

step 1. take Pn.'s FJ80-2 and bolt them to the top of the frame rail as shown in the picture.



step 2. Take pn.'s FJ80-3 and place them over the slot on FJ80-2 as shown on the inside of the frame rail. only tack weld one side at first .

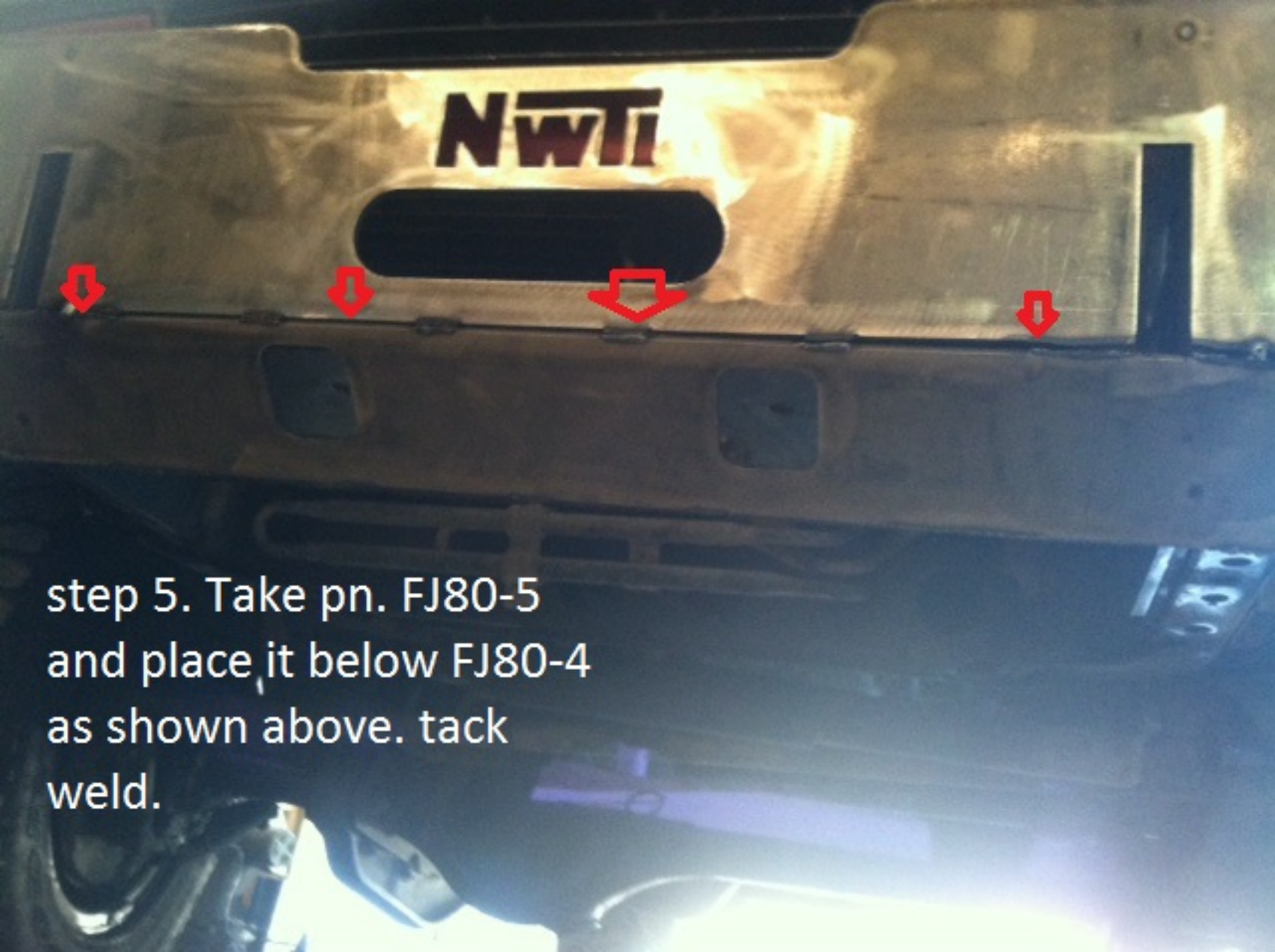


step 3. Take Pn.FJ80-1 (winch mount plate) and using the slots for alignment place it between pn.'s FJ80-3 as shown. This can be a bit tricky but once its together properly it will hold itself. make sure pn.'s FJ80-3 are the same distance from the core support to judge fitment.





