Frame brackets:

4" tall x 3-1/2" wide x 1/4" flat plate - 4 or 6 pcs. depending on how many mounts you want. You can cut a 45* bevel off one corner, approx 1.5" - 2" on a side if you want to use as a gusset between the bracket and support leg.

For bolt on, drill 2 ~1/2" dia. holes vertically one side to match the bolt hole spacing in the frame, approx. 15/16" up from the bottom of the plate for the bottom hole, upper hole 2-3/8" up from the lower hole

Holes centered ~3/4" from the edge.

Support legs:

Front: 2"x2"x0.120" wall sq. tubing, 5.5" long - 2 pcs. 90* cuts both ends

Middle: (if desired) 2"x2"x0.120" wall sq. tubing, 5.25" long - 2 pcs. 90* cuts both ends

Rear: 2"x2"x0.120" wall sq. tubing, 5.25" long - 2 pcs. 90* cuts both ends

Note, on above lengths, different year XTerras may have slightly bent frame rails resulting in minor frame-pinch weld distances, so double check those measurements at the 2 or 3 mounting bolt locations and measure the distance from the outer frame rail to the body pinch weld. Then subtract 1.25" from that length to get the above lengths. E.g. if you measure 6.5", 6.5 - 1.25 = 5.25", etc. Adjust your lengths above to match your vehicle. This will ensure the outer bars of the sliders line up parallel to the body.

Gussets can be added between bracket and leg is desired. 3/16" or 1/4" scraps, cut at 45* (see above) - 1 pr leg.

Body Lift considerations:

For no body lift, weld support leg flush to bottom of frame bracket

For 1" lift, weld leg up 1" from bottom of frame bracket

For 2" lift, weld support leg flush to the top of the frame bracket

Outrigger legs:

1.5"x1.5"x0.0120" sq. tubing - 8 pcs. typical, 4 per side

28.5* parallel bevel cuts each end, 4.25" long for standard width outer bar location

23* parallel bevel cuts each end, 5.125" long for extra wide width outer bar location

Inner tube:

2"x2"x0.120" wall sq. tube, 64" long - 2 pcs. 45* bevel cut on each end

Outer tube:

2"x2" sq. tube, 62" long - 2 pcs. 0.180" wall for ultimate sliders, 0.120" wall for standard sliders, 45* bevel cut on each end

For 1" kick out, cut 12" off each end @ 2.5* vertical angle and swap ends and re-weld or notch out a 5* (included angle) wedge and bend/weld

End caps:

2"x2.75"x0.120" flat - 8 pcs., weld onto 45* bevel cut ends of inner/outer tubes to cap them off.

Vehicle frame can be used as the assembly jig. Frame brackets bolt to the existing frame mounting boles for the factory step bars. You can add the middle frame bracket and support leg for the unused middle set of bolt holes for added strength. The front bracket typically will have the support leg in front, holes to the rear, the middle and rear brackets have the bolt holes in front and the support legs towards the rear.

As noted in the above assembly instructions page, you'll tack the support legs to the frame brackets, then bolt the frame bracket to the frame using the M10x1.25 factory bolts, or 4Crawler Offroad can supply new mounting bolts. Then tack the inner tube to the support legs, keeping the inner bar approx. centered between the front and rear wheel wells. This will ensure all the frame bracket bolt holes line up when you are finish the welding. When tack welding, try to get 1 or 2 tack welds on each side of the square tube sections. Then you can then remove the bars from the truck, add the outrigger legs, spaced evenly, to the outside face of the inner tube, angled upward, then lay the outer tube on the ends of the outriggers and finish welding all the joints.

And you can make the bars longer or shorter (than the 64"/62" lengths) if desired. For example, to save some money, you could cut all 4 bars at 60" long from one 20' stick of 2"x2" square tube. Likewise, you can use thicker or thinner wall tubing in any of the locations. And you can add more of less outrigger legs as you see fit.

It is your truck, your sliders, you can make them whatever length you want.

Here are some example photos showing the finished sliders:
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https://4crawler.com/4x4/ForSale/Images/Xterra01.jpg
https://4crawler.com/4x4/ForSale/Images/Xterra02.jpg
https://4crawler.com/4x4/ForSale/Images/Xterra03.jpg
https://4crawler.com/4x4/ForSale/Images/Xterra04.jpg
https://4crawler.com/4x4/ForSale/Images/Xterra05.jpg

Assembly instructions:
https://www.4crawler.com/4x4/ForSale/Docs/NerfBarKit_HowTo.shtml

Installation instructions:
https://www.4crawler.com/4x4/ForSale/Docs/NerfBar_HowTo.shtml