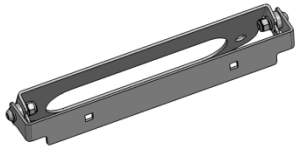




TT68346/TT68347

S1 HD Front Bumper
24+ Toyota Tacoma**INSTALLATION INSTRUCTIONS****PARTS LIST:**

Qty	Description	Qty	Description
1	CS1 Front Bumper Assembly	2	8-1.25mm x 20mm Double Bolt Plate
1	Winch Tray	4	8-1.25mm x 25mm Hex Bolt (Stainless Steel for Lights)
1	Bull Nose Hoop	8	8mm x 24mm x 2mm Flat Washer (Stainless Steel for Lights)
1	Driver/Left Mesh Plate	4	8mm Lock Washer (Stainless Steel for Lights)
1	Passenger/Right Mesh Plate	4	8mm Hex Nut (Stainless Steel for Lights)
1	Driver/Left Outer Mounting Bracket	2	8-1.25mm x 25mm Hex Bolt
1	Passenger/Right Outer Mounting Bracket	4	8mm x 22mm x 2mm Flat Washer
1	Driver/Left Inner Mounting Bracket	6	8mm x 24mm x 2mm Flat Washer
1	Passenger/Right Inner Mounting Bracket	2	8mm Lock Washer
1	Driver/Left Lower Support Bracket	6	8mm Nylon Lock Nut
1	Passenger/Right Lower Support Bracket	2	10-1.5mm x 30mm Button Head Bolt (Stainless Steel for License Plate Bracket)
1	Driver/Left Upper Support Bracket	2	10mm x 20mm x 2mm Flat Washer (Stainless Steel for License Plate Bracket)
1	Passenger/Right Upper Support Bracket1	2	10mm Nylon Lock Nut (Stainless Steel for License Plate Bracket)
1	Driver/Left Inner "L" Bracket	2	10-1.5mm x 40mm Hex Bolt
1	Passenger/Right Inner "L" Bracket	6	10mm x 20mm x 2mm Flat Washer
1	Center Mesh Fill Panel	2	10mm x 24mm x 2mm Flat Washer
1	License Plate Bracket	6	10mm Lock Washer
1	2000mm Edge Trim	6	10mm Hex Nut
6	Sensor Cover Kit	2	10mm Double Bolt Plate
10	2.75mm x 1mm x200mm Nylon Wire Ties	2	12-1.25mm x 100mm Fine Thread Hex Bolt
2	Plastic Plugs for License Plate Mount	12	12-1.25mm x 40mm Fine Thread Hex Bolt
2	Plastic Sensor Plug	6	12-1.75mm x 45mm Hex Bolt
2	15.5mm x 25mm x 2mm Foam Washer	12	12mm x 24mm x 2.5mm flat Washer
2	22+Toyota Parking Sensor Wire Harness Extension	18	12mm x 32mm x 3mm Flat Washer
19	6-1.00mm x 20mm Button Head Combo Bolt	20	12mm Lock Washer
2	6-1.00mm x 25mm Hex Bolt	10	12mm x 1.25mm Hex Nut
4	6mm x 18mm x 1.6mm Flat Washer	1	S=4 Allen Wrench
2	6mm Nylon Lock Nut	1	S=6 Allen Wrench
11	6mm Flange Nut		



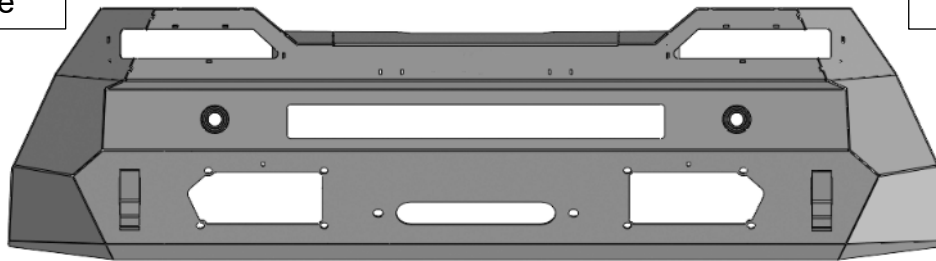
License Plate



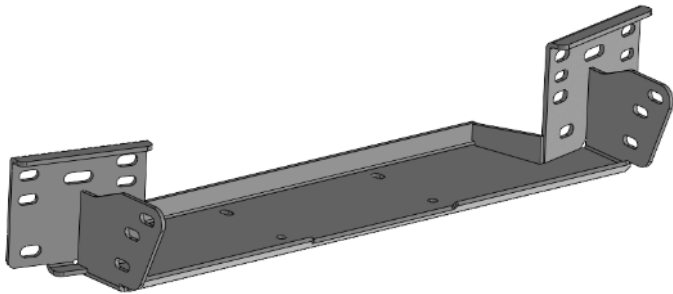
Bull Nose Hoop



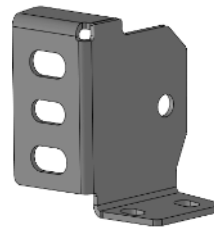
Center Mesh Fill



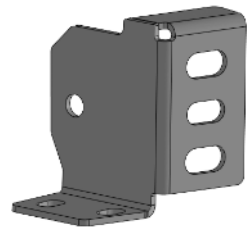
Front Bumper Assembly



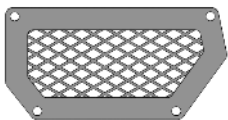
Winch Tray



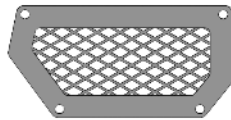
Driver/Left Inner Mounting Bracket



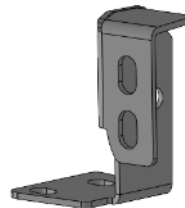
Passenger/Right Inner Mounting Bracket



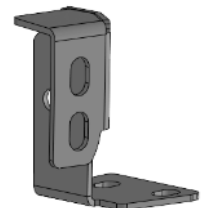
Driver/Left Mesh Plate



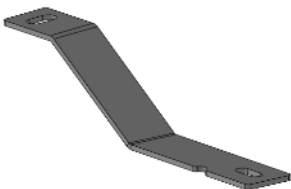
Passenger/Right Mesh Plate



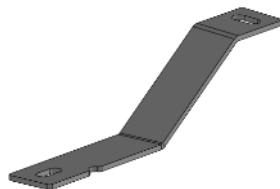
Driver/Left Outer Mounting Bracket



Passenger/Right Outer Mounting Bracket



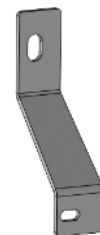
Driver/Left Lower Support Bracket



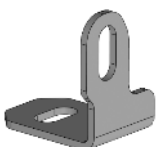
Passenger/Right Lower Support Bracket



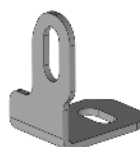
Driver/Left Upper Support Bracket



Passenger/Right Upper Support Bracket



Driver/Left L Bracket



Passenger/Right L Bracket



Hex Bolt



Lock Washer



Flat Washer



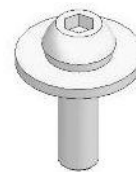
M8 Nylon Lock Nut



Hex Wrench



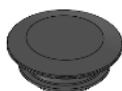
Button Head Bolt



Button Head Combo Bolt



Edge Trim



Rubber Plug



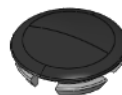
Plastic Plug



Double Bolt Plate

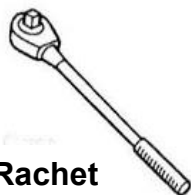


Parking Sensor
Harness Extension



Plastic Sensor Plug

TOOLS REQUIRED



Ratchet



Socket



Extensions



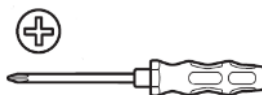
Wrench



Cutting Tool



Pry Tool



Phillips Screwdriver

1

Follow **Fig 1 - 21** to carefully remove Front Clip from vehicle. Refer back to these Figures for reinstalling the Front Clip.



(Fig 1) Starting on Passenger Side wheel well, remove three screws and two plastic clips to release the liner from the front clip. Pry tool may help with separating liner from front clip. Repeat for Driver side. Be sure to retain all hardware.



