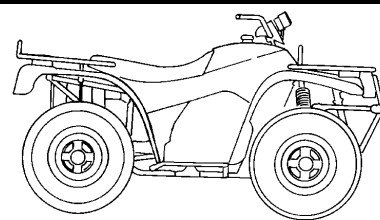


Arctic Cat® ATV

Installation Instructions - Accessory Kit

Front Bumper Kit (p/n 1436-031)



■ **NOTE:** Read these installation instructions thoroughly before beginning the installation process. Retain these Installation Instructions for future reference.

Application: 2008 500,650,700,TRV and Thundercat

Kit includes:

p/n	QTY	DESCRIPTION
2506-639	1	Front Bumper Assembly (LE)
2506-641	2	Bumper Support Strap
8410-835	2	Cap Screw (8 mm x 35 mm)
8424-805	2	Flanged Nut
0441-501	1	Decal (Arctic Cat)
0453-456	1	Instructions

1. Remove the hardware securing the existing front bumper to the ATV. Be sure to take note of the mounting locations and orientation of hardware for assembly purposes. Retain hardware for assembly purposes.

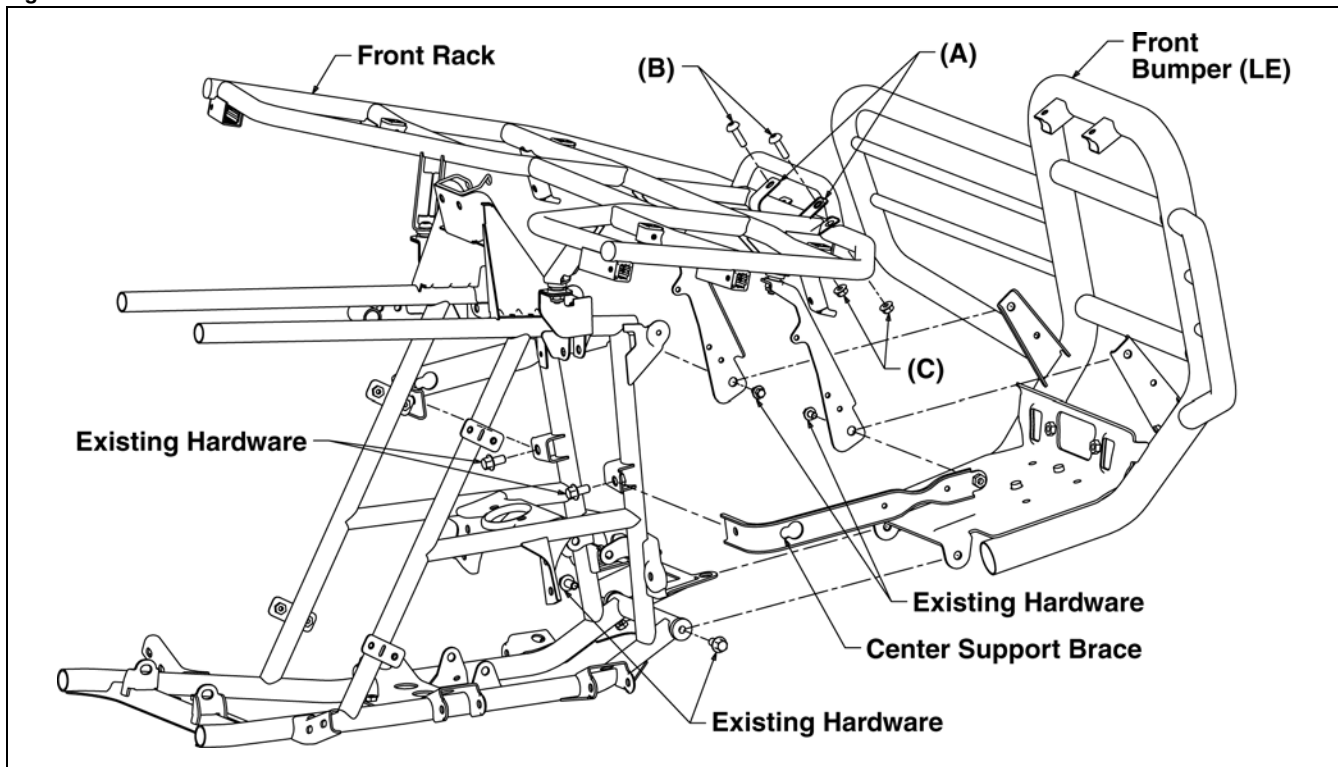
■ **NOTE:** When removing the existing bumper, it is not necessary to remove the hardware securing the rear of the center support braces to the ATV frame. The hardware, however, should be loosened enough to allow for the braces to be moved for alignment purposes.

