



TOMS OFFROAD

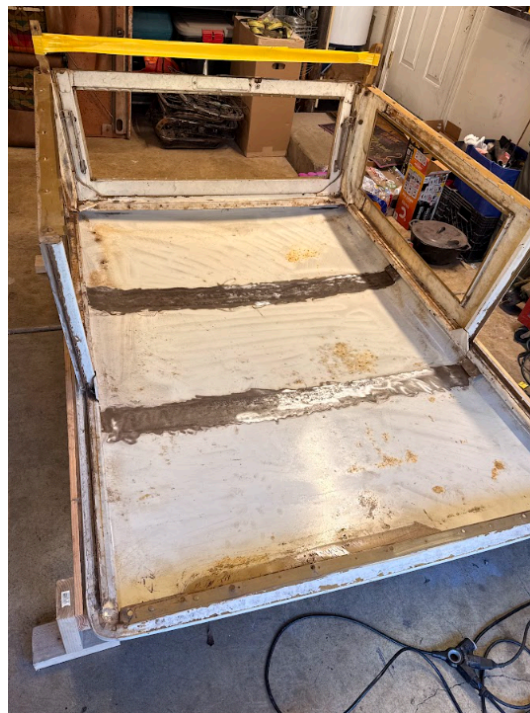
Tools & Materials Recommended

- Wire wheel
- Drill with 5/16" bit or spot weld cutter
- Clamps
- Self-tapping sheet metal screws
- Welder (if welding)
- Panel bonding adhesive (optional alternative)
- Grinder
- Anti-flutter foam (recommended: Lord Fusor 121)

Installing hard top support bows

Step 1: Build a Work Stand

To simplify installation, build a basic stand to support the hard top upside down. This provides easier access to mounting areas and improves overall working comfort.



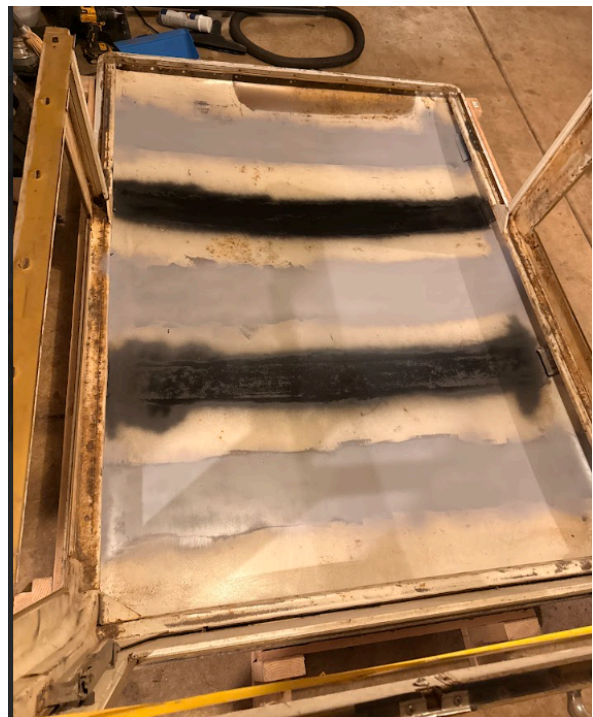
Step 2: (Optional) Remove Existing Support Bows

1. Use a wire wheel to expose factory spot welds on the brackets.
2. Drill out spot welds using a **5/16" drill bit** or spot weld cutter.
3. Remove the existing support bows.
4. Take this opportunity to:
 - Recondition the underside of the bows
 - Remove rust and debris from mounting surfaces



Step 3: Prepare Mounting Surface

1. Use original mounting locations to determine spacing for new support bows.
2. Remove all paint, primer, and rust from mounting surfaces.
3. Clean to bare metal to ensure proper welding or bonding.
4. Mock up new brackets in the same orientation as factory brackets.



Step 4: Position & Install Support Bow Brackets

1. Determine final placement of brackets.
2. Brackets are designed to be **rosette welded to the inner flange**.

If welding:

- Drill **5–6 holes per side (5/16")** for rosette welds.

