



INSTALLATION INSTRUCTIONS

Item Description
Vehicle

Front bumper
2003-2009 GX Lexus

DEMELLO-OFFROAD

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Kit contents for bumper	
1- 2003-2009 GX front bumper	6- 3/8in x16x2" bolts
2- Frame brackets	
2- M12x1.25x30 bolts	12- 3/8in uss washers
2- M8x1.25x35 bolts	12- 12" wire loom for AC line
2- 5/16in Lock washers	1 – installation guide
2- 5/16in uss washers	

Tools recommended for installation	
3/8" ratchet	12mm, 13mm, 14mm, 10mm
Torque wrench (0-60 lb-ft)	
Flat head screwdriver	Pliers
Helpful tips: a couple friends to help lift the bumper into place is always a plus.	

Bolt torque settings	
2 – side frame bolts 60 lb-ft	

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These instructions are for a 2003-2009 DeMello off-road Lexus GX bumper. We made these instructions to the best of our knowledge to cover the different models of the 2003-2009 Lexus GX, as any aftermarket equipment, we recommend common sense and being comfortable with modifying your vehicle. If you are not comfortable with that, please contact your local off-road shop for installation. Please feel free to contact us as well so we can help make that choice for you. If you find our instructions lacking any information, please let us know so we can correct it.



Step 1.) Start off with your 2003-2009 on nice level ground, pop your hood and follow the directions.



Step 2.) After the hood is open, start removing the plastic rivets that hold the plastic radiator cover in place. There are several across the top and then three that go into the bumper.

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Step.2) The plastic rivets can be removed with a flat screwdriver. Simply pry the inner button part and the outer ring. Then lift out of the bumper. It's not a bad idea to clean these first to insure they come out easily if your vehicle has a lot of road grime.



Step.3) on both sides of the bumper you will find 10mm bolts tucked away up in the fenders. You need to remove these

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from both sides of the bumper.



Step 4.) you will also find two bolts on both sides of the bumper that need to be removed as well.



Step 5.) You will also remove the bolts holding the bottom tabs of the front bumper to crash bar behind it. Different years have a different amount of bolts. Be sure to remove them all.

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Step 6.) On the inside of each bumper, you will find 10mm bolts holding the bumper to the inner plastic fender, remove as well from both sides.



