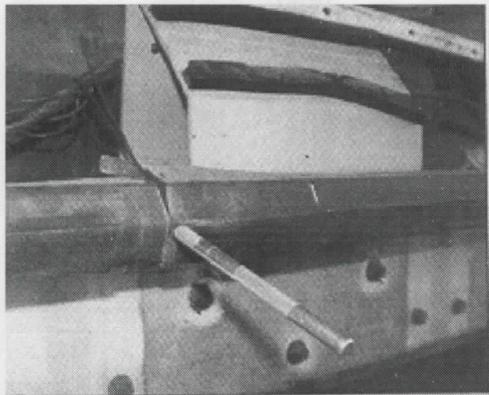


FIG. 10C



FIG. 10D

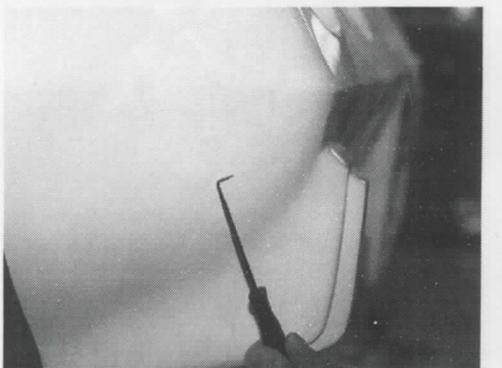


FIG. 11

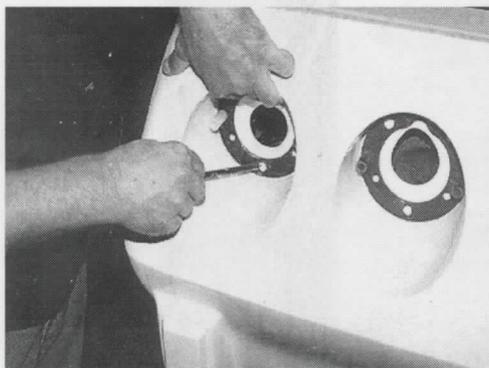


FIG. 12A



FIG. 12B

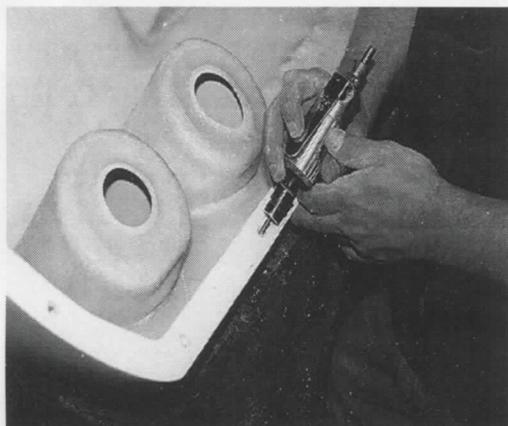


FIG. 14A

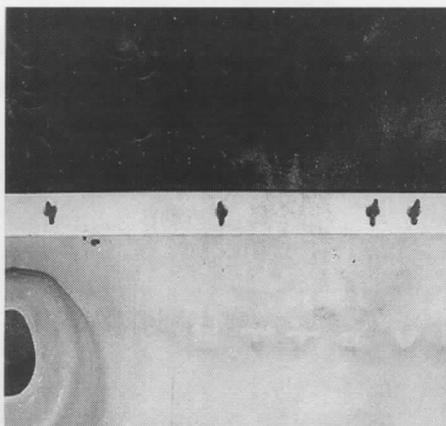


FIG. 14B

