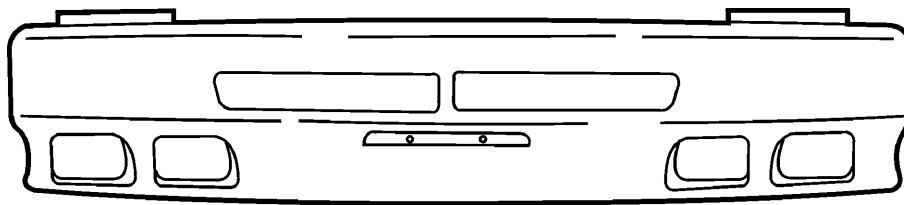


This Service Bulletin is a supplement to Service Manual, Group 86, Front Bumper, VNL, VNM, PV776-TSP103726/1

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Front Bumper
VN, VNM

Blank Bumper Modification



W8002401

This service bulletin details the modification of the VN Blank Bumper into a bumper with 2 fog light cut outs, or 2 fog light cut outs together with 2 driving light cut outs. The holes for the lamps are cut out in pre-designed recesses in the bumper.

This bulletin contains the following information:

- [“Fog Light Bumper Holes, Fabricating” page 2](#)
- [“Fog/Driving Light Bumper Holes, Fabricating” page 3](#)

8611-17-03-01 Fog Light Bumper Holes, Fabri- cating

See "Blank Bumper Modification" page 1.

The tools below are used for the operation and can all be purchased locally.

- Dust mask
- Safety Glasses
- Reciprocating Sheet Metal Saw
- Air Drill or Die Grinder
- Carbide bit for de-burring
- 10 mm (3/8 in.) drill
- 13 mm (1/2 in.) drill
- Air Blower
- Tape Measure

 **DANGER**

Before working on a vehicle, set the parking brake, place the transmission in neutral, and block the wheels. Failure to do so can result in unexpected vehicle movement and can cause serious personal injury or death.

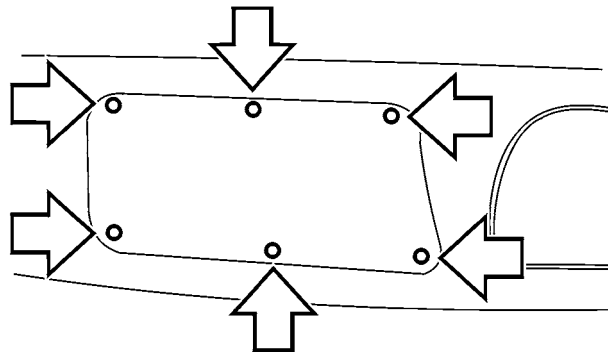
 **WARNING**

Always wear a respirator when sawing, grinding or sanding. Failure to use a respirator could result in foreign material in the lungs.

 **WARNING**

Always use safety goggles. Failure to use safety goggles could result in damage to the eyes.

1



W8002402

Drill six 10 mm (3/8 in.) holes in the recess cut out as shown above.

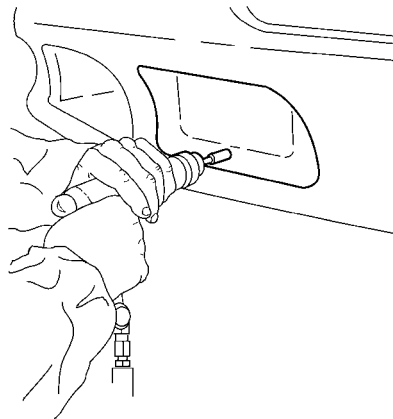
2



W8002403

Cut out the recess using a reciprocating saw.