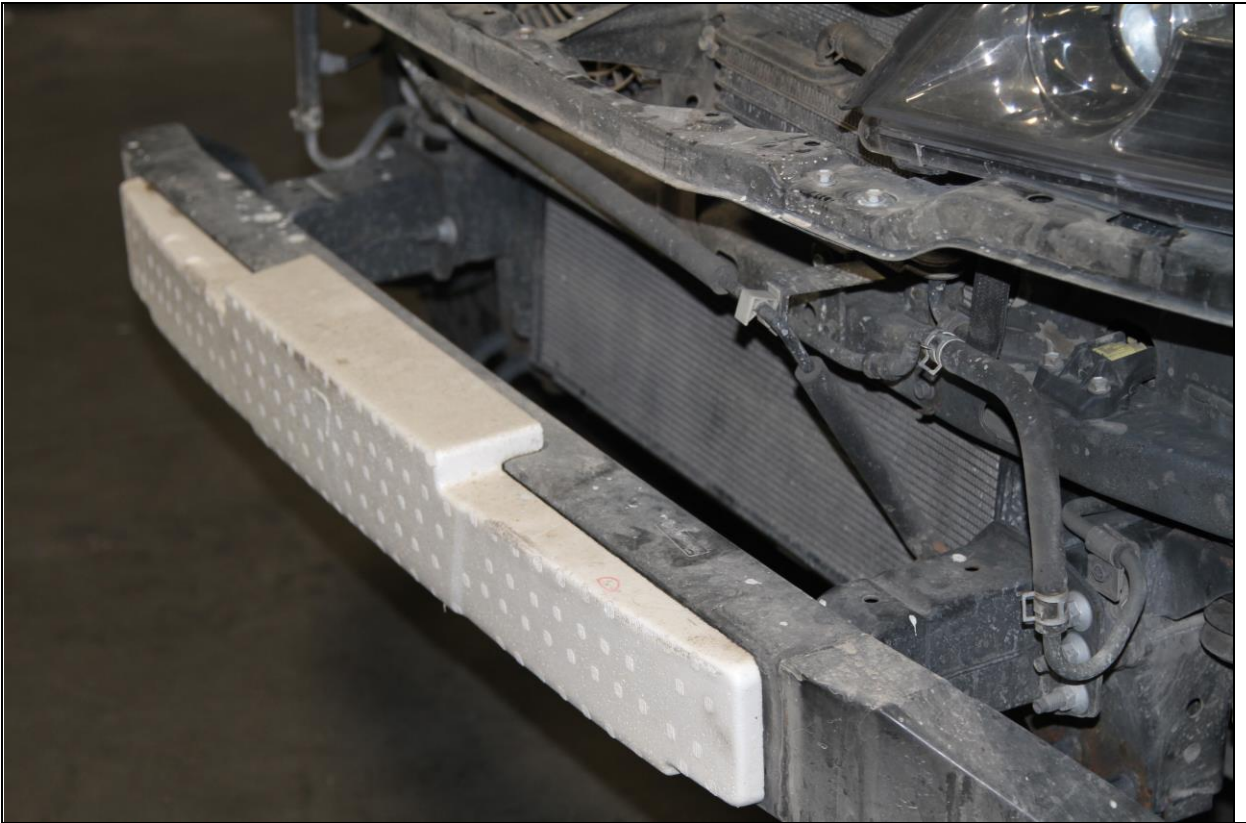
Step 7.) Once you have removed all the bolts, all the plastic rivets from the front bumper that secure it. You are now ready to give one side a sharp tug and "POP" the outside edge off. Repeat this step on both sides.



Step 8.) while the ends are both off it's a good time to unplug the factory fog lights from the factory harness.



Step 9.) You are now ready to remove the factory bumper and put it aside.



