



REAR BUMPER INSTALLATION INSTRUCTIONS **TOYOTA TACOMA 05-10 (WITH STOCK HITCH)**

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*
- *Standard installation time is 3 to 4 hours*



Required tools

- Metric and standard wrench set
- Flat head screwdriver
- C-clamps
- Drill, with 3/8" drill bit

Included hardware

Quantity

• 70102 - M8-1.25 x 65mm Hex head bolt	4
• 70020 - 5/16" ID Washers	4
• 30013.1 - RB Strap Driver	1
• 30014.1 - RB Strap Passenger	1
• 70102 - M8-1.25 x 65mm Hex head bolt	4
• 70020 - 5/16" ID Washers	4
• 70060 - 1/4"-20 x 1 1/4" Button head cap screw	6
• 70009 - 1/4" ID Washers	12
• 70008 - 1/4"-20 Nuts with nylon locking inserts	6
• 400503.4 - Keys	1 set

Installation Instructions

1. To remove the stock bumper, begin by taking off the plastic covers on the bumper as described in the next few steps
2. To remove the side covers, pull up on them until the plastic clips holding them pop out as shown in Figure 1—start on the outside edge near the tail light and pull straight up from the bumper, as the clips come out, work your way inwards until they are all released; then, remove the screws in the center and take the cover off
*You will have to pull hard, but take care not to damage anything
It may be difficult to get your fingers underneath the edge of the plastic—a pry bar may help to lift the edge in order to get your fingers underneath*
The use of gloves is recommended to protect your fingers
3. To remove the center plastic trim, pry up the square plastic inserts indicated by arrows in Figure 2, then remove the plastic fasteners as shown in and described below; then remove the two bolts underneath the bumper as shown in Figure 4; now the piece should slide off
To remove the plastic fasteners, pry up on the inside with a flat head screwdriver until it pops up, then it may be removed by hand—see Figure 3

These are often difficult to remove—if you are not going to re-use the stock bumper or any of its fasteners, these may be drilled out and removed



Figure 1: Pulling up on stock plastic cover



Figure 2: Stock plastic center cover



Figure 3: Toyota plastic fasteners, showing closed (left) and open (right) positions



Figure 4: Center plastic cover retaining bolts



Figure 5: Stock plastic cover removed with mounting bolts exposed

4. Remove the two bolts indicated above in Figure 5 by the circle
5. Remove the four bolts which were covered by the center plastic piece—two large bolts in the center and two smaller bolts outside of these—**NOTE: Save the two large bolts and nuts, you will be re-using them for your Aluminess bumper**

6. Remove the license plate lights from the bumper—the easiest way to do this is to simply reach underneath and behind the bumper, grab the light, twist, and pull it out of its hole as seen in Figure 6—then remove the bulbs or unclip them from the wiring harness



Figure 6: Stock license plate light removed

7. With someone supporting the bumper so that it doesn't fall, undo any remaining bolts underneath the bumper—there should be two more bolts underneath the bumper near the trailer hitch frame
8. Remove the stock bumper by pulling it away from the vehicle—if any resistance is encountered, inspect the bumper to check for any additional fasteners or wiring
9. The rear end of the truck should now resemble Figure 7 below



Figure 7: Stock rear bumper removed



CAUTION: DO NOT LEAVE ANYTHING ON TOP OF THE BUMPER, OR LEAVE THE TOOL BOX HANDLE IN THE “UP” POSITION, AS THIS WILL DAMAGE YOUR TAIL GATE WHEN OPENED

10. Lift up your Aluminess bumper, and with someone holding it in place on the frame, insert the two large bolts into the holes in the bottom of the bumper's toolbox seen in Figure 8 below, and loosely screw on the nuts



Figure 8: Toolbox holes

11. With washers on the bolt heads, screw in the supplied M8 bolts through the four holes on top of the Aluminess bumper into the four threaded holes on top of the frame—It is helpful to have someone move the bumper to line up the holes

Note: Steps 12- 16 are for bumpers with swing arms—if your bumper does not have this option, skip to step 17

12. The swing arm support straps attach to bolt holes on the inside of the truck bed indicated by the circle in Figure 9—there are two per side; remove them, then use them to bolt the supplied strap in place
 - Do not tighten the bolts down fully yet*
 - The support straps bend slightly outwards towards the tail light; make sure to install the straps on their correct sides*
 - If the straps are not bent enough, place the side with two holes in a vice and push on the top to bend them*
13. Check to make sure the tailgate opens and closes without hitting the support strap—on some Tacoma models, the tailgate clearance is too tight for our standard support straps—we have special support straps for these models; Call or email Aluminess in order to have these sent to you; The installation instructions will be the same; Do not carry tires or cargo on the swing arms until the support straps are installed
14. Using C-clamps, rotate the support strap in position so that you are able to drill through the hole in the strap in the position indicated by the arrow in Figure 9 through the swing arm blade without hitting the brush guards
15. Remove the C-clamp and fasten the support strap to the swing arm blade using the supplied 3/8" hardware, with a washer on both sides of the bolt, and the bolt head on the inside surface of the swing arm blade, facing outwards



16. Tighten down all of the swing arm support strap fasteners, then check the tailgate clearance again
17. Check that the bumper is centered and level, then tighten down all of the bumper mounting hardware
18. Install your license plate using the supplied 1/4" hardware—you may have to drill holes to mount the plate
19. The bumper is now installed and should now resemble the one shown in Figure 10



Figure 9: Swing arm support strap



Figure 10: Installed Aluminess bumper