



INSTALLATION INSTRUCTIONS

89-95 Toyota Pickup Front Winch Bumper P/N 68450

Your safety, and the safety of others, is very important. To help you make informed decisions about safety, we have provided installation and operating instructions and other information on labels and in this guide. This information alerts you to potential hazards that could hurt you or others. It is not possible to warn you about all potential hazards associated with this product, you must use your own good judgment.

CARELESS INSTALLATION AND OPERATION CAN RESULT IN SERIOUS INJURY OR EQUIPMENT DAMAGE. READ AND UNDERSTAND ALL SAFETY PRECAUTIONS AND OPERATING INSTRUCTIONS BEFORE INSTALLING AND OPERATING THIS PRODUCT.

This guide identifies potential hazards and has important safety messages that help you and others avoid personal injury or death. **WARNING** and **CAUTION** are signal words that identify the level of hazard. These signal words mean:

▲WARNING signals a hazard that *could* cause serious injury or death, if you do not follow recommendations.

▲CAUTION signals a hazard that *may* cause minor to moderate injury, if you do not follow recommendations.

This guide uses **NOTICE** to call attention to important mechanical information, and **NOTE**: to emphasize general information worthy of special attention

PARTS LIST

PART NO.	QUANTITY	DESCRIPTION
68449	1	Front Bumper
68448	1	RH Frame Bracket
68447	1	LH Frame Bracket
68468	2	Spacer Plate, Front Frame
68464	1	Hardware Kit
69434	1	Solenoid Box Bracket, Centered
69435	4	Shim Plate

TOOLS REQUIRED

Metric wrench set	Standard socket set
Standard wrench set	Metric socket set
Torque wrench	Ratchet
Phillips screw driver	Allen wrench set

TORQUE SPECIFICATIONS

1/4	8 lb. ft. (10.8 N-m)
5/16	19 lb. ft. (25.8 N-m)
7/16	50 lb. ft. (67.8 N-m)
M10-1.25	45 lb. ft. (61 N-m)
M12-1.25	75 lb. ft. (101.7 N-m)

1. Unplug the wiring from the turn signals in the front bumper and remove the turn signals from the bumper. Remove the front license plate from the bumper.
2. Remove the front bumper from the vehicle and discard.
3. Install the new left and right frame brackets to the vehicle using the M12 and M10 hardware provided. **See Figure 1.** Install the M12-1.25 x 30mm bolts, 1/2" lock washers, and 7/16" flat washers in the bottom frame holes. Install the M12-1.25 x 40mm bolts, 1/2" lock washers, and 7/16" flat washers through the front of the frame bracket, spacer plate, and into the frame. Install the new M10-1.25 x 30mm bolts, M10 lock washers and flat washers in the side holes of the frame. Once all seven bolts are installed, evenly tighten and torque all bolts using the torque chart.

