

# INSTALL INSTRUCTIONS FOR 05-15 TACOMA APPROACH SERIES FRONT BUMPER

**READ THROUGHOUT BEFORE INSTALLING BUMPER!**

## **DETAILS:**

- Bumper will fit 05-15 Tacomas, 03-09 4runners, and 03-09 GX470s.
- Removal/cutting of factory bumper fender and center support brackets is required.
- Cutting of wheel well liner is required.
- Currently only designed for stock body height and suspension lifted vehicles. Having a body lift will result in a gap between the bumper and body.
- Plated and hybrid wing styles are interchangeable. If you would like to purchase just the wing set to change up the look of your rig, please reach out for a custom invoice.
- The bumper is only shipped as raw steel. There may be evidence of anti-spatter spray, oils, areas with light surface rust, small amounts of weld splatter, and shallow scratches caused during manufacturing and/or shipping.
- INTENDED FOR OFF-ROAD USE ONLY.
- Winch fitment info
  - The bumper was designed using the Harbor Freight Badlands Apex 12K with synthetic line WITHOUT needing to remove and remote mount the control box. Although it is still recommended to remote mount the control box to offer more clearance for the AC lines and added room to fit a cover over the winch when not being used.
  - Other similar sized or smaller winches may fit.
  - Must have a 4.5"x10" mounting pattern.
  - Depending on winch size you might have to relocate the control box and/or clock the winch drum.
  - Will NOT work with roller fairleads. Must be used with a hawse fairlead.

## WHAT'S INCLUDED:

- BUMPER PARTS
  - 1X CENTER WINCH CRADLE WELDMENT
  - 1X CENTER ALUMINUM COVER
  - 1X LEFT WING WELDMENT (HYBRID OR PLATED)
  - 1X RIGHT WING WELDMENT (HYBRID OR PLATED)
  - HARDWARE
    - 8X M8\*16MM FLANGED BUTTON HEAD BOLTS
    - 2X M6\*14MM FLANGED BUTTON HEAD BOLTS
    - 10X M12\*35MM YELLOW ZINC GRADE 8 FLANGED HEX BOLTS
    - 10X YELLOW ZINC GRADE 8 WASHERS (1.06" OD X .53" ID)
    - 10X M12 YELLOW ZINC GRADE 8 NYLON LOCKNUTS
    - 6X M10 ZINC FLANGE NUTS
    - 2X ALUMINUM WASHER PLATE
    - 10X WASHERS (1.00 OD X .41 ID)
    - 4X M10\*110MM HEX HEAD BOLT
    - 4X M10 NYLON LOCKNUT
  - (OPTIONAL) 2X 12-15 HEADLIGHT FILLER BRACKETS
  - (OPTIONAL) 2X 05-11 TOP FILLER PLATES
  - (OPTIONAL) FILLER PLATE HARDWARE
    - 4X M6\*12MM BUTTON HEAD BOLTS
    - 4X M6 NYLON LOCKNUTS

## VEHICLE INSTALL:

\*Some pics may be from the 4G 4runner or GX470, but it is the same process for the Tacoma.

- 1) Read through entire instructions.
- 2) Ensure all parts and hardware are accounted for.
- 3) All raw steel parts should be painted/powdercoated prior to final install for rust protection.
- 4) Remove the stock bumper, fog lights, crash bar, and any bolt on brackets that held the plastic bumper cover.



- 5) Remove or cut back the bracket that sticks out near the center of the radiator. Can either trim it back or drill out the spot welds and remove it completely. If drilling out welds, be careful to not slip and damage the radiator. (Shown with it drilled out)

