



# INSTALLATION INSTRUCTIONS

## 89-95 Toyota Pickup Rear Bumper P/N 68490

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

### ▲ WARNING

#### INJURY HAZARD

**Failure to observe these instructions could lead to severe injury or death.**

- q **Always** Take time to fully read and understand this Installation Instruction and the related Warnings and Cautions.
- q **Always** tighten all nuts and bolts securely, per the installation instructions.
- q **Never** exceed capacity of tow bumper, towbar or towing vehicle. This class II bumper hitch has a maximum trailer weight capacity of 2000 lbs and maximum tongue weight capacity of 200 lbs.
- q **Always** periodically inspect bumper for damage or deformation. Any damage or deformation must be corrected immediately.
- q **Always** be sure Safety Cables are frame attached to both towing vehicle and towed unit using "criss-cross" method.
- q **Always** follow state and local regulations regarding lighting when towing.
- q **Always** be aware of bystanders, PARTICULARLY CHILDREN!
- q **Never** carry passengers on or in towed unit. NO PASSENGERS ALLOWED!
- q **Never** use this bumper for off road trail towing.
- q **Always** check all towing attaching points after first 5 miles and every 200 miles thereafter. Correct all problems immediately.

### NOTE

- q This automotive bumper hitch meets or exceeds the SAE J-684 standard. Modification will void Tow rating and warranty.

Read installation and operating instructions thoroughly.

### PARTS LIST

PART NO.	QUANTITY	DESCRIPTION
68489	1	Rear Bumper
68479	1	LH Frame Bracket
68478	1	RH Frame Bracket
68473	1	Plate, Stiffener, LH, Frame
68472	1	Plate, Stiffener, RH, Frame
68476	4	Plate, Spacer
68491	1	Hardware Kit

## TOOLS REQUIRED

Metric wrench set  
Standard wrench set  
Torque wrench  
Phillips screw driver

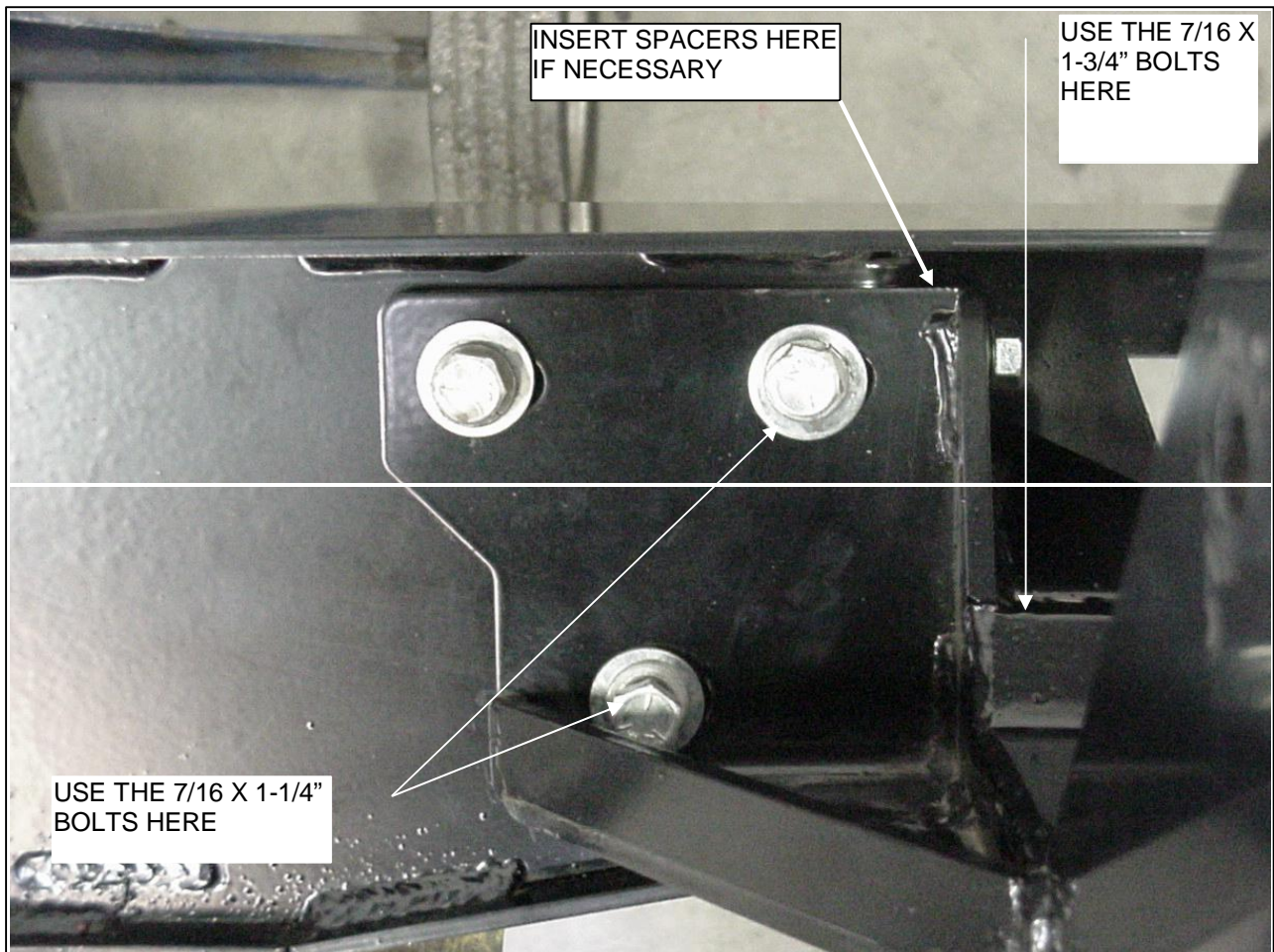
Standard socket set  
Metric socket set  
Ratchet  
Tape Measure