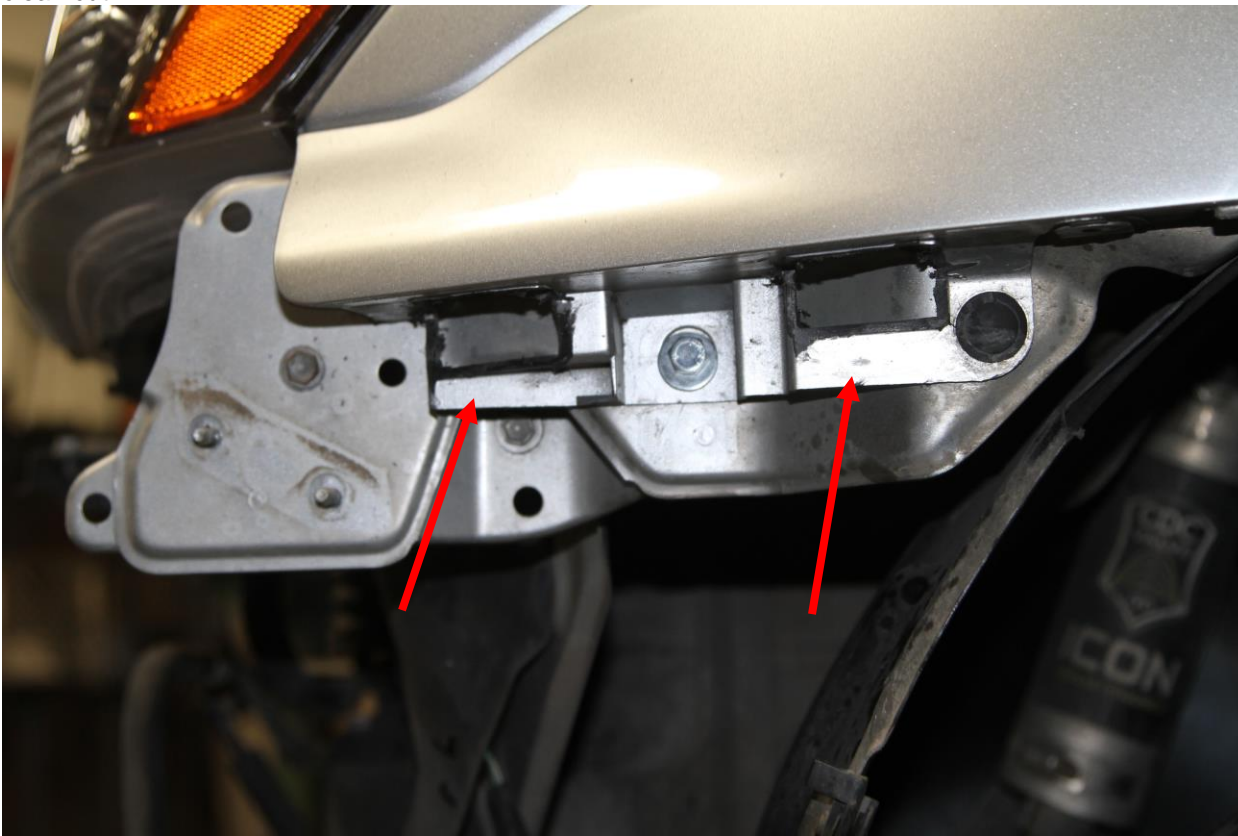
Step 10.) you can now start removing the metal and plastic pieces that will no longer be used. Please refer to the pictures of what to remove.



Remove all the hardware holding the metal light supports on both sides along with the center support.



Step 12.) you will also need to trim/cut the two plastic tabs on both sides of the lower (hidden) fender area. These tabs can be cut with a box cutter with a little heat applied to it or we use a mini air saw for a clean cut.



The trim pieces should look like this when cut.



Step 13.) Now you remove the bolts holding on your bash bar from the frame horns on both sides. An extension and 14mm socket is required for this.



Step 14.) once the bash bar is un-bolted you can remove it from the vehicle.



Step 15.) Now you can remove the 4 nuts per side holding on the frame extenders. None of these parts will be used again.



Step 16.) now using a small hammer or sledge tap the outer studs mounted in the frame at a 45° angle. (DO NOT HIT HEAD ON). This will knock the welds loose on the back side and they should fall out. Only remove the outer three bolts you will leave the middle ones for bumper alignment and resting the bumper on.



Step 17.) Optional Step for those that have the light bar version of the bumper. Now is a good time to install that 30in light bar. Please note that we have tested Baja designs light bars as well as rigid and KC 30in light bars and they fit good with a smitty built winch. We can't confirm what other makes or models fit. Please be sure to measure and or test fit before you order your winch and lights.



Step 18.) At this time, it's important to make sure your AC line is carefully bent out of the way and won't make contact with the bumper. While some won't need bent at all others will need to be bent to clear the bumper, we recommend bending it as much as possible with out kinking it or damaging it. This can be done carefully with two hands gently applying pressure to the upper section while firmly holding the lower section of the ac line shown above.



Step 19.) With the help of a friend, it is time to test fit the bumper. Be sure to be careful not to scratch the lights or fender flares.



