2012 TO PRESENT TACOMA WINCH BUMPER INSTRUCTIONS.

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. Installation of this kit may require removal of some factory clips and brackets, the Factory fasteners are reused for the bumper install.

1. Remove all parts from kit and verify that no parts are missing.
2. Place pn.2012-9-11 on a flat working surface with the long flat edge with the notch facing away from you, take pn. 2012-10 and align the slots so that they fit together, use the lower slot of the two.
3. Take pn.’s 2012 and place them on both sides of pn. 2012-10 align the slots with both sides and then slide the whole assembly into the slots on pn. 2012-9. The points on the bottom of pn.’s 2012-13 should look like the picture below (ignore the pn.’s in the picture) Once all parts are square to each other tack weld in a few spots. Making the sure the assembly is well clamped to a sturdy flat surface fully weld the assembly. DO NOT UNCLAMP UNTIL THE ASSEMBLY IS COOL. You now have a finished winch mount assembly.



1. Next place pn.2012-1 over the front of the assembly, align with the top of the pn.’s 2012-13 place pn.’s sm34 in the verticle slots on the bottom of pn. 2012-1. Using a clamp adjust the pn.’s sm34 till they are level to each other. the distance from pn. 2012-1 to the front rounded part of of pn. Sm34 should be 2 ¼”
2. Place pn. 2012-15 against the bottom of pn. 2012-1 and tack weld.
3. Place pn. 2012-7 on top the winch mount assembly make sure the slots in the part are offset towards the front of the bumper. Tack weld.
4. Place pn.’s 2012-2 on each side of 2012-1make two small tack welds, take pn.’s 2012-5 and place them on top of pn.’s 2012-2 and next to 2012-7 at this point need to adjust the parts so that the gap between the grill and the top of the bumper look even.tack weld together.
5. Place pn.’s 2012-3 next to pn.’s 2012-2 und underneath pn.’s 2012-5 the small pointed end face toward the back of the vehicle. Again adjust the bumper to make an even spacing between the fender and the bumper.
6. Place pn.’s 2012-4 next to 2012-15 and underneath pn.’s 2012-2 align and tack weld.
7. Place pn.’s 2012-6 underneath pn.’s 2012-3 and against pn.’s 2012-6 align and tack weld.
8. Place pn.’s 2012-8 in the junction between. Pn. ‘s 2012-6, pn.’s 2012-5 and pn.’s 2012-3.
9. The bumper is now assembled, proceed to tack weld every 2 inches throughout every joint, let the bumper cool and then remove it from the truck.
10. Completely weld all seams of the bumper, once it is cool grind all edges. Next take a 80 grit zirconia or ceramic flapper sander and continue to smooth out the edges, finishing with a belt sander will produce the nicest finish.
11. Paint or powder coat your bumper and enjoy.

OPTIONAL ADD ONS

RECESSED LIGHT MOUNT ASSEMBLY.

1. Take light buckets and rotate them until they point straight and align with the hole in 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.