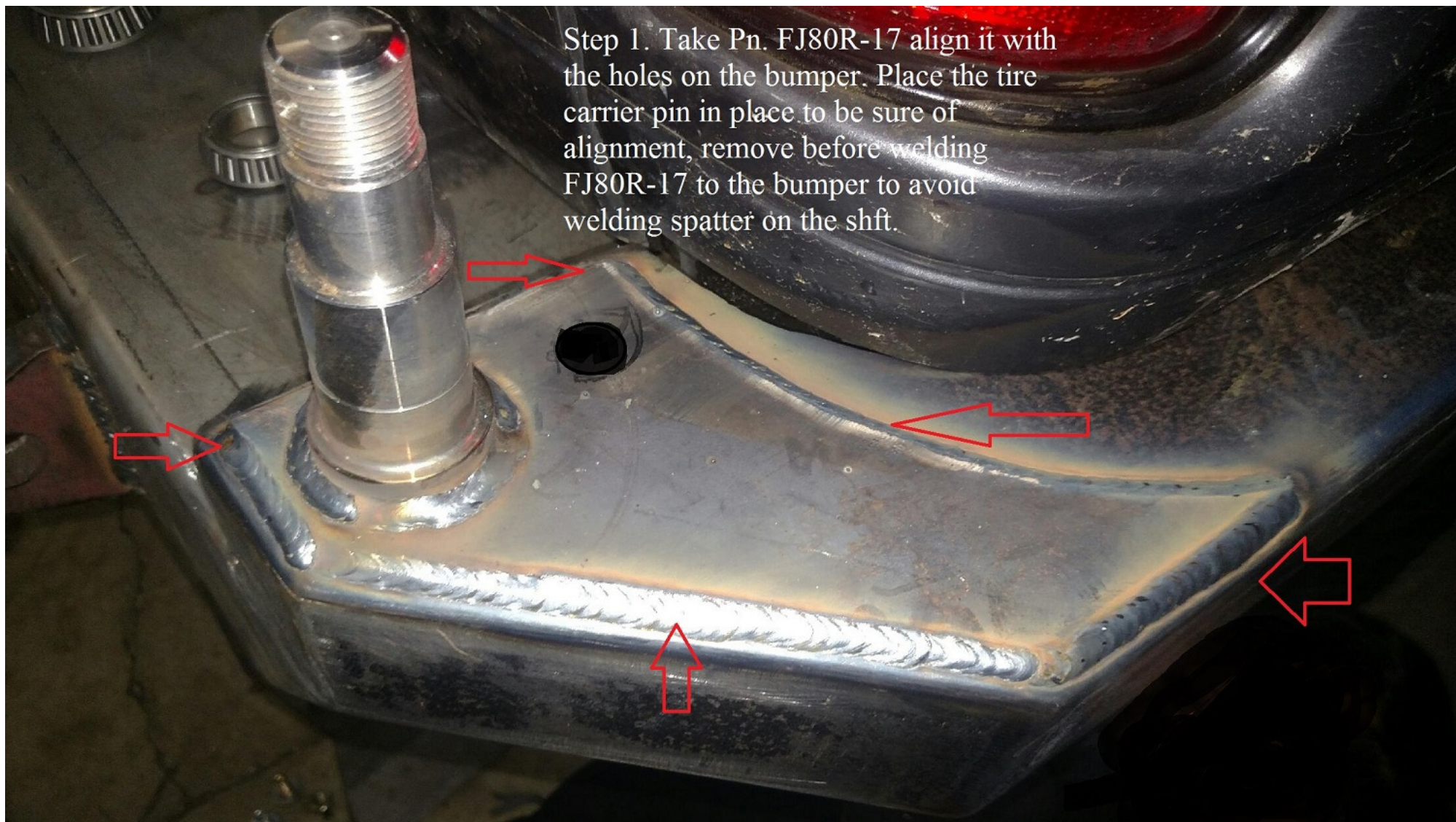
