

INSTALL INSTRUCTIONS FOR 2016-23 TACOMA APPROACH SERIES FRONT BUMPER

READ THROUGHOUT BEFORE INSTALLING BUMPER!

DETAILS / DISCLAIMERS:

- Bumper was designed to fit 2016-2023 3rd generation Toyota Tacomas.
- Cutting of factory bumper, flares, and wheel well liners are required.
- Compatible with R4T bumper caps/fillers to avoid needing to cut the stock bumper.
- 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:

- The bumper was designed using the Harbor Freight Badlands Apex 12K with synthetic line. It is recommended to remote mount the control box or offset to the side to avoid cutting the grille support brackets.
- 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.

PRIOR TO INSTALL:

- READ THROUGH ENTIRE INSTRUCTIONS!
- You should have basic mechanic knowledge, correct tools, and proper protective gear.
- Ensure all parts and hardware are accounted for.
- Test fit BEFORE coating parts.
- All raw steel parts should be painted/powdercoated prior to final install for rust protection.

WHAT'S INCLUDED:

PLATED WING VERSION

- **BUMPER PARTS**
 - 1X CENTER WINCH CRADLE WELDMENT
 - 1X CENTER ALUMINUM COVER
 - 1X LEFT WING WELDMENT
 - 1X RIGHT WING WELDMENT
 - **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

HYBRID WING VERSION

- **BUMPER PARTS**
 - 1X CENTER WINCH CRADLE WELDMENT
 - 1X CENTER ALUMINUM COVER
 - 1X LEFT WING WELDMENT
 - 1X RIGHT WING WELDMENT
 - **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)
 - 6X 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

VEHICLE INSTALL:

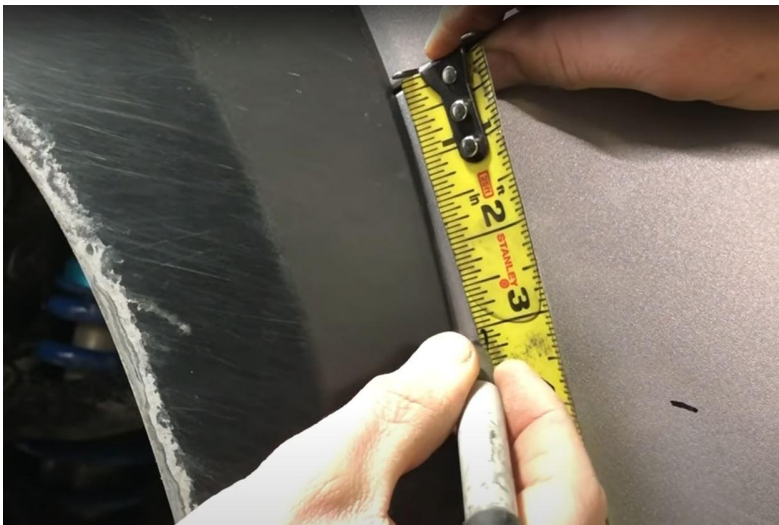
- 1) Mark and cut the stock bumper. (Skip this step if running R4T bumper caps)
 - a) If you do not run the R4T caps, you will have to cut your stock bumper cover. Ours is the same cut as the C4 fabrications bumper. You can also reference their install videos.
 - b) Mark a line on the outer surface of the bumper that is collinear with the inside top surface of the fog light pocket.



- c) Mark a line 6 inches straight down from the corner where the bumper meets the fender.



- d) Mark a line 3-1/8 inches down from the same edge and parallel to the fender flare.



- e) Using masking tape, connect the three marks.



- f) Remove the bumper from the vehicle.
- g) Using an appropriate cutting tool, cut the bumper along the edge of the tape.
- h) Deburr/sand the cut edges.
- i) Reinstall the upper cut portion of the bumper.

- 2) Remove the stock bumper (if uncut and running R4T caps), fog lights, crash bar, grille, and any bolt on brackets that held the plastic bumper cover. Leave air dams installed.

