1996- 2004 TACOMA WINCH BUMPER ASSEMBLY INSTRUCTIONS.

(98-00 VEHICLES REQUIRE TRIMMED FRAME HORNS, PLATES FOR THIS MOD INCLUDED)

Parts list:

1pc. 2004-1 ---------front plate

1pc. 2004-2----------top plate

1pc. 2004-3----------bottom skid plate

2pcs 2004-4----------front wing left and right (will include light hole if ordered)

2pcs 2004-5----------bottom wing

2pcs 2004-6---------bottom filler plate

2pcs 2004-7---------end plate

2pcs 2008-8---------end cap

1pc 2004-9 (1/4 plate) ----------frame mount

1pc 2004-10 (1/4” plate)---------winch plate

2pcs 2004-11 (1/4” plate)---------side plate

2pcs 2004-12 (1/4” plate)-----------frame bottom tabs

2pcs 2004-13 (1/4” plate)-----------body mount tab

2pcs sm34 ¾ plate------------- shackle mount

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

!!98-00 VEHICLES REQUIRE TRIMMED FRAME HORNS, PLATES (pn. FP316) FOR THIS MOD INCLUDED!!

Take pn. 2004-12 and bolt it to bottom of frame using stock hardware, Bolt pn. 2004-13 to body mounts with stock hardware, where these tabs end coming forward is where you will trim your frame back to minus the difference of the 3/16 plate included. weld ½” coarse thread nuts (not supplied) to the plates BEFORE weling them to the end of the frame rail.

1. Remove all parts from kit and verify that no parts are missing.
2. Place pn.2004-9 clamp it down on a flat working surface.
3. Place the lip on tha back of pn. 2004-10 on top of pn. 2004-9 .
4. 4. Place pn.’s 2004-11 over the slots on the winch plate and also into the slots on 2004-9
5. Making sure all pieces are square to each other tack weld all parts together.
6. Make a mark on pn.sm34 and mark 2 ¼” from pointed end of part. Align mark with the front of pn. 2004-11
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 bumper from truck, unbolt bumper extensions from front of frame rail.
9. Bolt assembly to your vehicle using the two front bolts on the end of the frame rail.
10. remove tow hooks from the bottom of the frame rail. Save hardware.
11. Bolt pn. 2004-12 to bottom of frame using stock hardware (part should just touch pn. 2004-9, if not grind to fit)
12. Bolt pn. 2004-13 to body mounts with stock hardware, grind to fit if necessary.
13. Once the winch bumper center section looks level and centered weld pn. 2004-12 and pn. 2004-13 to pn. 2004-9, be careful not to weld the tabs to your truck frame! Do not remove center section till welds cool.
14. Take pn. 2004-2 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.
15. Take pn. 2004-1 and slide it over the shackle mounts pn. Sm34

align with the top plate pn. 2004-2, tack the pieces together so that both are secure.

16. Take pn.’s 2004-4 and place them on the sides of 2004-1 align as necessary to get the proper look against the bottom of pn. 2004-2, 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. 2004-1 to get the alignment with the bottom of the grill now is the time to do it!)

17. Take pn. 2004-7 and align it with pn. 2004-4, again adjust the gaps of the end cap to properly gap match pn. 2004-3 to the bottom of the fenders. tack weld in place Repeat for opposite side

18. Take pn. 2004-3 and center it to the bottom of pn. 2004-1 tack weld in place.

19. Take pn. 2004-5 and place in the corner between pn.2004-1 and pn.2004-4 align and tack weld.

20. Take pn. 2004-6 and weld to the bottom between pn.2004-6 and pn.2004-7 tack weld in place.

21. Take pn. 2004-8 and align it against pn. 2004-7 and pn. 2004-6

22. Make sure the bumper is securely welded to the inner ¼” structure!

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

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

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

26. 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.

27. Enjoy your new winch bumper.

Thanks!

OPTIONAL ADD ONS

RECESSED LIGHT MOUNT ASSEMBLY.

1. Take light buckets and match up marking to align in pn. 2004-4, 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 gaurds take pre bent tube and notch to your preference tomatch up against the center hoop.