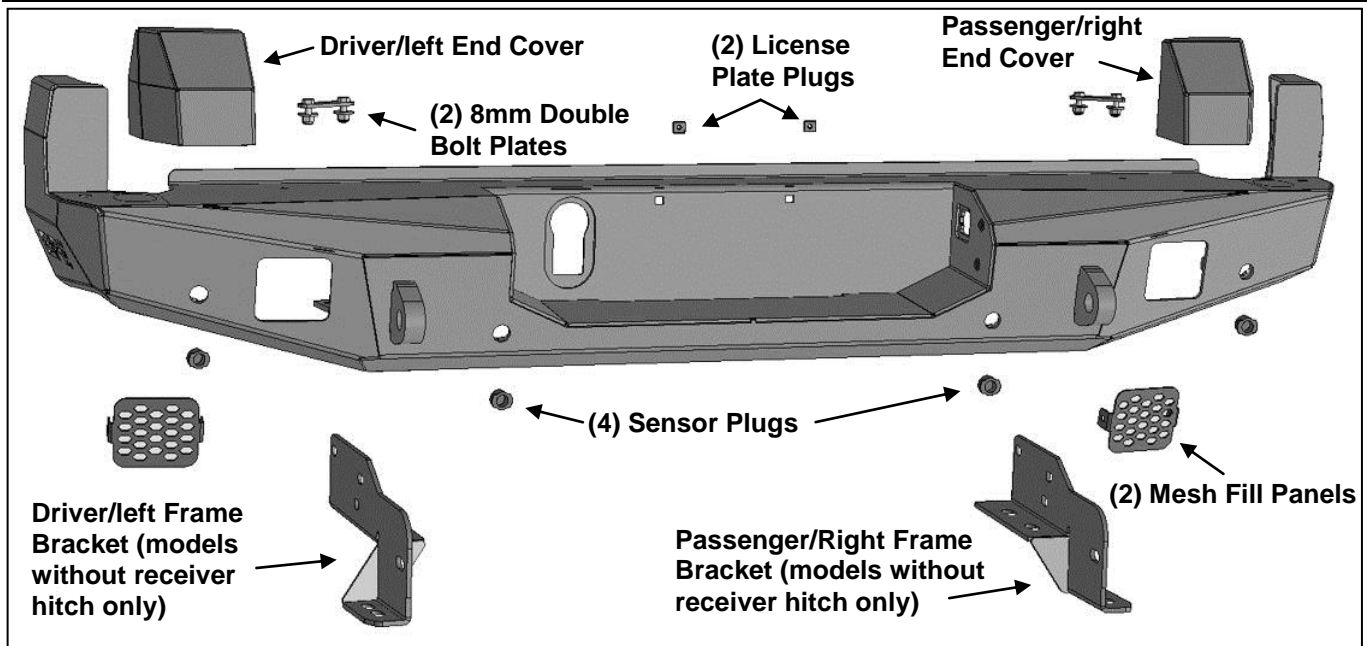


16-23 TOYOTA TACOMA PRO SERIES II REAR BUMPER PART #TC-2966

PARTS LIST:

1	Pro Rear Bumper Assembly Only	4	12mm x 24mm x 2.5mm STD Flat Washers
1	Driver/Left End Cover	4	12mm Lock Washers
1	Passenger/Right End Cover	6	12mm Nylon Lock Nuts
1	Driver/Left Mounting Bracket	2	8mm Double Bolt Plates
1	Passenger/Right Mounting Bracket	4	8mm x 24mm x 2mm Flat Washers
2	Mesh Fill Panels	4	8mm Nylon Lock Nuts
2	License Plate Plugs	4	6-1.0mm x 20mm Button Head Bolts
4	Sensor Plugs	4	6mm Flange Nuts
1	Sensor Cover Kit	8	4mm x 10mm Button Head Bolts
4	12-1.25mm x 45mm Fine Thread Hex Bolts	10	Wire Ties
6	12-1.75mm x 40mm Hex Bolts	1	4mm Hex Wrench
12	12mm x 32mm x 3mm Large Flat Washers	1	2.5mm Hex Wrench



PROCEDURE:

REMOVE CONTENTS FROM BOX. VERIFY ALL PARTS ARE PRESENT. READ INSTRUCTIONS CAREFULLY BEFORE STARTING INSTALLATION. BUMPER IS DESIGNED TO INSTALL WITH FACTORY RECEIVER HITCH, AFTERMARKET RECEIVER HITCH MAY INTERFERE WITH INSTALLATION. BUMPER IS HEAVY, ASSISTANCE IS RECOMMENDED TO AVOID POSSIBLE INJURY OR DAMAGE TO THE VEHICLE.