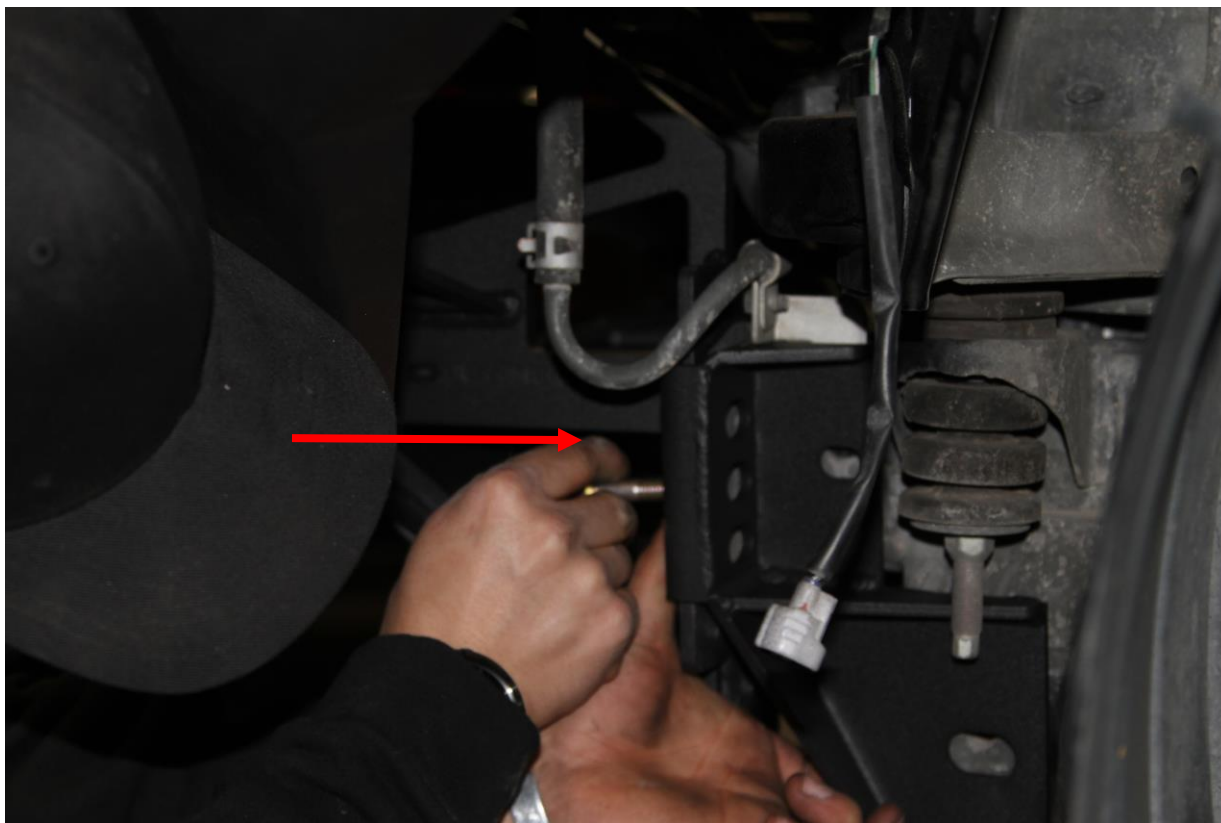
Step 20.) It's a good idea to tape off the fenders and or head lights to ensure you don't make contact with the bumper.