## TORQUE SPECIFICATIONS

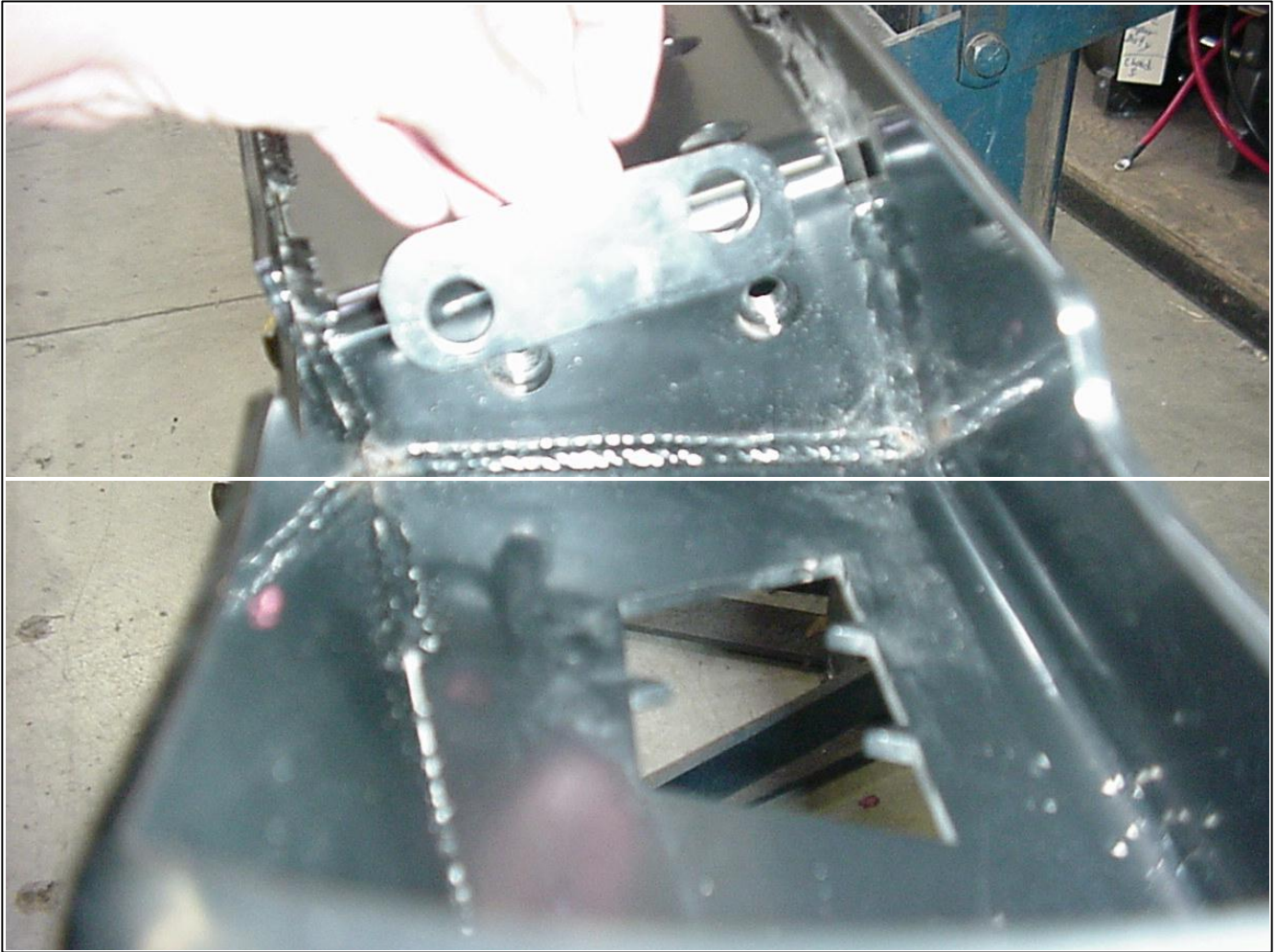
1/2  
7/16

75 lb. ft. (101.7 N-m)  
50 lb. ft. (67.8 N-m)

1. Remove the factory rear bumper and frame brackets from the vehicle. Discard these items.
2. Remove the new Warn rear bumper, frame brackets and hardware kit from the shipping box. Measure the width from the outside of the driver's side frame rail to the outside of the passenger's side frame rail. Record this measurement. Assemble the frame brackets to the rear bumper using the supplied 7/16" bolts, lock washers and flat washer. If the vehicle has a frame mounted trailer hitch it will be necessary to install the spacer plates. There are four supplied spacer plates to accommodate various widths. **See Figure 1 and 2.**



**Figure 1, Attach Frame brackets to the new Warn Rear Bumper.**



**Figure 2, Insert spacer plates if the vehicle is equipped with a frame mounted trailer hitch.**

3. Adjust the frame brackets using an angle finder to be sure that they are even side-to-side. **See Figure 3.** Once this position is found, torque the 7/16" bolts. Either using a bumper jack or multiple people install the bumper under the vehicle. Due to the large number of trailer hitch manufacturers it may be necessary to trim the Warn frame brackets for adequate clearance to the trailer hitch. See Note on page 1 before trimming Warn frame brackets.

