**03-06 Toyota tundra bumper kit instructions.**

Parts list:

1pc. 06-1-516 ( frame mount)

1pc. 06-3-14 (winch plate)

2pc. 06-4-14 ( side plate)

1pcs 06-5-316

1pcs 06-6-10

1pcs 06-7-10

2pcs 06-8-10

2pcs 06-9-10

2pc 06-10-10

2pc 06-11-10

2pcs 06-12-10

2pcs 06-13-14

2pcs 06-14-14

2pcs sm34 (shackle mounts)

TOOLS NEEDED FOR ASSEMBLY

1. Wire feed welder and safety equipment (and welding experience!)
2. Angle grinder
3. 90 degree magnets
4. Welding clamps
5. Welding square
6. Remove all parts from kit and verify that no parts are missing.
7. Place pn. 06-1 on a flat working surface
8. Place the lip on the long side of pn. 06-3 in the slot of pn. 06-1
9. place pn.’s 06-4 on each side of pn. 06-3 align the slots and push together the slots on the bottom of the part will fit in pn. 06-1 , squared all pieces and tack weld together.

5. Take pn.’s SM34 and lay them on a flat surface, from the pointed end of the shackle measure 2 3/8 and make a line across the shackle. Place pn.’s SM34 on the inside corner where pn. 06-3 and 06-4 meet. Align the line that was drawn on the SM34 with the front of the side plate, once you have it properly positioned tack weld in place.

1. Clamp the winch mount assembly that you have just tack welded down to a strong surface, brace as necessary to prevent warping. Weld alignment slots first then proceed to weld all the sections together I recommend a series of 4” welds throughout all joints. Do not unclamp until metal is cool.
2. Remove the stock bumper and any brackets that may interfere with the winch mount assembly, bolt it to the vehicle using the stock fasteners, center the assembly on the front of the truck. Once the assembly is mounted to the truck, weld in the vertical slots on pn. 06-1 to the left and right of pn.’s 06-4, be careful not to weld the assembly to the truck frame!
3. Take pn. 06-14 and bolt it to the stock bumper mounting tab using stock fasteners, and tack weld the tab to the winch mount assembly.
4. Take pn. 06-13 and bolt it to the bottom of the vehicles frame where the stock tow hooks usually bolt up. Align and tack weld.
5. Once all tabs look correct fully weld them to the winch mount assembly, make sure all bolts are tight. If you need to remove the assembly for any reason wait till the welds are cool.
6. Take pn. 06-5 and slide it over the shackles mounts,check alignment and tack weld.
7. Take pn.06-7( if this kit was shipped it will be in three pieces if it was picked up local it will be one solid piece) place it on top of the winch mount assembly align with pn. 06-5 and tack weld.
8. Take pn. 06-6 and place it on the bottom of the winch mount assembly, the side with the long slots fit up against the bottom of pn. 06-5
9. Take pn.’s 06-8 and place them on each side of pn. 06-5 and underneath pn. 06-7 adjust as necessary to make make bumper alignment look uniform with the bottom of the trucks grill and fenders tack weld when you are satisfied with the alignment.
10. Take pn.’s 06-9 and place next to 06-8 and under 06-5 adjust as necessary to make make bumper alignment look uniform with the bottom of the trucks grill and fenders tack weld when you are satisfied with the alignment.
11. Take pn.’s 06-10 and place them on both sides of pn. 06-6 and underneath pn. 06-8, tack weld.
12. Take pn.’s 06-12 and place them underneath pn.’s 06-9 and against pn.’s 06-10 tack weld.
13. Take pn.’s 06-11 and place at the junction where 06-7, 06-9 and 06-12 come together.
14. The next step is to tack weld every 2 inches along all joints, once cool remove the bumper from the vehicle and finish all welding.
15. Use a angle grinder initially to take down the welds then switch to a 100 grit flapper sander (zirconia or ceramic works best) then a belt sander for a good finish.
16. I recommend welding the visible shackle mounts welds and the optional grill guard tubing after all other finish grinding is done.
17. If you purchased the recessed light mount kit take the tubing supplied and spin it on the hole of pn. 06-8 till the holes align, when you are happy with fitment tack weld then weld three 1” Beads around the tube on the inside of the bumper. Place light mount tab whever works best for the lights you are using.
18. Enjoy Your new winch bumper!