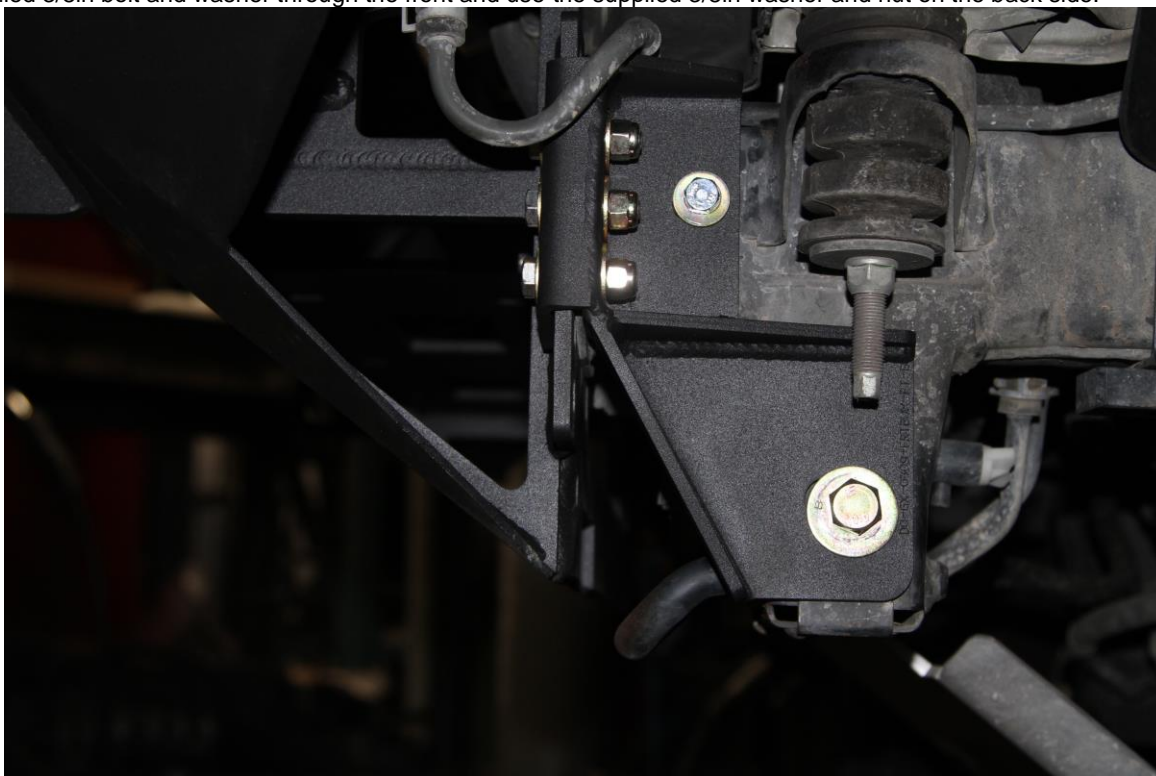
Step 21.) when installing the bumper, we recommend a $\frac{1}{4}$ = $\frac{1}{2}$ in gap around the fenders and lights. The body on frame design of all Toyotas and flexible body mounts allows the body to move a lot on and off-road the more clearance the more it will reduce bumper and body contact.