(Fig 2) With a pry tool, carefully pull the fender flare outwards to release it from the side. Repeat on Driver side.



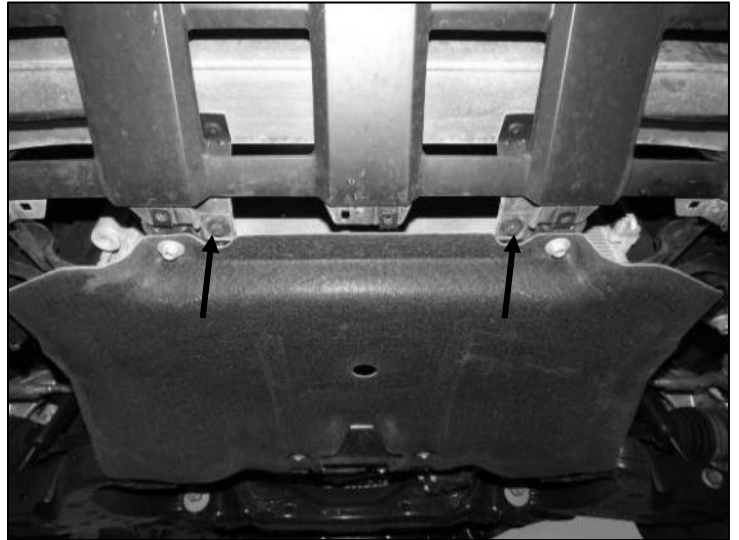
(Fig 3) Remove screw attached to side of front clip behind fender flare.



(Fig 4) Remove air dam from front clip by removing several screws from underneath on each side.



(Fig 5) Continue removing air dam by removing several screws from underneath at the center. Keep hardware in safe storage.



(Fig 6) Remove (2) factory bolts to loosen bottom section of front clip. Keep hardware in safe storage.



(Fig 7) Remove factory bolt to loosen side bottom section of front clip. Keep hardware in safe storage.



(Fig 8) Open the hood and remove plastic covers and air intake by unfastening clips and bolts. Plastic pry tool may help with removing plastic clips.



(Fig 9) After removing plastic covers and air intake, remove three bolts holding the upper clip.



(Fig 10) After removing plastic covers, locate wire harnesses for shutter and camera on each side.



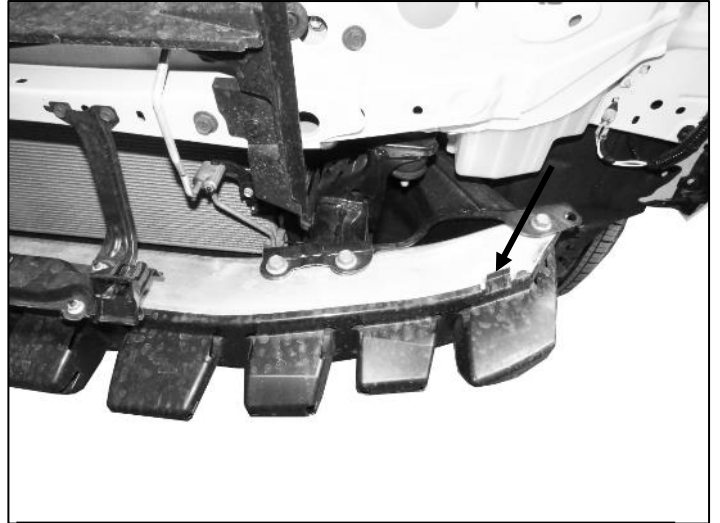
(Fig 11) Unplug passenger side wire harnesses shown



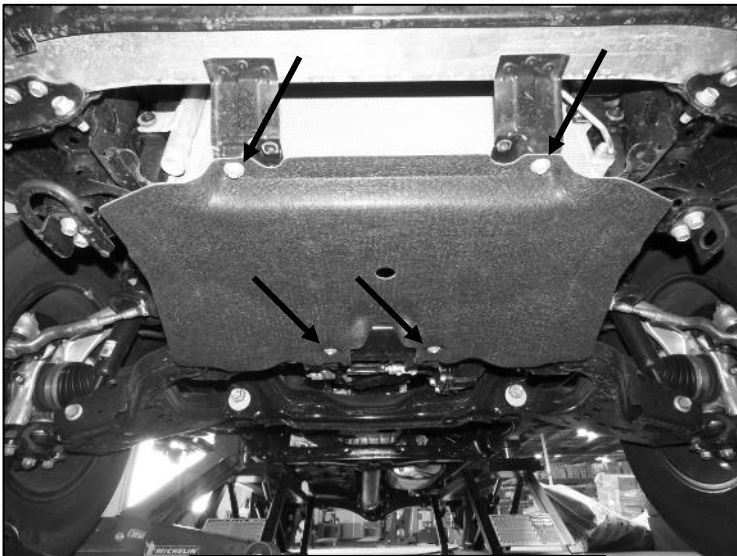
(Fig 12) Unplug driver side wire harnesses shown



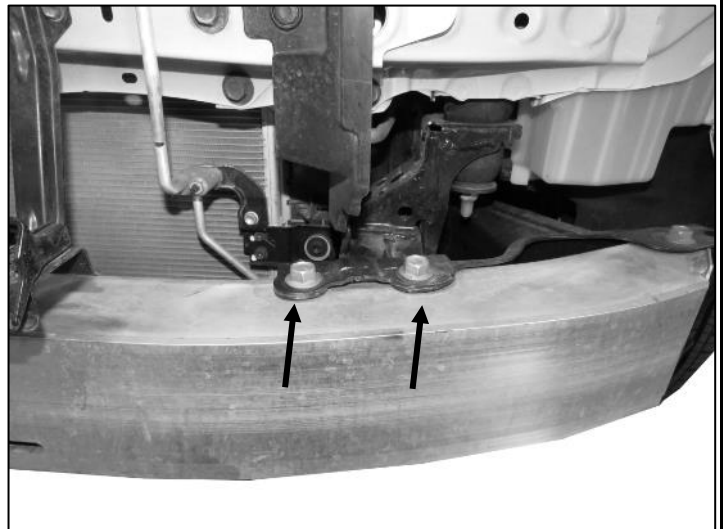
(Fig 13) Carefully release and pull the front clip off the vehicle and place it on a flat secure surface. Remove the plastic piece from the crash bar and place it aside.



(Fig 14) Remove plastic piece by unclipping from crash bar. There are several clips across the plastic piece above, in, and underneath.



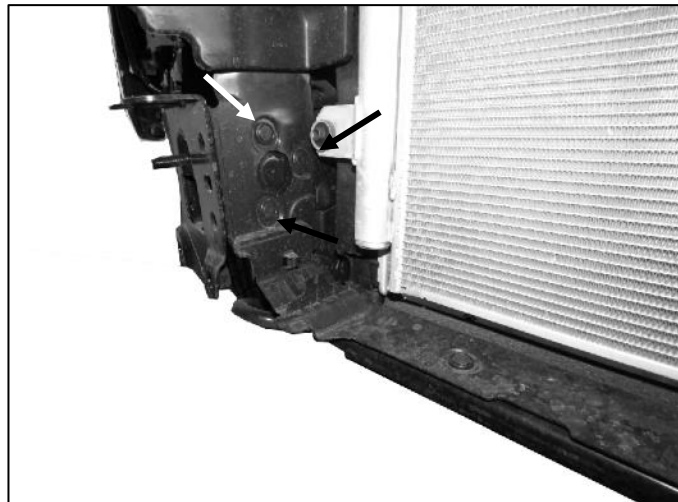
(Fig 15) Remove splash guard.



