Step 1.
9/16" hex head bolt with round washer, install thru quarter bumper bracket (1230 DS, 1231 PS Brackets), then flat washer and nut installed inside frame box.

Step 2.
9/16" hex head bolt with hex washer, install thru center bumper bracket then frame, then flat washer and nut installed inside frame box.

Step 3.
Stainless capped carriage bolt (049 Bolt) through bumper, then thru bracket(s), then flat washer and nut.

Step 4.
7/16" hex head bolt, first thru bumper center, then thru bumper end (757 Bumper Ends) and then screwed into inner brace (welded nuts are attached to brace).