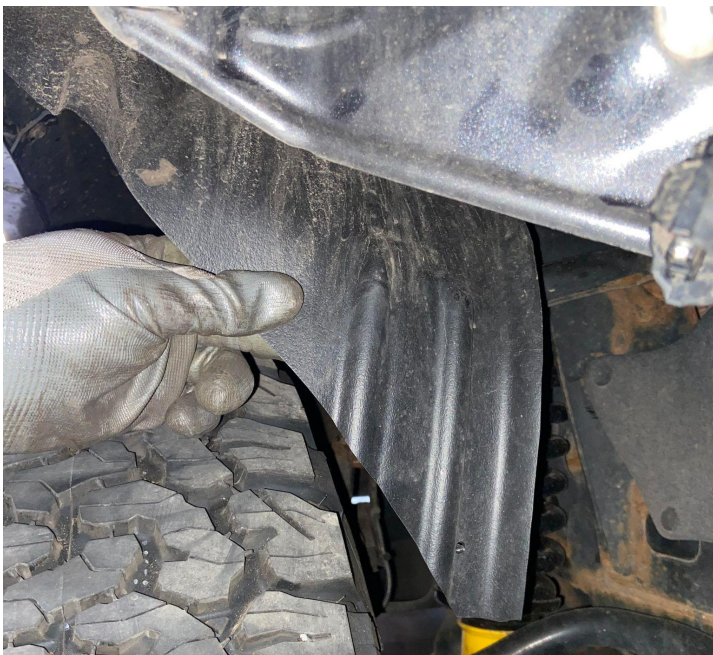


- 6) On 05-11 models, cut the stock fender support brackets under the headlights as shown. You want it to still be able to support the headlights. Deburr sharp edges.



- 7) Recommended to clean any cut or hammered areas and coat with spray paint to prevent rust from forming.

- 8) Cut wheel well liners. Using a sharpie or masking tape, mark a line going from the corner of the fender flare down to bottom of the liner that's closest to the truck frame. Ensure there are no wires directly behind your marked line. CAREFULLY cut along the line with a sharp box cutter or scissors.



- 9) On 12-15 models, remove the front lower screws from the headlights. Align brackets and reinstall the screw. Reinstall headlight fillers so the push clip fits into the larger hole on the brackets.



- 10) Install center winch cradle.

- a) Take the center winch cradle and install over the studs on the ends of the frame rails.
- b) Take the aluminum washer plates and install over the outer studs followed by the provided M10 flanged nuts. Leave somewhat loose for now.
- c) Take the 1" OD washer and install over the inner studs followed by the M10 flange nuts. Leave somewhat loose for now.



11) Install winch/recovery support bolts.

- a) Take the M10\*110mm bolts and put a 1" washer on each of them.
- b) Pass the upper bolt through the holes in the body mount bracket and into the bumper.
- c) Pass the lower bolt through the bumper and through the holes in the lower crossmember bracket.
- d) Install a washer and locknut on opposite end. Leave the nut somewhat loose for now.



12) Install side wings.

- a) (OPTIONAL) If running lights, it's highly recommended to install on the wings prior to putting the wings on the bumper.
- b) Align the wings to the sides of the winch cradle. It's helpful to either have a second set of hands or to use a clamp to hold them together.
- c) Take the flanged M12 bolts and install them through the aligned holes.
- d) Install washers and locknuts on the back sides of the bolts. Leave somewhat loose for now.
- e) If running the hybrid wings, the ends of both tubes have an internal weldnut. Install a M12 bolt into both of those. Leave somewhat loose for now.



13) Adjust the bumper.

- a) You can raise/lower the bumper on the mounting slots. Once its at your preferred height, tighten down the nuts on the mounting studs and winch support bolts.
- b) If offroading where you will experience lots of body on frame flex/movement. It is recommended to leave a 1/4" to 1/2" gap between the wings of the bumper and the underside of your fenders and headlights.
- c) There is a little adjustability in the rotation of the wing. Position them how you want and tighten down the nuts/bolts.
- d) If necessary, you can also add washers between the wings and the sides of the winch cradle to act as shims and further adjust the position of the wings.



- 14) If you are having contact between the lower fender brackets and wings or they are pretty close, put a large flathead screwdriver/prybar between them and bend in the fender brackets for extra clearance.





15) (OPTIONAL) If running a winch, it is recommended to install it at this point.

16) Install aluminum cover.

- a) Align the slots on the cover over threaded holes on the lower front of the bumper.
- b) Take the 8X M8 flanged head bolts and install them into the threaded holes and tighten down.



17) On 05-11 models, install aluminum filler plates on top of bumper in front of the grille.



18) If your state requires a front license plate, install it centered on the aluminum skid using the 2X M6 flanged head bolts. You will need to bend the plate forward to make it actually visible. Do NOT overtighten bolts!

19) (OPTIONAL) Install center lightbar.

20) Wire lights.

- a) Sorry no detailed instructions for this step as there are too many different ways to do it. But contact us if you are having trouble and we'd be happy to help or provide resources.

21) Enjoy your new bumper and send us cool pictures!