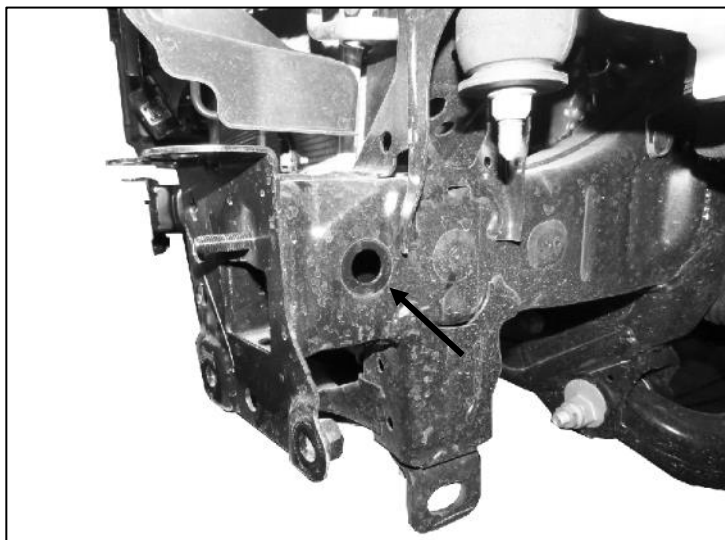
(Fig 16) On Driver Side, remove two upper frame horn bolts from crash bar.



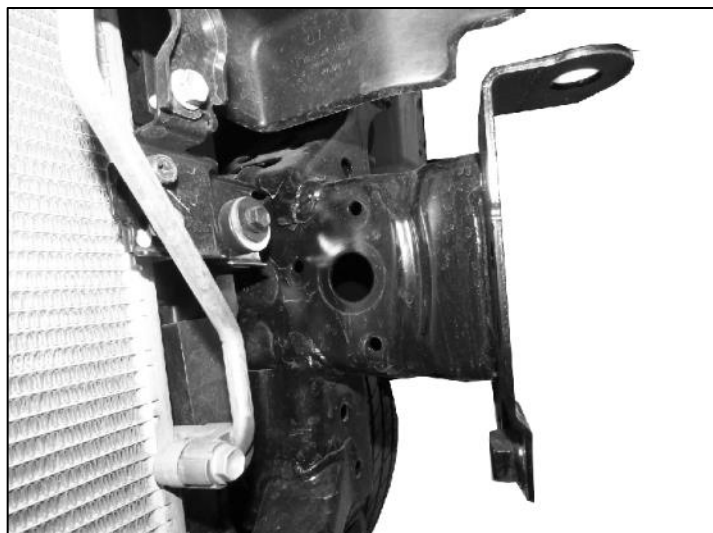
(Fig 17) Remove two lower frame horn bolts from crash bar. Repeat Steps 15-16 for Passenger Side, and fully remove crash bar.



(Fig 18) Remove side plastic pieces by removing factory clips. Repeat for other side.



(Fig 19) Remove plastic cover to outer frame hole. Repeat for other side.

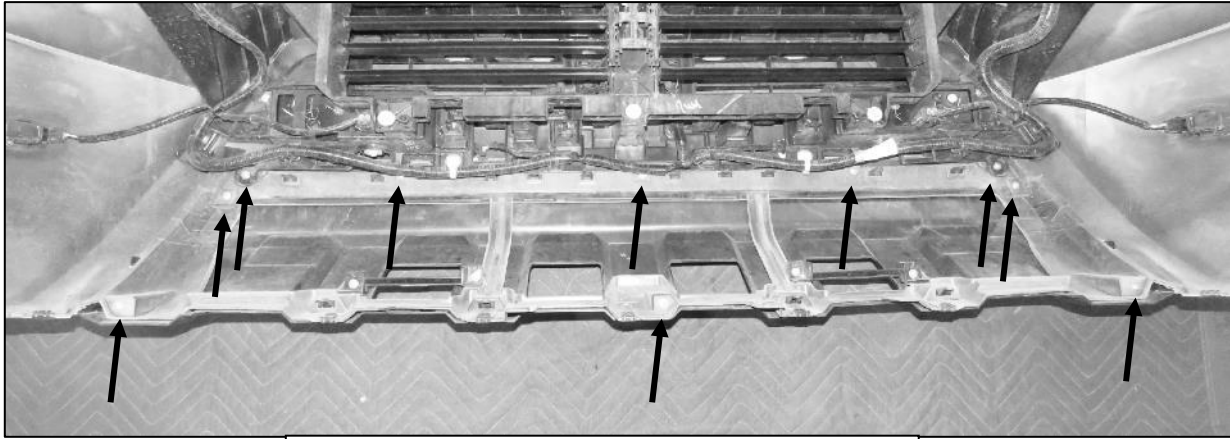


(Fig 20) Remove plastic cover to inner frame hole. Repeat for other side.

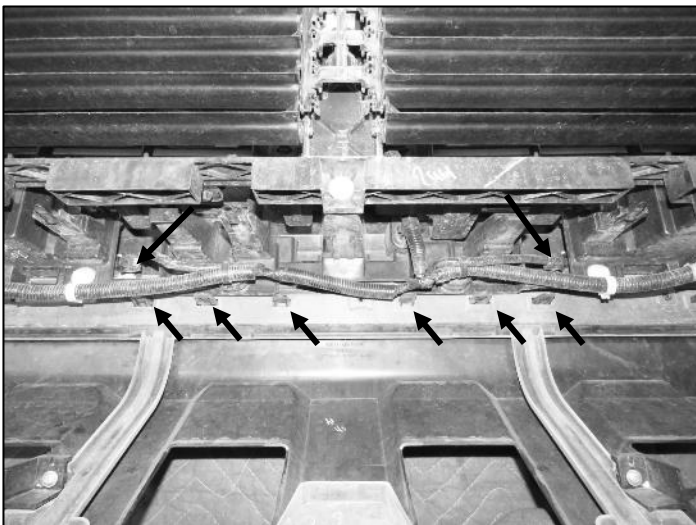


(Fig 21) Front area is now prepared for assembly.

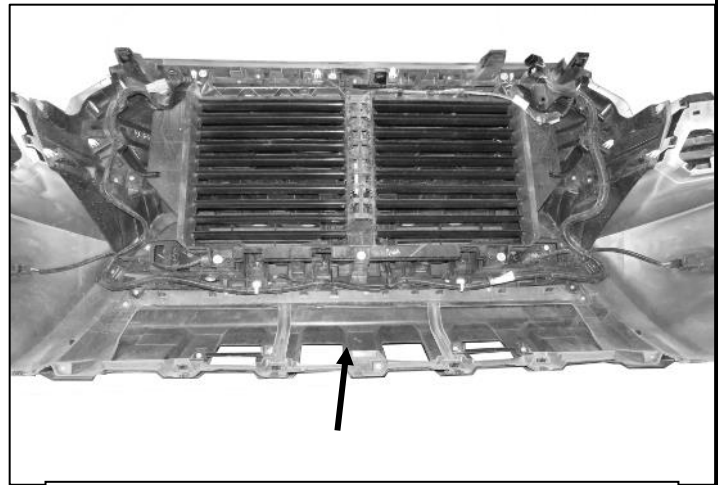
Follow [Fig 22-39](#) to properly prepare and trim bottom section of Front Clip.



(Fig 22) Locate and remove 10 small screws holding the panels.



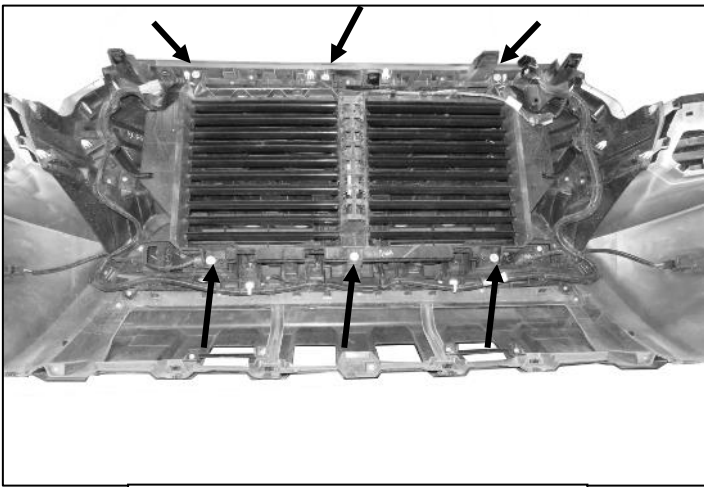
(Fig 23) If parking sensors are equipped, temporarily unplug them. Unclip the upper front bumper plastic panel using a pry tool by pushing on small tabs for each retainer along the panel.