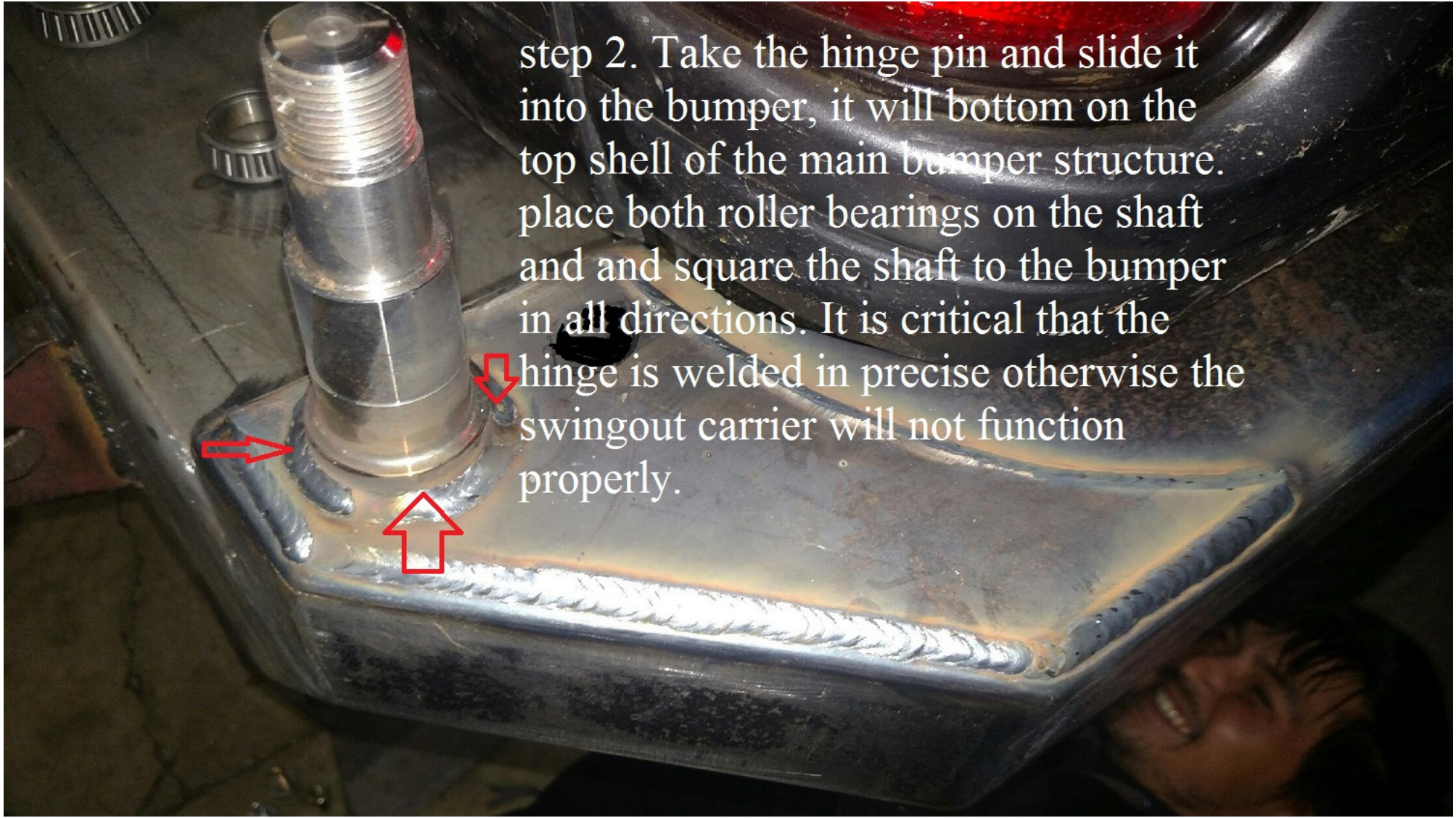