1. Locate BSM (Blind Spot Monitor) button underneath the radio display to turn off and RCTA (Rear Cross Traffic Alert) Systems, (if equipped). Next, unplug the wire harnesses from the (2) monitor sensors located on the sides of the Rear Bumper. **IMPORTANT:** The BSM and RCTA systems will not work with Bumper installation, monitor sensors cannot be reinstalled.
2. Unplug the wiring harness leading to the bumper, (**Figure 1**). Move all harnesses away from bumper.
3. Determine if vehicle is equipped with factory receiver hitch

Models without receiver hitch:

- a. Place blocks or jack stands under the bumper to support it during mounting bolt removal. Once the bumper has been safely supported, remove the factory hex bolts, (3 per side), attaching the bumper brackets to the sides of the frame. **(Figure 2)**. **IMPORTANT**: Assistance is highly recommended to hold bumper in position during bolt removal.
- b. Slide the bumper assembly with brackets off of the vehicle.
- c. Select the driver/left Frame Bracket. Reuse the (3) factory hex bolts to attach the Mounting Bracket to the side of the frame, **(Figure 3)**. Attach the bottom of the Mounting Bracket to the bottom of the frame with **(2) 12mm x 45mm Special Fine Thread Hex Bolts**, (2) 12mm Lock Washers and (2) 12mm x 32mm Large Flat Washers, **(Figure 3)**. Repeat this **Step** to attach the passenger/right Frame Mounting Bracket.

Models with factory receiver hitch:

- a. Remove the factory hex bolts attaching the bumper to the bottom of the hitch, **(Figure 4)**.
 - b. Remove the plastic cover from the top of the bumper, **(Figure 5)**. **NOTE**: Cover is attached at top, back and bottom by plastic clips. Use a flat blade screwdriver to release each clip.
 - c. Place blocks or jack stands under the bumper to support it during mounting bolt removal. Once the bumper has been safely supported, remove the factory hex bolts attaching the bumper to the top of the receiver hitch and remove the bumper, **(Figures 5 & 6)**. **NOTE**: Leave receiver hitch attached to vehicle.
4. Unplug and remove wiring harness from factory bumper, **(Figure 7)**. Release the clips and remove the license plate lights and trailer plug, (if equipped). Snap license plate lights and trailer plug into Pro Bumper. Install wiring harness into back of Pro Bumper and plug into lights and trailer plug if equipped.
 5. **Optional Light installation at ends of bumper** (light sold separately).
 - a. Follow the light manufacturer's instructions to attach each light to slot in the opening, **(Figure 8)**.
 - b. Repeat the previous **Step** for remaining light installation.
 - c. Follow light manufacturer's instructions for adjustment and to properly wire the light to the vehicle electrical system after Bumper installation.

For Flush mount Cube Lights

- a. Place the light onto the square hole and line up the light to the hole. Mark the holes on the side of the light.
 - b. Drill the marked locations and attach the Cube Lights.
 - c. Repeat the previous **Steps** for remaining light installation.
 - d. Follow light manufacturer's instructions for adjustment and to properly wire the light to the vehicle electrical system after Bumper installation.
6. Determine if vehicle is equipped with parking sensors. **NOTE**: It may be necessary or easier to install sensors before installing Bumper, if equipped.

Models without bumper sensors:

- a. Select (4) Rubber Plugs. From behind bumper, push Plugs into sensor mounts, **(Figure 9)**.
- b. Secure Plugs to the mounts with (2) 4mm x 10mm Button Head Screws, **(Figure 9)**.

