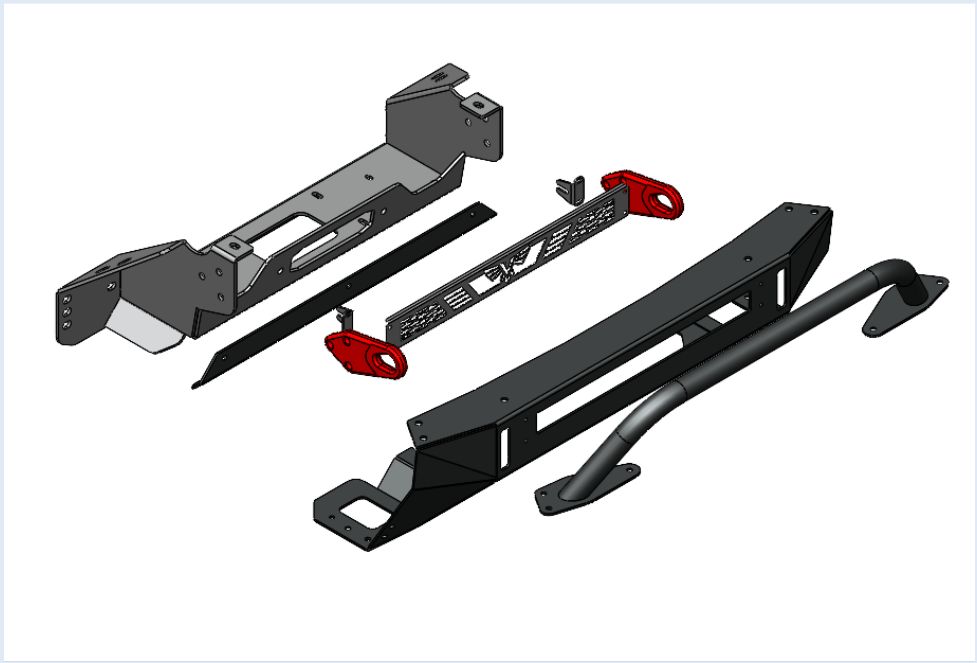
# INST: V4R5FB-T-PC

## Step 1




Step by step on how to install the EVO Front Bumper on the 5th Gen 4Runner! Questions or Support: Phone: 269-353-1184 Email: info@victory4x4.com

## Step 2



Included Parts:

## Step 3

### 046-0218 BOLT PACK

V4R5FB-EVO-BP • Bill of materials (per 1 bag)

PIECES / BAG 61

| BIN | QTY | PART # | DESCRIPTION |
|---|---|---|---|
| 1 | 4 | 040-0005 | 5/16-18 x 3/4 BUTTON HD SOC CAP 18-8 SS |
| 2 | 4 | 040-0012 | 1/4 USS FLAT WASHER ZNC |
| 3 | 2 | 040-0019 | 1/2-13 SERR FLANGE NUT |
| 4 | 4 | 040-0020 | 5/16-18 SERR FLANGE NUT HARD ZNC |
| 5 | 7 | 040-0025 | 1/4-20 SERR FLANGE LOCKNUT GR5 ZNC |
| 6 | 6 | 040-0026 | 3/8-16 SERR FLANGE NUT HARD ZNC |
| 7 | 2 | 040-0127 | 1/2-13 x 1 BUTTON HD SOC CAP ZNC |
| 8 | 7 | 040-0147 | 1/4 MIL-SPEC FLAT WASHER 18-8 SS BLK |
| 9 | 7 | 040-0148 | 1/4-20 x 3/4 BUTTON HD SOC CAP 18-8 SS BLK |
| 10 | 4 | 040-0178 | 3/8-16 x 3/4 BUTTON HD SOC CAP 18-8 SS BLK |
| 11 | 6 | 040-0275 | 3/8 MIL-SPEC FLAT WASHER 18-8 SS BLK |
| 12 | 2 | 040-0277 | 3/8-16 x 1-1/4 BUTTON HD SOC CAP 18-8 SS BLK |
| 13 | 4 | 040-0138 | 5/16 (M8) MIL-SPEC FLAT WASHER 316 SS |
| 14 | 2 | 040-0292 | 1/2 MIL-SPEC FLAT WASHER 18-8 SS |

Set bins out in this order • One bag at a time • Gold = zinc • Black = black finish