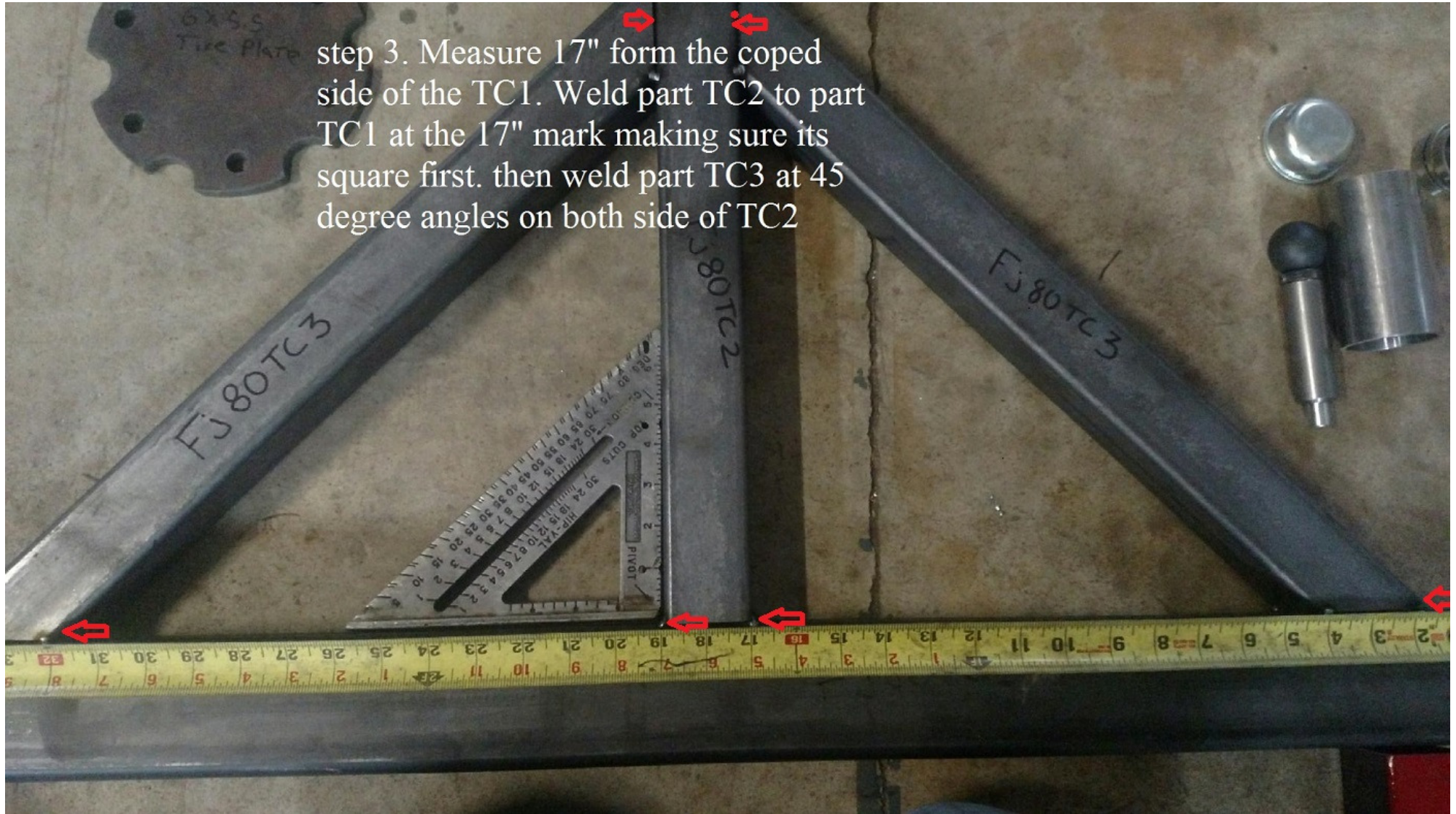
Step 1. Take Pn. FJ80R-17 align it with the holes on the bumper. Place the tire carrier pin in place to be sure of alignment, remove before welding FJ80R-17 to the bumper to avoid welding spatter on the shift.