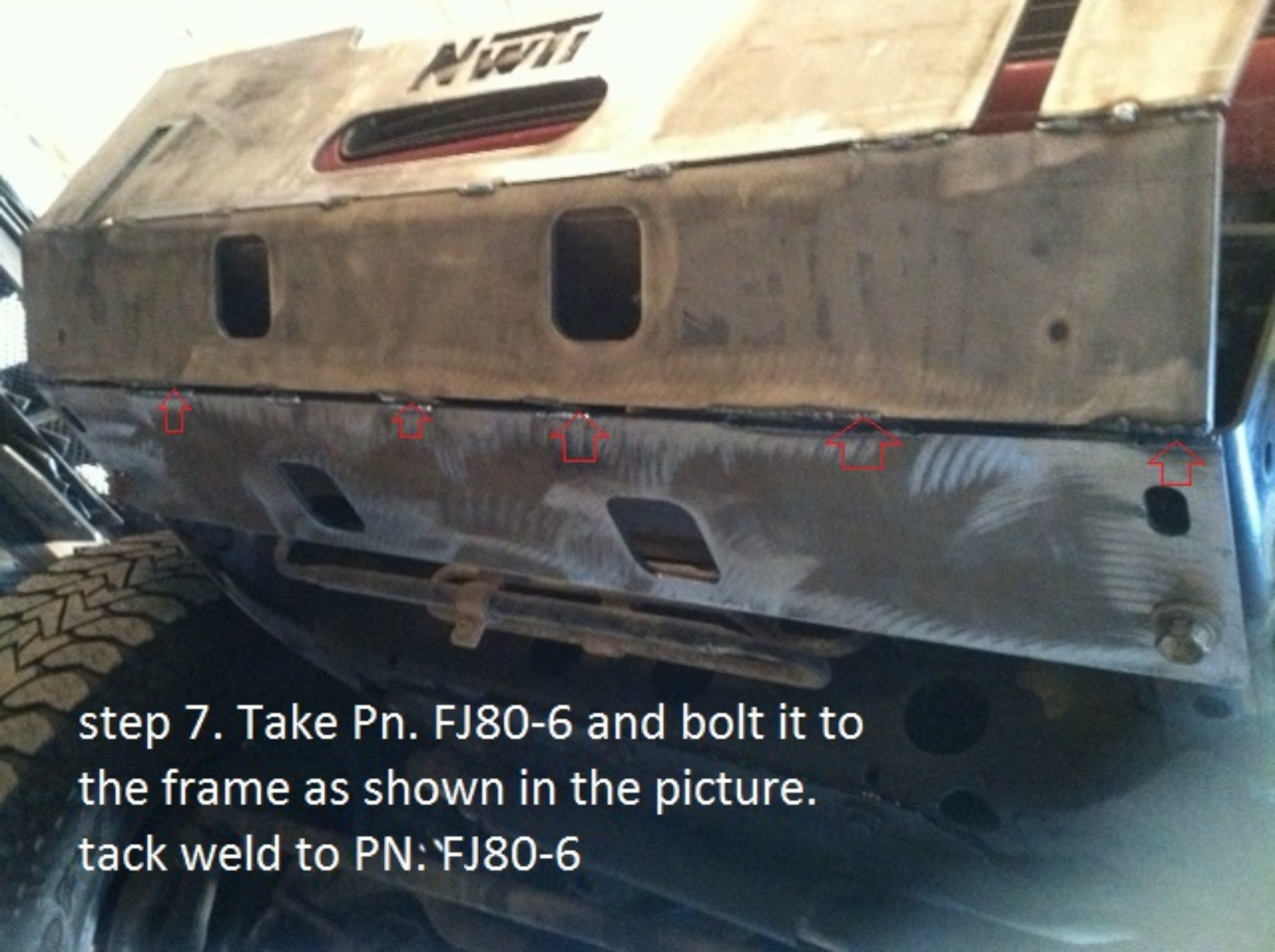
step 4. Take PN. FJ80-4 and place it against the front of Pn.'s FJ80-3. tack weld in place.



step 5. Take pn. FJ80-5
and place it below FJ80-4
as shown above. tack
weld.



step 6. take pn.'s FJ80-7 and place them as shown in the picture. Level them and tack weld.



