1989-1995 pickup/4runner WINCH BUMPER ASSEMBLY INSTRUCTIONS.

Parts list:

1pc. 1995-5 ---------front plate

1pc. 1995-4----------top plate

1pc. 1995-6----------bottom skid plate

2pcs 1995-7----------front wing - (will include light hole if ordered)

2pcs 1995-11-----------bottom wing

2pcs 1995-9---------bottom filler plate

2pcs 1995-8----------end plate

2pcs 1995-10---------end cap

1pc 1995-1 (1/4 plate) ----------frame mount

1pc 1995-2 (1/4” plate)---------winch plate

2pcs 1995-3 (1/4” plate)---------side plate

2pcs sm34 ------------- shackle mount

TOOLS NEEDED FOR ASSEMBLY

1. Wire feed welder and safety equipment (and welding experience!)

2. Angle grinder with grinding wheels and 1-2 80 grit flapper sander wheels.

3. 90 degree magnets.

4. Welding clamps.

5. Welding square.

TIPS FOR ASSEMBLY

1. Parts may sometimes require sanding or light grinding to fit properly for your vehicle.

2. Tack all pieces first, make sure alignment with the body and grill are to your satisfaction before welding any edges.

3. Use of a hand held belt sander with 80 grit ceramic or zirconia belts will make finishing the welded panels easier and will improve the finished product.

1. Remove all parts from kit and verify that no parts are missing.

2. Place pn.1995-1 on a flat working surface’

3. insert the tab on the back of pn. 1995-2 into the lower horizontal slot of top of pn. 1995-1, use the upper slot if you have a 1” body lift

4. insert pn. 1995-3 into the slots on both 1995-2 and 1995-1 the center section of the bumper will fit together like blocks once assembled Use 90 degree magnets, make sure everything is square then TACK together.

5. Making sure all pieces are square to each other tack weld all parts together.

6. take the ¾” shackle mount and mark 2 ¼” from pointed end of part. Align mark with the front of pn. 1995-3. Tack parts togther

7. With all pieces tack welded together clamp or tack frame mount down to a strong surface, this is to avoid warping when finish welding all pieces together. Do not unclamp until parts are cool. ( DO NOT SKIP THIS STEP!) Your winch bumper center section is now finished.

8. Remove stock bumper from truck.

9. Bolt center section assembly to your vehicle using stock hardware, use the four front bolt holes in the front of the frame and the four tow point holes underneath the frame.

10. Bolt 1995-12 to body mounts with stock hardware. Bolt 1995-14 to the tow hook mount holes.

11. Once the winch bumper center section looks level and centered weld pn. 1995-14 to 1995-, be careful not to weld the tabs to your truck frame! Do not remove center section till welds cool.

12. Before welding near the truck cover anything you don’t want burnt with with a non flammable material.

13. Take pn. 1995-4 and set it on top of the winch bumper center section. Align the front of the top plate with the top front of the winch bumper center section, make small tack weld to center section

14. Take pn. 1995-5 and slide it over the shackle mounts align with the top tack the pieces together so that both are secure.

15. Take pn.’1995-7 and place them on the sides of 1995-5 align as necessary to get the proper look against the bottom of pn.1995-4 tack weld it in place. Repeat for the opposite side(if you need to make a gap at the bottom or the top against pn. 1995-4 to get the alignment with the bottom of the grill now is the time to do it!)

16. Take pn. 1995-6 and align it to the bottom of 1995-5 , tack to the upper piece and the center section.

17. Take pn. 1995-11 and place it in the corner between 1995-5 and 1995-7 adjust till fit is good then tack it. Repeat for both sides.

18. Take pn. 1995-8 and place it in the corner of 1995-4 and 1995-7 again use this piece to adjust bumper alignment with the front of the truck, tack weld. Repeat for both sides

19. Take pn. 1995-9 and weld to the bottom between pn 1995-11 and pn.1995-8 and tack weld in place. repeat for both sides

20. Take pn. 1995-10 and align it against pn. 1995-9 and pn. 1995-8

21. Once you are happy with alignment of bumper to the truck tack weld all seems on bumper every three inches.

22. Remove bumper from truck, now you can begin welding all the seams together.

23. After the outside is fully welded begin welding 2” beads along the inside every 10”

28. Once the bumper is fully welded you can begin grinding the welds, I recommend using an angle grinder with an abrasive wheel to take down the majority of the seam. Next switch to an 80 grit flapper sander and go over all the edges till you are satisfied with the finish. For a professional finish I recommend the use of a belt sander with a 80 grit ceramic or zirconia belt.

29. Enjoy your new winch bumper.

Thanks!

OPTIONAL ADD ONS

RECESSED LIGHT MOUNT ASSEMBLY.

1. Take light buckets and set them on pn 1995-7 rotate them until the holes line up, the large part of the bucket will face towards the middle of the bumper., tack weld.

2. Once welded and cool place your light in the mount and weld on bolt bracket to your needs.

CENTER GRILL HOOP

1. Center pre bent center tube how you want it on finished bumper and weld in place

2. For outer hoop headlight guards take pre bent tube and notch to your preference to match up against the center hoop.