step 2. Take the hinge pin and slide it into the bumper, it will bottom on the top shell of the main bumper structure. place both roller bearings on the shaft and square the shaft to the bumper in all directions. It is critical that the hinge is welded in precise otherwise the swingout carrier will not function properly.

step 3. Measure 17" from the coped side of the TC1. Weld part TC2 to part TC1 at the 17" mark making sure its square first. then weld part TC3 at 45 degree angles on both side of TC2

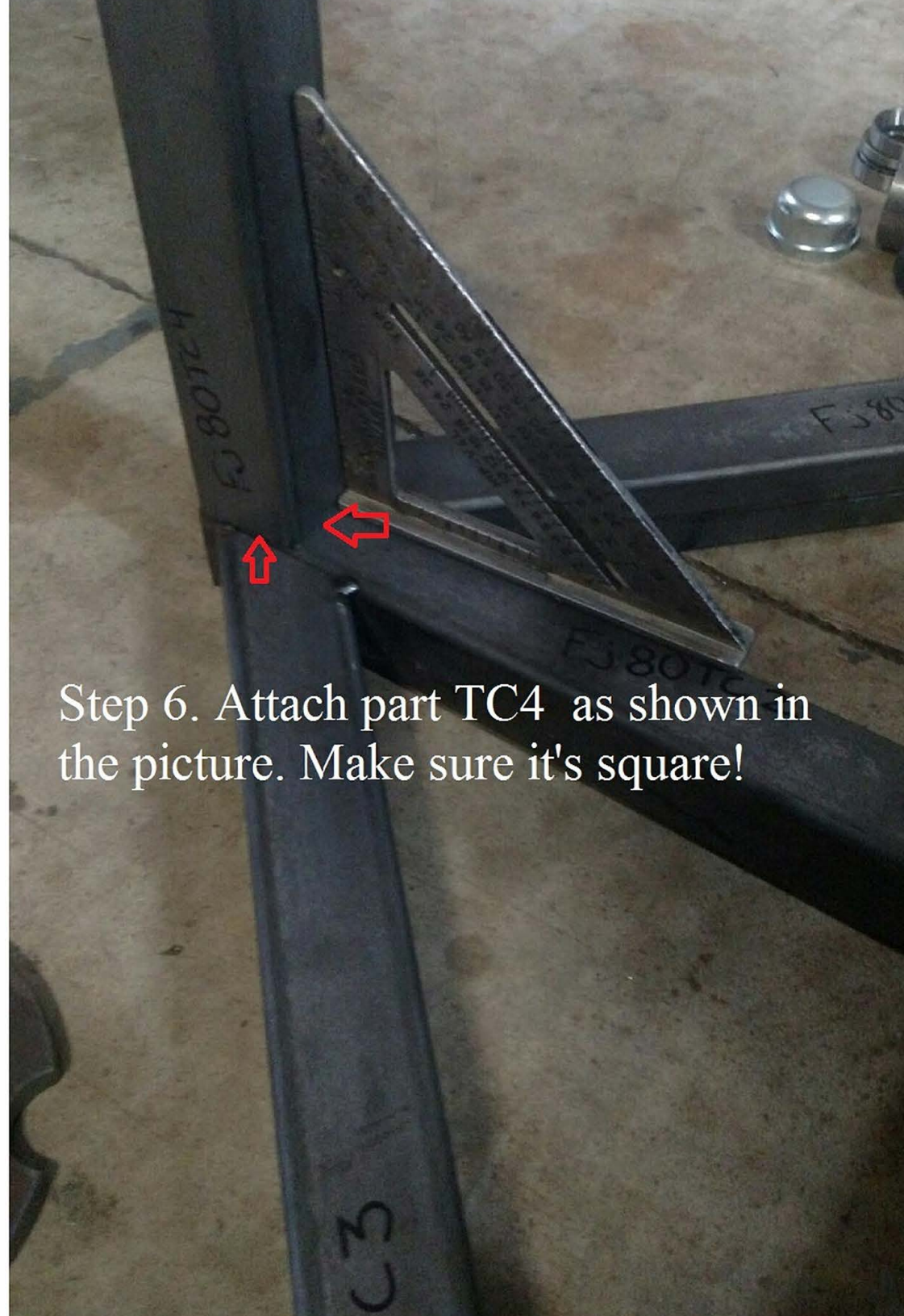


Measure from the backing plate of the wheel to the straight edge. Then add a half inch to determine the length of part TC4.