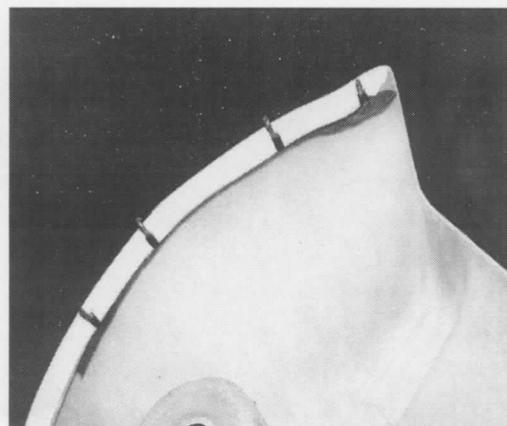


FIG. 14C

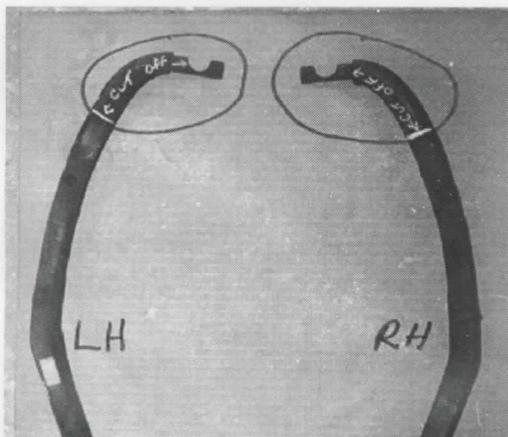


FIG. 15



FIG. 17

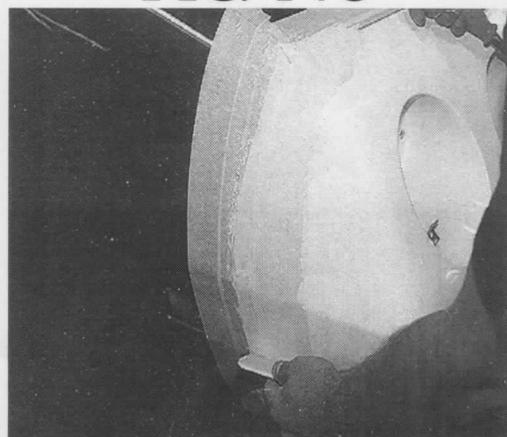


FIG. 19



FIG. 19B

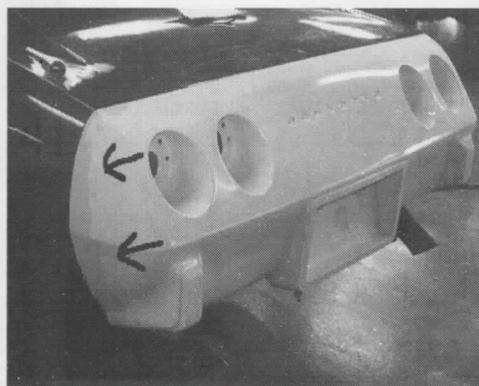
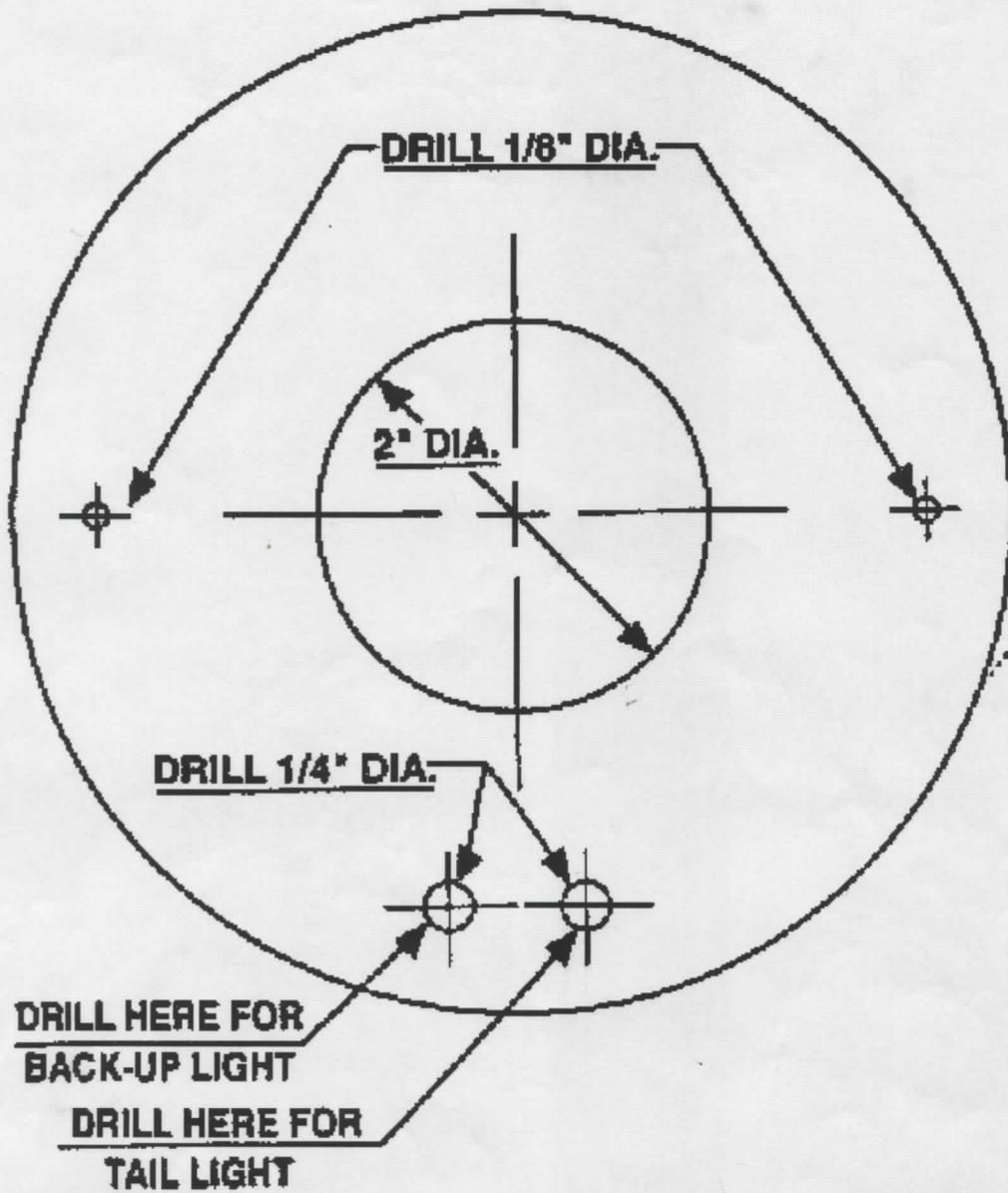


FIG. 22

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