



REAPER HD FRONT BUMPER WITH LED FOG LIGHTS

(2016-2023 TACOMA)

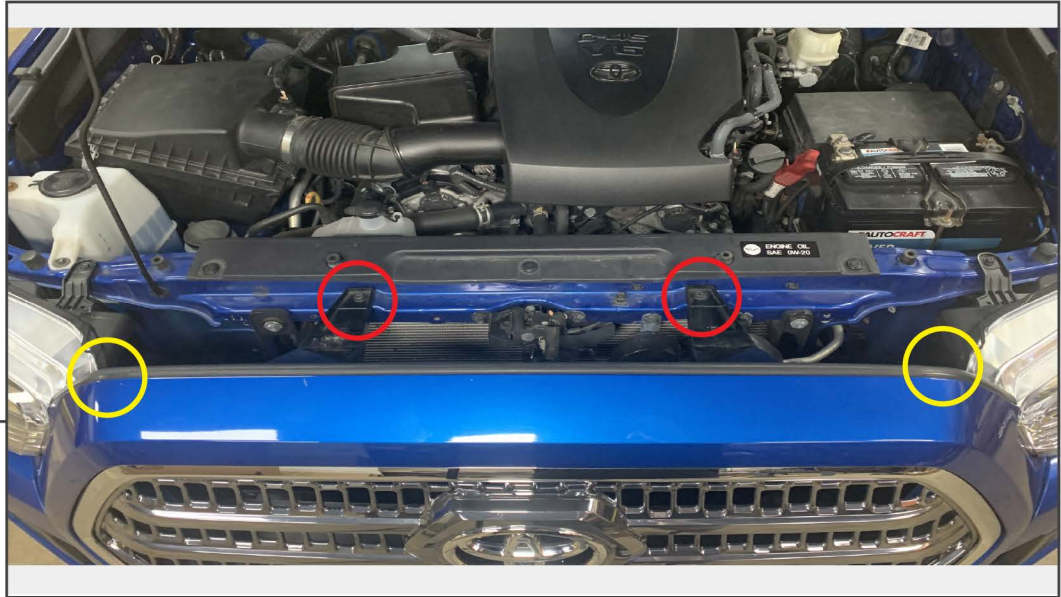
INSTALLATION INSTRUCTIONS

CONTENTS

(1) Bumper	(10) M10 Lock Washers	<u>LED Lighting Kit:</u>
(1) LH Modular Side Wing	(12) M10 Flat Washers [24mm OD]	(2) LED Lights
(1) RH Modular Side Wing	(4) M10 Flat Washers [20mm OD]	(1) Wiring Harness
(1) Skid Plate	(6) M10 Hex Nuts	(2) Mounting Brackets
(1) LH Inner Bracket	(2) M8x1.25 x 16mm Hex Bolts	(4) M6 x 12mm Allen Bolts
(1) RH Inner Bracket	(3) M8x1.25 x 25mm Hex Bolts	(4) M6 Lock Washers
(1) Center Inner Bracket	(2) M8 Flat Washers [24mm OD]	(2) M8 x 25mm Hex Bolts
(1) License Plate Bracket	(6) M8 Flat Washers [16mm OD]	(2) M8 Flat Washers
(2) License Plate Screw Inserts	(2) M8 Lock Washers	(2) M8 Lock Washers
(10) Cable Ties	(3) M8 Lock Nuts	(2) M8 Nuts
(2) M12x1.75 x 120mm Hex Bolts	(6) M6x1.00 x 25mm Allen Bolts	
(4) M12 Flat Washers	(6) M6x1.00 x 20mm Combo Allen Bolts	
(2) M12 Lock Nuts	(6) M6 Lock Washers	
(6) M10x1.50 x 40mm Hex Bolts	(2) M6 Flat Washers [18mm OD]	
(4) M10x1.50 x 25mm Hex Bolts	(12) M6 Flat Washers [12mm OD]	
	(8) M6 Lock Nuts	
	(1) 4mm Allen Key	
	(1) Power Steering Relocation Kit	

