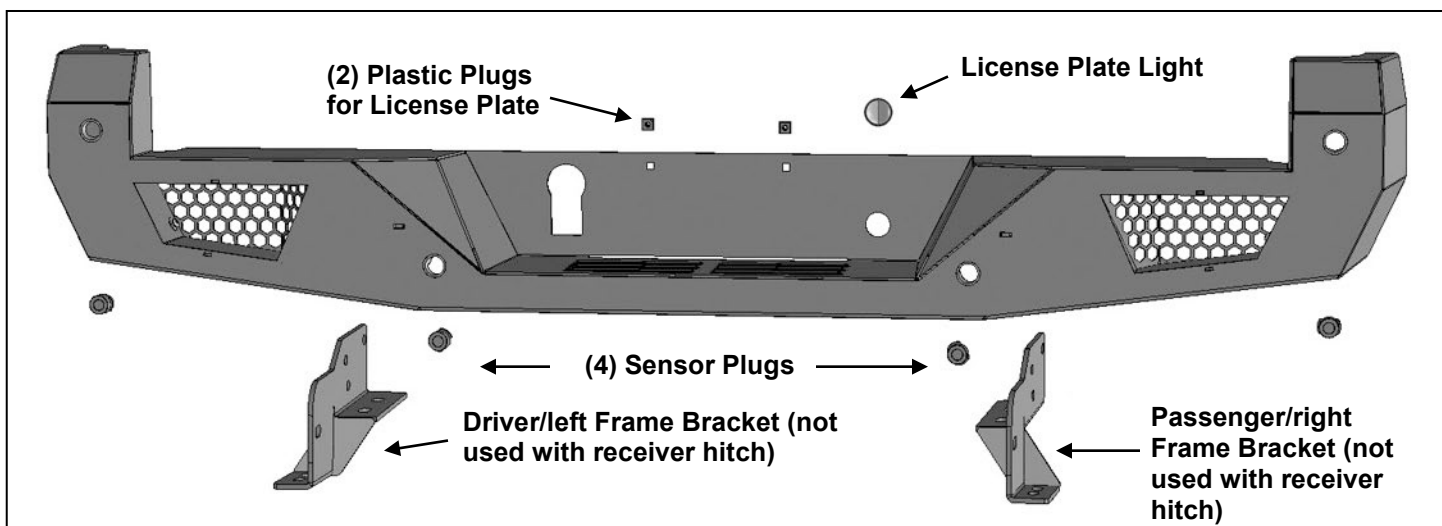




HD REAR BUMPER 2016-2023 TACOMA

PARTS LIST:

1	Rear Bumper Assembly	8	12mm x 32mm x 3mm STD Flat Washers
1	Driver/left Mounting Bracket	4	12mm x 24mm x 2.5mm SMALL Flat Washers
1	Passenger/right Mounting Bracket	6	12mm Nylon Lock Nuts
2	Plastic Plugs for license plate mount	8	4mm x 10mm Button Head Bolts
4	Sensor Hole Plugs	1	2.5mm Wrench
1	License Plate Light	1	4mm Wrench
6	12-1.75mm x 40mm Hex Bolts	10	Nylon Wire Ties



PROCEDURE:

REMOVE CONTENTS FROM BOX. VERIFY ALL PARTS ARE PRESENT. READ INSTRUCTIONS CAREFULLY BEFORE STARTING INSTALLATION. BUMPER IS DESIGNED TO INSTALL WITH FACTORY RECEIVER HITCH, AFTERMARKET RECEIVER HITCH MAY INTERFERE WITH INSTALLATION. BUMPER IS HEAVY, ASSISTANCE IS RECOMMENDED TO AVOID POSSIBLE INJURY OR DAMAGE TO THE VEHICLE.

1. Locate BSM button underneath the radio display to turn off the Blind-Spot Monitor (BSM) and Rear Cross Traffic Alert (RCTA) Systems, (if equipped). Next, unplug the wire harnesses from the (2) monitor sensors located on the rear ends of the Rear Bumper. **NOTE:** The BSM and RCTA systems will not work with Bumper installation, monitor sensors cannot be reinstalled.
2. Remove the license plate from the bumper. Next, unplug the license plate lights, trailer plug and (4) back up sensors, (if equipped). Release the wiring harness from the clips attached to the back of the bumper, (**Figure 1**). Move all wiring harnesses away from bumper.

