2005-2011 TACOMA WINCH BUMPER ASSEMBLY INSTRUCTIONS.

Parts list:

1pc. 2005-1 ---------front plate

2pcs. 2005-5 ---------top wing L+r

1pc. 2005-7----------top plate

1pc. 2005-9----------bottom skid plate

2pcs 2005-2----------front wing left and right (will include light hole if ordered)

2pcs 2005-4----------bottom wing

2pcs 2005-6---------bottom filler plate

2pcs 2005-3---------end plate

2pcs 2005-10---------end cap

1pc 2005-11 (1/4 plate) ----------frame mount

1pc 2005-12 (1/4” plate)---------winch plate

2pcs 2005-13 (1/4” plate)---------side plate

2pcs 2005-14 (1/4” plate)-----------frame bottom tabs

2pcs 2000-1 ¾ plate------------- 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.
6. Framers square is also handy for making alignment marks.
7. Sawzall or another cutting tool for removing the front tow hook.

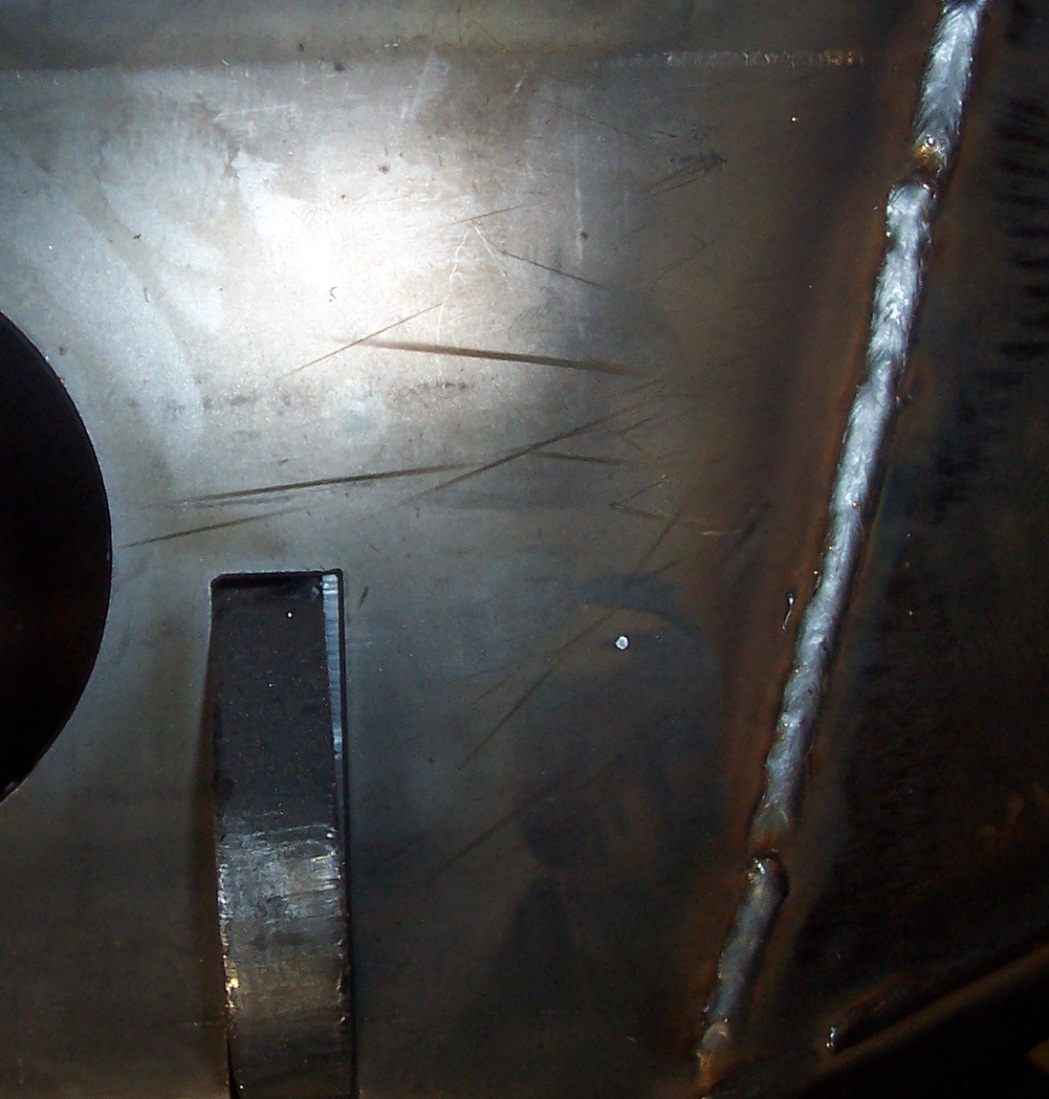
TIPS FOR ASSEMBLY

1. Parts may sometimes require sanding or grinding to fit properly for your vehicle.
2. Tack weld 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.
4. Remove all parts from kit and verify that no parts are missing.
5. Place pn.2005-11 on a flat working surface, place the lip of pn 2005-12 in the lower horizontal slot of pn. 2005-11 use a right angle magnet to hold in place.
6. Place the slots of 2005-13 in the slots on 2005-11 then place the winch plate in between the frame mounts and the side plates, all slots should line up.
7. 4. Place pn.’s 2005-13 on each side of pn. 2005-12