TOOLS REQUIRED

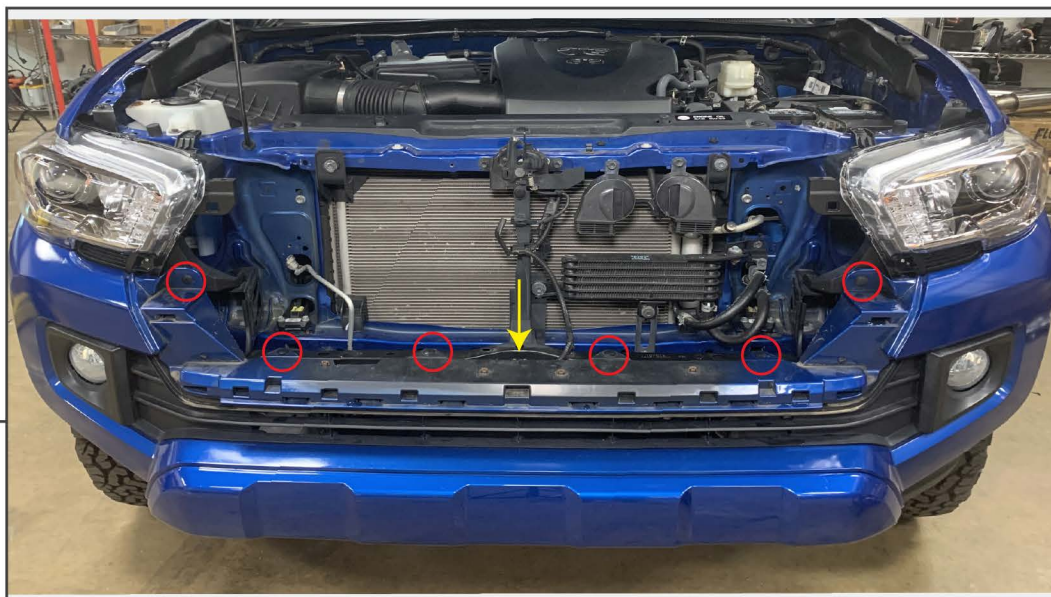
8, 10, 14, 16, 19mm Sockets/Wrenches
Ratchet
4mm Allen Key
Panel Removal Tool
Flathead Screwdriver

**STEP 1**

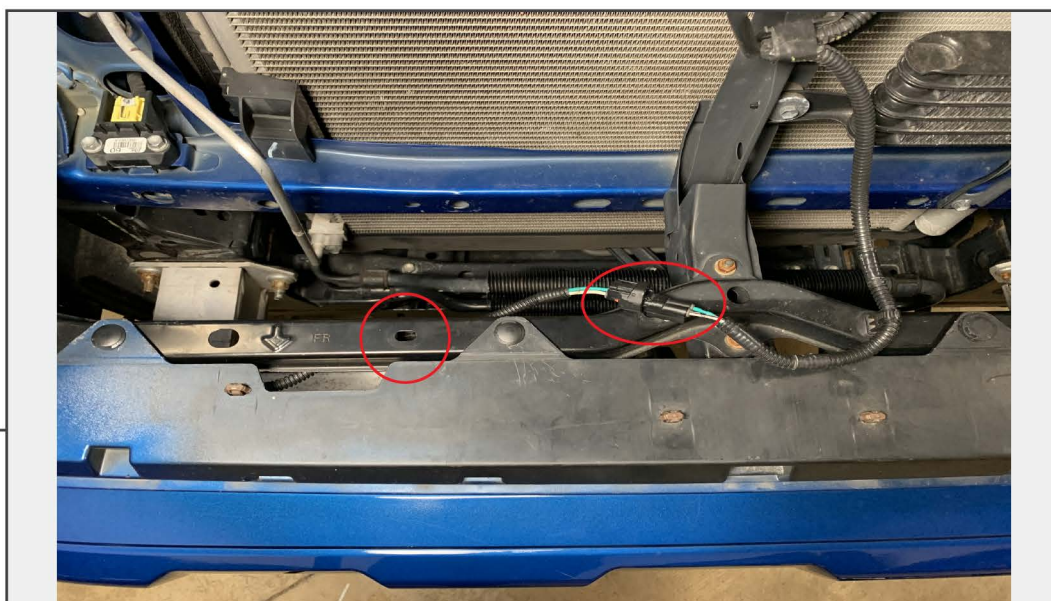
Remove grille from vehicle by removing (2) 10mm bolts, and removing (2) push clips. Lift grille away from vehicle.