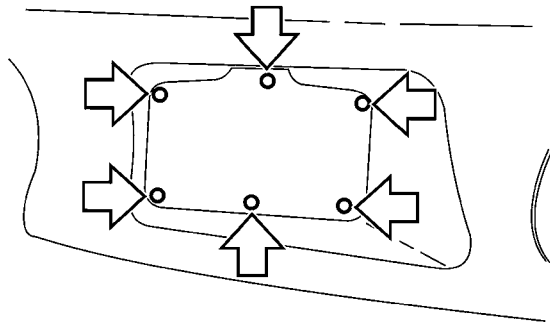
3



W8002404

Use a de-burring bit and die grinder to smooth the edges around the hole.

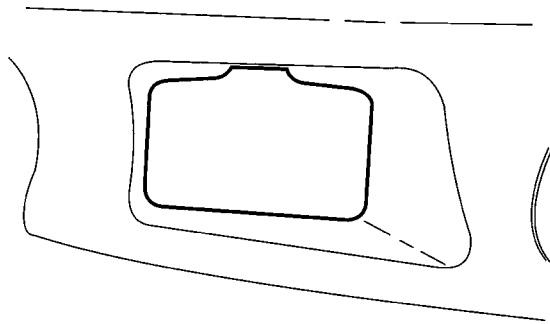
4



W8002405

Drill six 10 mm (3/8 in.) holes in the rear side of the lamp location as shown above.

5



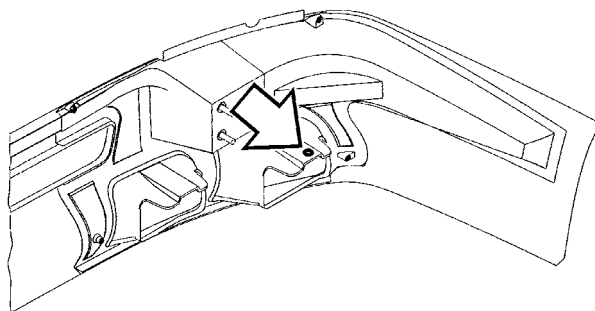
W8002406

Cut out the rear section using the reciprocating saw.

6

Use a de-burring bit and die grinder to smooth the edges around the hole.

7



W8002407

Drill a 13 mm (1/2 in.) mounting hole for the fog lamp at 28 mm (1 1/16 in.) from rear of the lip to the center of the hole.

8

Repeat step 1 through step 7 on the opposite side of the bumper.

8611-17-03-02 Fog/Driving Light Bumper Holes, Fabricating

See "Blank Bumper Modification" page 1.

DANGER

Before working on a vehicle, set the parking brake, place the transmission in neutral, and block the wheels. Failure to do so can result in unexpected vehicle movement and can cause serious personal injury or death.

WARNING

Always wear a respirator when sawing, grinding or sanding. Failure to use a respirator could result in foreign material in the lungs.

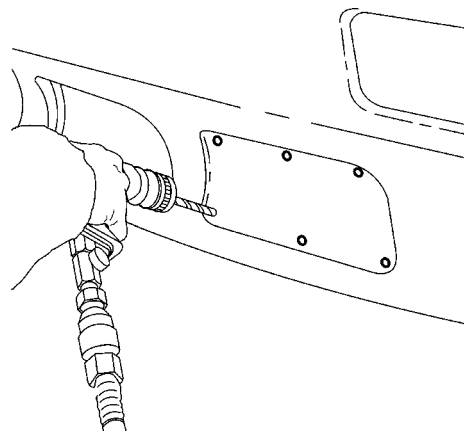
WARNING

Always use safety goggles. Failure to use safety goggles could result in damage to the eyes.

1

Cut holes for the fog light; see "Fog Light Bumper Holes, Fabricating" page 2.

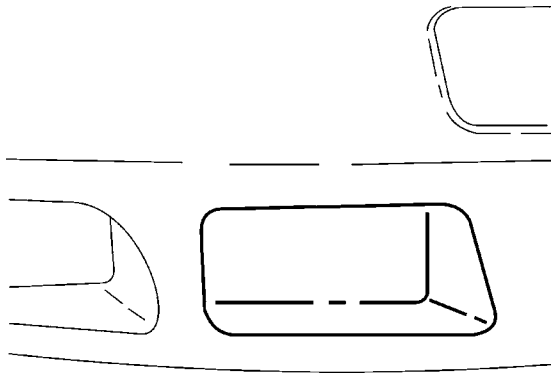
2



W8002408

Drill six 10 mm (3/8 in.) holes in the recess cut out. One hole in each corner and one in the middle top and bottom.

