



INSTALLATION INSTRUCTIONS FOR ACI
73-74 FRONT BUMPER
JBF010

IMPORTANT!
READ INSTRUCTIONS BEFORE BEGINNING INSTALLATION

THE FOLLOWING INSTRUCTIONS ARE INTENDED TO FACILITATE THE INSTALLATION OF THE PART NUMBER LISTED. YOU MAY CALL AMERICAN CUSTOM INDUSTRIES FOR TECHNICAL ADVICE, 8:00AM TO 5:00PM EASTERN, SHOULD YOU NEED ASSISTANCE AT 419-882-2091

1. REMOVE FRONT LOWER VALANCE.
2. REMOVE GRILLES USING A PHILLIPS SCREWDRIVER.
3. REMOVE URETHANE BUMPER COVER USING A 3/8" SOCKET.
4. REMOVE RUBBER STRIP FROM ACROSS THE FRONT OF THE IMPACT BAR (SEE DIAGRAM A).
5. TEST FIT YOUR NEW FIBERGLASS BUMPER TO THE CAR, CHECKING FOR ANY ADJUSTMENTS THAT MAY NEED TO BE MADE TO ACHIEVE PROPER FIT. THE IMPACT STRUCTURE MAY NEED TO BE ADJUSTED FOR PROPER CLEARANCE (SEE DIAGRAM A). SEE THE ADDITIONAL INFORMATION ABOUT CORVETTE BUMPERS AT THE END OF THESE INSTRUCTIONS FOR MORE INFORMATION REGARDING ALIGNMENT AND FITTING.
6. AFTER ADJUSTMENTS HAVE BEEN MADE, AND YOU ARE SATISFIED WITH THE FIT, MARK THE RETAINER HOLES USING THE FENDERS AND HOOD SURROUND. USING A 3/8" DRILL BIT, DRILL THE RETAINER HOLES IN THE BUMPER.
7. INSTALL RETAINERS IN BUMPER. **NOTE...** YOU MAY PAINT THE FLANGE AREA BEFORE INSTALLING RETAINERS.
8. CHECK BUMPER AGAIN FOR ADEQUATE FIT, DO NOT INSTALL UNTIL YOU HAVE COMPLETED ALL NECESSARY PREP AND PAINT WORK. REMOVE BUMPER AND COMPLETE NECESSARY PAINT WORK.
9. REINSTALL BUMPER, GRILLES, AND VALANCE.



ADDITIONAL BUMPER COVER INFORMATION FOR ACI
73-79 BUMPER COVERS
JBF010, EBF010

THERE ARE INSTANCES WHERE BUMPER COVERS DO NOT ALIGN OR FIT PERFECTLY. IT IS A KNOWN FACT THAT THE ORIGINAL GM BUMPER COVERS DID NOT FIT THE CARS PERFECTLY. DURING THE PROCESS OF ASSEMBLING THE FRONT AND REAR CLIPS, THE BONDS WERE SUBJECT TO DISCREPANCIES WHICH DID NOT ALLOW THE BUMPER COVERS TO FIT WELL. UNDERSTANDING HOW THE CORVETTES WERE ASSEMBLED DURING PRODUCTION WILL BENEFIT IN THE INSTALLATION OF YOUR NEW BUMPER COVER.

THE FRONT SURROUND WAS PLACED IN A LARGE JIG AND A CENTERING MECHANISM WAS PUSHED. THE TWO FENDERS WERE THEN INSERTED IN ANOTHER JIG AND AGAIN A CENTERING MECHANISM WAS PUSHED. ONCE IN THE JIG, A LARGE AMOUNT OF GLUE WAS SQUIRTED IN PLACE AND THE BONDING STRIPS ADDED. EXCESS GLUE CAUSED THE FENDERS TO BE PUSHED OUTWARD MAKING THE CAR WIDER, AND LESS GLUE WOULD CAUSE THE CAR TO BE SKINNIER. THE REAR CLIPS WERE ASSEMBLED IN A SIMILAR MANNER.

URETHANE, FIBERGLASS, AND FLEXIBLE FIBERGLASS FRONT AND REAR BUMPERS WILL NOT FIT PERFECTLY. WITH A URETHANE BUMPER YOU ARE STUCK WITH WHAT YOU GET, BUT FIBERGLASS AND FLEXIBLE FIBERGLASS BUMPERS CAN BE FILLED ON THE SIDES TO MAKE THE EDGES MEET PERFECT. IN SOME RARE CASES, MATERIAL MAY EVEN BE REMOVED TO ALLOW FOR A BETTER FIT. THE FIBERGLASS AND FLEXIBLE FIBERGLASS BUMPER COVERS CAN BE FIT WITH LITTLE PROBLEMS BY AN EXPERIENCED BODY SHOP. URETHANE COVERS CAN BE STRETCHED TO FIT CLOSER TO THE ORIGINAL NOSE OR REAR END OF THE CAR, BUT DOING SO WILL ONLY GIVE YOU WAVES AND DIPS IN THE BUMPER COVER.