**STEP 2**

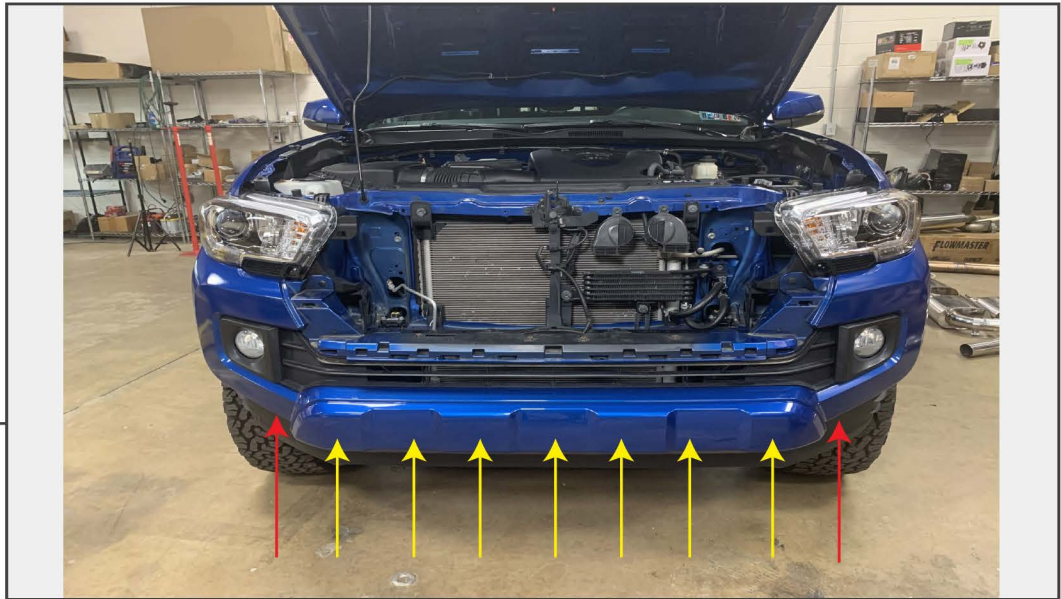
Remove (2) 10mm bolts from the fender liner from each side of the bumper.

**STEP 3**

Remove (6) push clips from the bumper. Unplug the connector in the middle of the bumper.

**STEP 4**

Unclip the fog light harness from the bumper support, then unplug the fog light connector.

STEP 5

Remove (2) 8mm bolts, and (7) 10mm bolts from underneath the bumper.

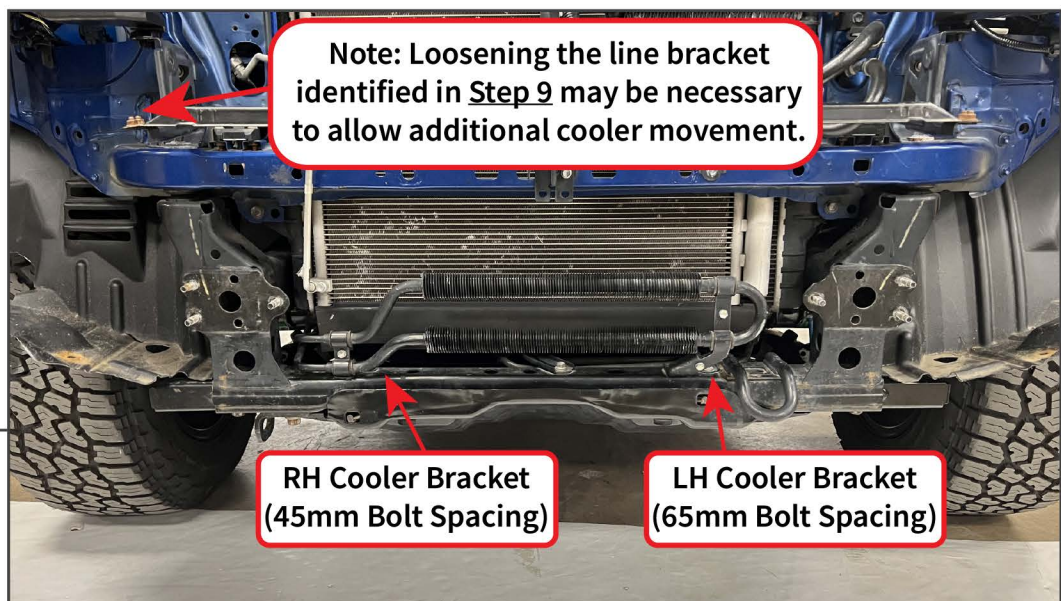
STEP 6

Firmly pull the bumper off the fender clips. Remove the bumper from vehicle and place on a soft workable surface.

