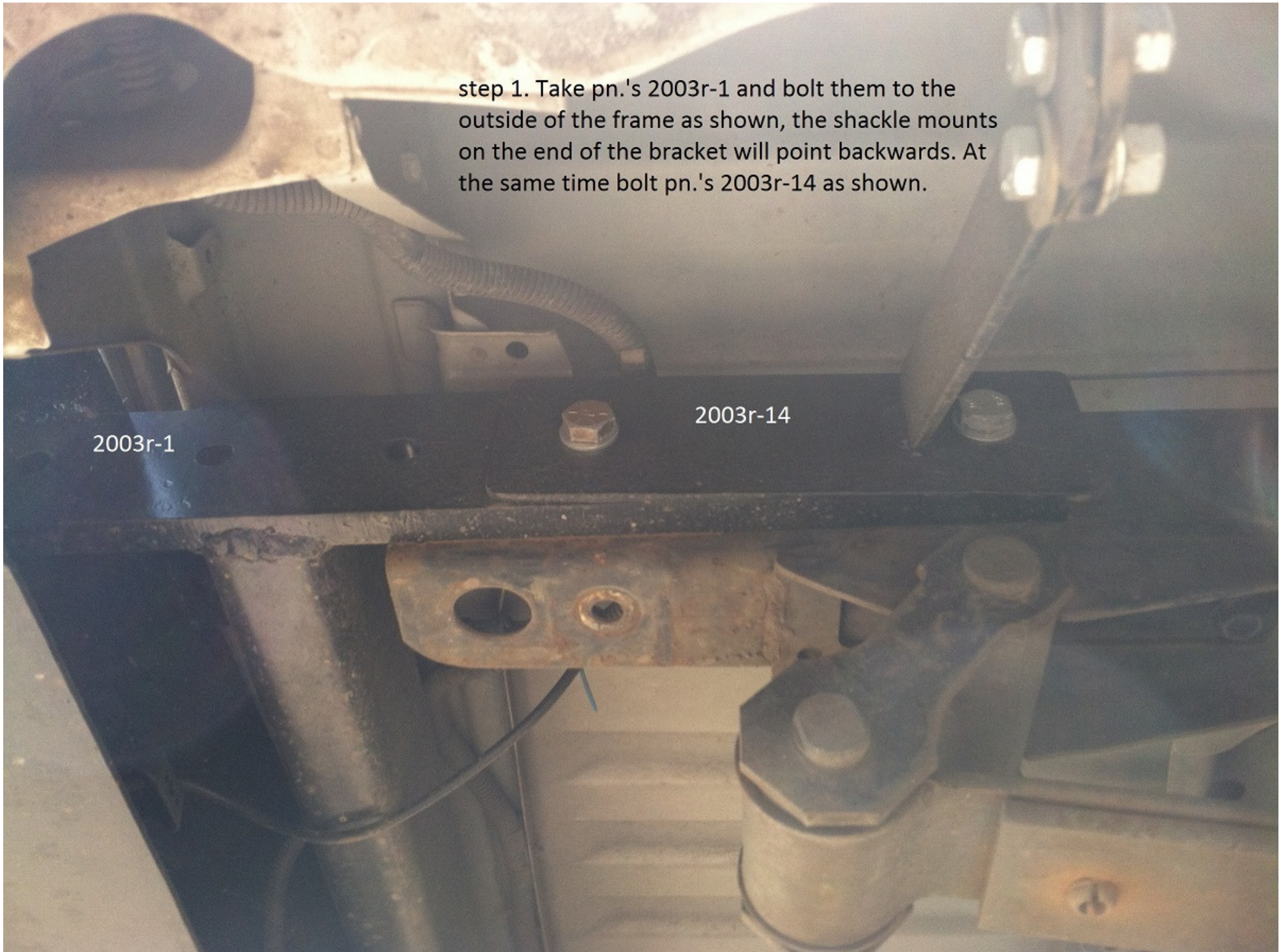


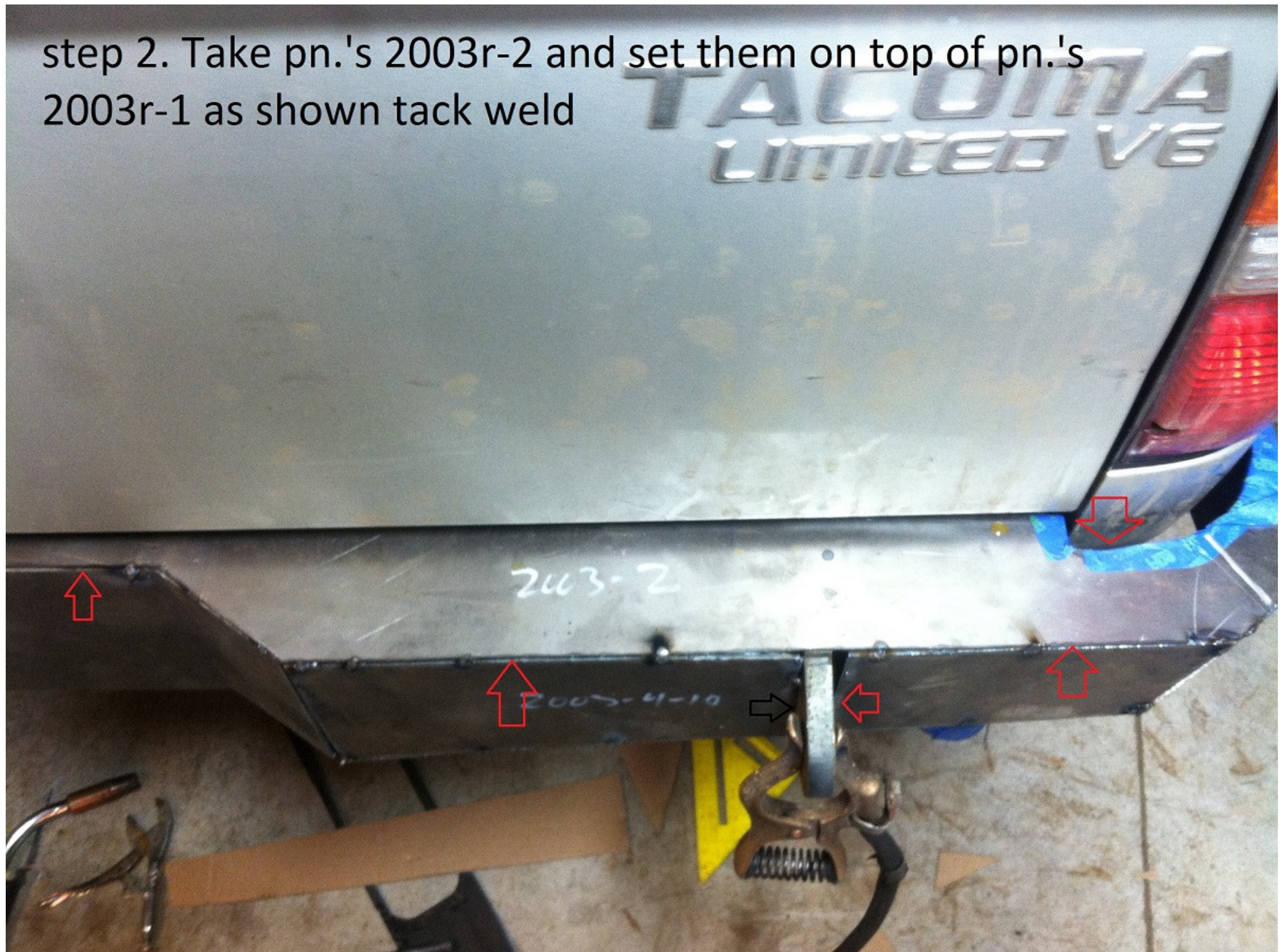
step 1. Take pn.'s 2003r-1 and bolt them to the outside of the frame as shown, the shackle mounts on the end of the bracket will point backwards. At the same time bolt pn.'s 2003r-14 as shown.