Step 5. Cut part TC4 to length



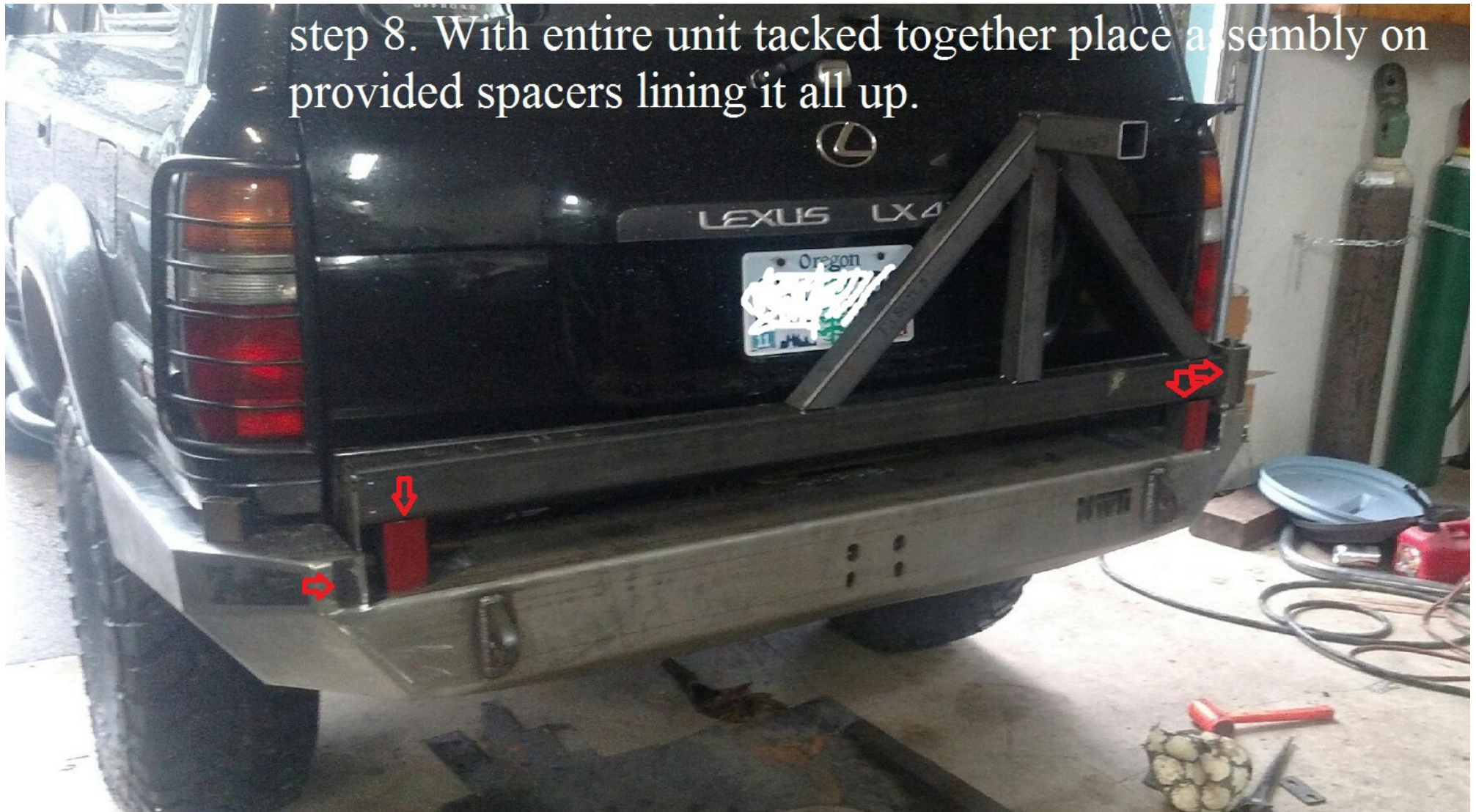
Step 6. Attach part TC4 as shown in the picture. Make sure it's square!



Step 7. attach TC6 to the
end of Tc1



step 8. With entire unit tacked together place assembly on provided spacers lining it all up.





lockout pin will engage the hole in FJ80R-17 when the arm is at 90 degrees.

step 9. With swingout assmebly solidly tacked together rotate the arm out 90 degrees. Attach the lockout pin as shown.