3. Determine if vehicle is equipped with factory receiver hitch

Models without receiver hitch:

- a. Place blocks or jack stands under the bumper to support it during mounting bolt removal. Once the bumper has been safely supported, remove the factory hex bolts, (5 per side), attaching the bumper brackets to the sides and bottom of the frame and slide the bumper assembly off of the vehicle.

Models with factory receiver hitch:

- a. Remove the plastic cover from the top of the bumper, **(Figure 2)**. **NOTE:** Cover is attached at top, back and bottom by several plastic clips. Use a small flat blade screwdriver to carefully pry up the center pin to release each clip.
 - b. Place blocks or jack stands under the bumper to support it during mounting bolt removal. Once the bumper has been safely supported, remove the factory hardware attaching the bumper to the top and bottom of the receiver hitch and remove the bumper, **(Figures 3 & 4)**. **NOTE:** Leave hitch attached to vehicle.
4. Remove the sensors, (if equipped), from bumper. Release the clips securing the trailer plug and remove the plug.
5. **Optional LED light installation at ends of bumper** (sold separately).
 - a. Insert light into opening and up to mounting slot. Check for clearance between front and back of light. If necessary, remove the screens from the back of the openings, **(Figure 5)**. **IMPORTANT:** Screens may be easier to remove before Bumper is installed.
 - b. Follow the light manufacturer's instructions to attach each light to slot in the opening.
 - c. Repeat the above steps for remaining light installation.
 - d. Follow light manufacturer's instructions for adjustment and to properly wire the light to the vehicle electrical system after Bumper installation.
6. Depending on tow package, it may be necessary or easier to install sensors at this time, (if equipped), before installing the Bumper.

Models without bumper sensors:

- a. Select the included (4) Rubber Plugs.
- b. From behind bumper, push plugs into sensor mounting holes, **(Figure 6)**.

Models with bumper mounted back up sensors:

- a. Push the sensor into the mounting socket in the back of the bumper.
- b. Secure each sensor to the socket with (2) 4mm x 10mm Button Head Screws, **(Figure 6)**. **IMPORTANT:** Sensors fit snug in sockets. The 4mm Screws are used to apply slight pressure to lock the sensors in place. Tighten both screws evenly until they touch the sensor body only. Do not overtighten screws or damage to sensors will result.

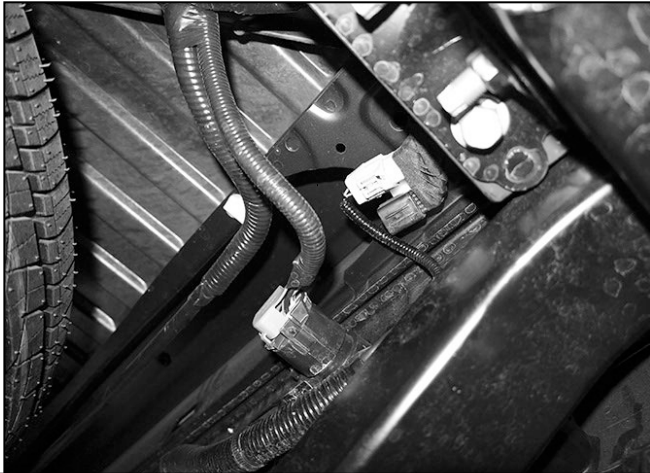
7. Models without factory receiver hitch only, (models with hitch, skip to Step 7):

