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FRONT BUMPER INSTALLATION INSTRUCTIONS

2005-2012 Toyota Tacoma

Please read before beginning

- *Stainless steel hardware may bind together when tightening—It is recommended that you apply an anti-seize assembly lubricant to the threads of each bolt before assembly*
- *This installation requires two people*

Required tools

- Standard and metric wrench set
- Cutting tool (Shears, saw, etc)
- Drill and 3/8" drill bit
- Flathead and Philips-head screwdrivers



Included hardware

Quantity

- | | |
|--|---|
| • 400511- Winch, Fairlead Cover | 1 |
| o 70008- 1/4-20 Nylock Nuts SS | 4 |
| o 70039- 1/4 x 7/8 Fender Washer SS | 8 |
| o 70060- 1/4-20 x 1" Button Head Bolt SS | 4 |
| • 400503.4 - Keys, tool box lock set | 1 |
| • 70076 – 3/8x4 Hex Bolt | 2 |
| • 70028 – 3/8 stainless washer | 4 |
| • 70024 – 3/8 stainless nylock nut | 2 |
| • Side Trim Pieces | 2 |
| • Stainless Steel Plates | 2 |

Assembly instructions

1. First, prop the hood up
2. Remove the grill- it is held on by 2 plastic clips and 2 bolts. In order to remove the plastic clips, pry up on the edge of the center piece of the clip with a flathead screwdriver until the center piece pops up as shown in the picture below. The plastic insert can then be removed by hand



3. Un-clip the stock fog light harness
4. Remove the hardware holding the stock bumper on—there are various plastic clips similar to the ones on the grill which hold it on, carefully remove them
5. Take the stock bumper off and set aside—at this point, your truck should look like the picture below



6. The aluminum beam in the center must be removed—there are three nuts on each side holding it on as seen in the picture below; unscrew these and slide the beam off. **NOTE: Do NOT throw these nuts away, you will be re-using them for your new Aluminess bumper**



7. If you have a winch for the bumper, install it in the bumper now, you will not be able to install it once the bumper is on the truck
8. With someone assisting you, lift up the aluminess bumper and place it on the studs which previously held the bumper beam—with a winch installed, this may require 2 people
9. After the bumper is on, place the provided stainless steel plate on the two outside studs
10. Re-install the nuts removed from the studs earlier, do not tighten them down fully yet
11. Looking at the front of the truck, you will see the plastic inner fender liners hanging down as seen circled in the picture below—using a cutting tool, trim these back so they are not visible from the front

Before
trimming
fenders





12. Visually inspect the bumper to make sure it is centered and level, then tighten down the nuts
13. **MAKE SURE THE BUMPER IS POSITIONED WHERE YOU WANT IT TO BE!** Now you will need to drill two holes in the vehicle's frame. Locate the predrilled holes on your Aluminess bumper. They are located below the factory bumper mounting holes. These holes can be used as a guide to drill into the frame. Use a 3/8" drill for this procedure
14. Install the 3/8" bolts with washers and lock nuts in the newly drilled holes and then tighten
15. Install the provided fender trim pieces using the factory mounting hardware. Once installed, it should resemble the picture above
16. Re-install the grill
17. The bumper is now installed! Re-check the bolts after 100 miles of driving to make sure they are still tight