2003r-1

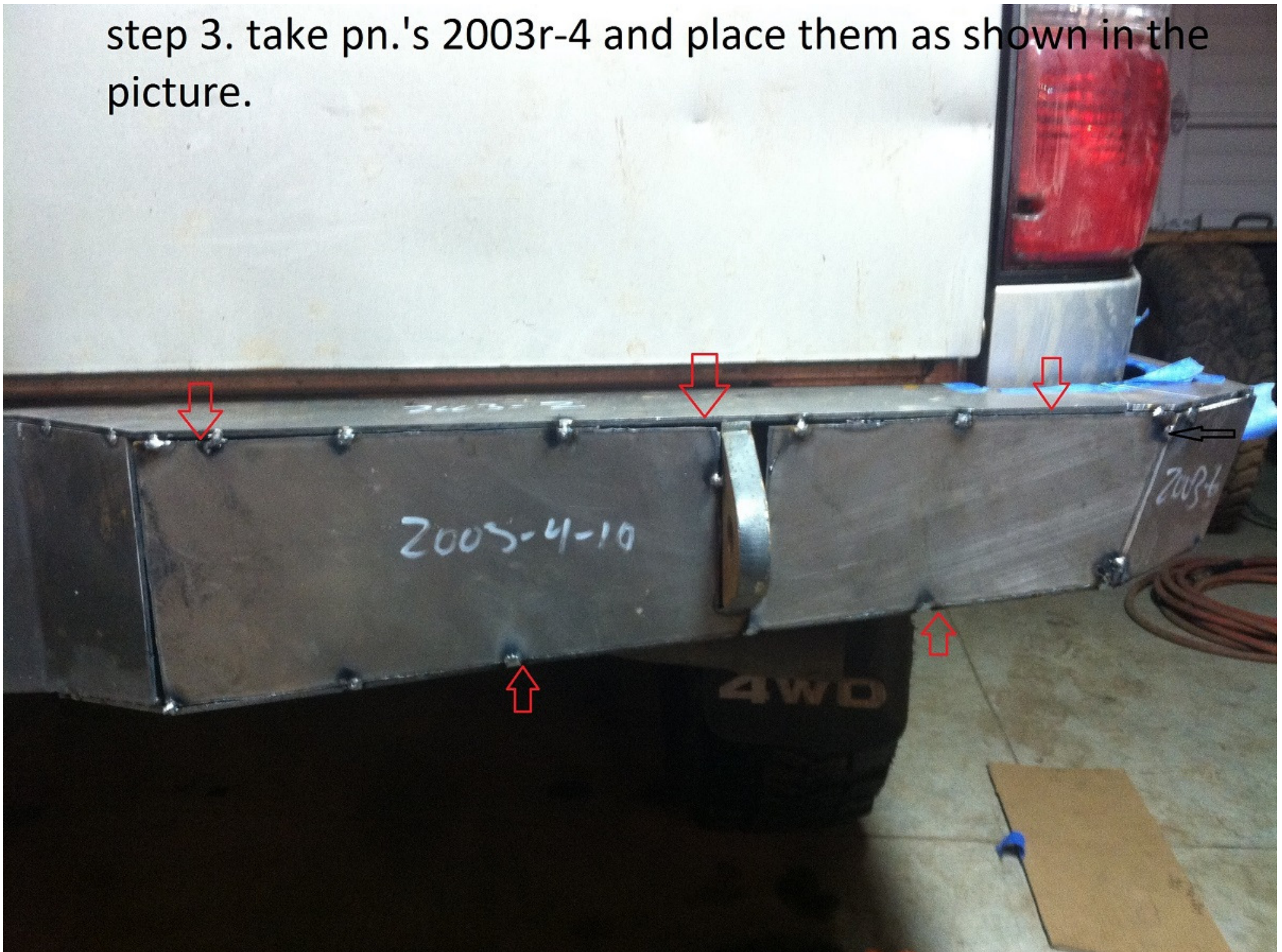
2003r-14



step 2. Take pn.'s 2003r-2 and set them on top of pn.'s 2003r-1 as shown tack weld



step 3. take pn.'s 2003r-4 and