- a. Select the driver/left Frame Mounting Bracket. Reuse the factory bumper bracket hex bolts to attach the driver/left Mounting Bracket to the sides and bottom of the frame, **(Figures 7 & 8)**. Snug but do not fully tighten hardware at this time.
 - b. Repeat the previous Step to install the passenger/right Frame Mounting Bracket.
8. With assistance, hold the Bumper assembly up to the Brackets or receiver hitch. Temporarily support the weight of the Bumper. **WARNING:** To avoid possible injury or damage to the vehicle, do not proceed until the bumper is fully and safely supported.
9. Attach the Bumper to the bottom of the driver/left Bracket or to the hitch with the included (2) 12mm x 40mm Hex bolts, (2) 12mm x 32mm Large Flat Washers, (bottom), (2) 12mm x 24mm Small Flat Washers, (top), and (2) 12mm Nylon Lock Nuts, **(Figures 9—13)**. Snug but do not fully tighten hardware at this time.
10. Next, attach the bumper to the side of the Bracket or hitch with the included (2) 12mm x 40mm Hex bolts, (4) 12mm x 32mm Large Flat Washers and (2) 12mm Nylon Lock Nuts, **(Figures 9—13)**.
11. Slowly open tailgate and check for clearance. Level and adjust the bumper and fully tighten all hardware including the Mounting Bracket to Bumper hardware.
12. Attach the wiring harness to the sensors and trailer plug. Use the included Wire Ties to secure the wiring harness to the bumper and frame as necessary.

13. Use the included (2) push-in plugs to attach the license plate to the Bumper, **(Figure 14)**.
Insert the License Plate Light into the hole in the Bumper. Connect the harness to the License Plate Light.
14. Do periodic inspections to the installation to make sure that all hardware is secure and tight.

To protect your investment, wax this product after installing. Regular waxing is recommended to add a protective layer over the finish. Do not use any type of polish or wax that may contain abrasives that could damage the finish. Mild soap may be used to clean the Bumper assembly.

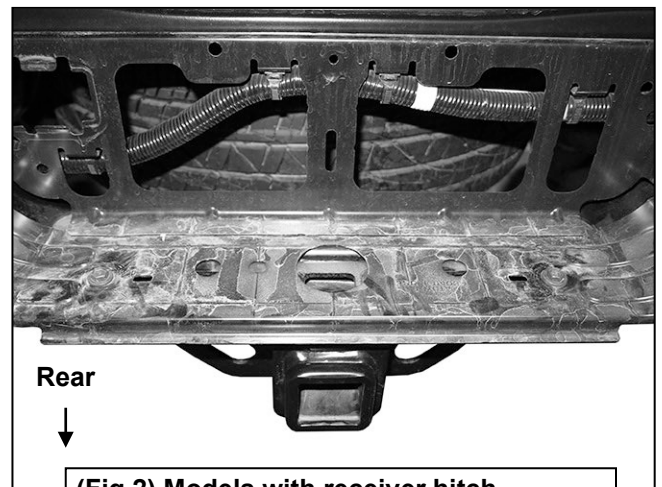
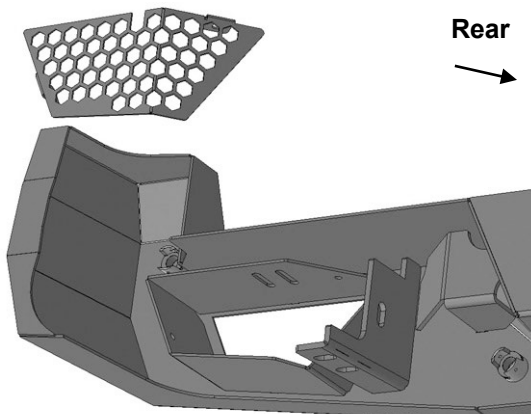
Driver/left Side Installation Pictured



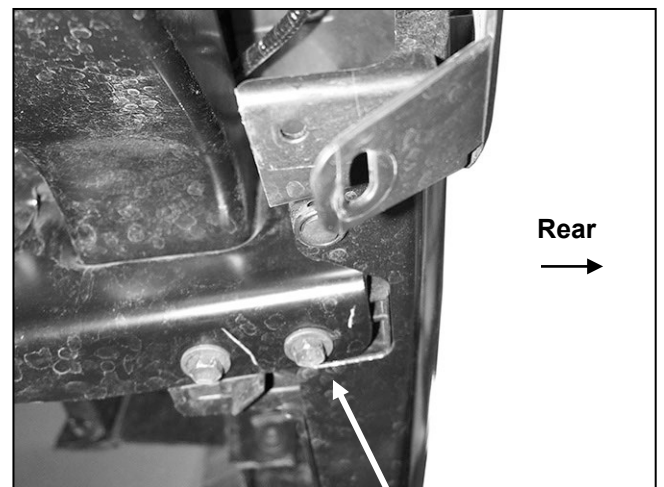
(Fig 1) Unplug and remove 7-wire trailer plug, unplug license plate lights and sensors if equipped



