

HEFTY FABWORKS....2005-2012 Xterra and Frontier bumper installation instructions:

Hardware included:

- (6) 1 ½" x ½" Grade 8 bolts
- (4) 12mm 125x45 bolts
- (4) 12mm 125x30 bolts
- (14) ½" Lock washers
- (14) 1/2" flat washers
- (2) Frame mount brackets
- (2) 8mm bolts and washers for lower part of radiator skid
- (1) Radiator Skid
- (1) Bumper

Step 1: Remove factory bumper fascia

Start by removing the Grill assembly (xterra only) by pulling the factory clips, the grill is held in on top by 6 grill clips and inside the grill by additional clips.

Remove the lower bolts/screws in the bumper and remove the factory radiator skid plate.

Once all lower attachments are removed pull back the inner fender skirts. There is a screw that goes up into the fender that must be removed. The bumper is held in with clips. Pull the bumper from the clips to remove the plastic bumper making sure to disconnect the fog lights.

Step 2: Remove inner support

Remove the lower frame crash bar. It is held on with 4 bolts. Use a 17mm socket to remove this piece.

Remove the upper grill support. There will be a wire attached to it that will need to be removed. It is held on using (6) 10mm nuts.

Step 3: Remove clips (Xterra)

Remove any additional bumper clips attached to the body (xterra only)

Step 3: Trim bumper (Frontier Only)

In order to mount the bumper, the factory bumper fascia must be trimmed. On most models only minor trimming to the upper (plastic) bumper may be required. On Off Road and Pro 4x models with one piece plastic bumpers, the bumper must be cut along the horizontal seam line dividing the bumper into an upper and lower section. Once the upper portion has been separated reattach this portion to the truck the same way it was removed.

Step 4: Fog Lights

Remove the fog lights from the factory bumper by removing the 10mm screw in the plastic housing and pulling it off the clip. Reinstall this entire assembly in the new bumper using the

supplied hardware. There are 2 square holes in the factory housing that will slide over the 2 bolts on the new fog light housings. Using a washer and nut, Tighten down the fog lights.

Step 5: Winch installation

If you are planning on running a winch, now is the time to install it into the new bumper. Only non-integrated solenoid winches (separate control box) will fit in this bumper. Install the winch with the hardware supplied by the winch manufacturer. The gear box side of the winch must be clocked in order to turn the engagement lever towards the bottom of the bumper.

Step 6: Frame brackets

Install the new bumper frame brackets to the front of the frame horns using the supplied (4) 12mm 125x30 bolts with a flat washer and lock washer. Do not tighten the bolts at this point to allow for adjustment. Do not install the lower bolts at this time.

Step 7: Bumper installation (do not attempt alone)

Now we are ready to install the bumper. There are various holes in the frame mounts that will allow adjustment up or down for use with either a stock truck or one equipped with a 2" body lift.

Using the (6) 1 ½" x ½" bolts and supplied flat washers, lock washers and nuts, lift the bumper into place and install the (6) bolts loosely through the bumper into the frame mounts.

With the bumper supported, adjust the frame mounts side to side to fit the bumper and tighten the front bolts.

Align the bumper and tighten down the (6) ½" bolts working from side to side. When adjusting the bumper make sure there is adequate space between the bumper sides and the fenders to allow for body flex. We recommend between 1/2" to 1" of gap. (some frontier models may require additional upper plastic bumper trimming)

Step 7: Install the radiator skid

Recheck the alignment and make adjustments to the bumper if needed

Install the radiator skid using the (4) 12mm x 125 x 45 bolts and the (2) 8mm bolts supplied.

Tighten to approximately 80-100 ftlbs of torque

Step 9: Final

Recheck all of the bolt for tightness and the installation of the bumper is complete.

Step 10: Follow up

After a few weeks please recheck and retighten all bolt as they have a tendency to loosen a little as things settle into place.

If you have any issues or questions with the installation call (719) 600-1242 for assistance.