place them as shown in the picture.

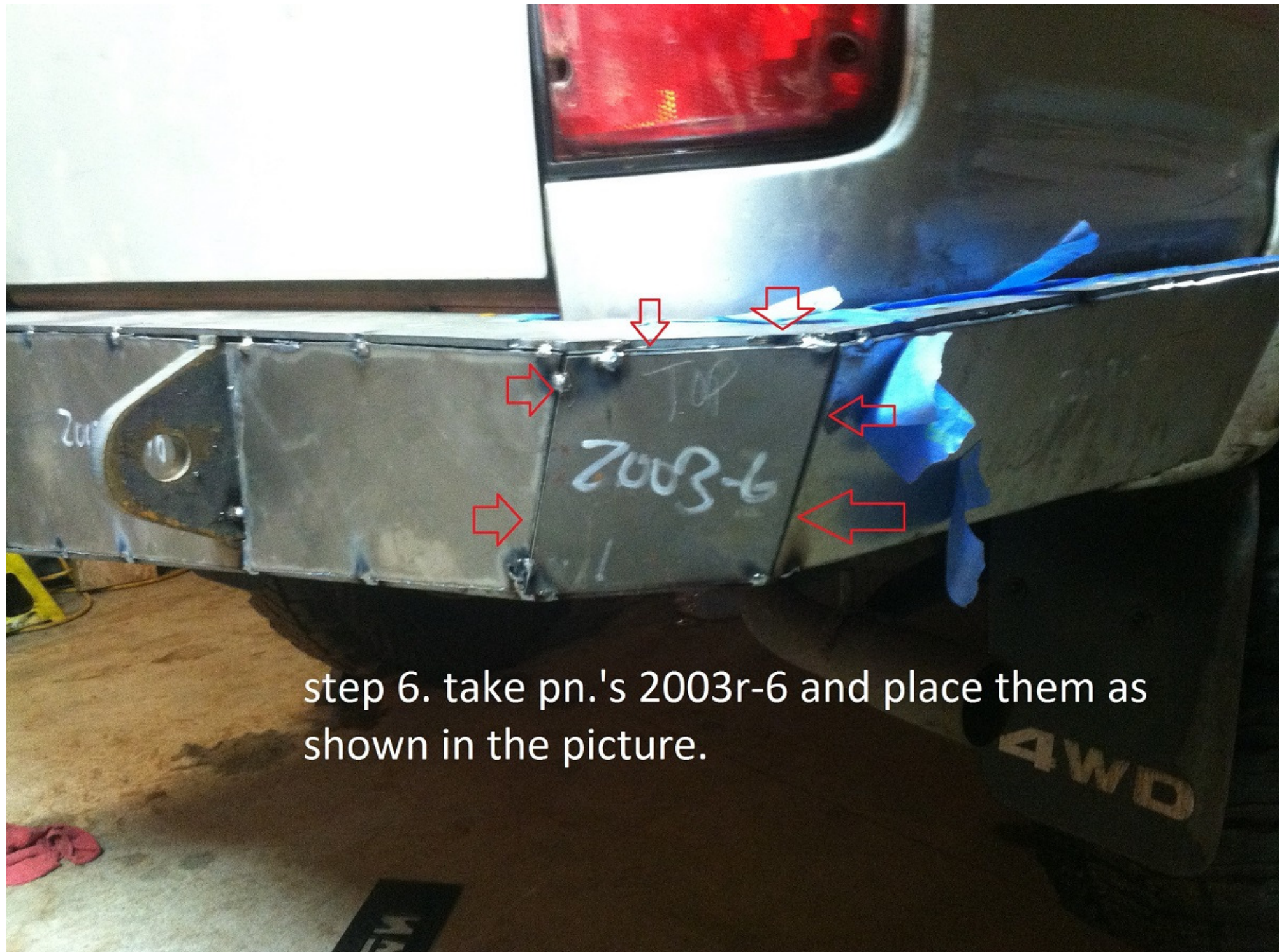


step 4. take pn. 2003r-5 and bend along the slots until it forms to the shape of the bumper as shown.