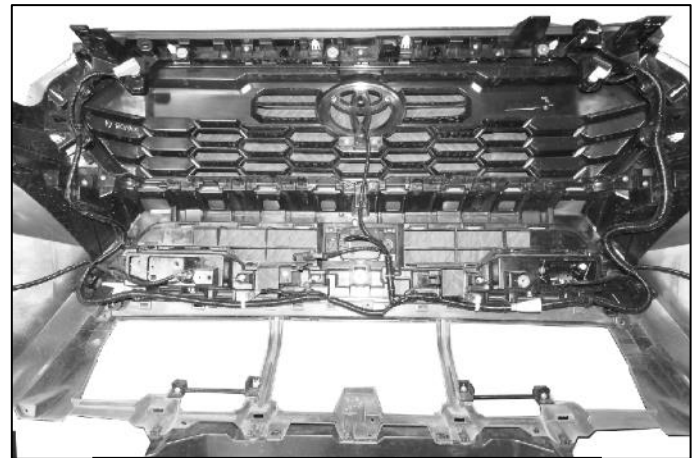
(Fig 24) On back side of the Front Clip, locate and remove lower front bumper plastic.



(Fig 25) Upper and lower front bumper plastic removed



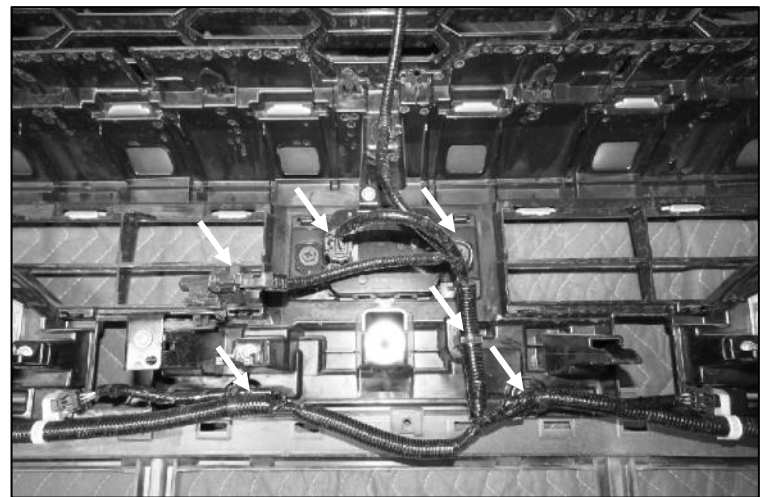
(Fig 26) Temporarily remove active shutter assembly



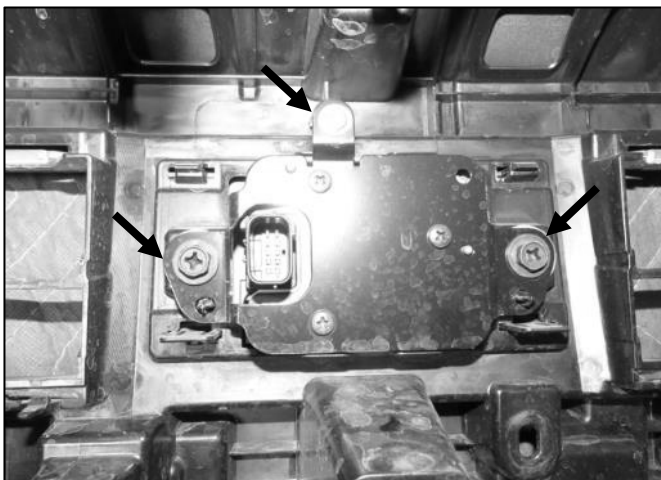
(Fig 27) Unclip wire harness from plastic and move away from trimming area.



(Fig 28) On Left fog light area, unfasten indicated clips and unplug fog light. Repeat for Right fog light.



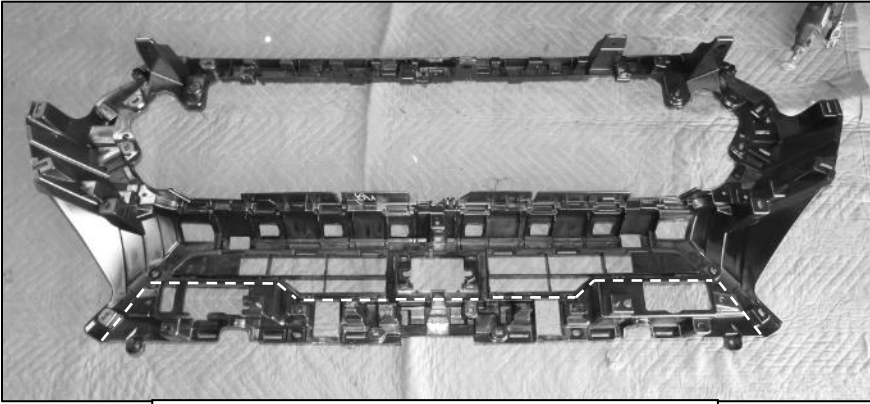
(Fig 29) Unfasten indicated clips in the center and unplug TSS module



(Fig 30) Temporarily remove TSS module



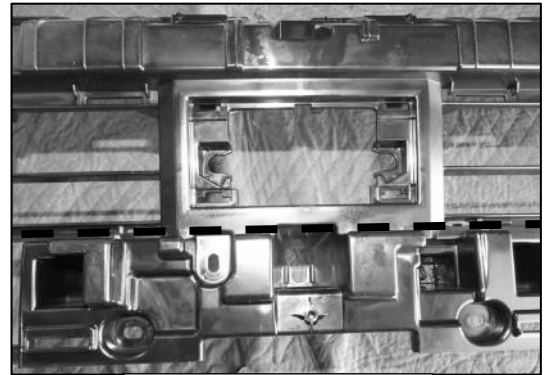
(Fig 31) From front side, remove fog lights.



(Fig 32) Trim lower section of inner plastic bumper under white guide lines. Bumper disassembled for illustrative purposes only



(Fig 33) Cut along the edge on the side and under the grille opening



(Fig 34) Cut a straight line across the center



(Fig 35) Front side of trimmed removed black inner plastic.



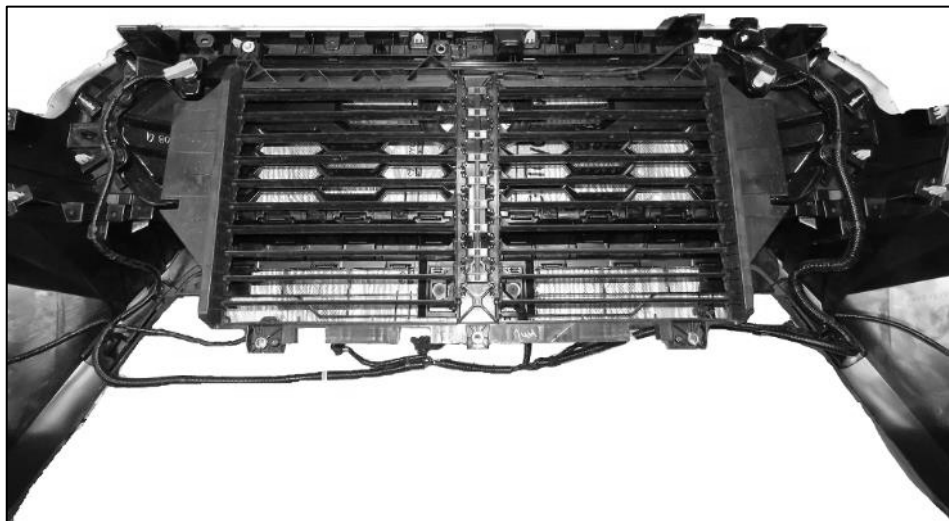
(Fig 36) Trim lower section of front clip under guide lines. Bumper disassembled for illustrative purposes only