Models with bumper mounted back-up sensors:

- a. Remove driver/left outer sensor from the back of the factory bumper, **(Figure 10)**.
 - b. Remove the plastic sleeve from the sensor, **(Figure 10)**. Insert the sleeve into the front of the sensor mount in the Bumper, **(Figure 12)**.
 - c. Push the sensor into the back of the Sensor Mount and into the sleeve. Secure Sensor to mount with (2) 4mm Button Head Screws, **(Figure 11—13)**. **IMPORTANT**: Sensors fit snug in mounts. The 4mm Screws are used to apply slight pressure to lock the sensors in place. Tighten both screws evenly until they touch the sensor body only. Do not overtighten screws or damage to sensors will result.
 - d. Repeat previous **Steps** to install the remaining (3) sensors.
 - e. Plug wiring harness into sensors.
7. Use the included Wire Ties to secure the factory wiring harness to the Bumper as necessary.

8. Next, select the driver/left Bumper End Cover, **(Figure 14)**. Attach the Cover to the top of the Bumper with the included 8mm Double Bolt Plate, (2) 8mm Flat Washers and (2) 8mm Nylon Lock Nuts. Line up Cover with Bumper and fully tighten hardware, **(Figure 15)**. Repeat this **Step** to attach the passenger/right Cover.
9. Select the correct installation for your model.
Models without factory receiver hitch only:
 - a. With assistance, hold the Bumper assembly up to the Mounting Brackets. Temporarily support the weight of the Bumper. **WARNING:** To avoid possible injury or damage to the vehicle, do not proceed until the bumper is fully and safely supported.
 - b. Select (1) 12mm x 40mm Hex Bolt and (1) 12mm x 32mm Large Flat Washer, **(Figure 16)**. Insert the Hex Bolt through the driver/left mounting plate on the back of the Bumper and through the side of the Bumper Bracket. Secure the Bumper to the Hex Bolt with (1) 12mm x 32mm Large Flat Washer and (1) 12mm Nylon Lock Nut. **(Figure 16)**. Snug but do not fully tighten hardware. Repeat this **Step** to attach the passenger/right side of the Bumper to the side of the Bumper Bracket.
 - c. Attach driver/left side of the Bumper to the bottom tab on the Bumper Bracket with the included (2) 12mm x 40mm Hex Bolts, (2) 12mm x 24mm STD Flat Washers (top), (2) 12mm x 32mm Large Flat Washers (bottom) and (2) 12mm Nylon Lock Nuts. **(Figure 17)**. Do not tighten hardware. Repeat this **Step** to attach the passenger/right side of the Bumper.
- Models with factory receiver hitch:**
 - a. With assistance, hold the Bumper assembly up to the receiver hitch. Temporarily support the weight of the Bumper. **WARNING:** To avoid possible injury or damage to the vehicle, do not proceed until the bumper is fully and safely supported.
 - b. Select (1) 12mm x 40mm Hex Bolt and (1) 12mm x 32mm Large Flat Washer. **(Figure 18)**. Insert the Hex Bolt through the driver/left mounting plate on the back of the Bumper and through the side of the hitch. Secure the Bumper to the Hex Bolt with (1) 12mm x 32mm Large Flat Washer and (1) 12mm Nylon Lock Nut. **(Figure 18 & 19)**. Snug but do not fully tighten hardware. Repeat this **Step** to attach the passenger/right side of the Bumper.
 - c. Attach driver/left side of the Bumper to the bottom tab on the hitch with the included (2) 12mm x 40mm Hex Bolts, (2) 12mm x 24mm STD Flat Washers (top), (2) 12mm x 32mm Large Flat Washers (bottom) and (2) 12mm Nylon Lock Nuts. **(Figures 18 & 19)**. Do not tighten hardware at this time. Repeat this **Step** to attach the passenger/right side of the Bumper to the receiver hitch.
10. Slowly open tailgate and check for clearance. Level and adjust the Bumper and tighten all hardware.
11. Plug bumper wiring harness into main vehicle harness.
12. Push the included (2) Plastic Plugs into the square holes in the Bumper for the license plate, **(Figure 20)**. Reuse the factory screws to attach the license plate to the (2) Plastic Plugs.
13. Do periodic inspections to the installation to make sure that all hardware is secure and tight.

To protect your investment, Do not use any type of polish or wax that may contain abrasives that could damage the finish. Mild soap may be used to clean the Bumper assembly.

