



05-15 Tacoma Standard Rear Bumper Install Instructions

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 and its steel bracket from the bumper. 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.



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 any brand flush mount LED pods. 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 its trigger. Using the

circuit for backup lights on the 7 pins trailer harness is also an option, but be careful not to overload the circuit if using for a trailer as well.

Now install new bumper. It may help to have a buddy's assistance in lifting. It may also be helpful to rest the bumper on a floor jack with a block of wood to guide it in place.

Lift bumper in place and slide into the two rearmost bolts you left halfway threaded in.

Thread in the other 8 bolts you removed earlier but leave loose.

The slotted holes in the bumper's mounts allow for up/down adjustment and tilt adjustment. Take your time to get it adjusted properly so it sits level. You only need to

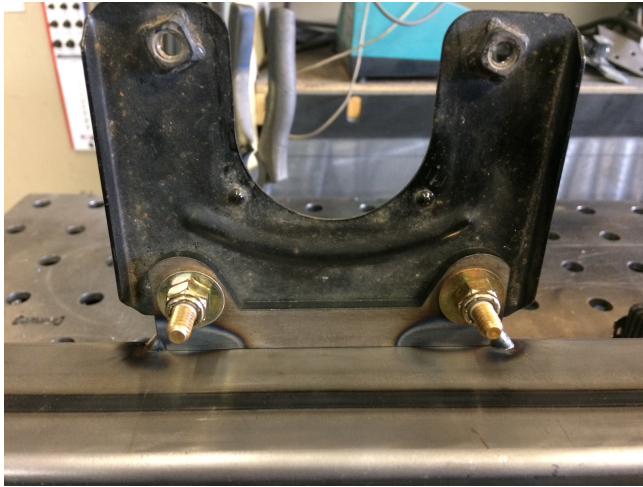
to tighten one bolt on each side to check your adjustment and a floor jack will help with this. Double check that the tailgate opens without touching the bumper. With the tailgate closed, check gap between bumper and lower edge of tailgate with a tape measure on both sides. Tighten all 10 bolts after adjustment.



Note Tacoma beds are all set slightly different from the factory. You can slightly adjust the bed left/right by loosening the six T55 torx bed bolts and sliding it either way.

Reinstall factory license plate lights using the provided #10 machine screws/washers/nuts.

Reinstall trailer plug using the factory bracket and the small bracket welded to the receiver reinforcement tubing. Orient the factory bracket so the welded nuts are facing upward.



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 is now complete. Enjoy the added protection of your new rear bumper!