2. Position the bottom mounting bracket of the bumper onto the outside of the frame mounting holes and loosely secure with existing hardware. See Fig. 1 or 2.

■ **NOTE:** Do not tighten any hardware at this time. It is very important that the hardware remain loose to ensure easy alignment of all the remaining brackets and mounting holes.

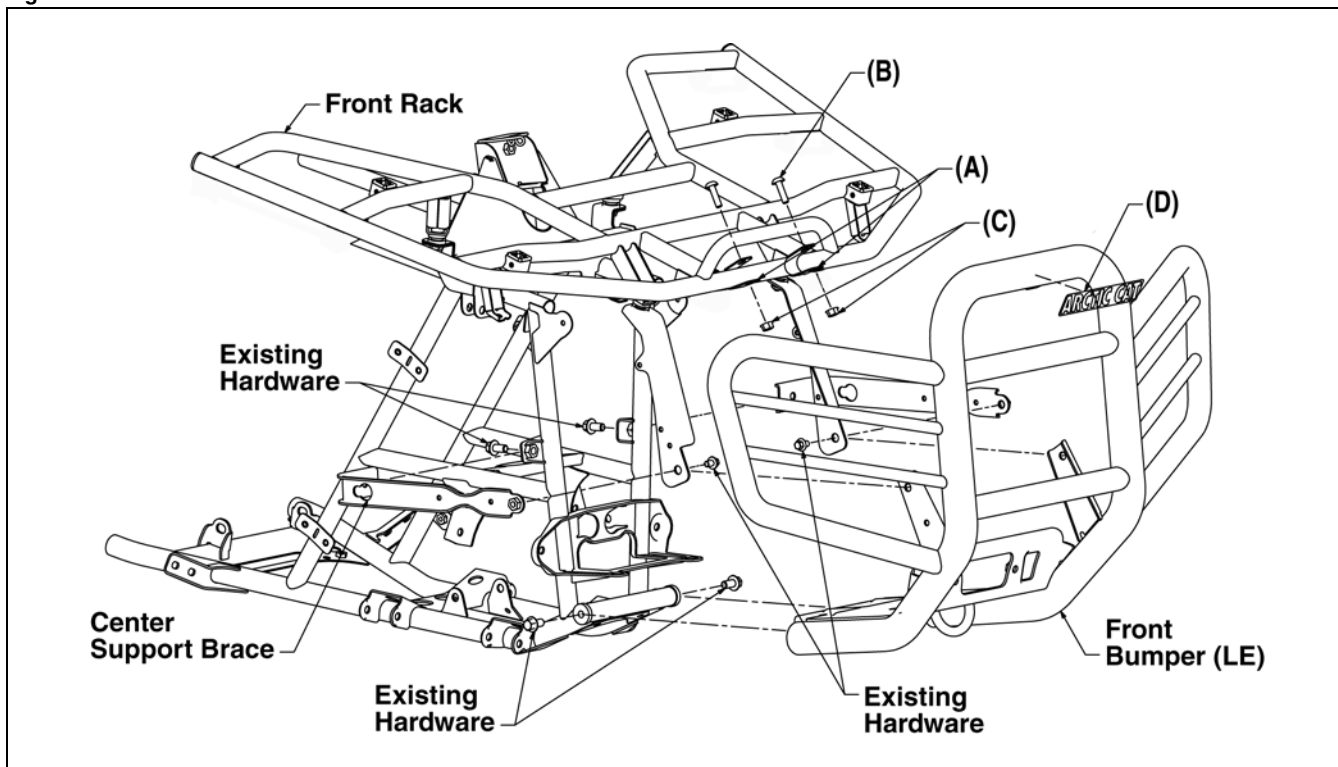
3. Position the center mounting brackets of the bumper onto the outside of the center support braces and rack brackets. Align the mounting holes; then loosely secure with existing hardware removed in step 1. See Fig. 1 for mounting locations and orientation of hardware.
4. Loosely secure the top of the bumper to the ATV rack using two Bumper Support Straps (A), Machine Screws (B), and Flanged Nuts (C). See Fig. 2 for mounting locations and orientation of straps and machine screws.
5. Making sure all mounting brackets and braces are properly positioned and aligned, tighten all hardware until snug.
6. Tighten the hardware securing the support straps to 2.8 kg-m (20 ft-lb).
7. Tighten the hardware securing the bottom of the bumper to 5.5 kg-m (40 ft-lb).
8. Tighten the hardware securing the rear of the cross support to 5.5 kg-m (40 ft-lb).
9. Tighten the hardware securing the front of the cross support to 2.8 kg-m (20 ft-lb).
10. Thoroughly clean the upper front bumper location where Decal (D) is to be affixed. Allow the area to dry; then affix the decal. See Fig. 2.

Fig. 1



453-315C

Fig. 2



453-315D