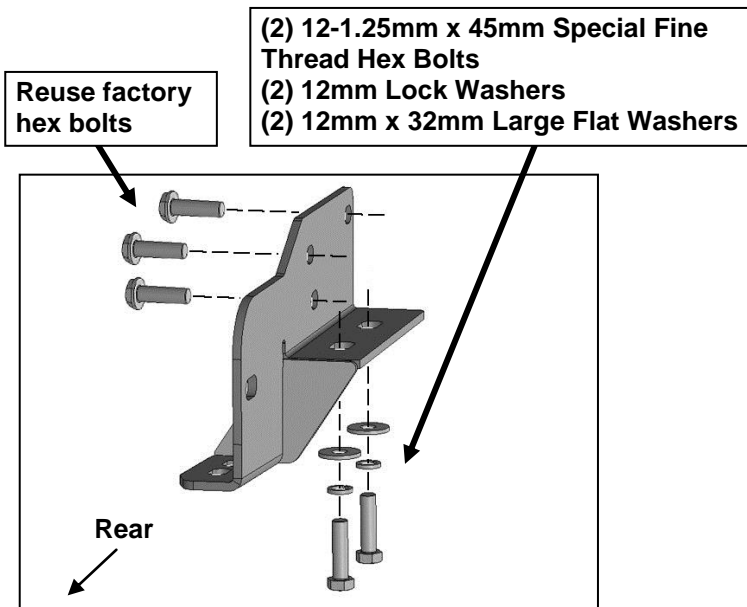
Driver/Left Side Installation Pictured



(Fig 1) Unplug all wiring harnesses leading to the rear bumper

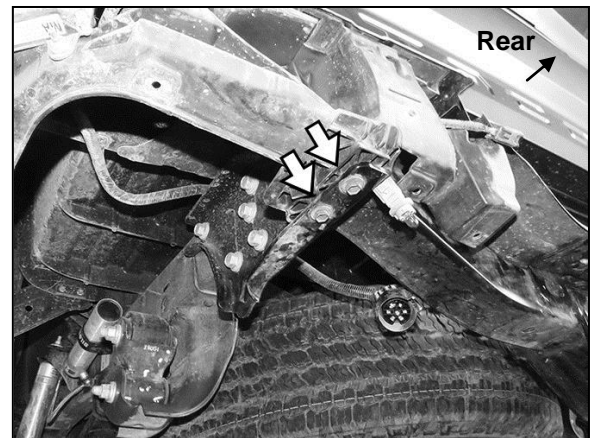


(Fig 2) Models without factory receiver hitch: Remove factory hex bolts attaching bracket to side of frame (driver/left side pictured)



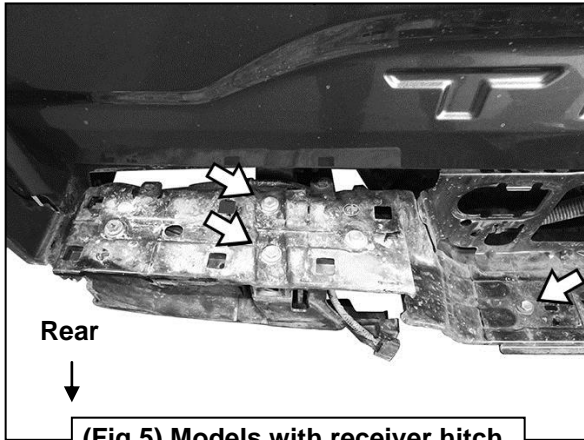
(Fig 3) Models without factory receiver hitch: Reuse (3) factory hex bolts to attach Bumper Bracket to side of frame (driver/left illustrated). Attach the bottom of the Mounting Bracket to the bottom of the frame

WARNING! Do not remove bumper bolts unless the bumper is properly supported on blocks or stands or it may fall.