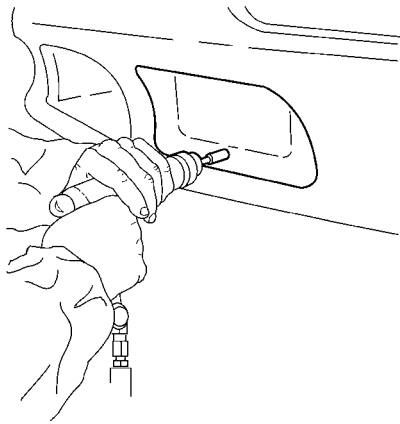
3



W8002409

Cut out the recess with a reciprocating saw.

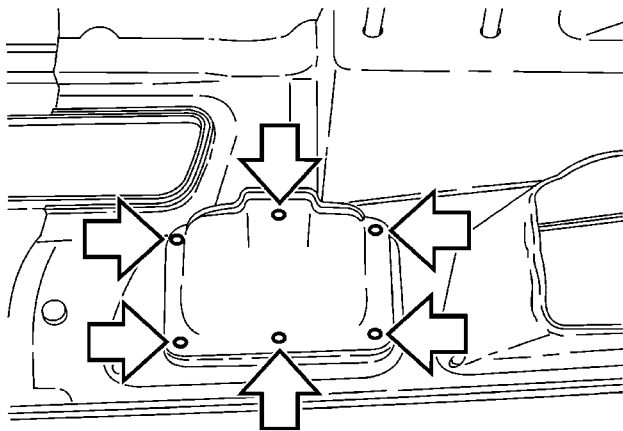
4



W8002404

Use a de-burring bit and die grinder to smooth out the edges.

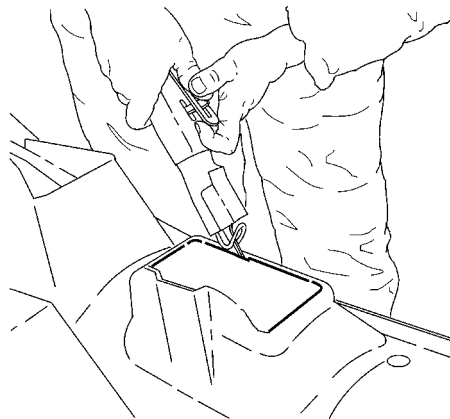
5



W8002410

Drill six 10 mm (3/8 in.) holes in the rear side of the driving light location as shown above.

6



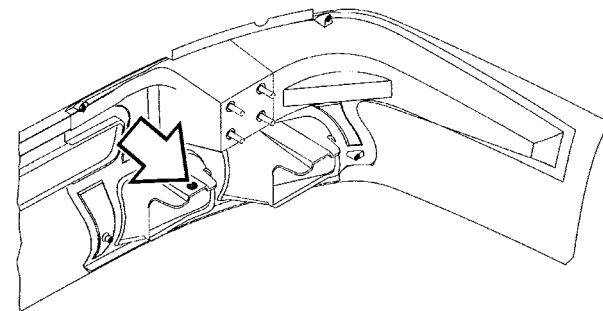
W8002411

Cut out the rear section with the reciprocating saw.

7

Use the de-burring bit and die grinder to smooth the edges around the hole.

8



W8002412

Drill a 13 mm (1/2 in.) mounting hole for the driving light at 28 mm (1 1/16 in.) from the rear of the lip to the center of the hole.

9

Repeat step 1 through step 8 on the opposite side of the bumper.