Remove the bumper retaining brackets from the fender by removing (2) 10mm bolts per bracket.

**STEP 7**

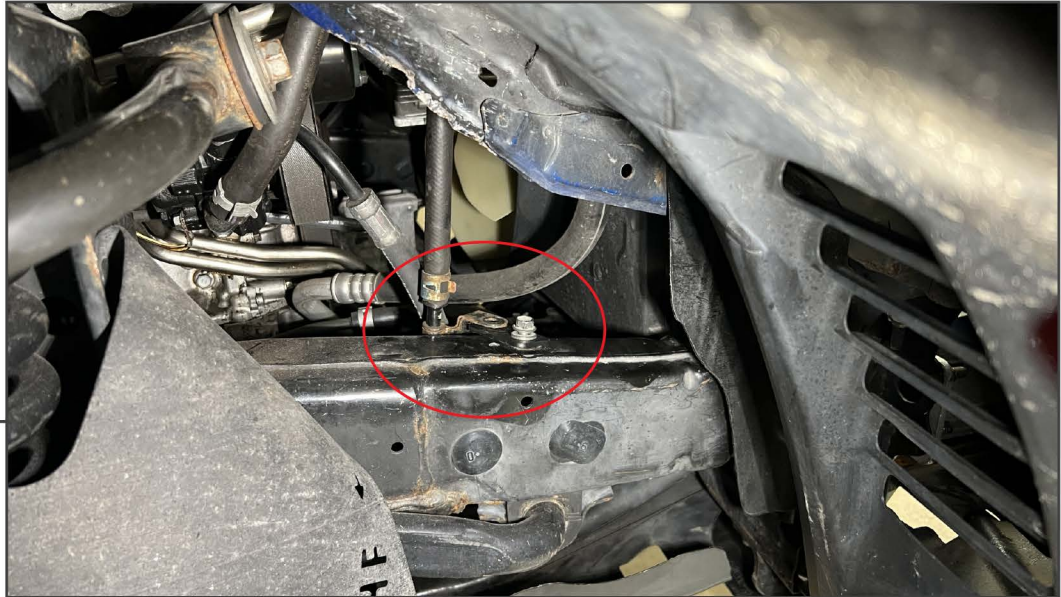
Remove (6) 14mm nuts from the aluminum bumper bar, and remove the bumper bar from the vehicle. The OEM (6) 14mm nuts will be reused.

**STEP 8**

Power Steering Cooler Relocation: Unbolt the power steering cooler from the front frame of the vehicle. Using the cooler relocation brackets, bolt the appropriate bracket to each side of the cooler using the included (1) M8 x 25mm bolt, (2) M8 flat washers [16mm OD], and (1) M8 lock nut per bracket. Then, secure the cooler relocation bracket to the vehicle frame bolt hole and secure using the original 12mm bolt.

LH Cooler Bracket (65mm Bolt Spacing)

RH Cooler Bracket (45mm Bolt Spacing)