(Fig 4) Models with receiver hitch, remove the hex bolts attaching bumper to bottom of hitch (arrows)

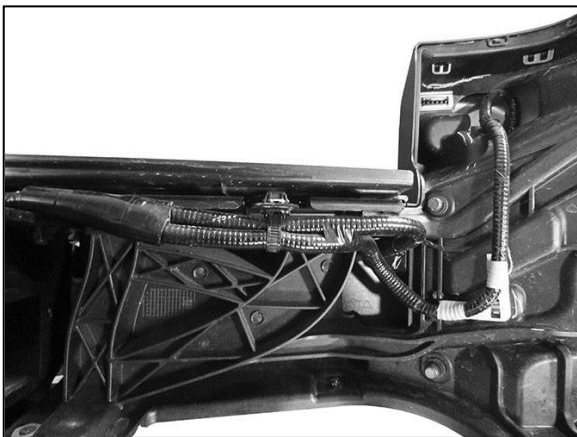
Driver/Left Side Installation Pictured



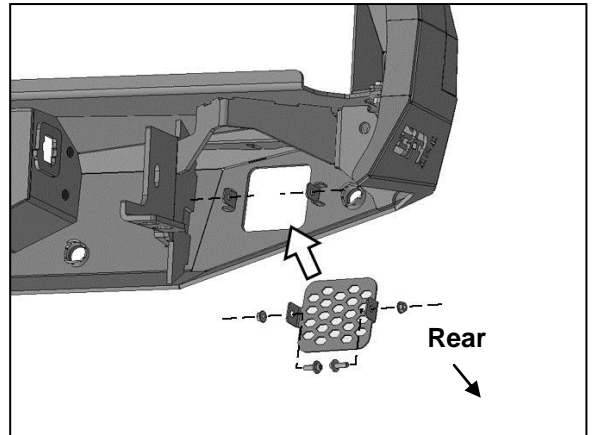
(Fig 5) Models with receiver hitch, remove plastic cover from top of bumper. Remove the hex bolts attaching bumper to top of hitch



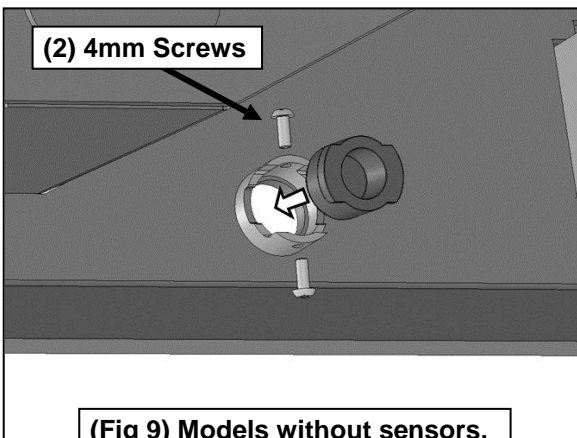
(Fig 6) Models with receiver hitch



(Fig 7) Unplug and remove wiring harness from factory bumper. Remove license plate lights and towing plug (if equipped) and install in Pro Bumper

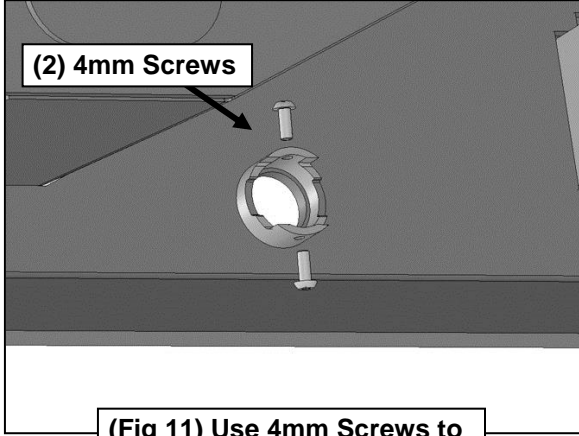


(Fig 8) Driver/left light mounting location (light not included).
For Flush mount Cube Lights (not shown), place the light onto the square hole and line up the light to the hole. Mark the holes on the side of the light. Drill the marked locations and attach the Cube Lights

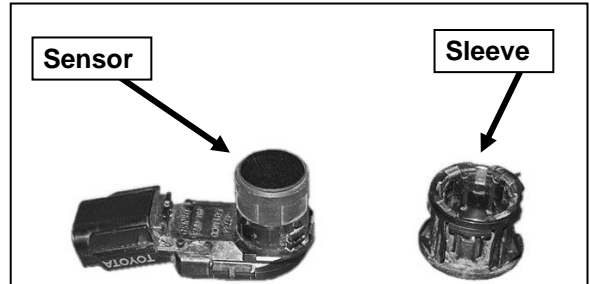


(Fig 9) Models without sensors, push Sensor Plugs into mounts

Driver/Left Side Installation Pictured



(Fig 11) Use 4mm Screws to lock sensor in place (Fig 13)