(Fig 37) Cut along the edge on the side of the front clip

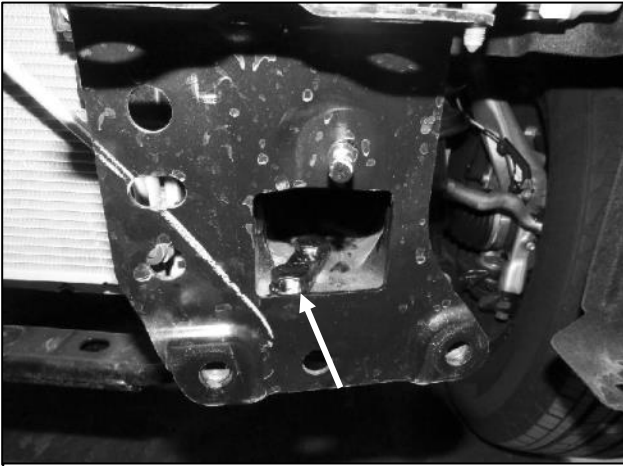


(Fig 38) Trimmed lower section of front clip

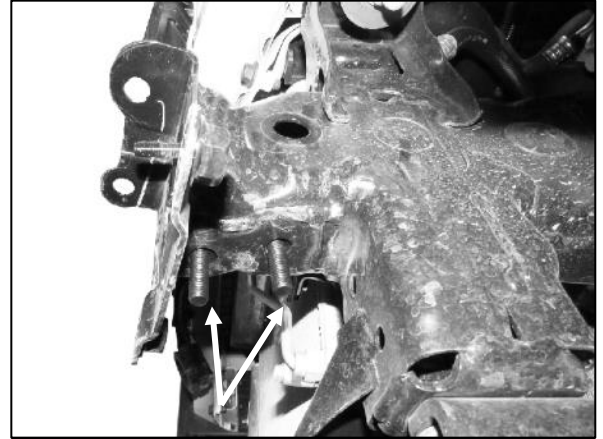


(Fig 39) Reinstall active shutter assembly using the top three mounting points. Reattach the wire harness and connect to all parking sensors and TSS module.

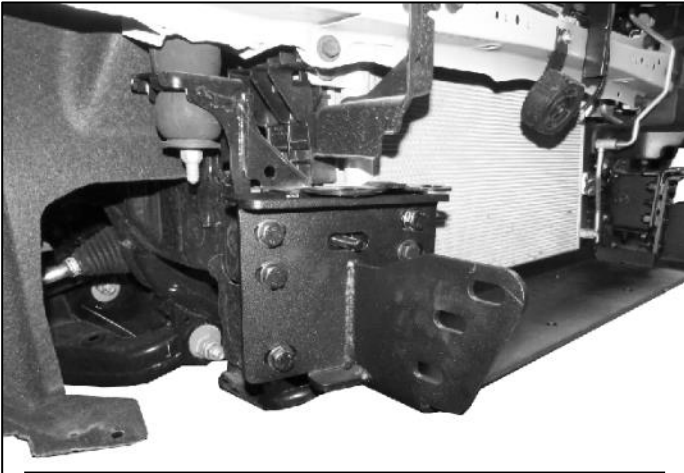
Follow **Fig 40 - 63** to mount Front Bumper Assembly and complete installation.



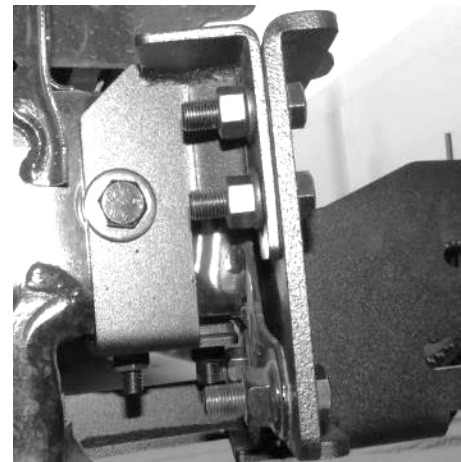
(Fig 40) Insert double bolt plate into channel frame on both sides.



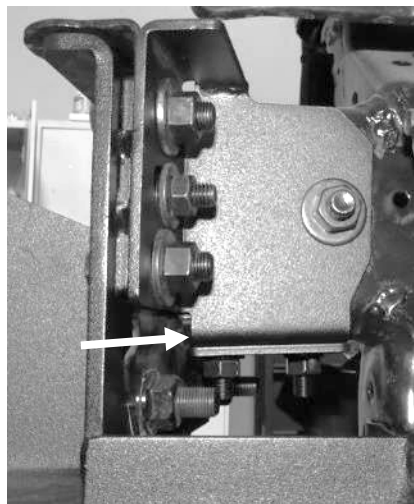
(Fig 41) Ensure both bolts go through the bottom slots of the frame.



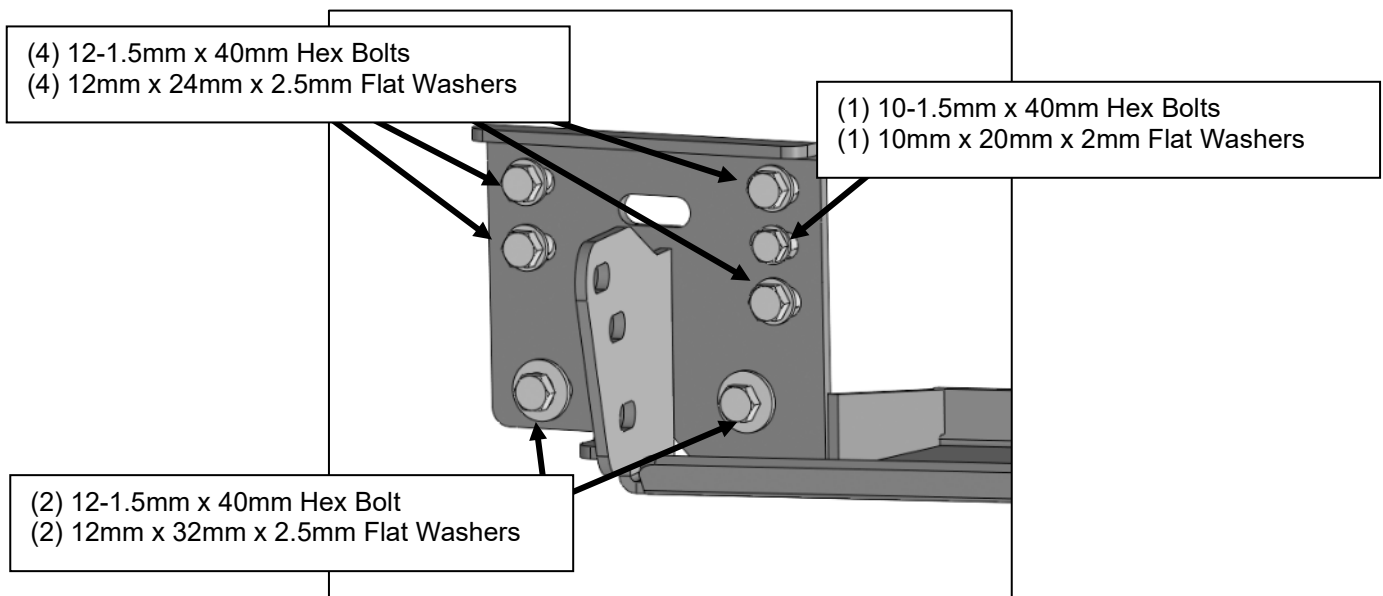
(Fig 42) Mount winch tray with outer and inner support brackets to frame on both sides. Hardware indicated in **Figs 39 - 41**.