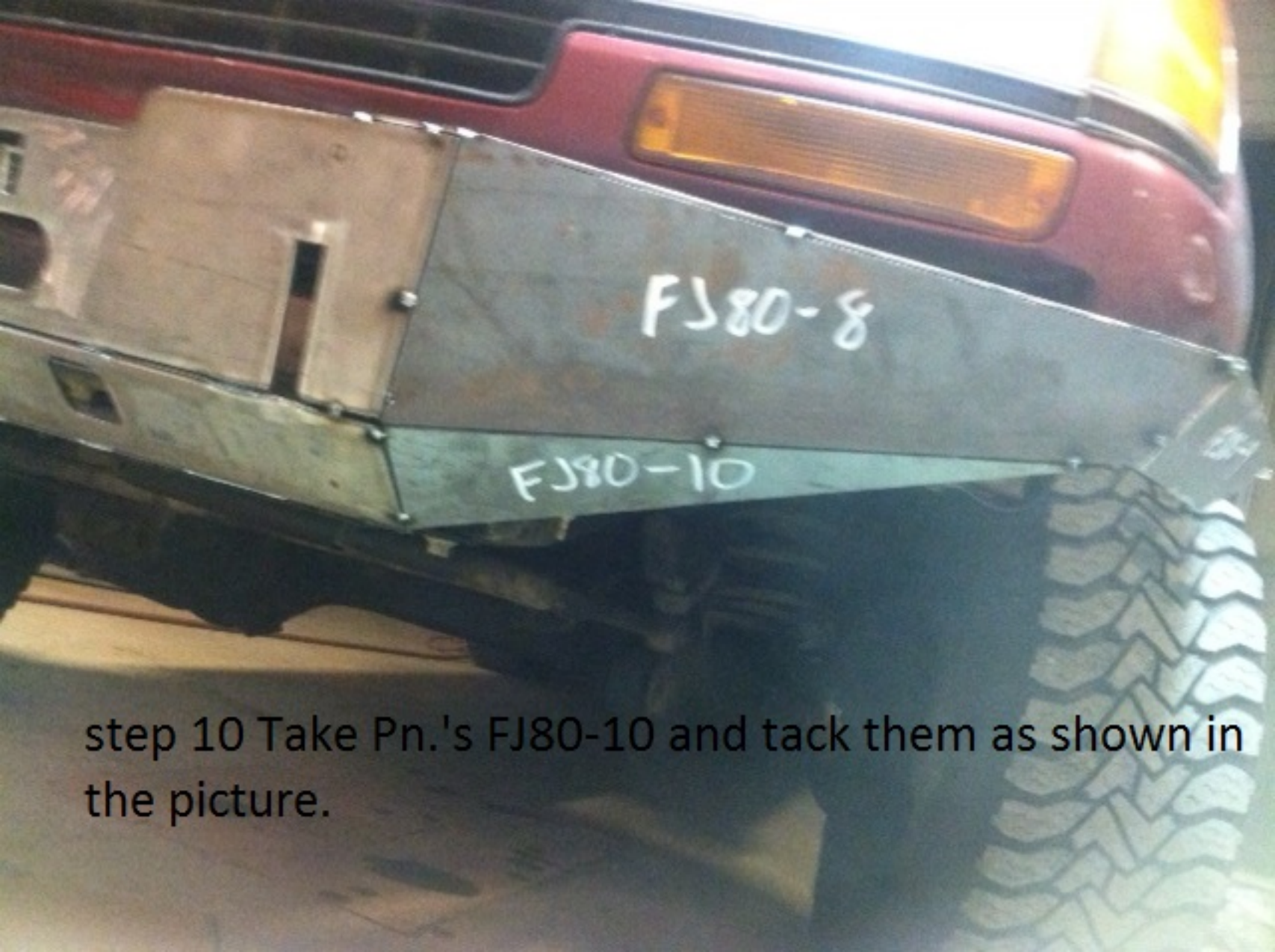
step 7. Take Pn. FJ80-6 and bolt it to the frame as shown in the picture.
tack weld to PN: FJ80-6