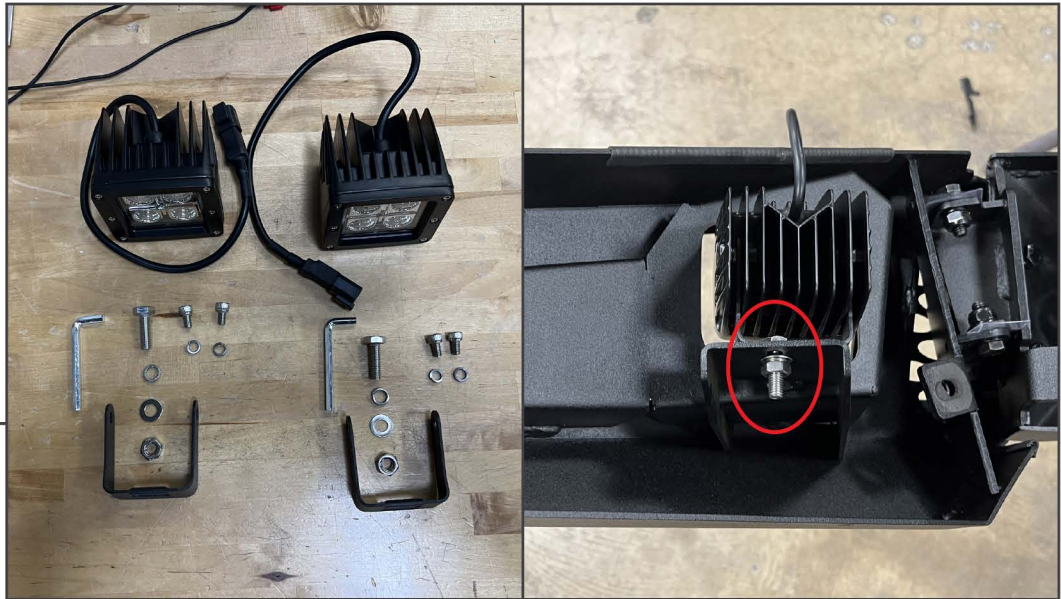
STEP 9

Power Steering Cooler Relocation (cont.): Through the RH side wheel well, remove the rubber liner covering the engine bay components. Unbolt the power steering cooler line from the frame. Then, fit the (1) line bracket between the cooler line and the vehicle frame. Use the original 12mm bolt to secure the bracket to the frame, and the included (1) M8 x 25mm bolt, (2) M8 flat washers [16mm OD], and (1) M8 lock nut through the cooler line bracket.

STEP 10

Place the new bumper on a workable surface. Un-fold the bumper wings after removing the retaining bolts, and loosely secure the wings in the open position using (4) M10 x 25mm bolts, (4) M10 lock washers, and (4) M10 flat washers [20mm OD].

Note: The M10 bolts and the hinge bolts will need to be loose to allow for adjustments during installation. Do not fully tighten at this time.

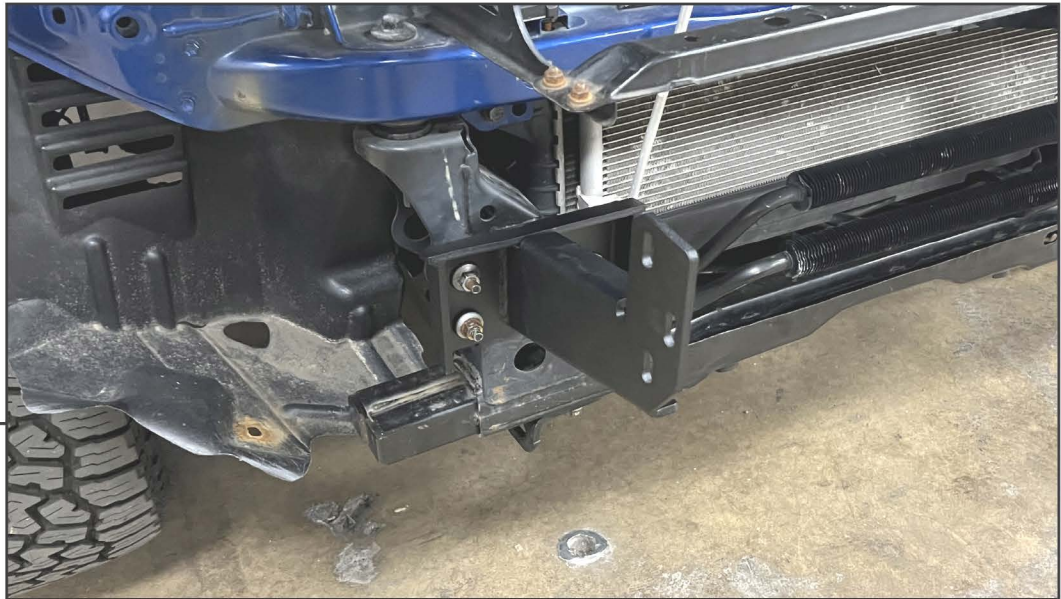
STEP 11

Lay out and identify the hardware included with the LED lighting. Secure the LED light mounting brackets to each LED light using (2) M6 Allen bolts and (2) M6 lock washers. Then, fit the LED light to the bumper mounting bracket and secure using (1) M8 x 25mm bolt, (1) M8 lock washer, (1) M8 flat washer, and (1) M8 nut.

