



2005-2015 Tacoma High Clearance Rear Bumper Install

DISCLAIMER: This product is intended for off road use only. By installing this product, you are assuming all risk and all responsibility for property damages or personal injury from use or abuse of this product.

Only use kinetic type recovery straps when freeing a stuck vehicle. The stretching of the strap greatly reduces strain on both vehicles and requires less energy to recover the stuck vehicle. Chains or tow straps are ok for towing a vehicle only. They are never ever to be used for pulling out a stuck vehicle because they 'shock load' the recovery points, which break things and people... Winching with steel or synthetic cable is fine because no shock load is applied but traditional safety measures should still be taken. More info on winching and recovery can be found on pirate4x4.com and the US Army field manual 21-305, chapter 22.

Your bumper was shipped bare steel and needs to be coated prior to final install. It is suggested that a 'dry run' mockup install be performed before coating to see how everything goes together. This will make final install go much smoother with less risk of scratching anything.

Remove factory rear bumper.

Remove license plate and license plate lights. To remove the lights, unscrew the Phillips head screw holding the light on, pull out lights, and twist the bulb connector out of the back. Be careful not to touch the bulbs with your bare hands. Feed the light harnesses back through the bumper. Remove trailer plug via the steel bracket from the bumper and leave the steel bracket attached to the plug. Remove all bolts holding the bumper to the frame, WITH THE EXCEPTION of the bolt closest to the front of the truck on each side. Only unthread those halfway. Be sure all wiring is free from the factory bumper before removal.

Now carefully remove the factory bumper by pulling out and upward. There is a pin on each of the bumper's mounts that sits in a slot in the frame. You will need to lift the bumper upward to get the pins out of the slots. See pic below.



Install factory license plate light housings into new bumper using the supplied #8 machine screws, washers, and nuts.

If you are installing backup lights, it is easier to bolt them on with the bumper off the truck but can be done after the bumper is installed as well. The holes are cut for Rigid Industries D Series flush mount lights, but any brand similar to those will work as they all use the same hole pattern. Wiring is up to you, but it is best to use a relay switch powered directly from the battery and use the reverse light circuit as it's trigger so they turn on automatically. Using the circuit for backup lights on the 7 pin trailer harness is also an option, but be careful not to overload the circuit if using for a trailer as well.

Prepare bedsides for cutting. Use a level, bar, pipe or anything very straight that is long enough to sit on top of the bed so it rests on either side and has at least 6" of overhang. If you have a camper shell you can remove the clamps and temporarily prop it off the bed for this step. You will be cutting the bedsides and fender flares 20.00" below the top of the bedsides. Using painter's tape, mask off a broad section that will cover your cut line. Using a tape measure, measure from the bottom of your overhanging bar down 20.00" and make a few marks on the bedsides and fender flares. Use a straight edge to draw a line connecting your marks, and continue the straight line under the tail light, and then angled down as shown in the pics on the next page. Double check your measurements to be sure everything looks good. Remove the plastic rivets and bolts (10mm socket) on the fender flares. Do not remove the support bracket that connects to



the bed yet, it will help to leave this installed to stabilize the bed while cutting. Always wear proper protective equipment such as safety glasses, face mask, and gloves when cutting metal. Using a 4-1/2" angle grinder with cutoff wheel or body saw, cut along your line. If you didn't cut through both the fender flare and metal bedside in one shot, pull off the cut section of fender flare and carefully finish off the cut. Cut remaining section of the wheel well liner level with your cut line using a utility knife. Remove the

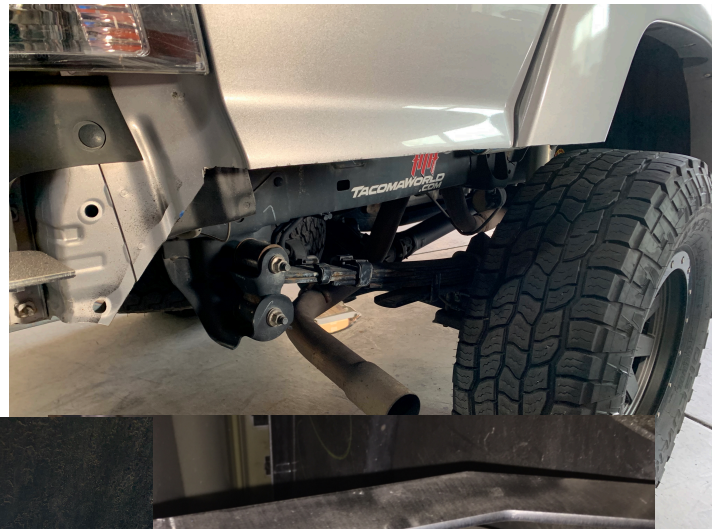
bedside support bracket at the bed (10 mm socket) and save the bolts.



Remove any burrs from your cut edge with a file and paint the edge to protect from corrosion.

Install new bedside support brackets (long brackets with bent ends) using the original factory bolts and drill a 5/16" hole in the bedside behind the fender flare for the single hole on the brackets . DO NOT DRILL ALL THE WAY THROUGH FENDER FLARE. Use the supplied 1/4" x 3/4" bolts to bolt the brackets to the bedsides. You can tape the nut to a wrench and sneak it between the fender flare and metal bedside from below. The slotted holes in the bracket allow for adjustment to push or pull the bedsides in or out slightly when you are finished. Firmly push on the supplied edge trim, following the bedside cut line under the tail lights and cut it to length. Use a separate section of the trim for the fender flare cut line.

Drill a 5/16" hole through the fender flare and wheel well liner and secure the liner to the flare as shown in the pic below.



Now install new bumper. It may help to have a buddy's assistance in lifting. Line up the bumper and slide it into the two bolts you left halfway threaded in. Once it's locked in to those bolts, it should be able to rest there. You can use a floor jack with wood blocking under the receiver to slightly lift it to thread in the other 8 bolts. Leave all bolts loose for now. The best way to line up the bumper is to use a floor jack with wood blocks on each side of the bumper, lifting both sides of the bumper into place simultaneously so it butts up to your cut line. If you don't have two floor jacks, you can use a bucket or crate with wood blocks to shim to the correct height. Once everything is lined up, tighten all ten bolts.



Reinstall trailer plug using the factory bracket and the small bracket welded to the receiver reinforcement tubing us in the supplied 1/4" x 1" bolts. Orient the factory bracket as shown in the pic below.



Adjust bedside width so it's even on both sides (if necessary) by loosening the bedside bracket bolts and sliding them in their slotted holes.

Hidden receiver license plate hinge: Using the provided 1/4" x 3/4" bolts, fasten the hinge to the bumper using the lower holes that are further apart. Then bolt the license plate to the hinge using the shorter 1/4" x 1/2" bolts, so the bolt heads are inside the hinge and the nuts are facing out. The upper holes on the bumper are provided if you don't want to run the hinge license plate bracket. Stick the provided magnets with



adhesive backing to the backside lower corners of the license plate to keep it in place while driving.

Install complete. Enjoy your new armor!