the bottom pointed end of the side brackets will be flush with the bottom of the frame mount(2005-11) (fig 1)



5.Next measure down 8 1/8 from the top 2005-13 and make a horizontal mark, the bottom of the shackle mount will align with your mark, this gives you a height lay out. Next lay the shackle mount flat , measure from the pointed end of the shackle mount back 2 ¼ inches and make a mark across the width. Now take the shackle mounts and align the bottom with the line on part number 2005-13 adjust the mark on the shackle mount to align with the front of 2005-13 clamp both pieces in place. Take part number 2005-1 and make sure it fits flush with the top of 2005-13 and over the shackle mounts.



6.Making sure all pieces are square to each other TACK WELD all parts together.

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

7.Remove stock bumper from truck, unbolt the aluminum extensions from front of frame. The factory tow hook must be cut off to fit the center section onto the frame.

8.Using the factory hardware Bolt assembly to your vehicle using the six front bolts on the front of the frame rail. Tighten all bolts.

9.Next remove the stock bolts from the outer bottom of the frame, take parts 2005-14 and bolt them to the bottom of the frame where you just removed the bolts. Tack weld the tabs to your bumper center section.

10.Before welding near the truck cover anything you don’t want burnt with a nonflammable material.

11.Take pn. 2005-7 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.