step 5. Take pn.'s 2003r-3 and tackweld them to 2003r-2 as shown. this step can be tricky, if you have a piece of wood or metal to prop the part up till the next steps it will be easier!





step 6. take pn.'s 2003r-6 and place them as shown in the picture.

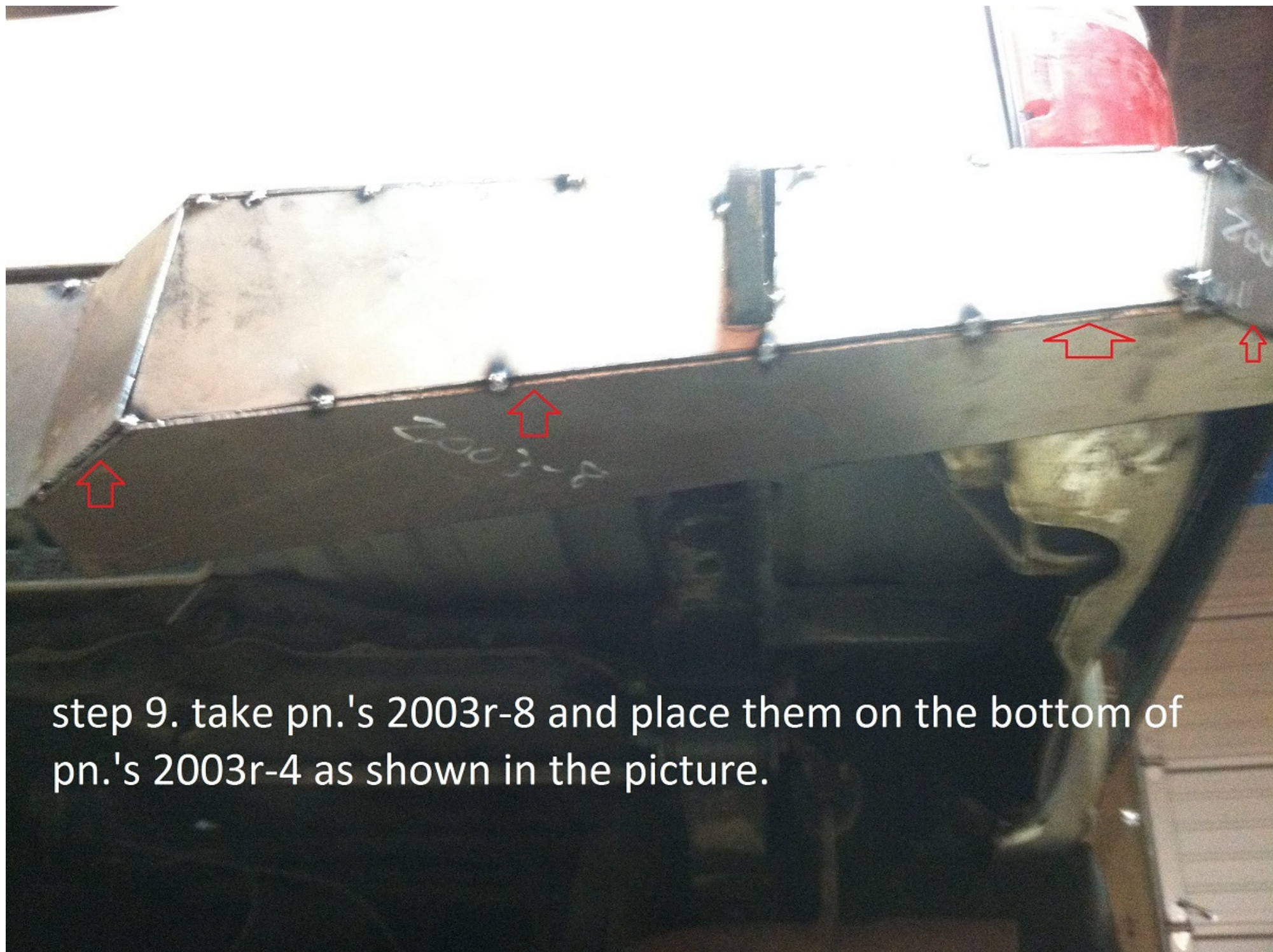
step 7. take pn.'s 2003r-7 and place them beneath pn.'s 2003r-3 as shown. at this point level pn.'s 2003r-3 to align with the truck.

A photograph showing the installation of a blue-painted metal rail (pn. 2003r-7) beneath a larger metal component (pn. 2003r-3) on a truck. Red arrows point to the alignment points. The truck body has "TOYOTA RACING DEVELOPMENT" and "OFF ROAD" text.