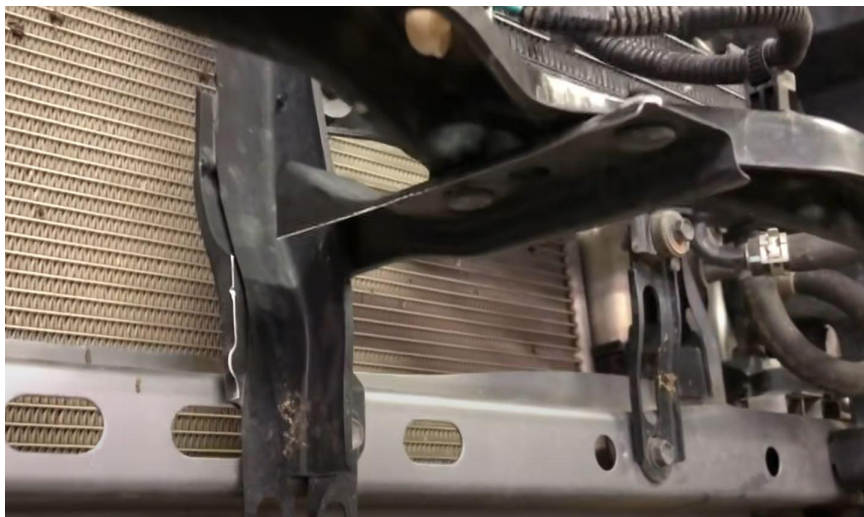




3) (OPTIONAL) Remove side crash bars from below the frame rails.



4) (OPTIONAL) If running a winch with an integrated control box that is not able to be offset to the side or remote mounted, cut out the bottom of the grille support bracket for extra clearance. Deburr and paint any cut edges.



5) (OPTIONAL) Install R4T bumper caps.

a) We designed the bumper to work with these so you don't have to cut your stock bumper.



6) Mark and cut flares.

a) Take a piece of masking tape and align it with the bottom edge of the bumper caps (or cut edge of stock bumper) and mask it over the flares.



b) Using an appropriate cutting tool, cut the flares along the edge of the tape.



c) Cut the bottom of the plastic bracket parallel to the cut edge on the end of the flares.



d) Deburr/sand the cut edges.

7) Cut wheel well liners.

- a) Using a sharpie or masking tape, mark a horizontal line going from the bottom corner of the fender flare down to going inwards towards the engine.
- b) Ensure there are no wires directly behind your marked line.
- c) CAREFULLY cut along the line with a sharp box cutter or scissors.



- 8) 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.



9) Install side wings.

- a) 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.
- b) Take the flanged M12 bolts and install them through the aligned holes.
- c) Install washers and locknuts on the back sides of the bolts. Leave somewhat loose for now.
- d) If running the hybrid wings, the ends of both tubes have an internal weldnut. Install a M12 bolt with washer into both of those. Leave somewhat loose for now.

