

INSTALL INSTRUCTIONS FOR FRAME BRACKETS

READ THROUGHOUT BEFORE INSTALLING!

DETAILS:

- Frame reinforcement brackets to add strength to your aftermarket bumper or hidden winch mount and prevent the stud plates on the ends of your frame rails from getting ripped off during winching/recovery.
- Will fit 03-24 4runner, 03-09 GX470, 10-24 GX460, and 06-14 FJ Cruiser.
- On raw steel orders, parts may arrive with small amounts of oils, rust, or light scratches on surfaces caused during manufacturing, handling, and shipping processes. Customer is responsible for painting/powdercoating prior to installation.
- On powdercoated orders, parts may arrive with light scratches caused during shipping. Powdercoat may also add an additional 1-3 weeks to lead time if we don't have any coated parts in stock. Cost of powdercoating also includes a zinc primer base coat.
- Will work with all Ascend Fabrications front bumpers and most other aftermarket bumpers as long as they don't have a permanently attached bracket that covers the M8 or M12 bolt holes shown in the instructions below.

WHAT'S INCLUDED:

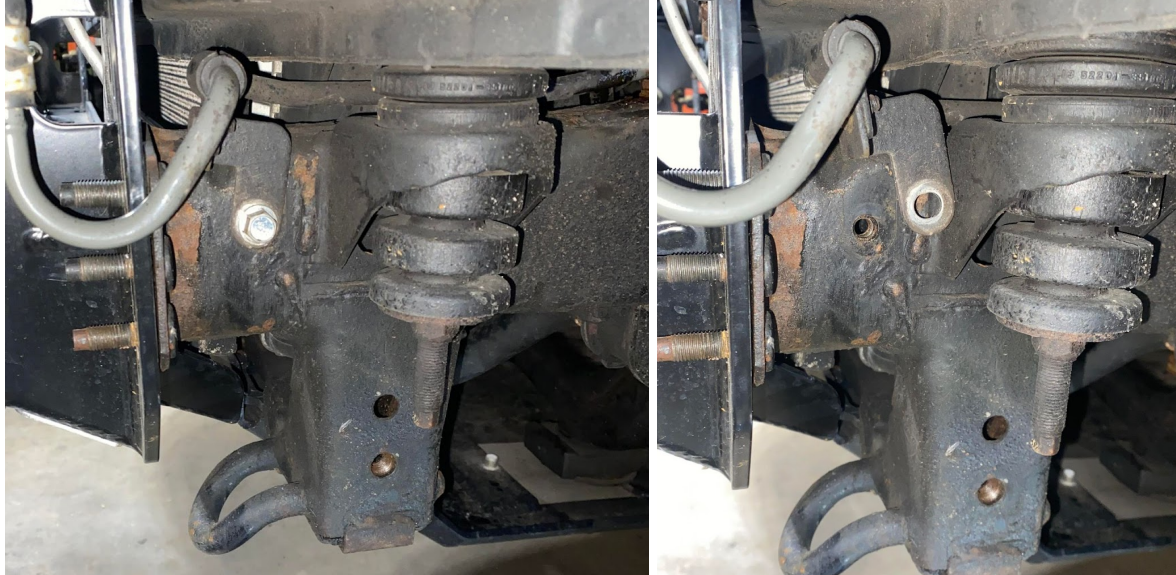
- 1X LEFT BRACKET
- 1X RIGHT BRACKET
- HARDWARE
 - 6X M10*35MM FLANGED HEX HEAD BOLT
 - 2X M12*30MM FLANGED HEX HEAD BOLT
 - 2X M8*30MM FLANGED HEX HEAD BOLT
 - 2X WASHER (1.06 OD X .53 ID)
 - 2X WASHER (.69 OD X .34 ID)
 - 6X WASHER (1.00 OD X .41 ID)
 - 6X M10 FLANGED NUT

WHAT YOU WILL NEED:

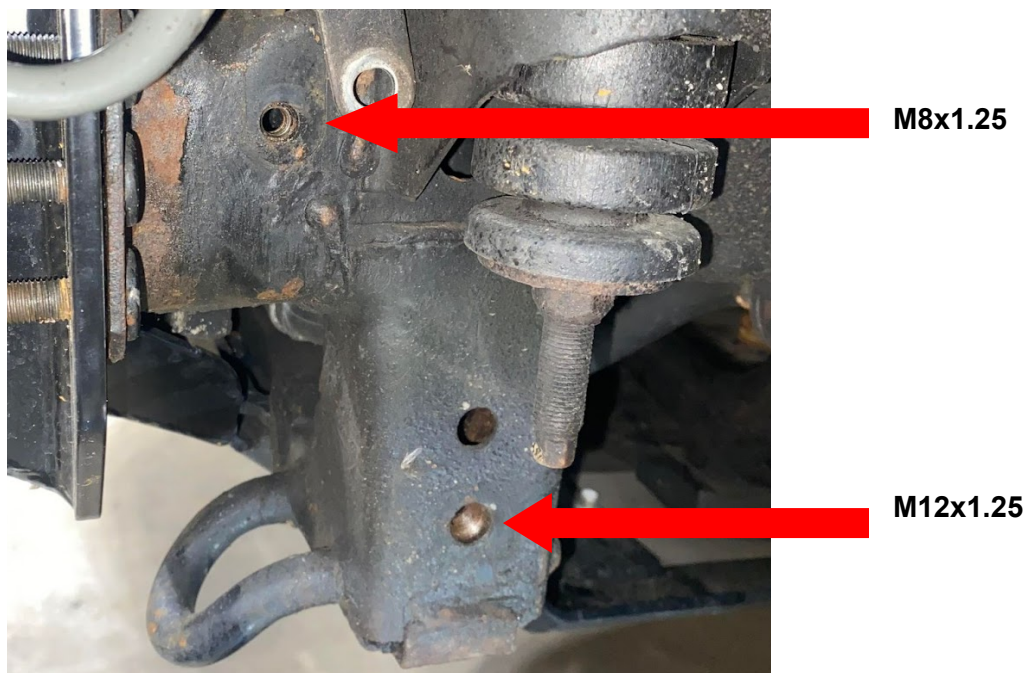
- Hammer
- Wrenches/sockets
- (OPTIONAL) Drill with tapping bits
- (OPTIONAL) Paint / anti-rust coating

INSTALL INSTRUCTIONS:

- 1) On some models, you will have to remove the M8 bolt holding the hard line on the outer side of the frame rail on both sides. Once the bolt is removed, rotate the bracket up and out of the way.



- 2) (OPTIONAL) Using a drill and M8x1.25 thread tap, run it through the upper holes to clean the threads of any rust/debris. Repeat this process with a M12x1.25 tap on the lower holes.



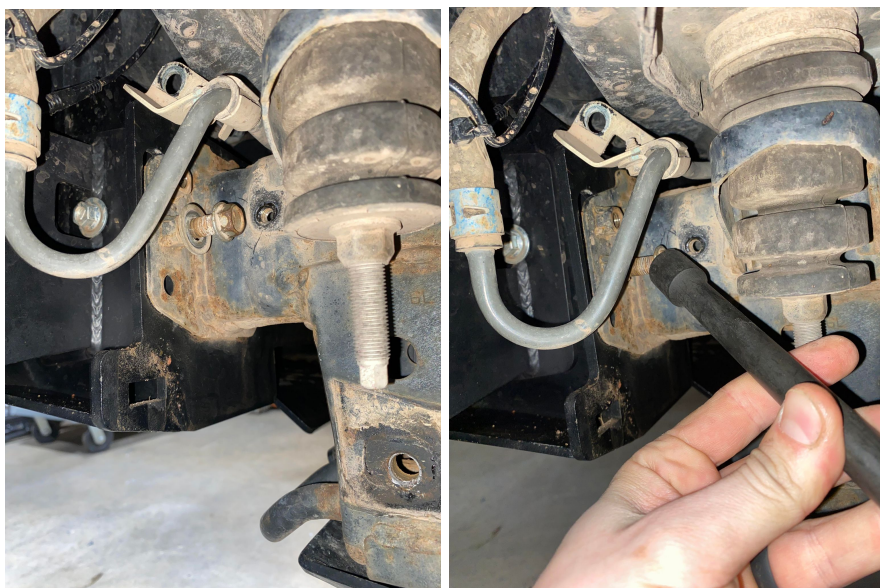
3) Undo and remove the M10 nuts and any other hardware on the outer three studs on the ends of either frame rail.

4) Remove studs/nuts

a) On models with studs, using a hammer CAREFULLY knock out the outer three studs. DO NOT hit the studs straight on. Hit the studs from the sides/top/bottom to break the spot welds on the stud head on the back side of the end plate. Once the studs are broken loose you can tap them out of the end plate and discard them.



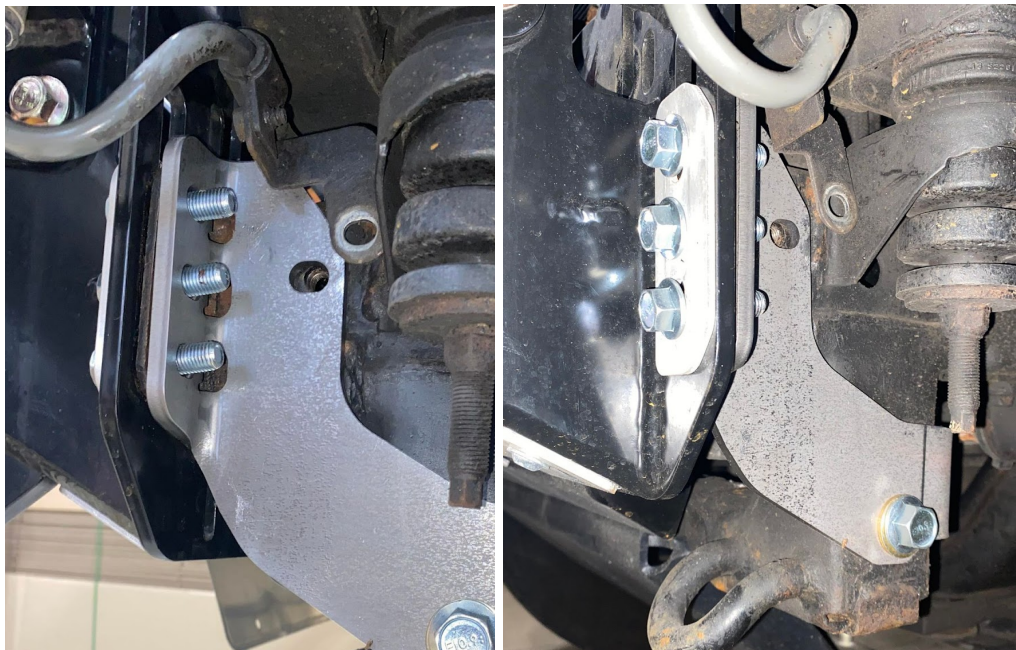
b) On models with nuts on the back side of the end plate, take one of the old bolts and install it part way into the nut on the back side. CAREFULLY hit the bolt from the side/top/bottom to break the spot welds on the nut on the back side of the end plate. You may need to use a punch rested on the bolt and hit the other end with the hammer if you can't get the hammer head in there without damaging other parts.