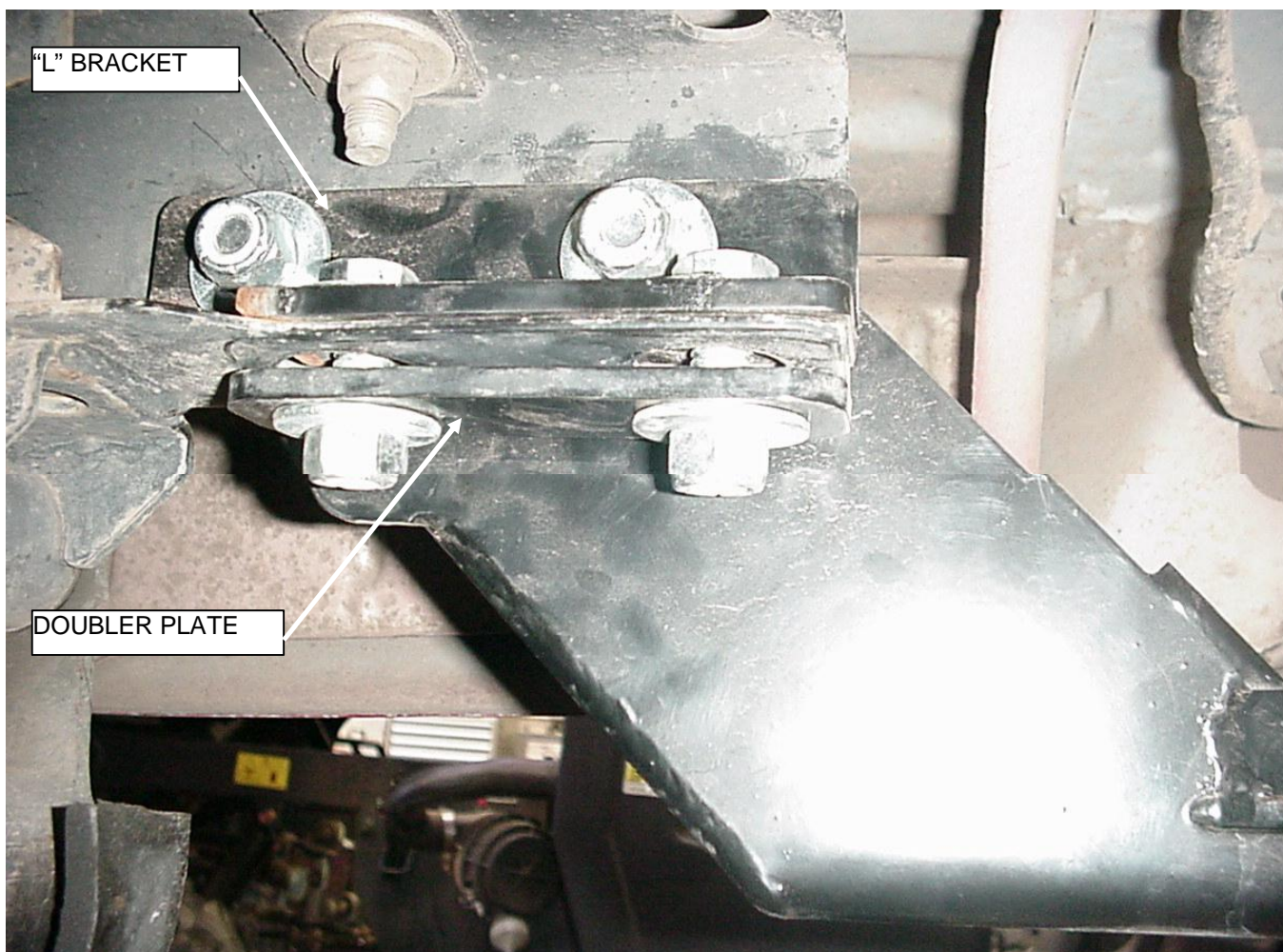




USE SPACERS TO MAKE INSIDE DIMENSION OF FRAME BRACKETS EQUAL TO OUTSIDE DIMENSION OF VEHICLE FRAME OR TRAILER HITCH.

**Figure 3, Align frame brackets. Use provided spacers to allow for frame mounted trailers hitches bolted to the outside of the frame rails.**

4. Carefully install the rear bumper and frame bracket to the vehicle frame using the existing mounting holes in the frame. **See figure 4.** The supplied “L” brackets are left and right specific. Insert the “L” brackets inside the frame rails and insert the supplied ½” bolts with flat washers through the bumper bracket, hitch side plate (if applicable), vehicle frame and “L” bracket. Install a flat washer and ½” lock nut onto each bolt. Insert a ½” bolt and flat washer through the “L” bracket, bottom of the frame and doubler plate. Install a flat washer and ½” lock nut onto each bolt.



**Figure 4, Installation of frame bracket, “L” bracket, and doubler plate to frame.**



5. Once all of the bumper bolts are installed, carefully adjust the bumper in relation to the body and torque all of the  $\frac{1}{2}$ " bolts. **See Figure 5** for finished appearance.



**Figure 5, Bumper aligned and mounting hardware torqued.**

6. Double-check all of the mounting hardware for the proper torque.