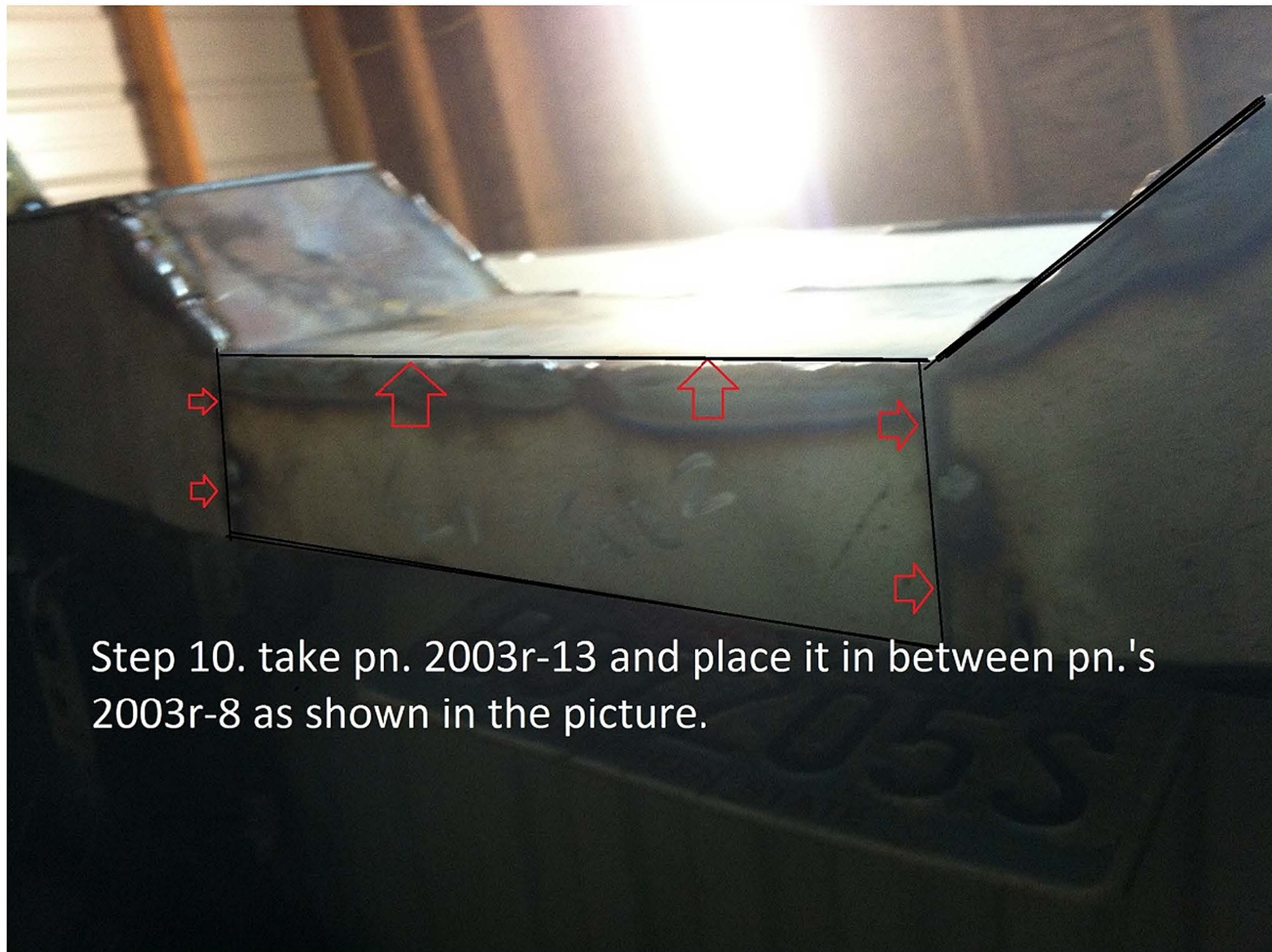
step 8. take pn.'s 2003r-12 and place them as shown in the picture.