(Fig 3) Models with receiver hitch, remove the hex bolts attaching bumper to top of hitch



(Fig 2) Models with receiver hitch, remove plastic cover from top of bumper

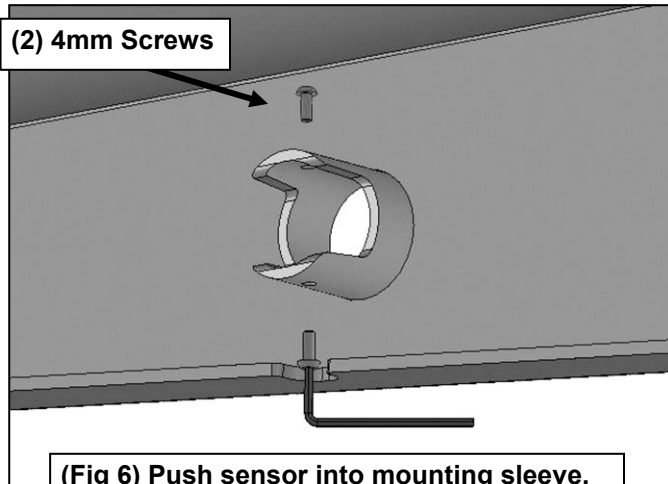


(Fig 4) Models with receiver hitch, remove the hex bolts attaching bumper to bottom of hitch

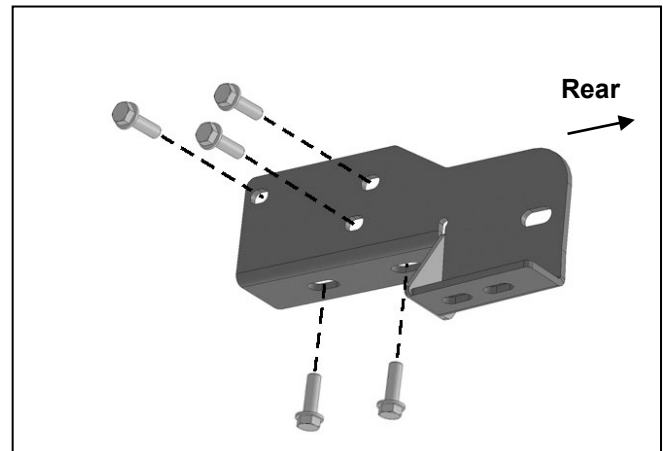
WARNING! Do not remove bumper bolts unless the bumper is properly supported on blocks or stands or the bumper may fall.

(Fig 5) Remove screens if necessary for additional clearance around or access to lights

Driver/left Side Installation Pictured



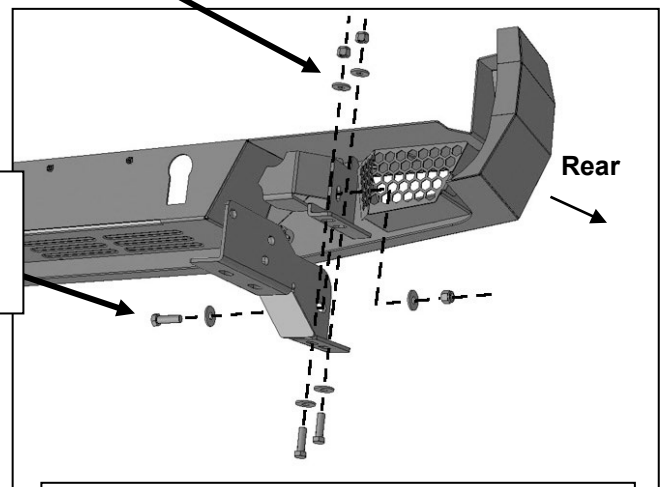
IMPORTANT: Sensors fit snug in sockets. The 4mm Screws are only used to apply slight pressure to lock the sensors in place. Tighten both screws evenly until they touch the sensor body only. Do not overtighten screws or damage to sensors will result.



