



Product Instructions

80 Series Land Cruiser Front bumper Installation

Product Overview

Our front bumper kit consists of the Center section (winch cradle), L&R wings, L&R wing supports and hardware. This kit bolts on using all factory bolt holes with no cutting or drilling required.

Tool list

- Ratchet or socket driver
- 19mm socket
- 17mm socket
- 17mm wrench



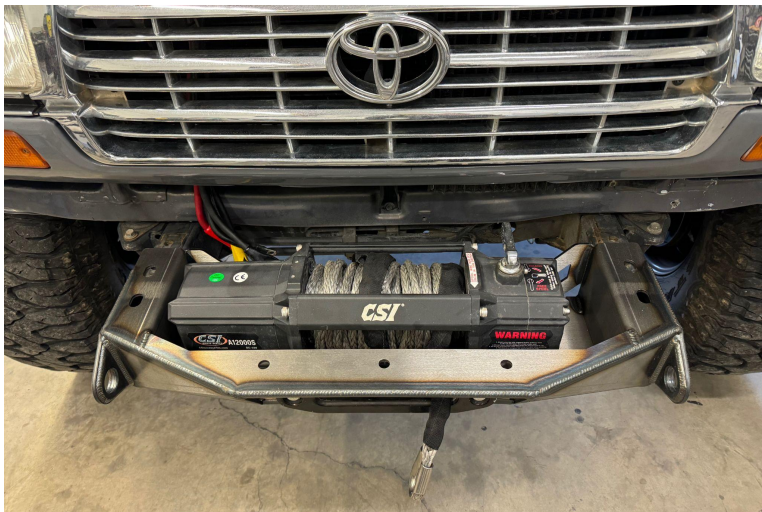
Step 1: Lay out hardware as shown

The (8) 12mm bolts with washers are used for the top and bottom of the frame rails, The (4) 10mm bolts with large fender washers are used for the side of the frame rails and the remaining (4) 10mm bolts with the smaller washers are use to bolt the wing supports to the wings.



Step 2: Center section

Set the center section on the frame rails. This is the easiest time to install your winch, fairlead and any lights that are going on the center section. Once the bumper is fully installed you may not be able to get your winch in and access to the fairlead and light holes will be more limited.



After you install the accessories you can now slide the center section back into place. You'll notice the holes on the center section along with all the other holes throughout the bumper are slotted. This is to allow for adjustment to account for imperfections in the frame rails and allow you to square the bumper up to the truck should you need to make some adjustments.

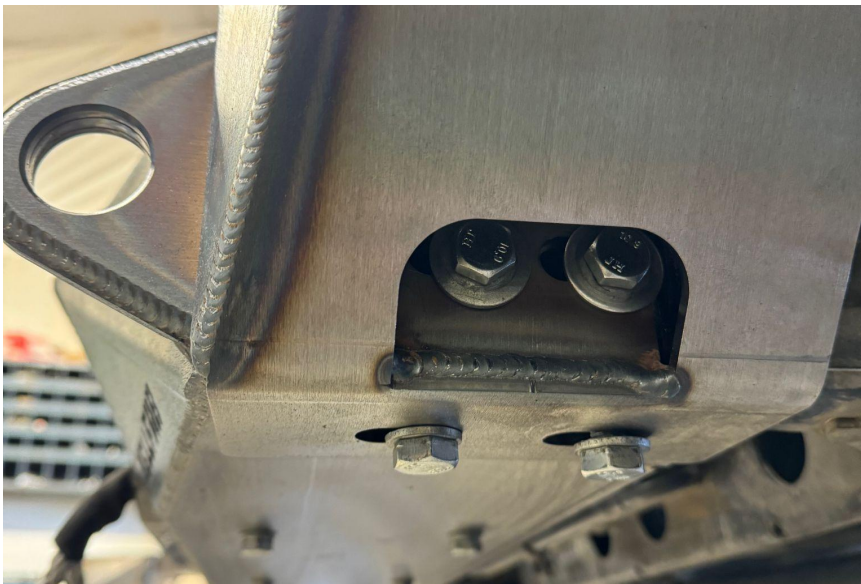


Step 3: Wing install



Before you install the wings, now is the time to install your lights. Although the wings do come off easily should you need to make adjustments, you will not be able to access the lights once the wings are on. Our light mounts are designed to run Baja Designs Squadrons, fitment of other lights may vary and is not guaranteed. There are two mounting hole, The forward hole closest to the cutout is designed to sit the light a little more flush to the cutout and

will point the light slightly downward which can be good for more of a flood light. The rear hole is designed to set the light back and position the light a little more flat for a farther reach. You may have to test out each position and see what works best for you.