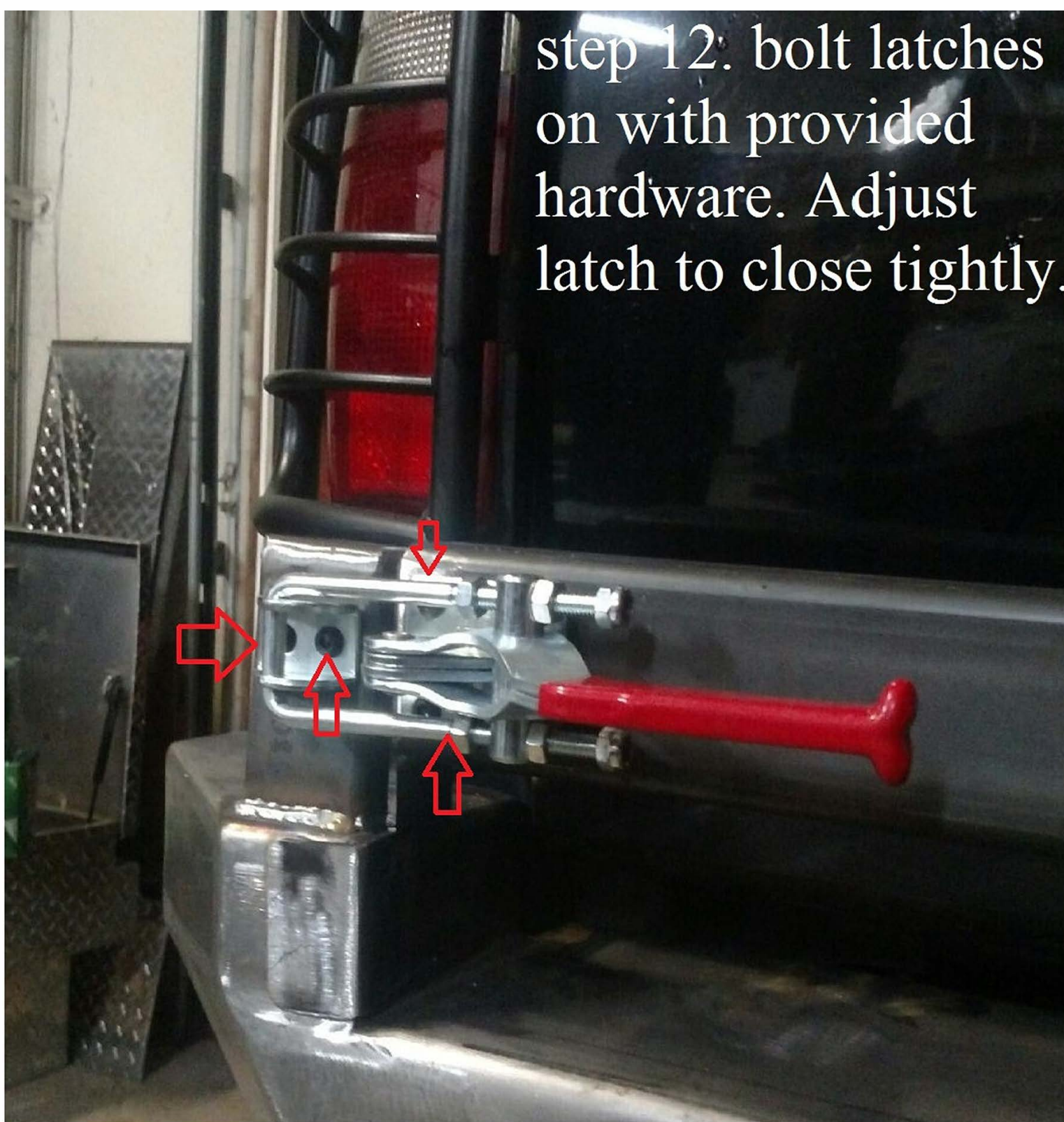
step 10.
place part TC5 inline with
tire carrier, tack in place



step 11. Tack weld EC2 as shown in the picture.



step 12: bolt latches
on with provided
hardware. Adjust
latch to close tightly.





step 13. Weld the wheel mount flange to the end of TC4, make sure it is centered.



step 14. Finish all welding and paint or powdercoat to keep from rusting!