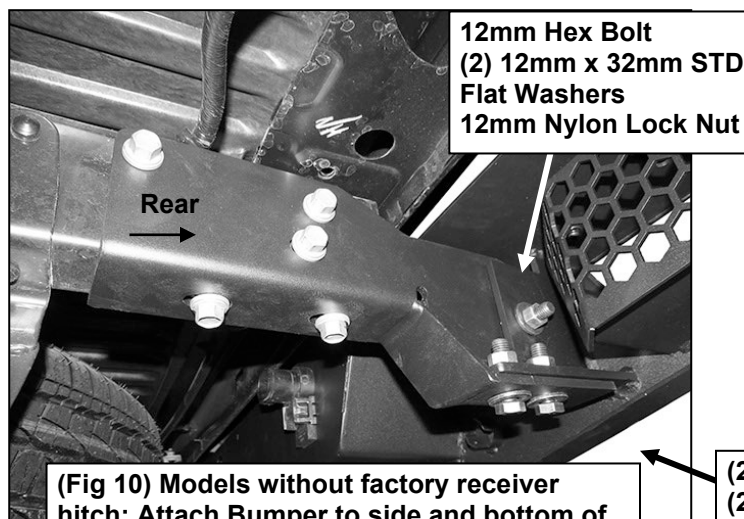
(Fig 7) Models without factory receiver hitch: Reuse factory hex bolts to attach Bumper Bracket to side and bottom of frame (driver/left illustrated)



- (2) 12mm Hex Bolts**
- (2) 12mm x 24mm Small Flat Washers (top)**
- (2) 12mm x 32mm STD Flat Washers (bottom)**
- (2) 12mm Nylon Lock Nuts**

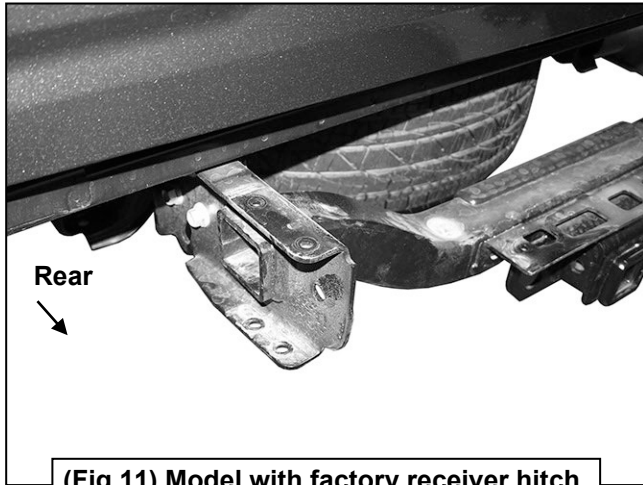


(Fig 9) Models without factory receiver hitch: Attach Bumper to side and bottom of Frame Bracket (driver/left illustrated)



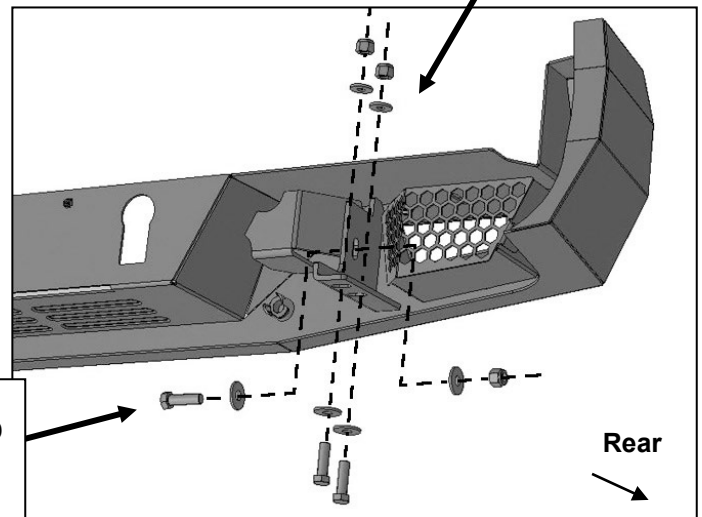
- (2) 12mm Hex Bolts**
- (2) 12mm x 24mm Small Flat Washers (top)**
- (2) 12mm x 32mm STD Flat Washers (bottom)**
- (2) 12mm Nylon Lock Nuts**