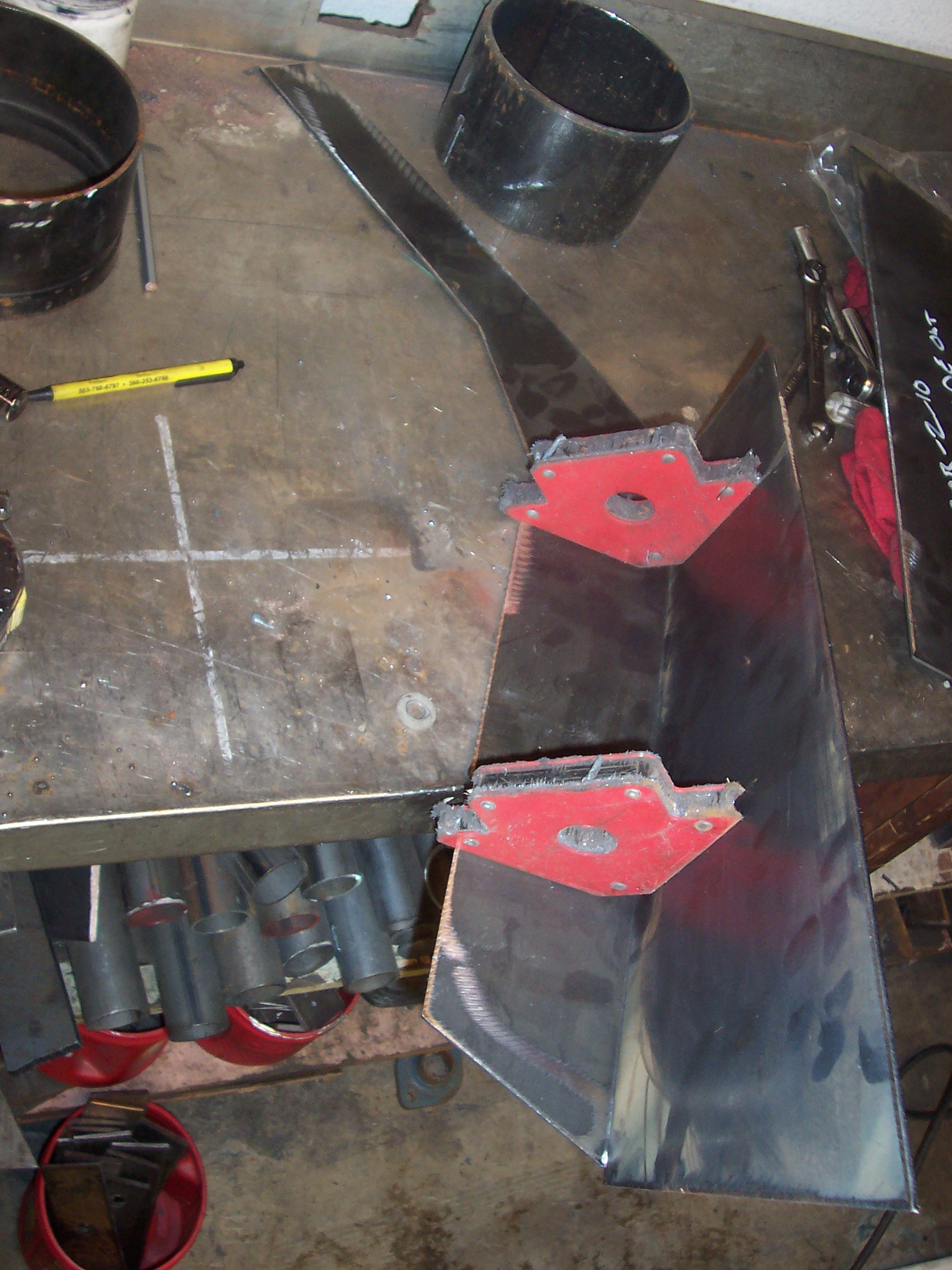
12.Take pn. 2005-1 and slide it over the shackle mounts. align with pn. 2005-7, tack the pieces together so that both are secure. Be sure once properly fitted to tack weld this piece to the inside 1/4 “ center structure in many places

13.Take part 2005-9 and place it below part 2005-1 once aligned tack weld it to the inner ¼ “ center structure.

14.Take pn.’s 2005-5 and place them on the work bench mirror opposite, take pn. 2005-2 and align with the corner of 2005-5 as seen in the pictures below.