- 5) (OPTIONAL) Clean and touch up any bare metal areas with spray paint or an anti rust coating such as fluid film or wool wax.
- 6) Hold up the bracket and align the bottom hole with the lower M12 hole on the frame. Loosely install the M12 bolt and washer into the bottom hole.



- 7) Loosely install the M10 bolts through the bumper, old stud holes, and frame bracket. You might have to tap or spin them through. Can be installed either direction. If running an Ascend Fab bumper, also install the aluminum washer plate.



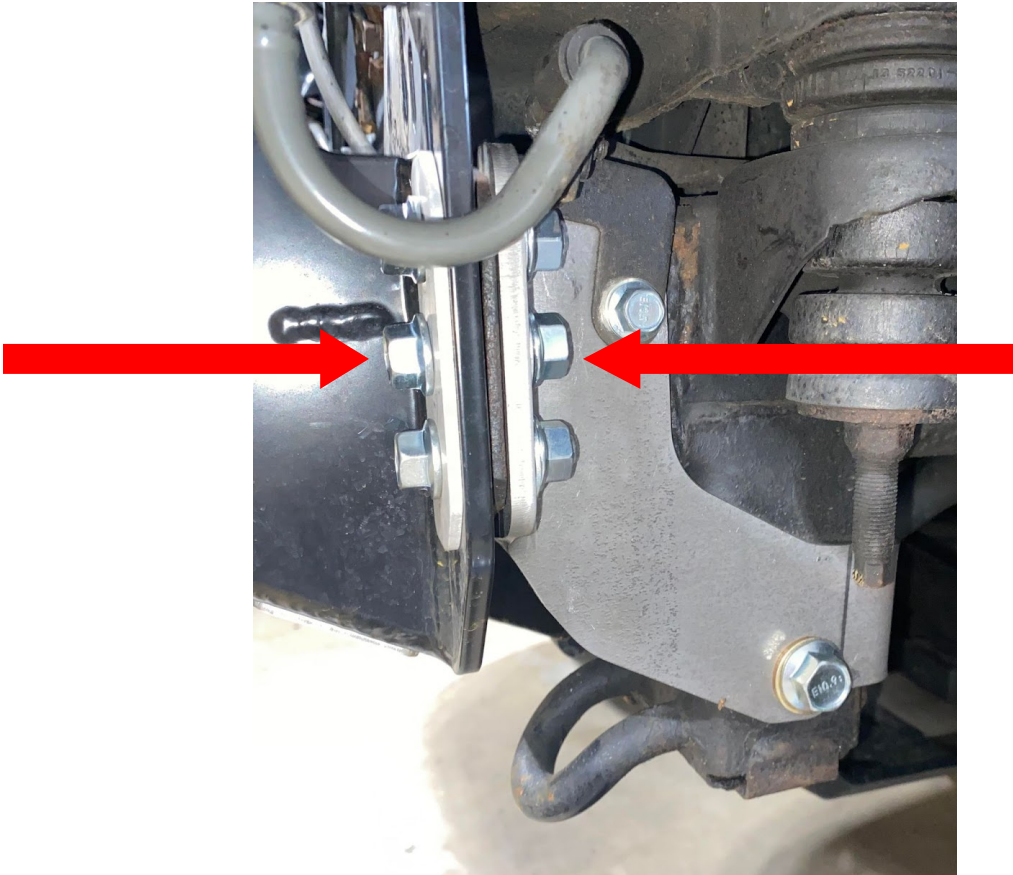
8) Loosely install the M10 nuts and washers on the ends of the M10 bolts.



9) Loosely install M8 bolt and washer into the upper hole. If you have a hard line, first move the bracket for it over the frame bracket and install the bolt through both. You may have to trim/bend part of the bracket.



10) Tighten down M10 bolts/nuts to draw the frame bracket forward.



11) Tighten down both the M12 and M8 bolts.