Driver/left Side Installation Pictured

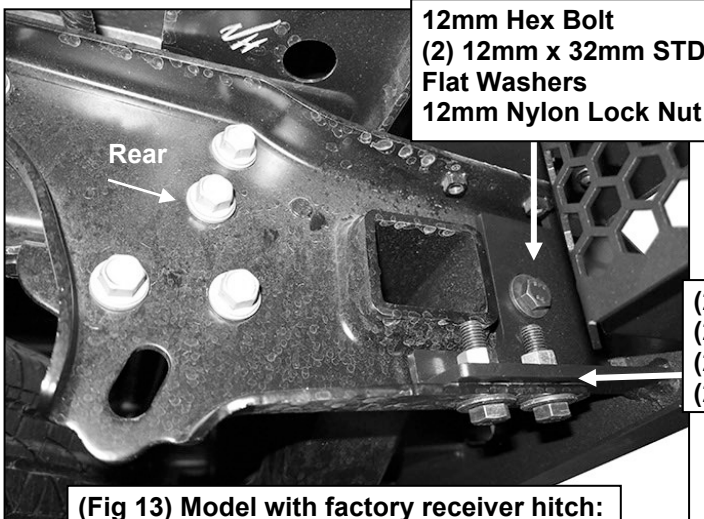


(Fig 11) Model with factory receiver hitch

- (2) 12mm Hex Bolts
- (2) 12mm x 24mm Small Flat Washers (top)
- (2) 12mm x 32mm STD Flat Washers (bottom)
- (2) 12mm Nylon Lock Nuts

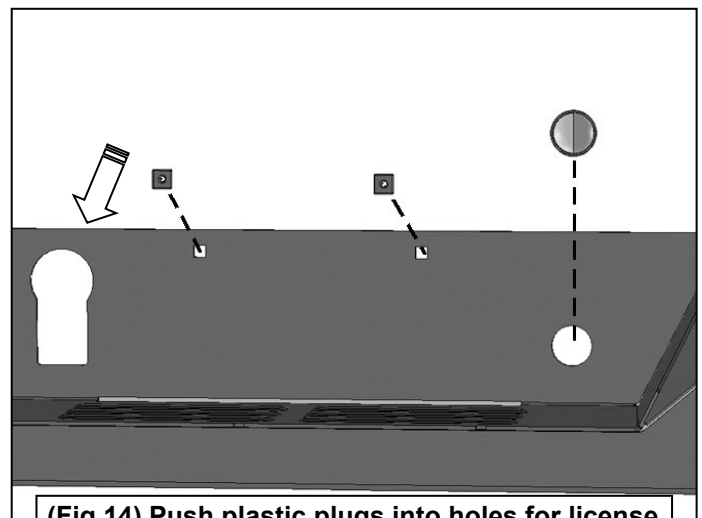


(Fig 12) Model with factory receiver hitch:
Attach Bumper to side and bottom of
hitch (driver/left illustrated)



(Fig 13) Model with factory receiver hitch:
Attach Bumper to side and bottom of
hitch (driver/left installation pictured)

- (2) 12mm Hex Bolts
- (2) 12mm x 24mm Small Flat Washers (top)
- (2) 12mm x 32mm STD Flat Washers (bottom)
- (2) 12mm Nylon Lock Nuts



(Fig 14) Push plastic plugs into holes for license
plate. Install trailer plug and License Plate Light

Complete Installation