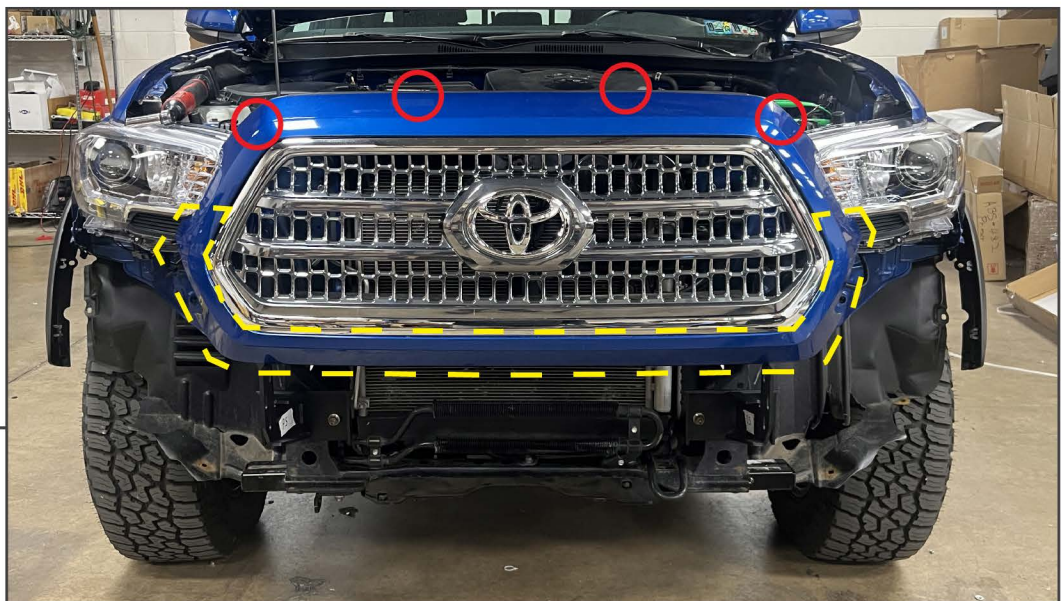
STEP 12

Fit and loosely the LH and RH upper bumper plates to the bumper using (6) M6 x 25mm Allen bolts, (12) M6 flat washers [12mm OD], and (6) M6 lock nuts.

Allow the plates to remain loose at this time to allow for adjustments later.

STEP 13

Fit the LH and RH mounting brackets to the vehicle frame using the original (6) 14mm nuts. Do not fully tighten the brackets at this time to allow for adjustments later.

STEP 14

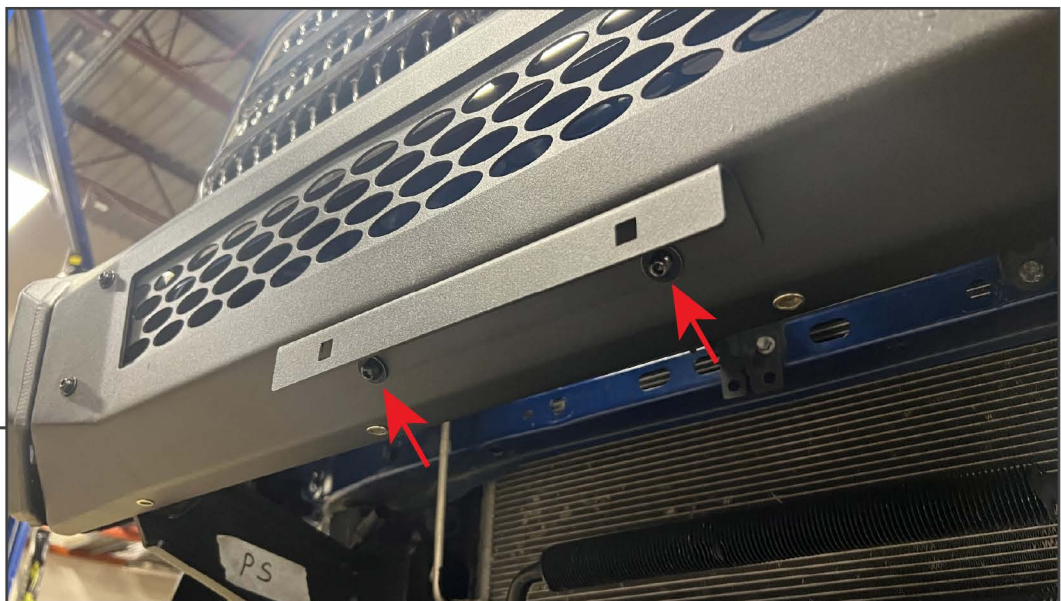
Re-install the OEM grille to the vehicle reusing the original hardware.