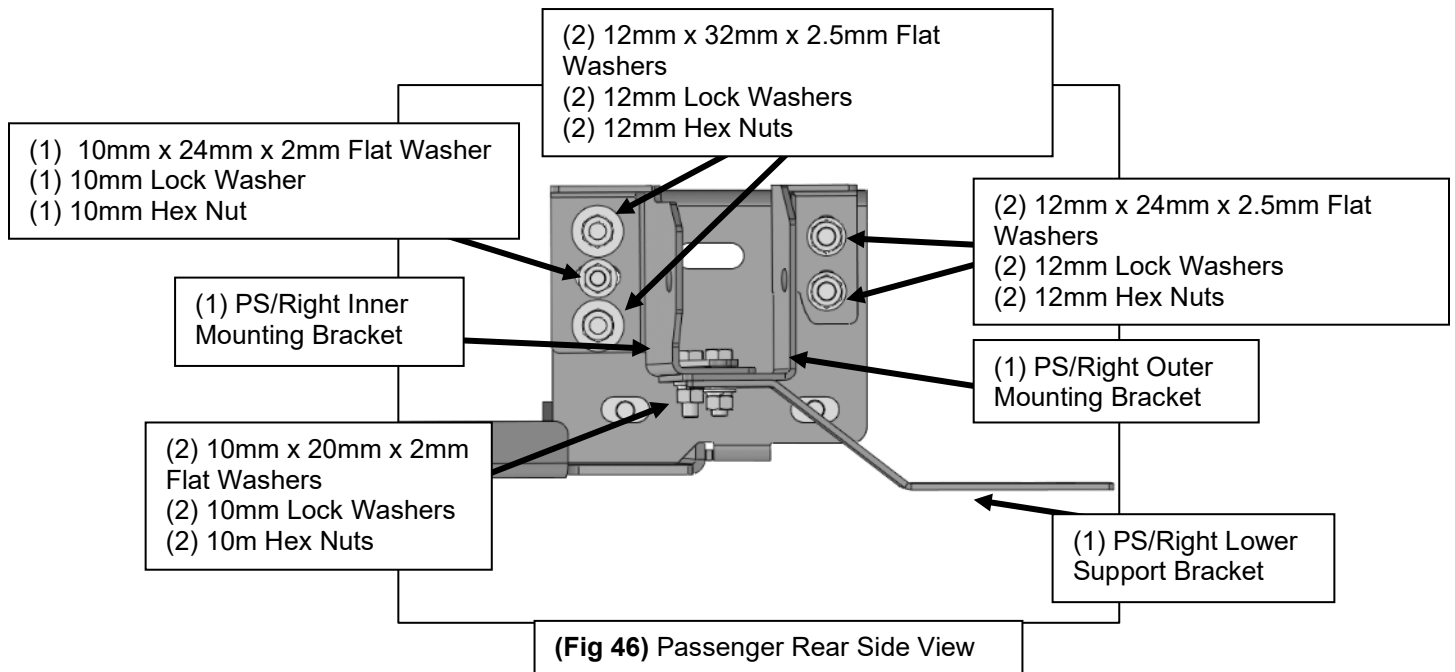
(Fig 43) Outer support bracket installed (Passenger side shown)



(Fig 44) Inner support bracket installed (Passenger side shown). Bottom of inner support bracket will be sandwiched between the frame and the outer support bracket

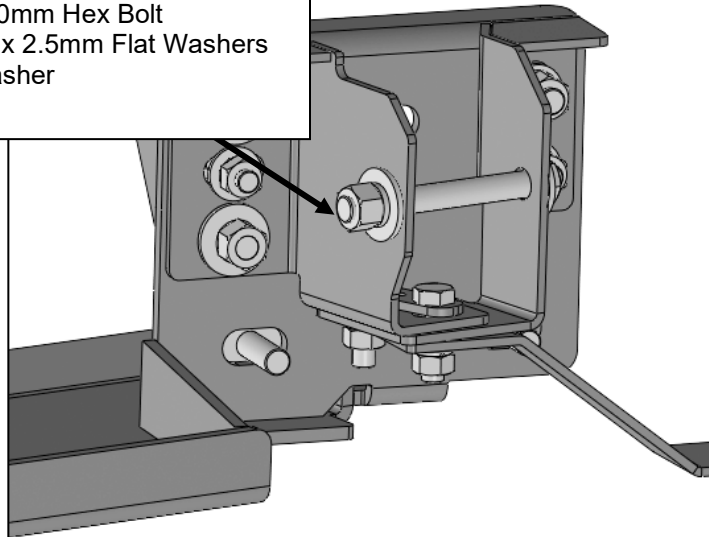


(Fig 45) Passenger Front Side View



(Fig 46) Passenger Rear Side View

- (1) 12-1.5mm x 100mm Hex Bolt
- (2) 12mm x 32mm x 2.5mm Flat Washers
- (1) 12mm Lock Washer
- (1) 12mm Hex Nut



(Fig 47) Passenger Rear Side View

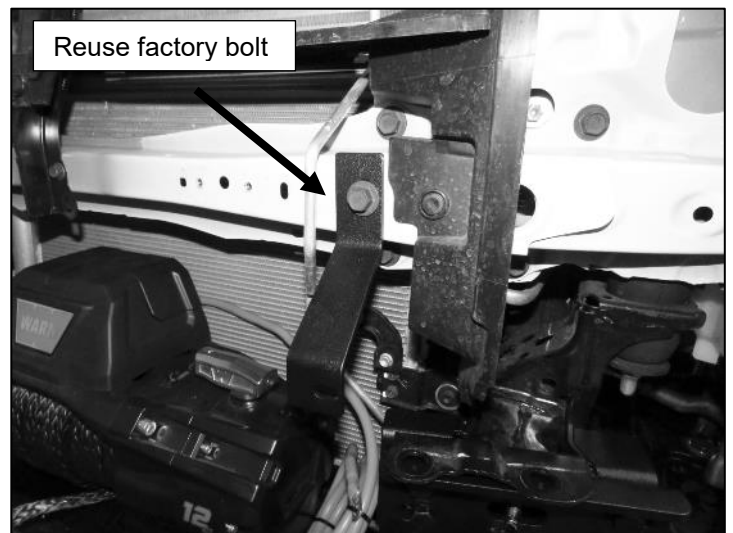


(Fig 48) Install Winch at this point if available.

Hybrid Vehicles Only: Depending on the winch dimensions it may be necessary to relocate the Pedestrian warning speaker



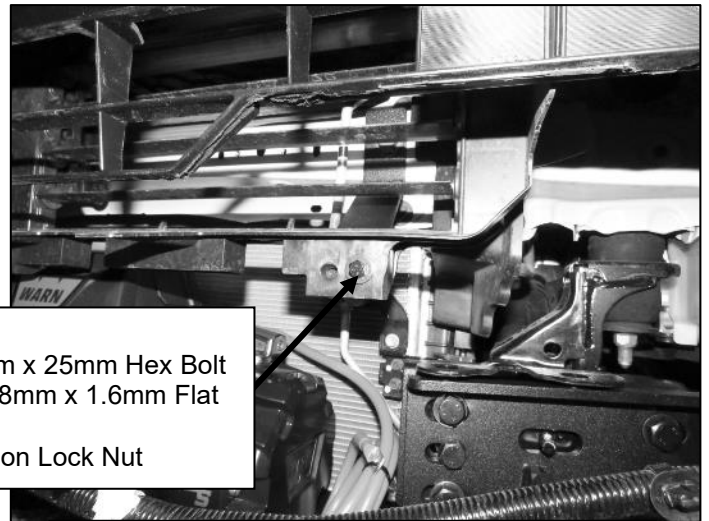
(Fig 48a) Hybrid Vehicles Only: Relocate pedestrian warning speaker if necessary



(Fig 49) Install Upper Support Brackets for both sides vehicle center area.



(Fig 50) Carefully reinstall the Front Clip onto the vehicle. Make sure all clips go into their original latch points and wire harness is not caught between any choking points.