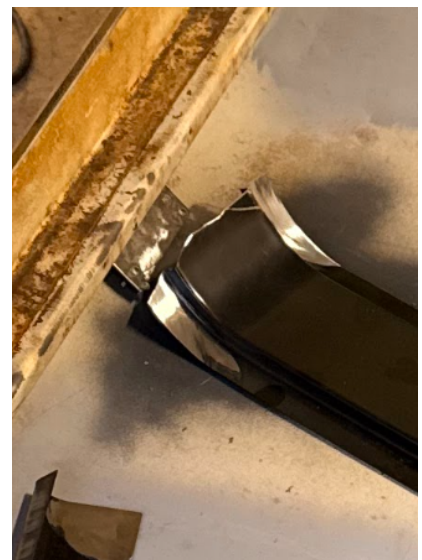
If not welding (alternative):

- Use panel bonding adhesive
 - Clamp brackets in place (no drilling required)
3. Temporarily secure brackets using **self-tapping sheet metal screws** before final installation.



Step 5: Fit Support Bows

1. Seat one end of the bow into the bracket.
2. Trim the opposite end to length (typically several inches).
3. Slightly bevel the trimmed end to ease installation.
4. Ensure each bow fits snugly between brackets and against the roof panel.
5. Once all bows are fitted, proceed to final installation.



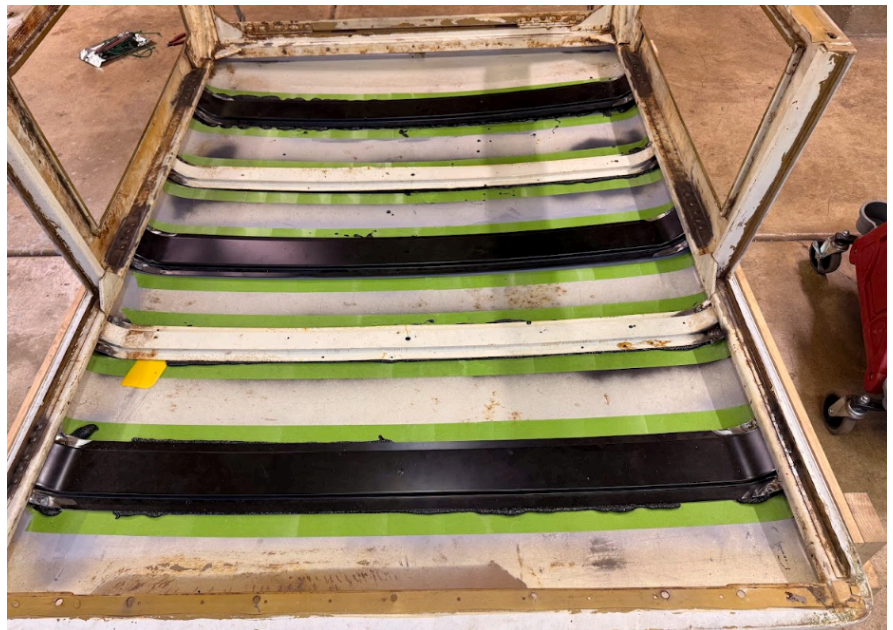
Step 6: Install & Weld Support Bows

1. Drill two 5/16" rosette weld holes in each bow flange.
2. Remove factory primer and prepare metal surfaces.
3. Clamp each bow securely in place, ensuring:
 - Proper alignment
 - Tight contact with the roof panel
4. Weld bows to the mounting brackets.



Step 7: Finish & Seal

1. Grind all welds smooth after cooling.
2. Apply painter's tape along edges of each bow.
3. Install **anti-flutter foam** between bows and roof panel to prevent vibration and noise
 - Recommended: *Lord Fusor 121*
4. Trim foam as needed and remove tape for a clean finish.



Notes & Tips

- Test-fit everything before final welding or bonding
- Proper surface prep is critical for strength and longevity
- Adhesive bonding is a viable alternative if welding is not available