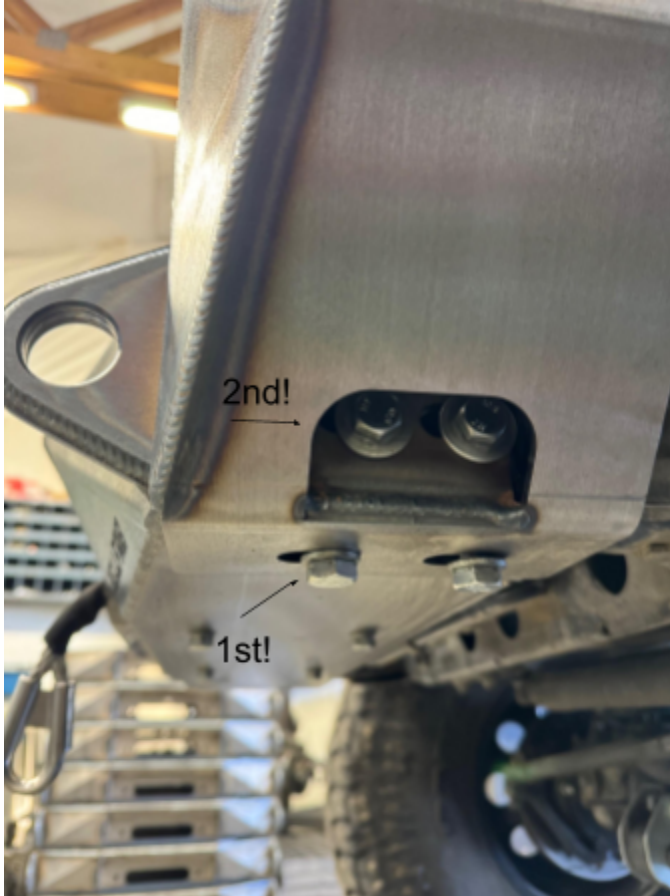
Now you can hold the wing up to the center section and install the lower 12mm bolts and then the side 10mm bolts with the larger fender washers. Leave all hardware loosely installed till the end when all pieces are installed. Repeat wing install on the other side.



Step 4: Wing Braces

Set wing braces on and line them up with the edge of the wing as shown below. Use the remaining 12mm bolts to go through the center section and the remaining 10mm bolts with the smaller washers for the top holes that bolt into the wing. Again, leave everything loosely bolted.





Step 5: Squaring and Final tightening sequence

Now that all the pieces are installed it's time to go back, line everything up and fully tighten everything in the order shown.

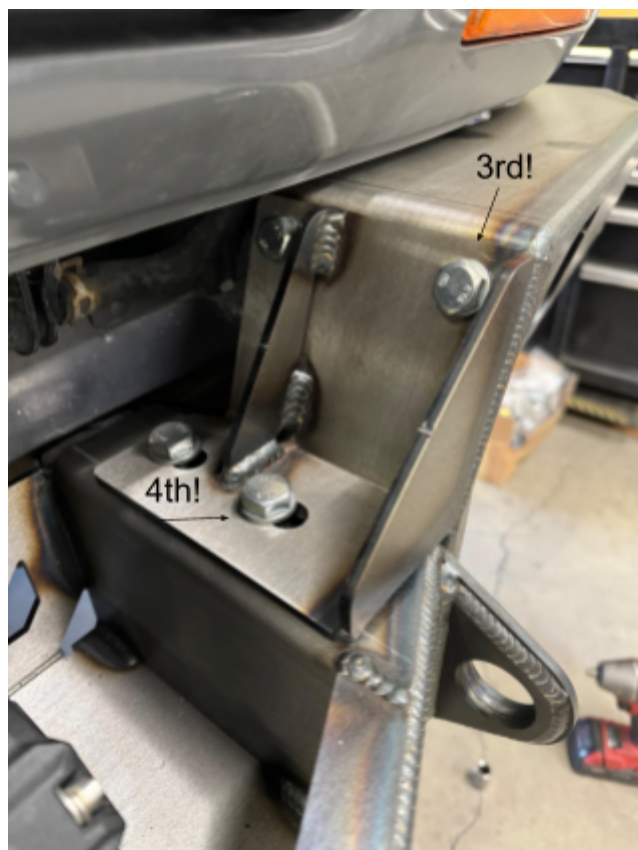
Go around and make adjustments necessary to line up the edges of the bumper pieces and make sure the bumper looks visually pleasing against the body. You'll notice in our photos that all of our bumper pieces are pulled all the way out to the end of the slots, this lined everything up good for us. Move things around till you're happy with the fitment and look.

Start with lower 12mm bolts. This is very important to pull the bumper up tight against the frame rails.

Next, Tighten the side bolts then move to the top side and tighten the top bolts on the supports and last, the top frame rail bolts.

Note: There is some extra clearance left intentionally between the top of the frame rail and the bumper should you need to shim and make adjustments to get the bumper to sit and look correct against the body. Although This won't be needed in most cases we have found that some trucks have a discrepancy between frame and body and may need some shimming to sit correctly. If needed Contact us for help with this.

That's it, you're done!



Thank you for purchasing our products, please contact us with any questions!