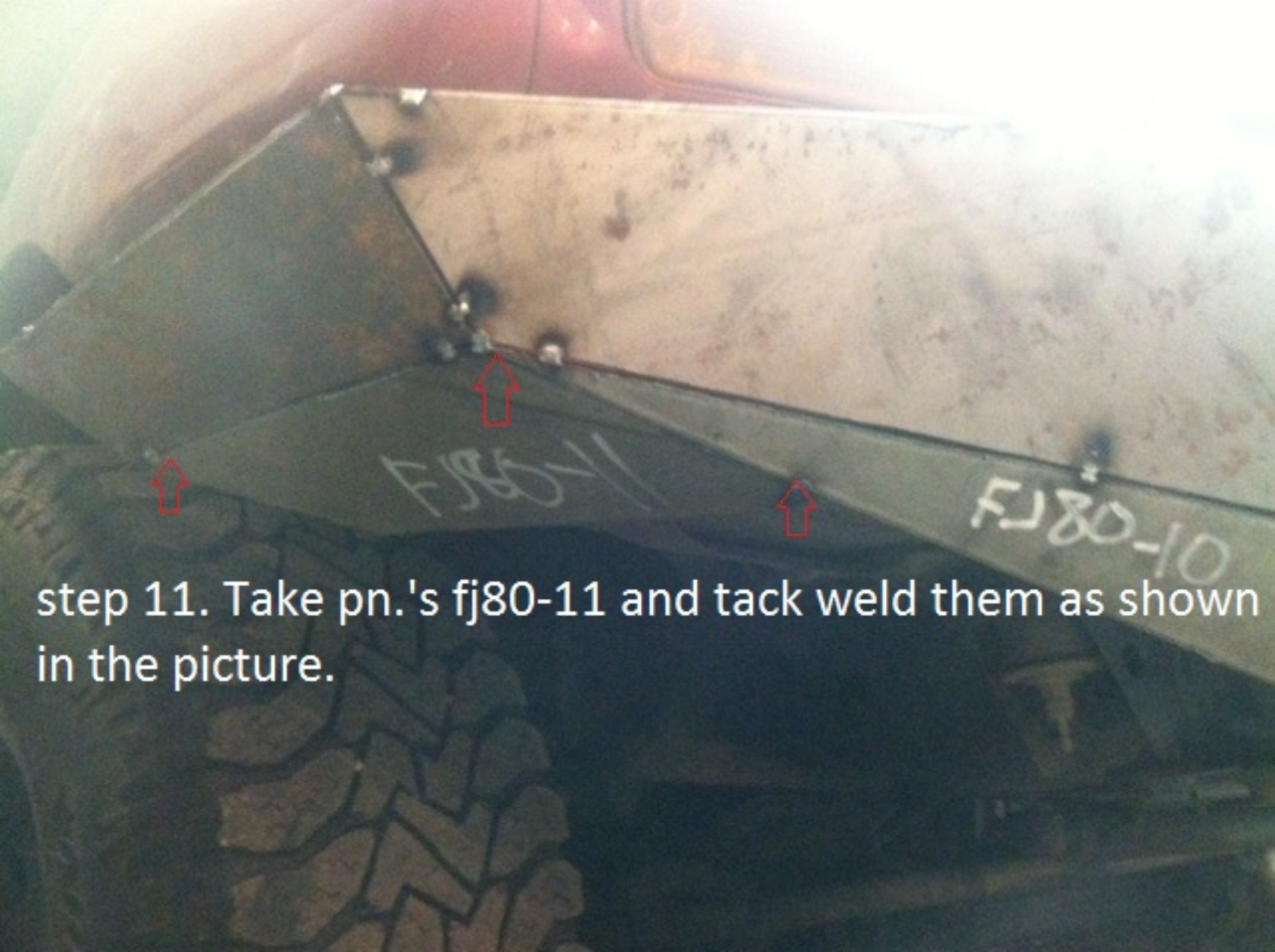
step 8. Take PN.'s FJ80-8 and tack weld them as shown in the picture.

step 9. take pn.'s FJ80-9 and tackweld them as shown in the picture.





step 10 Take Pn.'s FJ80-10 and tack them as shown in the picture.