2003r-7

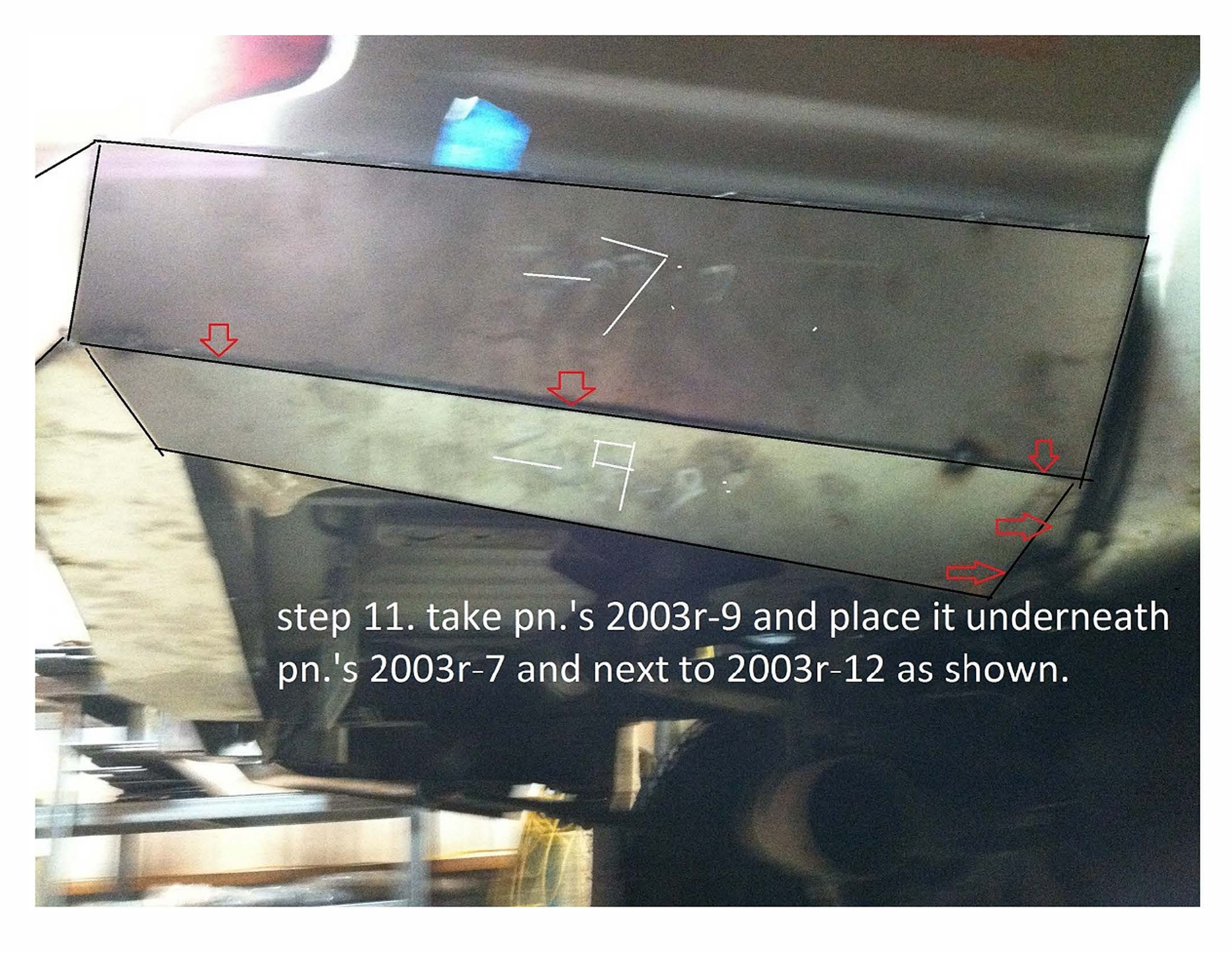




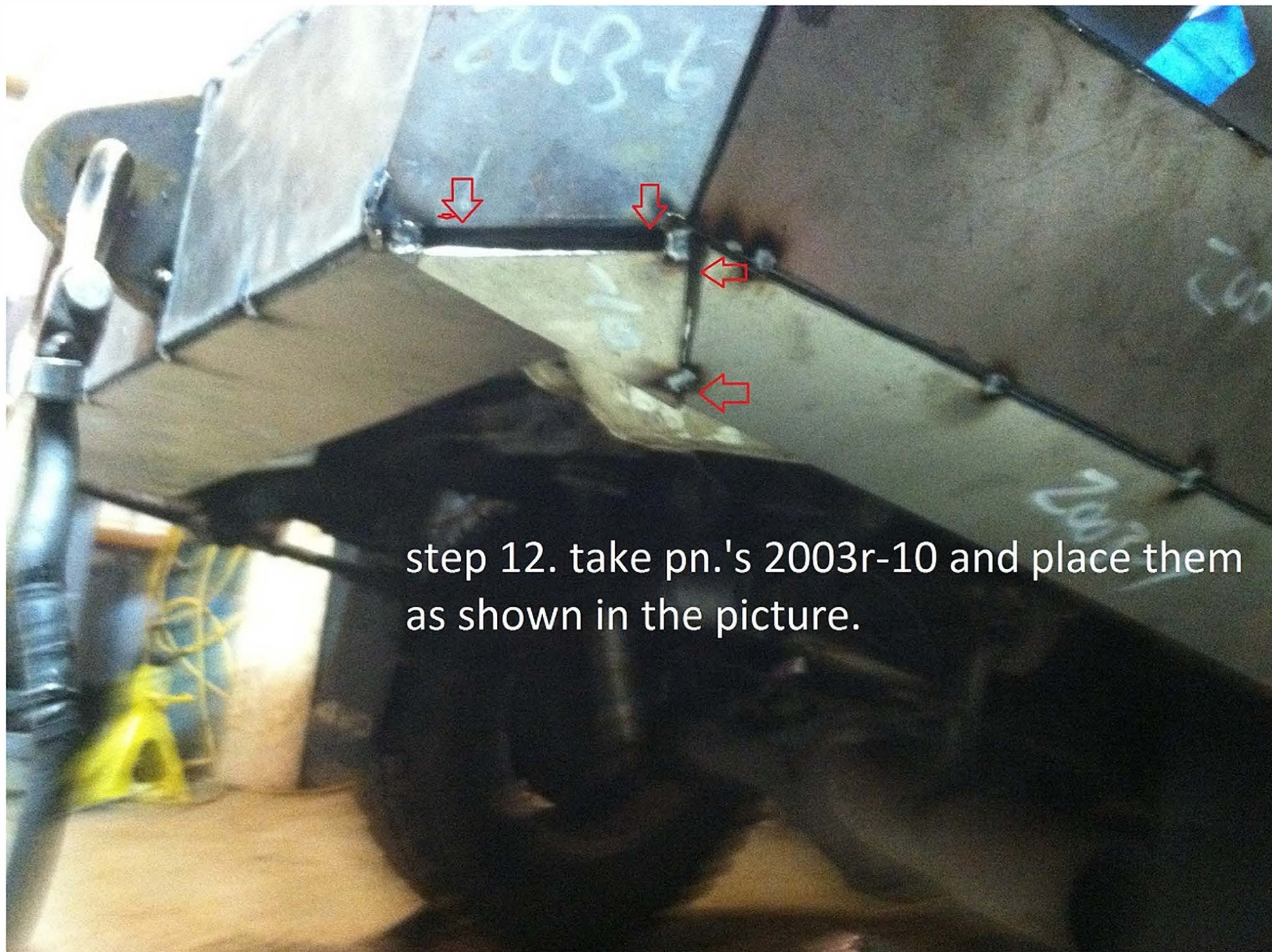
step 9. take pn.'s 2003r-8 and place them on the bottom of pn.'s 2003r-4 as shown in the picture.