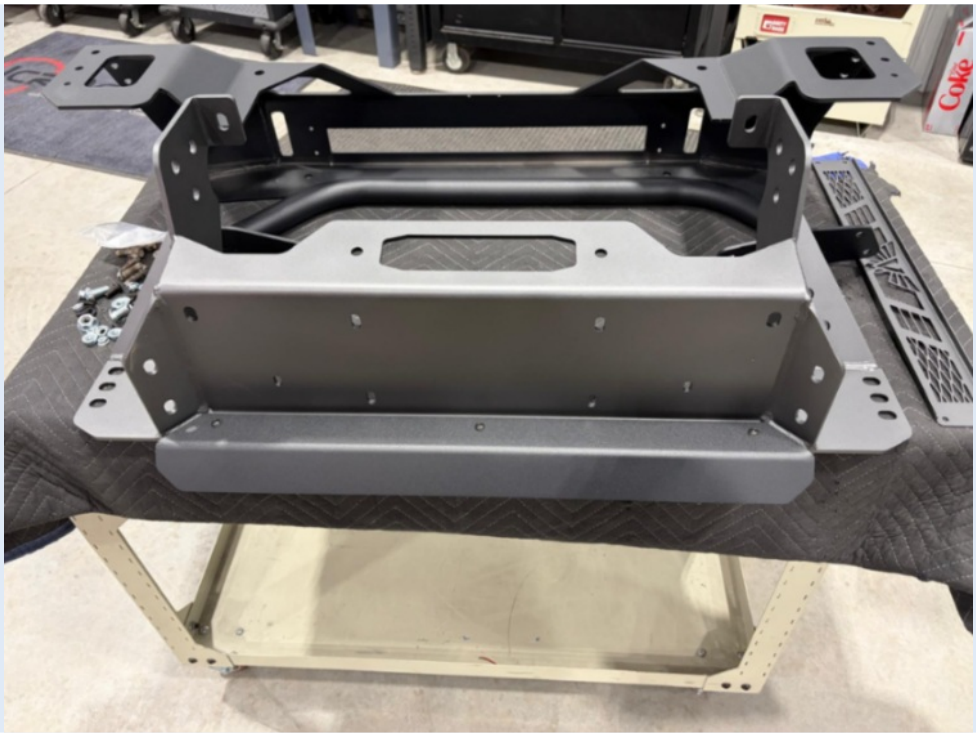
Odoo BOM link in description

Included Hardware:

## Step 4

Prior to install, check the product page for the disassembly and cut video.

## Step 5



Loosely install the lower cover plate to the to the bottom of the cradle using the provided 1/4" bolts, washers and flange nuts.

## Step 6



Trim the plastic behind the fascia along the red line shown in the image. More or less can be cut depending on how much clearance you want to the bumper.

## Step 7



Loosely install the light bezel and light bar mounts to the inside of the bumper using 1/4" bolts, washers and nuts as shown.

## Step 8



If installing a light bar, do so now, prior to tightening up the hardware securing the bezel to the bumper.

## Step 9




Loosely install the cradle to the vehicle using the factory hardware. If installing a winch, place it in the cradle prior to lifting the assembly up into place.

## Step 10



If installing the tube, loosely bolt it to the top of the bumper using the provided 3/8"-16 x 3/4" bolt, washers and flange nuts. Leave the inner most bolts out for now as they will be used to mount the shell to the cradle.

## Step 11




Loosely install the D-Rings onto the cradle as shownn using the 1/2" hex heads, washers and locking nuts. Use a washer on both the nut side and the bolt head side. Snug up the bolts but leave them just loose enough that adjustments to the D-Rings can be made.

## Step 12




Place the shell onto the cradle and loosely secure it using the longer 3/8"-16 x 1-1/4" bolts, washer and flange nuts.

## Step 13



Use the 1/2" button heads and flange nuts to bolt the bottom of the shell to the tray of the cradle.

### Step 14



If installing without viper wings, tie the fascia in to the bumper using the small, flat bracket and 5/16" hardware as show.

### Step 15

Adjust the position of the cradle and shell as needed. Once it is sitting as desired, tighten all hardware fully into place. Start with the cradle to frame, then the shell to the cradle and finish up with the cover plate and tube. With that the install is complete

### Step 16




Confirm all hardware is tightened. **Congrats! Your installation, is now complete. Enjoy!**