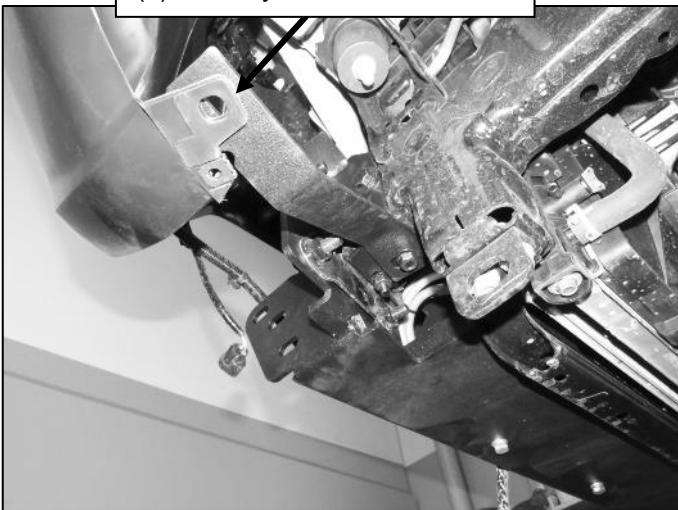
Each Side:

- (1) 6-1.00mm x 25mm Hex Bolt
- (2) 6mm x 18mm x 1.6mm Flat Washers
- (1) 6mm Nylon Lock Nut

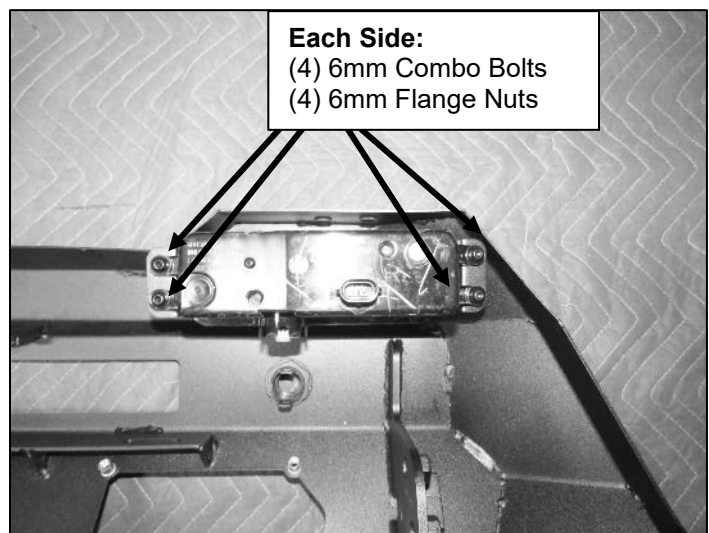
(Fig 51) Secure the lower outer mount points of the active grille shutter assembly onto Upper Support Brackets using indicated hardware.

Each Side:

- (1) 8-1.25mm x 25mm Hex Bolt
- (2) 8mm x 24mm x 2mm Flat Washers
- (1) 8mm Nylon Lock Nut



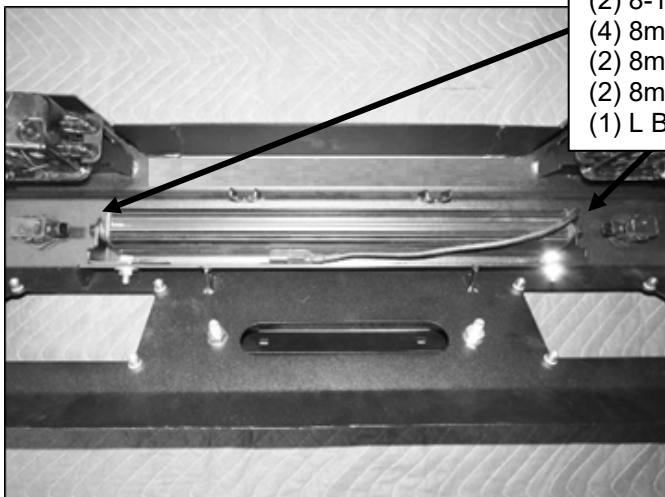
(Fig 52) Secure the lower section of the Front Clip onto Lower Support Brackets using indicated hardware.



Each Side:

- (4) 6mm Combo Bolts
- (4) 6mm Flange Nuts

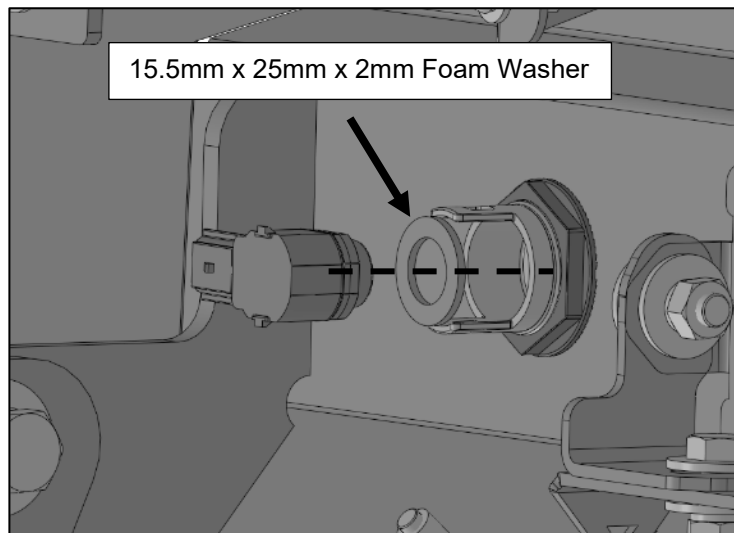
(Fig 53) Install Factory Fog Lights onto Fog Light Housing using indicated hardware.



Each Side:

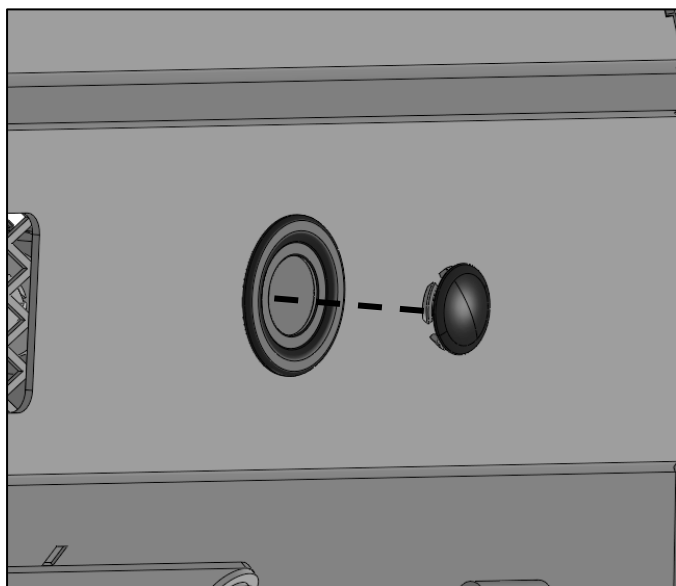
- (2) 8-1.25mm x 25mm Hex Bolt
- (4) 8mm x 24mm x 2mm Flat Washers
- (2) 8mm Lock Washers
- (2) 8mm Hex Nuts
- (1) L Bracket

(Fig 54) Install LED Light Bar or Center Mesh Fill Panel using indicated hardware.



15.5mm x 25mm x 2mm Foam Washer

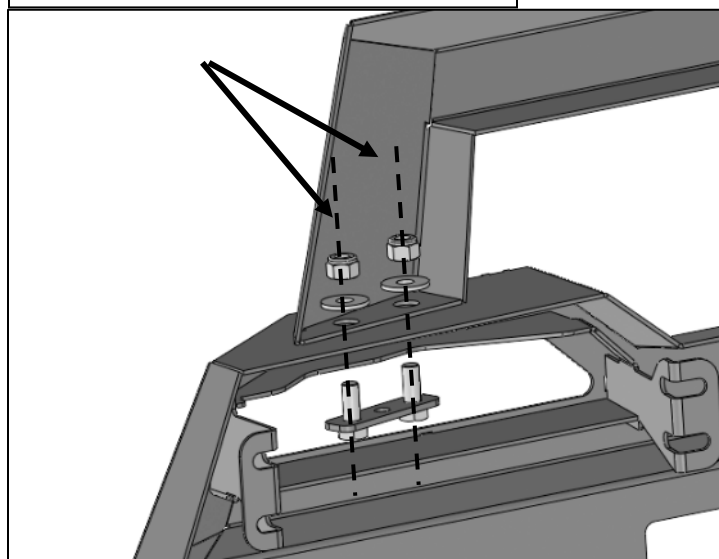
(Fig 55) Install front parking sensors if applicable