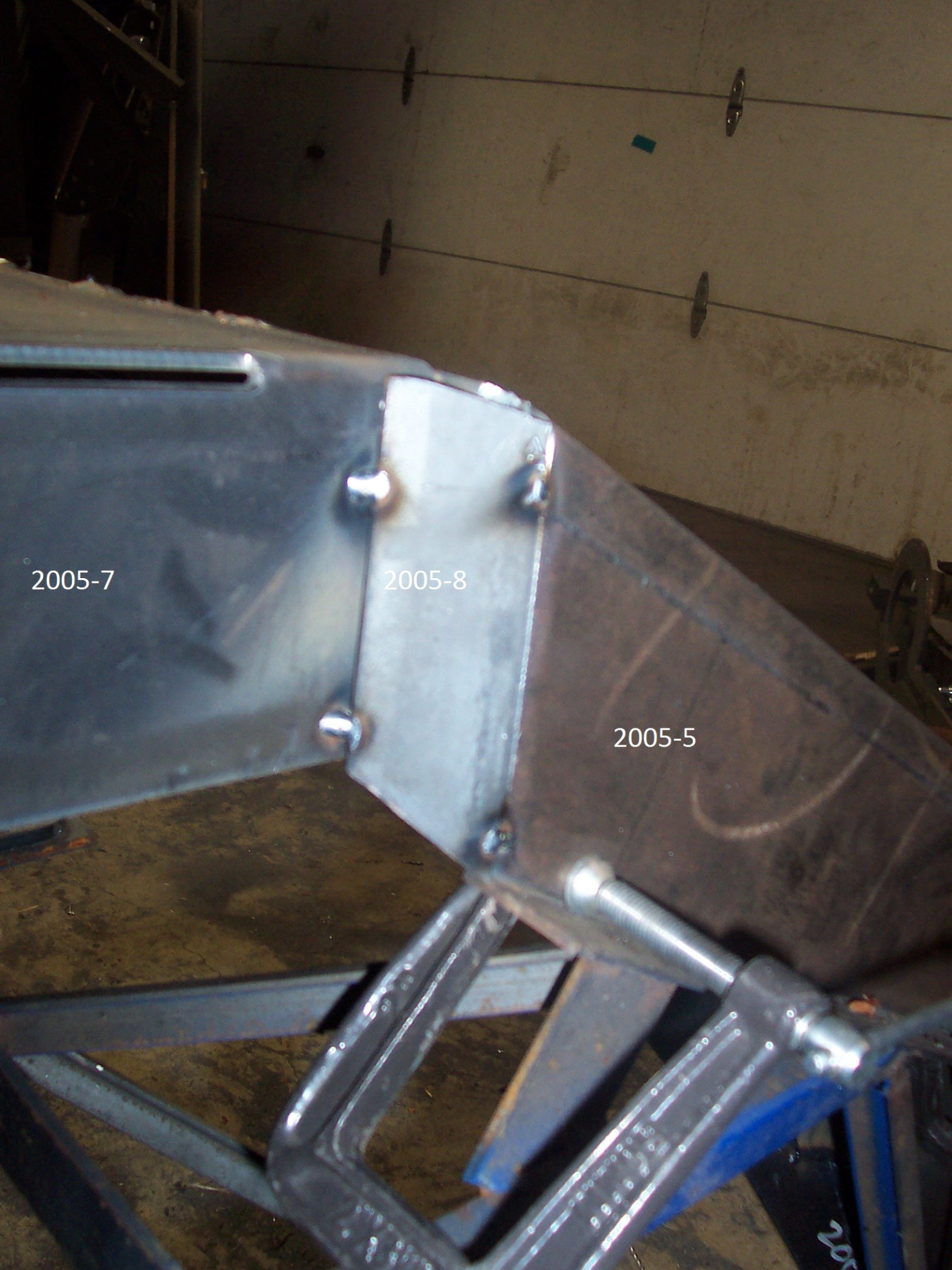


15.Take the two pieces and put them together with a pair of right angle magnets when they aligned and at 90 degrees to each other tack weld together. Repeat process for other side.

16.Take the two pieces that were just tacked together in the previous step and place them on their respective sides next to pn. 2005-1 make sure the the alignment of these parts look good with the grill and fender profile of your truck! get it close to where you want it then put a tack near the top of the two pieces, if you have a friend to help align this part it can be a big help! Once perfectly in position tack weld in place.repeat for other side.



17.Next take part 2005-8 and connect the 2005-7and 2005-5, after the bumper is completely assembled you will fill in the gap in the front were these pieces meet.





18.Take pn. 2005-4 and placed at the corner in between the bottom of 2005-2 and 2005-9 align and tack weld repeat for both sides.

19.Take pn. 2005-3 and tack weld in to the spot on in the corner between pn. 2005-5 and 2005-2 and tack weld in place. Repeat for other side.

20.Take pn. 2005-6 and place it in the corner between 2005-3 and 2005-4 align and tack weld into place. Repeat for both sides.

21.Take part 2005-10 and weld it to connect pieces 2005-5, 2005-6 and 2005-3Make sure the bumper is securely welded to the inner ¼” structure!

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

23.Before you weld this joint (picture below)



24Remove 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. 2005-2, 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.