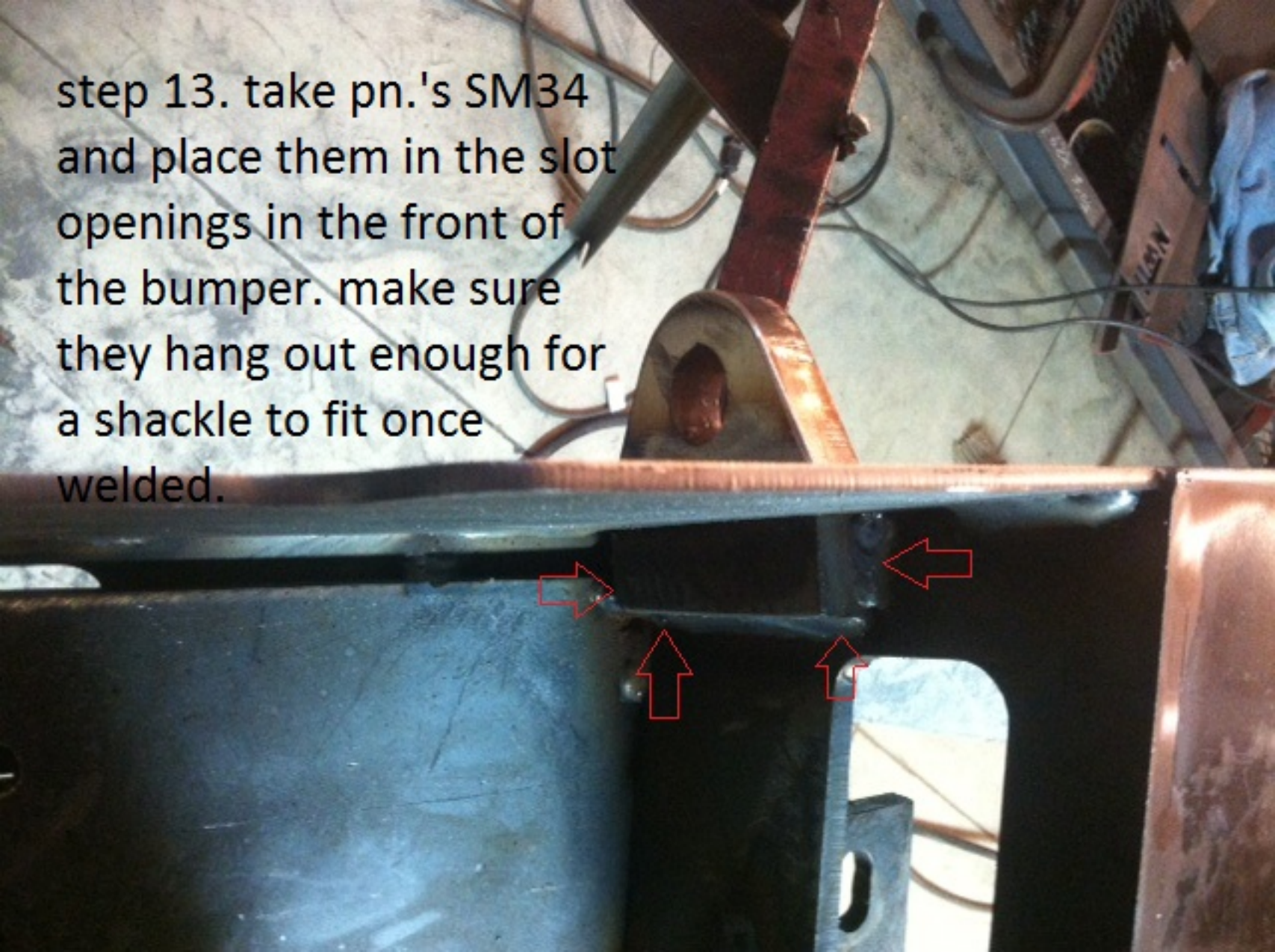


step 11. Take pn.'s fj80-11 and tack weld them as shown in the picture.



step 12. take Pn.'s Fj80-12 and tack weld them as shown in the picture.

step 13. take pn.'s SM34
and place them in the slot
openings in the front of
the bumper. make sure
they hang out enough for
a shackle to fit once
welded.





place it on top of the bumper center it and lean it forward or back as you prefer.

step 15. weld all outer seems, then weld inner seam every few inches. To install light mounts (optional) set the provided tubing against the inside of the light opening on the bumper. Rotate the tube until it aligns with the opening in the bumper. make sure the tube is pointing forward.

Once all seams are welded grind the welds down smooth, next we recomend an 80 grit zirconia sanding disk or flapper sander. Thanks for purchasing our FJ80 front winch bumper kit. If you have any questions call or text 360-798-2337