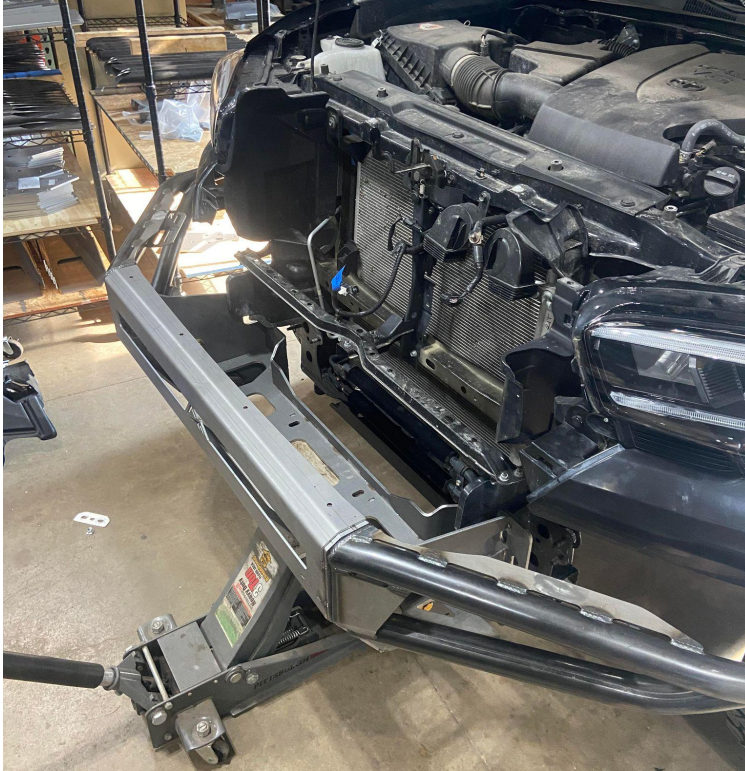


10) Adjust wings.

- a) There is a little adjustability in the rotation of the wing. Position them to be parallel to the bottom edge of the cut bumper or R4T caps, or however you want.
- b) 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.
- c) Once aligned, tighten down the nuts/bolts.



11) Remove the bumper from the vehicle.



12) (OPTIONAL) If running a winch, it is recommended to install it in the bumper at this point.

13) (OPTIONAL) If running lights, it is recommended to install them in the bumper at this point.

14) Reinstall the grille.

15) Reinstall the bumper.

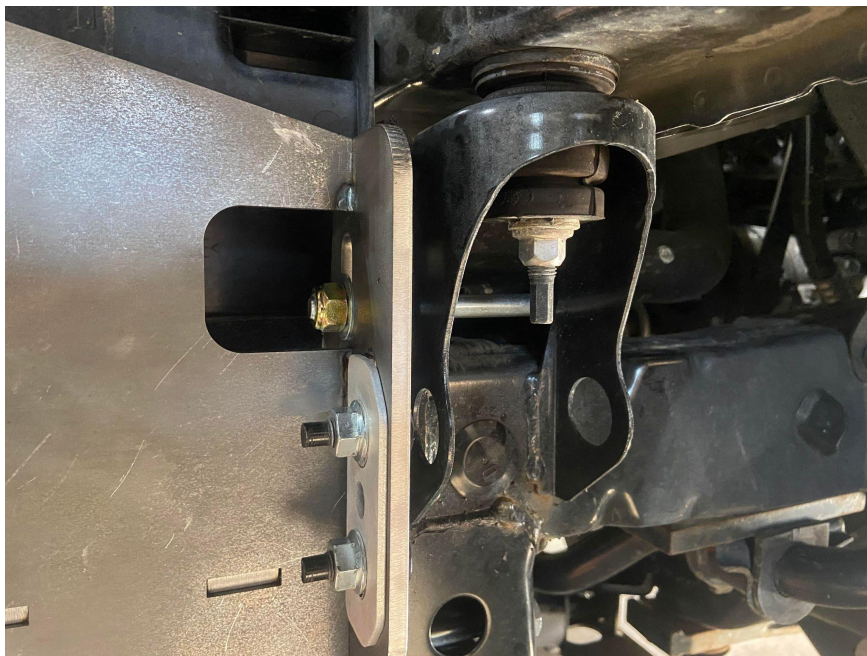
a) Reinstall the washer plates with M10 flange nuts. Leave somewhat loose for now.

b) Take the 1" OD washer and install over the inner studs followed by the M10 flange nuts. Leave somewhat loose for now.



16) 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 holes in the lower crossmember bracket and into the bumper.
- d) Install a washer and locknut on opposite end. Leave the nut somewhat loose for now.



17) Adjust bumper height.

- a) You can raise/lower the bumper on the mounting slots. Once it's at your preferred height and symmetrical from side to side, 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 outer wings of the bumper and the underside of your fenders.



18) 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
- c) Once all bolts are partially threaded in their holes, tighten them all down.



19) 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!

20) Wire lights and/or winch.

- 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!