Apply masking tape along the bottom of the grille to prevent accidental damage to the grille during bumper installation.

STEP 15

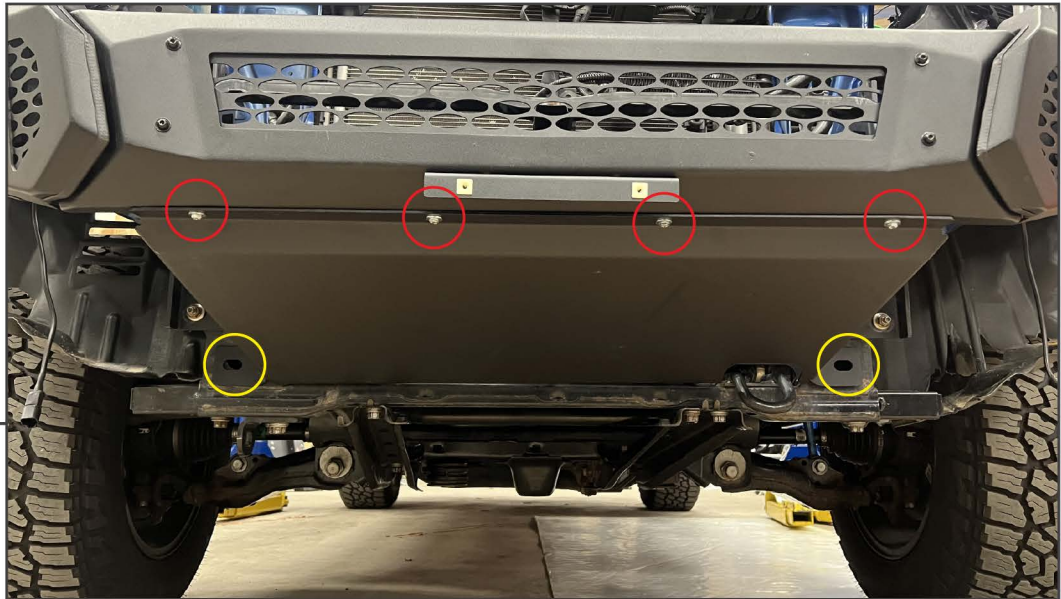
With a helper, lift the bumper to the previously installed mounting brackets. Loosely secure the bumper to the brackets using (6) M10 x 40mm bolts, (6) M10 lock washers, (12) M10 flat washers [24mm OD], and (6) M10 nuts.

Adjust the bumper to best fit the vehicle. The wings may need to be hinged inwards/outwards. Take your time during alignment, it can be difficult to properly align. Once properly aligned, fully tighten all mounting hardware to secure the bumper into place. Then, tighten the bumper hardware.

STEP 16

If desired, install the included license plate bracket to the bumper using (2) M6 x 20mm Allen bolts, (2) M6 flat washers [18mm OD], and (2) M6 lock nuts.

Fit the (2) square fittings into the license plate bracket, and secure the front license plate using OEM license plate screws.

STEP 17

Install the skid plate to the bumper using (4) M6 x 20mm Allen combo bolts. Then, secure the skid plate to the vehicle frame using (2) M12 x 120mm bolts, (4) M12 flat washers, and (2) M12 lock nuts. Adjust the skid plate to the vehicle, and tighten all hardware.

STEP 18

Carefully mark the OEM fender flare, and cut the fender flare to match the bumper edge. The flare will clip into the front-most fender clip.



STEP 19

Verify all hardware is fully tightened. Ensure fender liners and fender flares are secure to vehicle.

Installation is now complete.