WE SUGGEST SEEKING A PROFESSIONAL BODY SHOP WITH CORVETTE EXPERIENCE TO INSTALL YOUR NEW FIBERGLASS BUMPER COVER(S). PLEASE REFER TO THE INSTALLATION INSTRUCTIONS PROVIDED TO FACILITATE THE INSTALLATION PROCESS.

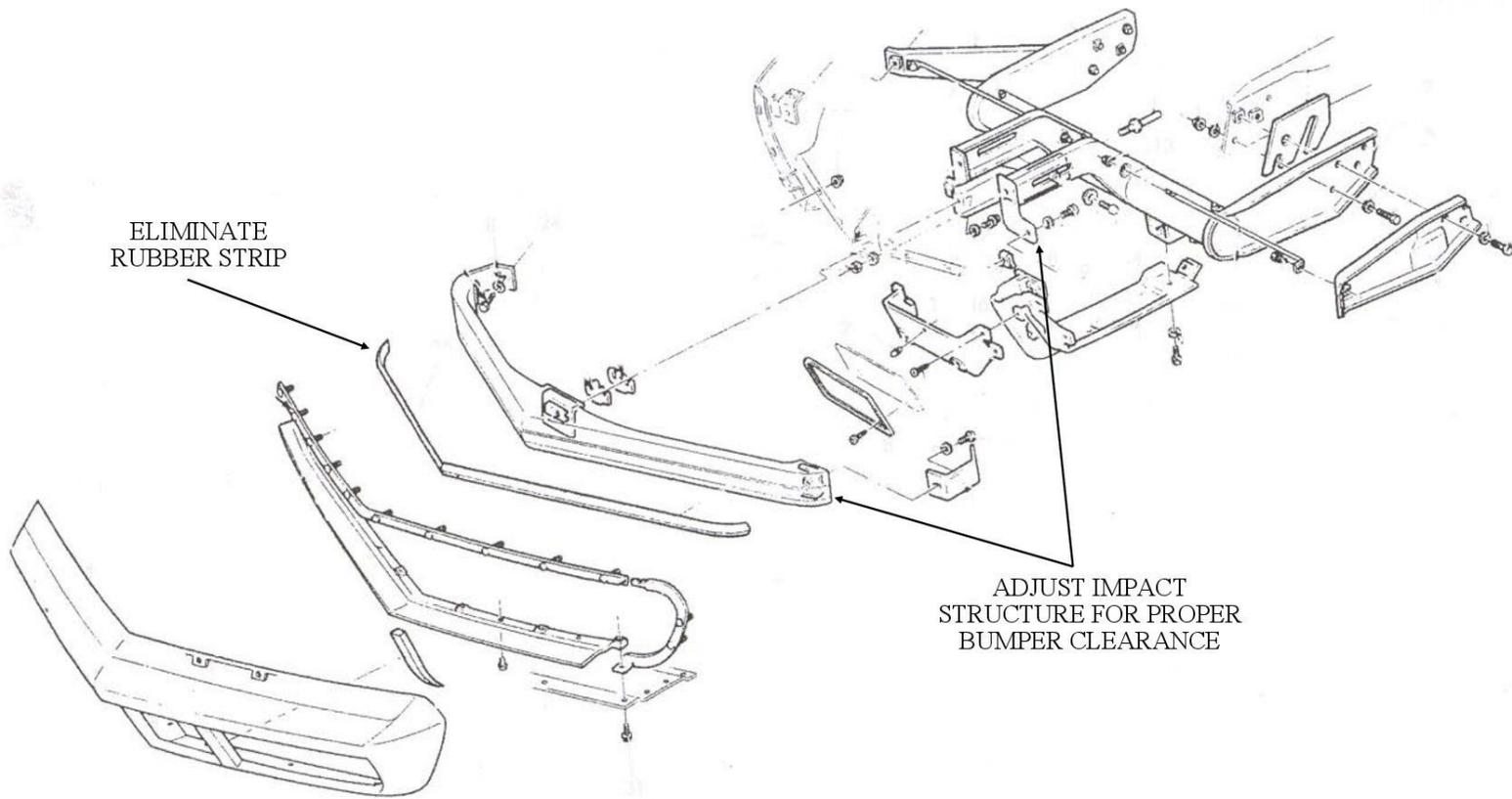


DIAGRAM A