



## **2016 + Tacoma High Clearance 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](http://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.

1. Remove factory bumper. Unplug the three wiring harnesses and license plate light harnesses behind the bumper. Remove and save 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. You may need to strike the bumper with a dead blow hammer from the receiver to slide off the frame.



2. You will need to remove the plastic center section and side caps off the factory bumper to retrieve the wiring harness. Remove license plate, trailer plug, and plastic pop rivets by pulling the centers out and pulling up. Disconnect wiring from license plate lights. Disconnect tabs holding the wire loom to the backside of bumper. The center section can now be released by pulling/prying firmly to dislodge the rest of the plastic connectors. Use caution if you have backup sensors and do not rip out the wiring. Unplug the connectors for the backup sensors if equipped and remove sensors. **BE EXTREMELY CAREFUL** removing these as they are delicate. You can gently rock the sensors back and forth to remove them from the grommets holding them to the bumper. Carefully remove the grommets by pushing out from the backside while squeezing the small prongs. Remove side caps and unplug the BSM sensors. The connectors for these sensors can only be released by removing the side caps. No need to remove the BSM sensors as they will not be used with the new bumper.



3. Install license plate on new bumper. If you chose the standard receiver under the license plate, use the upper round holes and the provided 1/4" bolts/nuts/washers. If you chose the hidden receiver, use the provided license plate flip up bracket and bolts. The 5/16" bolts fasten the bracket to the bumper, and the short 1/4" bolts fasten the license plate to the flip bracket.

Install provided license plate lights with provided #6-32 screws/nuts/washers.

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 it's trigger. 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.

Cut bed sides.

The best tool for cutting your bed sides is a 4-1/2" angle grinder with cutoff wheel.

Measuring from the edge of bed caps where they meet the bed sides (see pic), measure down 20-3/4" at the tail light and 21-1/2" at the fender flare (see pic). Make marks at each of those points and mask a straight line being sure the tape is sealed tight against the paint. Check your line with a straight edge. Don't worry about removing the bedside support brackets or other fasteners yet, you will want them in place to keep the bedside stable while cutting. Make your cuts. Cut areas under the tail lights as shown in the pics. The bumper will cover this area so it doesn't need to be perfect. (Pics on next page).





Cut wheel well liners with a utility knife level with the cut line on the bedsides. Remove and save the two bolts (10mm) holding the bedside support bracket to the tab on the bed near the frame on each side. Bolt on new bedside support brackets (long brackets with bent ends) and drill a 5/16" hole in the bedside behind the fender flare. **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 and follow the bedside cut line under the tail lights.



4. Now install new bumper. It may help to have a buddy's assistance in lifting. Lift bumper in place and slide into the two rearmost bolts you left halfway threaded in. It is helpful to place a floor jack with wood blocking under the receiver to lift and hold it in place. 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 and matches your bedside cuts. A small gap between the bumper and bedsides is normal and allows the frame to flex. You only need to tighten one bolt on each side to check your adjustment and a floor jack will help with this. Double check that the tailgate fully 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.

Reinstall the factory wire loom you removed from the original rear bumper and plug in the connectors. Reinstall backup sensors (if equipped) and splice license plate lights into the factory wiring. Zip tie wiring loom to secure it. Install trailer plug into bracket behind the bumper. It should snap into place, but if your coating is thick, you may need to 'help' the metal prongs seat into place by lifting them up. Reconnect trailer plug harness.

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.



If you purchased a tire carrier, refer to separate tire carrier instructions.

\*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.

Install is now complete. Enjoy the added protection of your new armor!