Step 10. take pn. 2003r-13 and place it in between pn.'s 2003r-8 as shown in the picture.



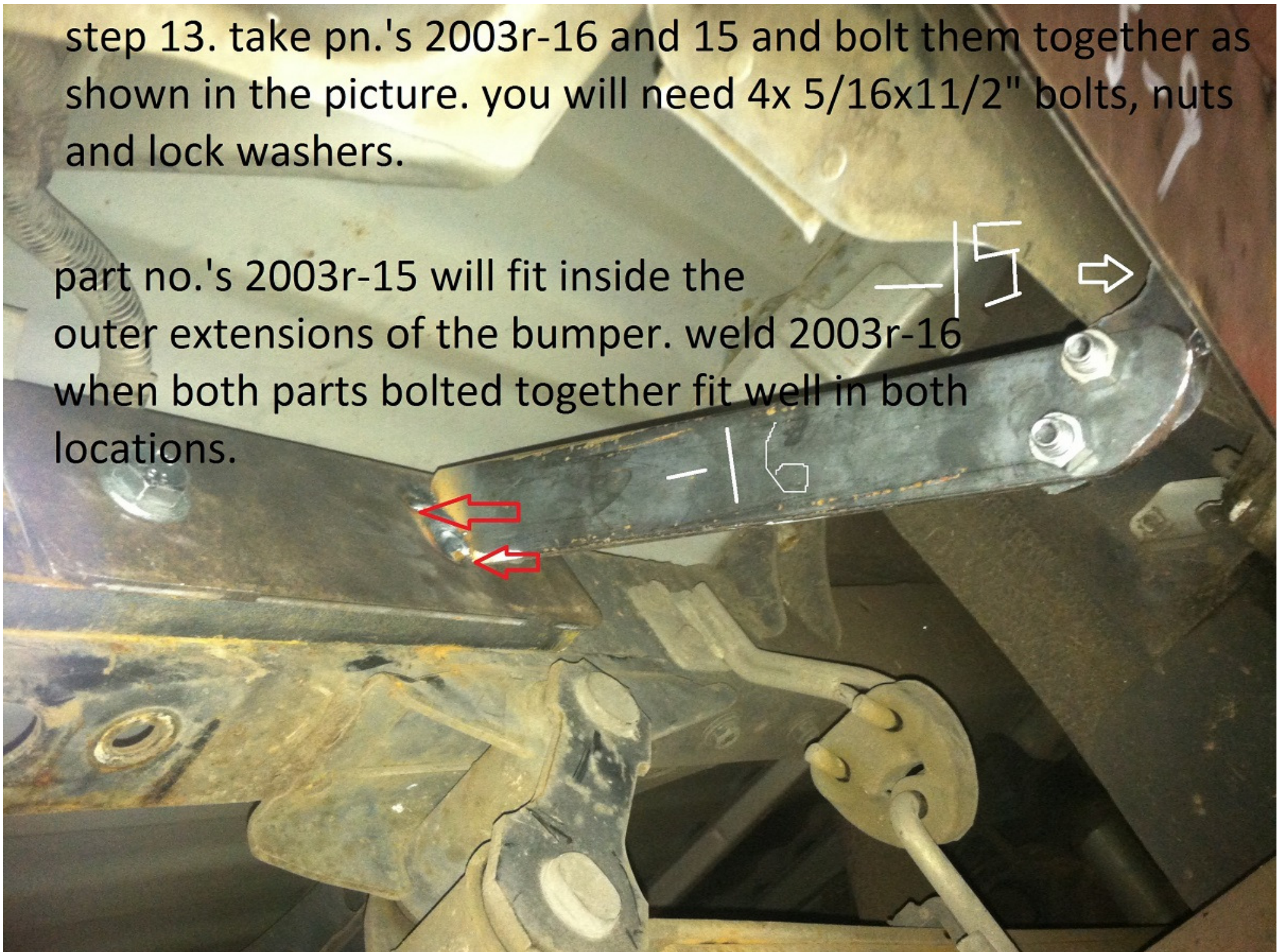
step 11. take pn.'s 2003r-9 and place it underneath
pn.'s 2003r-7 and next to 2003r-12 as shown.