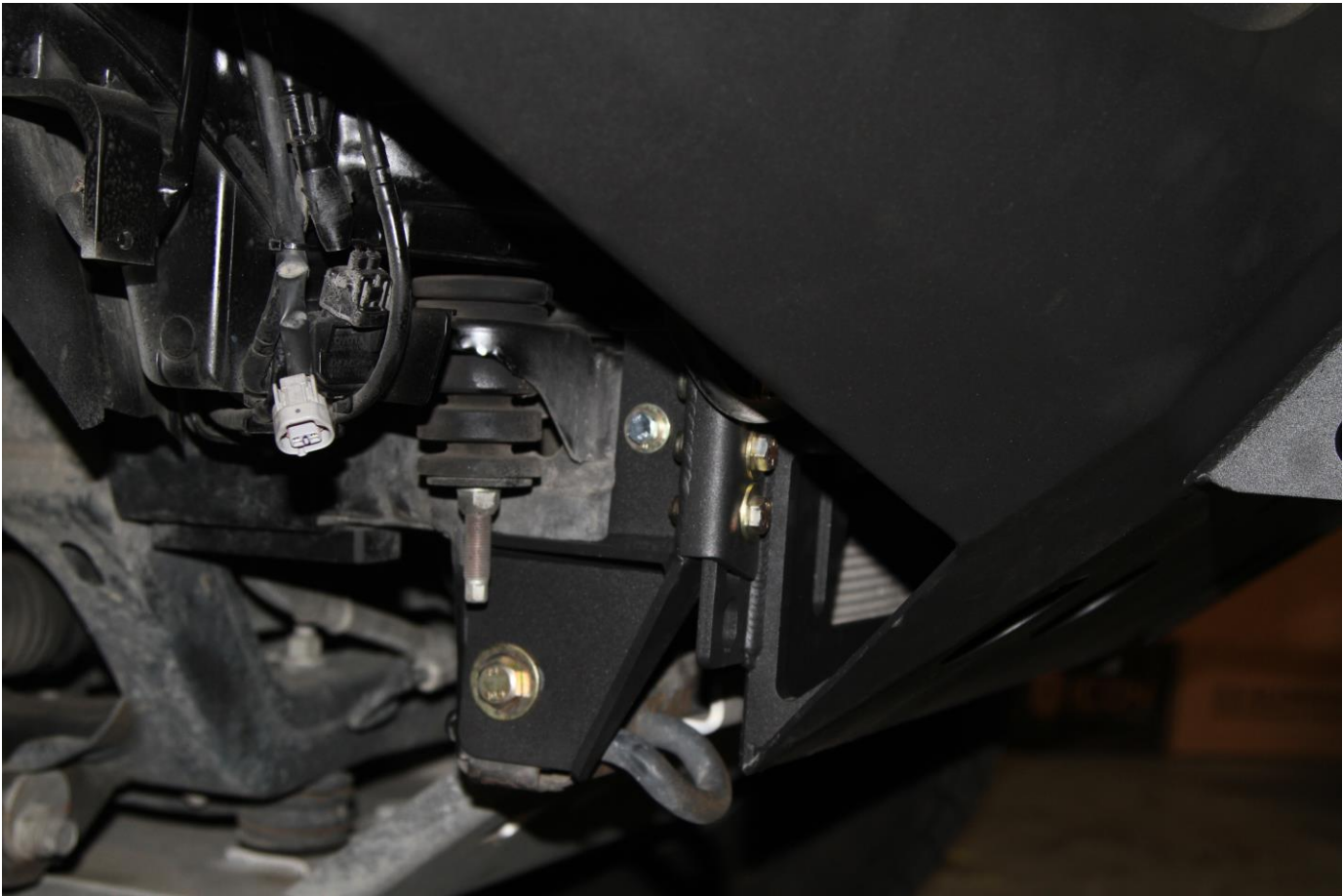
Step 22.) While the bumper is being held in place we recommend installing the factory nuts onto the inside studs at this point to hold the bumper in place. It's again ideal to have someone hold the bumper in place while this is done. Once you have both hand tight you can use a floor jack to level off the bumper left to right and then tighten the two inner nuts down.



Step 23.) now you can add the re-enforced side brackets. These are placed over the bumper and the frame as shown above. Then run the supplied 3/8in bolt and washer through the front and use the supplied 3/8in washer and nut on the back side.



Step 24.) insert the remaining bolts that mount into the side of the frame. M8 with 5/16 lock washer and nut go in the top position and the m12 goes in the lower position. Be sure bumper is level and how you want it to sit. Then tighten all bolts down alternating from side to side. The bumpers have adjustments built in for body lifts and or adjustment for left to right heigh difference.



Optional: It has been our experience with some Toyota/Lexus late model vehicles that the super soft body mounts that mounts the body to the frame can become compressed over time, causing the body to sit lower on the driver side compared to the passenger side. This could be due to the vehicles having an offset weight left to right with the battery, gas tank and driver all on one side of the vehicle. It can also be because the bushings simply wear out over time. If your bumper is hard to level left to right we recommend loosening up both the left and right front body mounts and add several washers between the body and the body mounts to the front driver side body mount. You can also add washers to the passenger side just below the nut, giving you more threads and tighten the passenger side down.



You are now ready to enjoy your Lexus front bumper! If you have any questions please feel free to contact us!