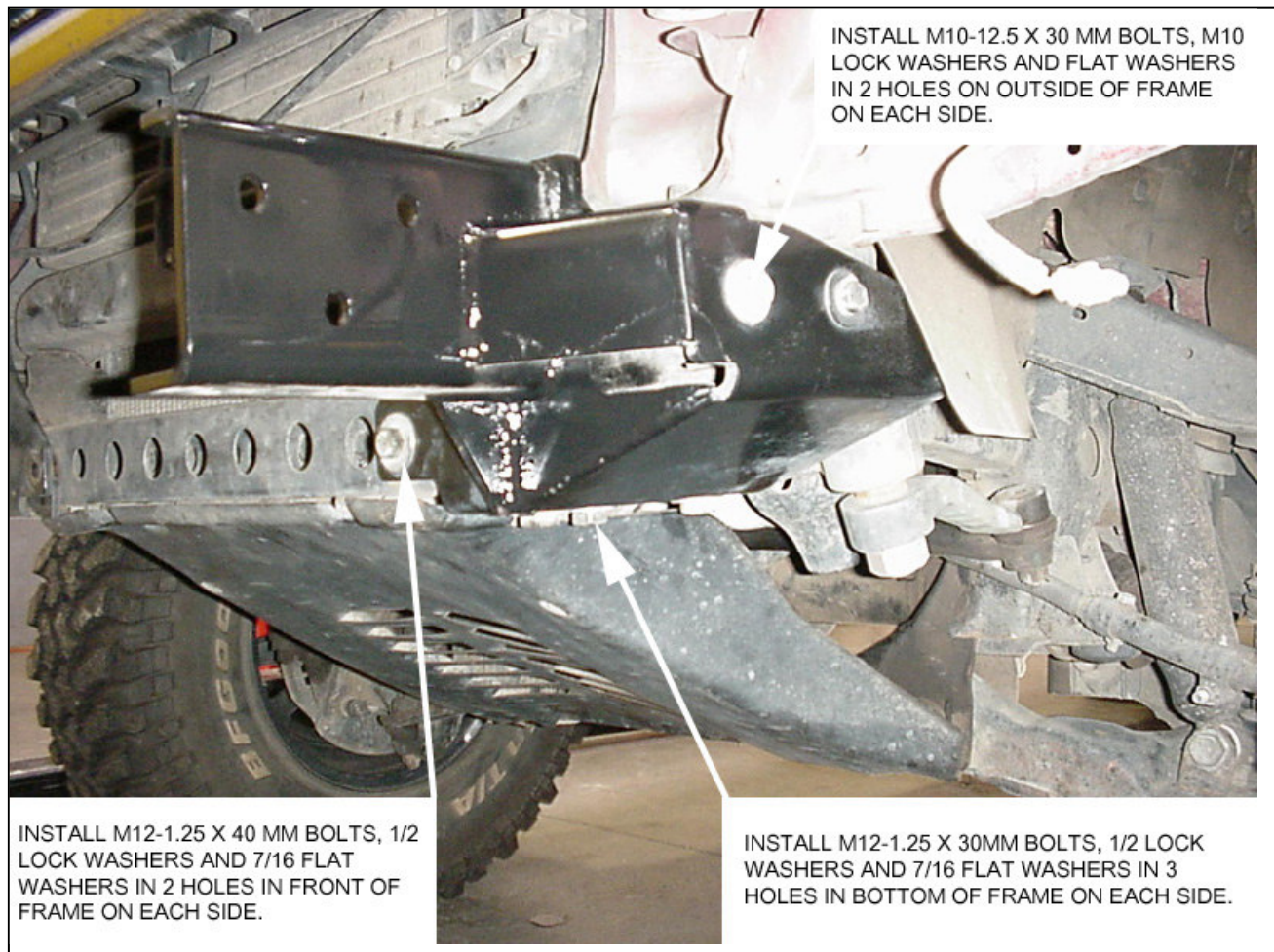


FIGURE 1, FRAME BRACKET INSTALLATION.

4. Install the factory turn signals into the front bumper using the new #8-32 screws and spring nuts. **See Figure 2.**



FIGURE 2, TURN SIGNAL INSTALLATION.

5. Install the front bumper to the frame brackets. Initially mount the front bumper to the bottom holes in the frame brackets until the side-to-side position is set. Insert the 7/16" carriage bolts through the bottom of the bumper, the frame bracket, and install a 7/16" flat washer and 7/16" lock nut to each carriage bolt. **See Figure 3.**



FIGURE 3, BUMPER INSTALLATION USING BOTTOM HOLES IN FRAME BRACKETS.

6. With the four bolts in the bottom of the bumper loosely installed, adjust the bumper side to side until the desired position is found. Install the appropriate number of shim plates to each side between the frame bracket and the bumper. **See Figure 4.** Install a 7/16" carriage bolt through each hole in the side plate inside the bumper, the shim plates, and the frame brackets and install a 7/16" flat washer and lock nut onto each carriage bolt. **See Figure 5.** Torque all hardware using the torque chart.