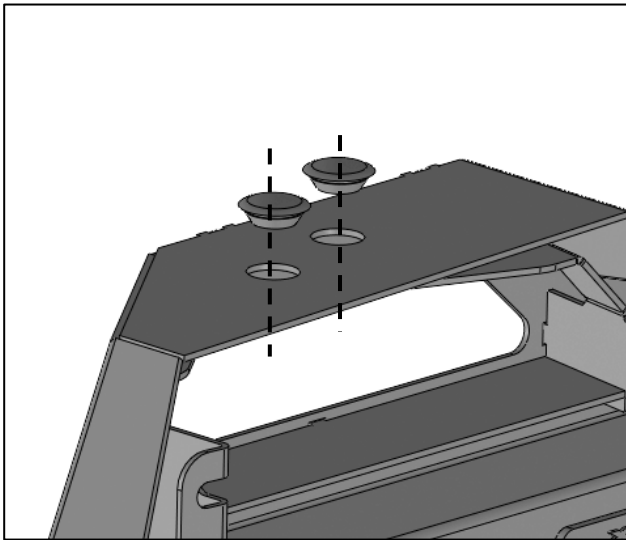
(Fig 56) Install plastic sensor cap for vehicles without front parking sensors

Each Side:

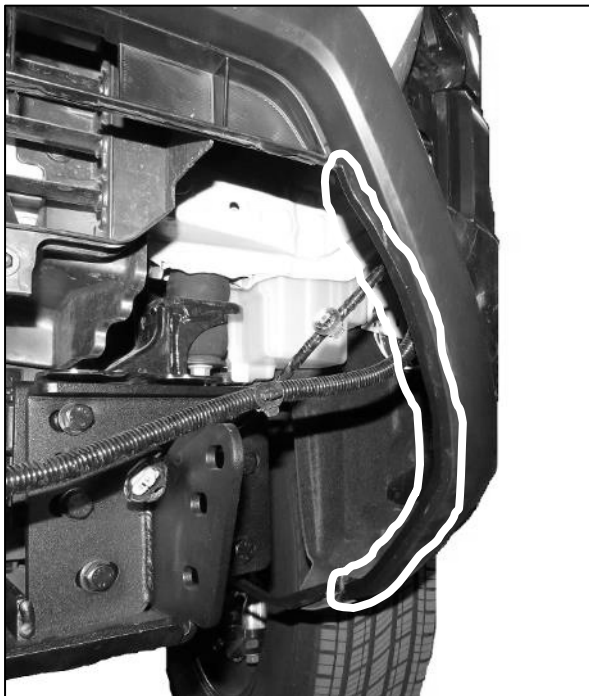
- (1) Double Bolt Plate
- (2) 8mm x 24mm x 2mm Flat Washers
- (2) 8mm Nylon Lock Nuts



(Fig 57) Install Bull Nose Hoop using indicated hardware if using.

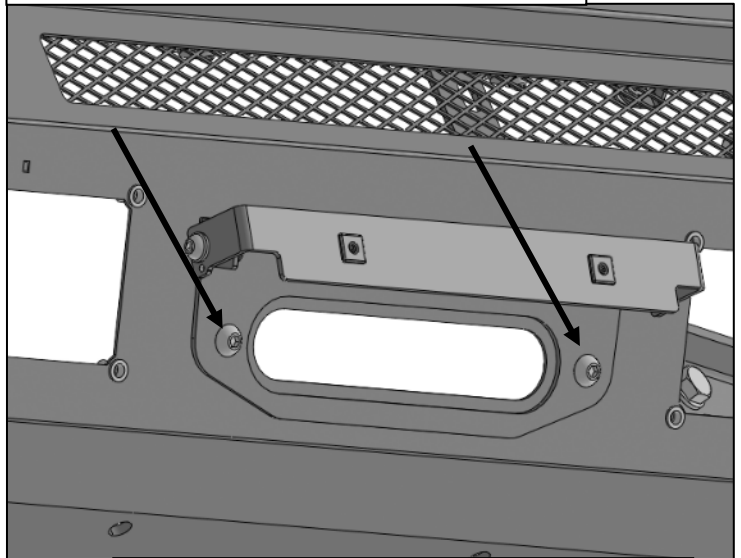


(Fig 58) If you are not using the Bull Nose Hoop, install Rubber Plugs into Bull Nose Hoop mounting points.



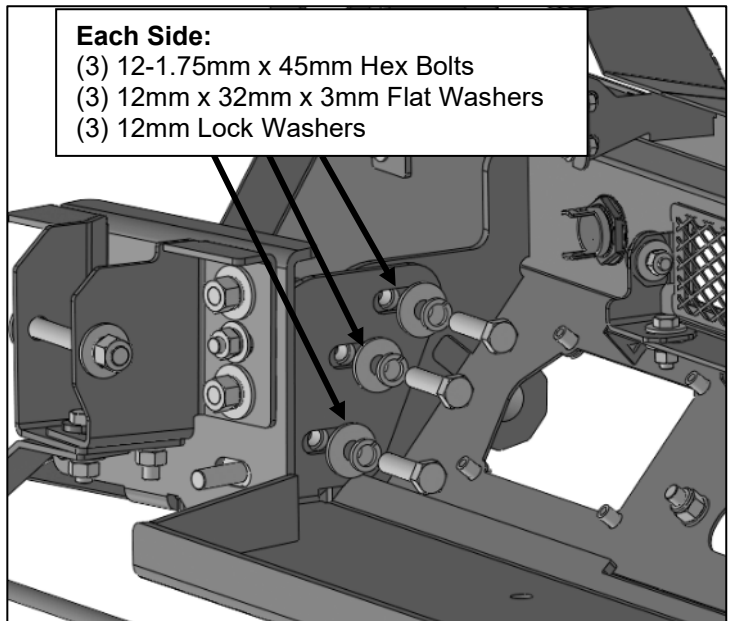
(Fig 60) Optional: Install rubber edge trim along the sides of the factory plastic front fascia

- (2) 10-1.5mm x 30mm Button Head Bolt
- (2) 10mm Nylon Lock Nut
- (2) 10mm x 20mm x 2mm Flat Washers



(Fig 59) Install License Plate Bracket using indicated hardware if using. Install Winch Fairlead over License Plate Bracket if using.

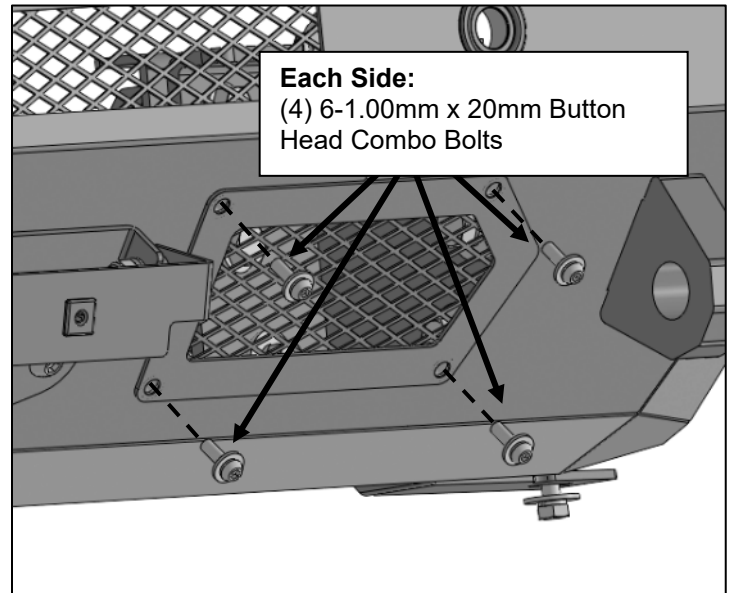
- Each Side:**
- (3) 12-1.75mm x 45mm Hex Bolts
 - (3) 12mm x 32mm x 3mm Flat Washers
 - (3) 12mm Lock Washers



(Fig 61) With assistance, position Front Bumper Assembly over Winch Tray mounting points. Mount the Front Bumper Assembly by reaching through the cut out and fastening the indicated hardware to Winch Tray weld nuts.



(Fig 62) Reach through the cutouts on each side of the Front Bumper Assembly and plug in the fog lights and front parking sensors using the Parking Sensor Extension Harnesses (if equipped)



(Fig 63) Install Mesh Plates after securely fastening the Front Bumper Assembly onto the Winch Tray.



Complete Installation