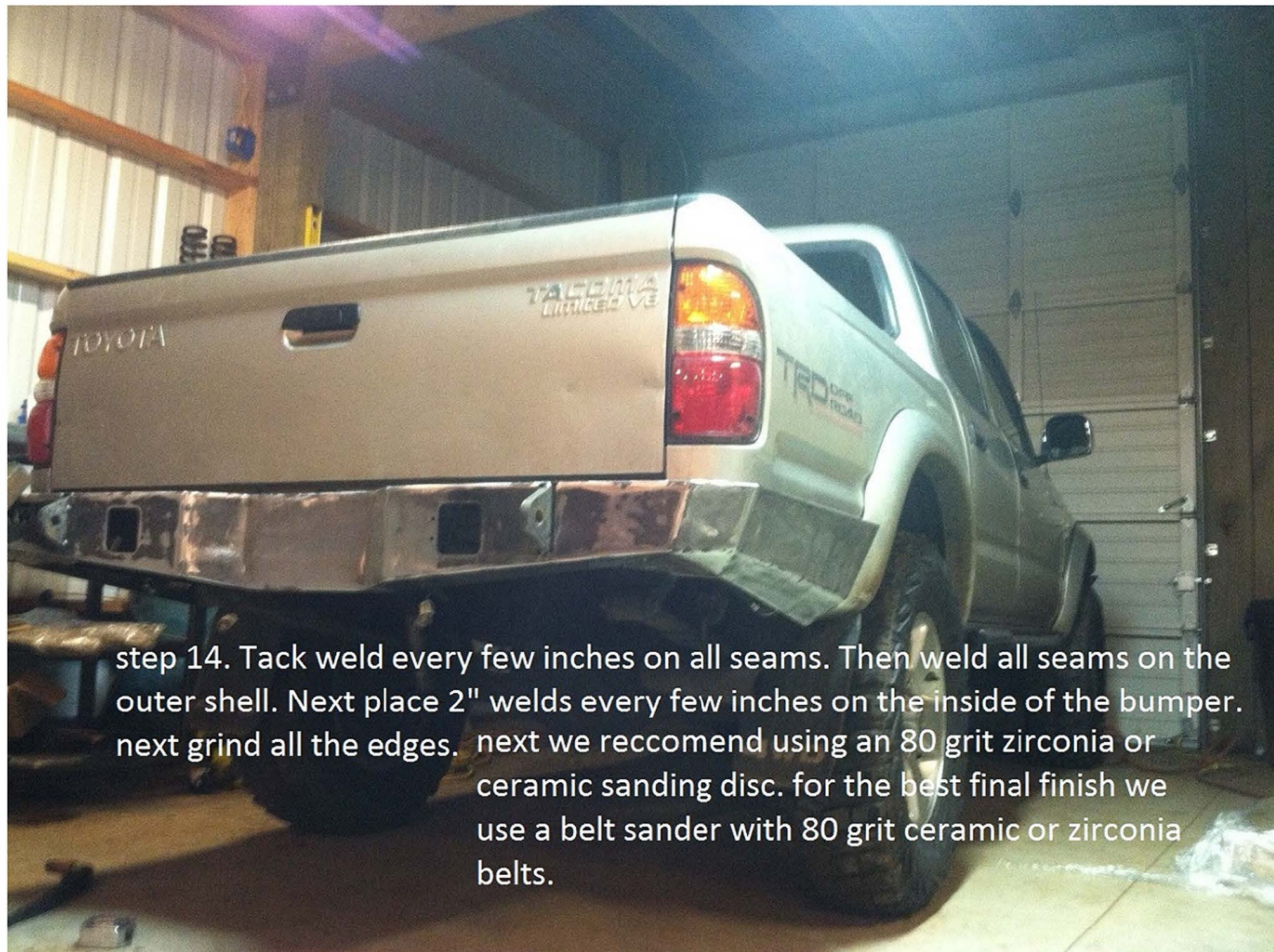


step 12. take pn.'s 2003r-10 and place them as shown in the picture.

step 13. take pn.'s 2003r-16 and 15 and bolt them together as shown in the picture. you will need 4x 5/16x11/2" bolts, nuts and lock washers.

part no.'s 2003r-15 will fit inside the outer extensions of the bumper. weld 2003r-16 when both parts bolted together fit well in both locations.





step 14. Tack weld every few inches on all seams. Then weld all seams on the outer shell. Next place 2" welds every few inches on the inside of the bumper. next grind all the edges. next we reccomend using an 80 grit zirconia or ceramic sanding disc. for the best final finish we use a belt sander with 80 grit ceramic or zirconia belts.