FIGURE 4, SHIM PLATE INSTALLATION.

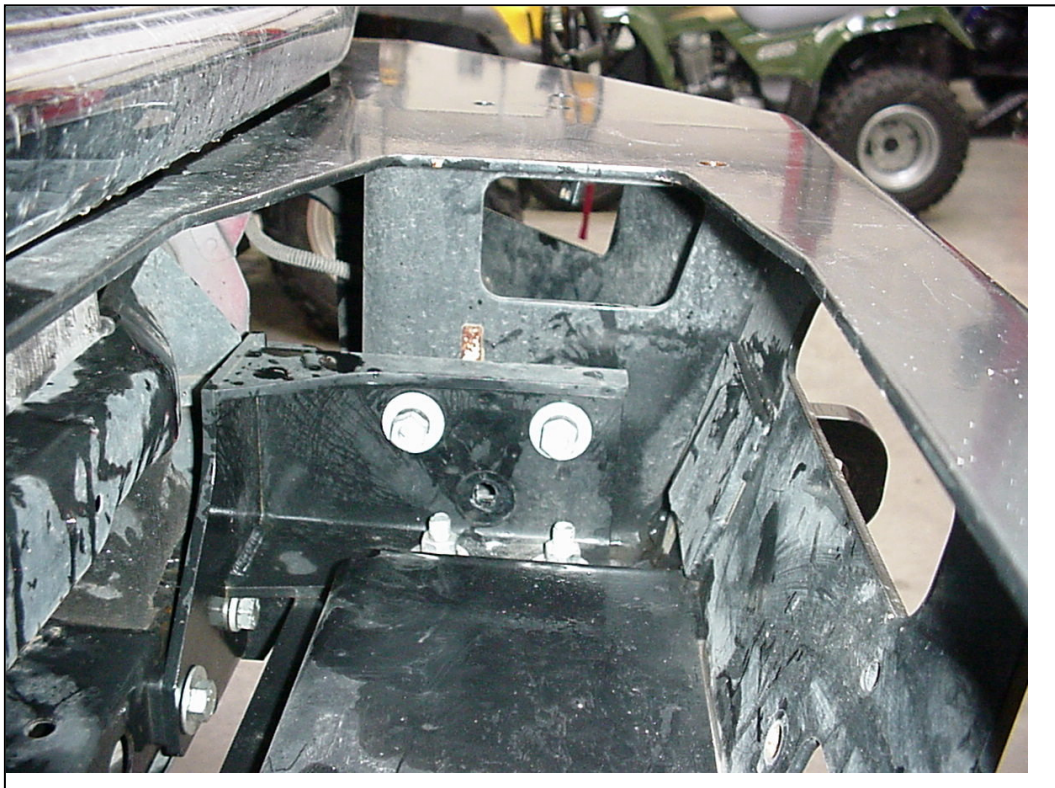


FIGURE 5, BUMPER TO FRAME BRACKET BOLTS.

7. Plug the turn signal wiring into the turn signals.
8. If installing a winch, use the instructions provided with the winch. A solenoid box-mounting bracket is provided with this bumper. If installing a Warn low profile winch, mount the solenoid box to the supplied bracket and install the bracket to the winch. **See Figure 6.** One at a time, remove the 5/16" Allen head bolts from the right hand side of the winch tie rod and install the bracket using the existing hardware.



FIGURE 6, SOLENOID BOX MOUNTING BRACKET.

9. Pre-drilled light holes are provided in the bumper as well as holes for the Warn Rock Crawler Tube.
10. Pre-drilled holes are provided for the mounting the front license plate to the front bumper. Two locations are provided. The license plate can be mounted either above or below the fairlead opening in the bumper. Use the 1/4" bolts, flat washers, and lock nuts and torque using the torque chart.