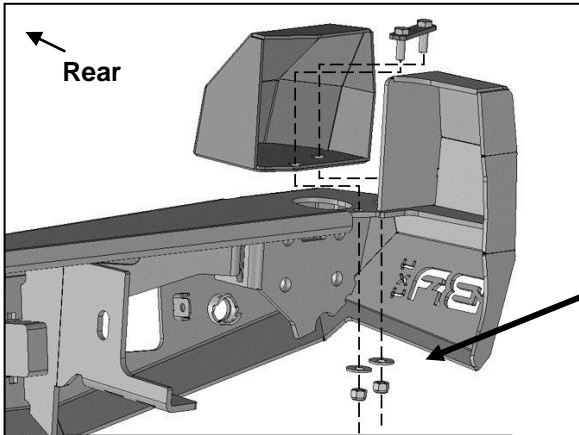
(Fig 10) Models with sensors, remove sensor from sleeve. Push sleeve into mount from outside of Bumper (Fig 12). Push sensor into mount and sleeve from back of Bumper (Fig 13).



(Fig 12) Push sleeve into sensor mount in Bumper first, then from the back, snap sensor into sleeve (Fig 13)



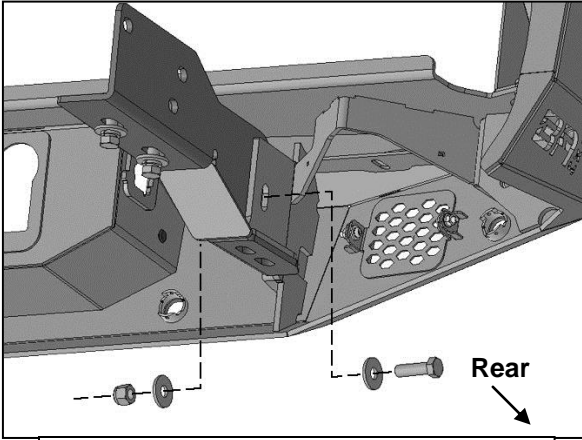
(Fig 13) Use 4mm Screws to lock sensor in place, if necessary, (Fig 11). Plug wiring harness into sensors



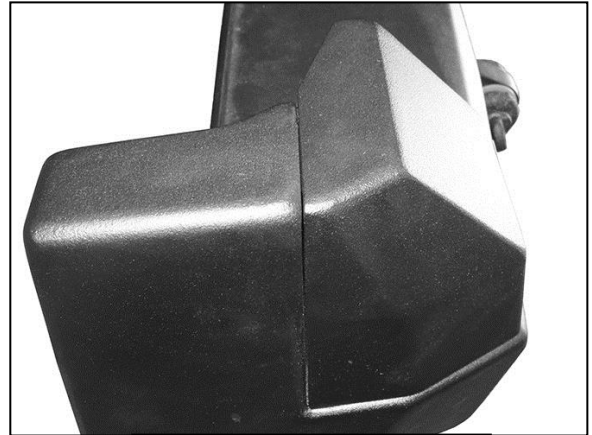
(Fig 14) Attach driver/left Bumper End Cover to top of Bumper

- 8mm Double Bolt Plate
- (2) 8mm Flat Washers
- (2) 8mm Nylon Lock Nuts

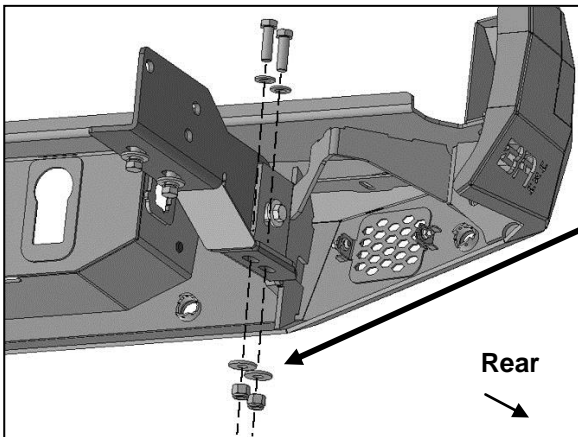
Driver/Left Side Installation Pictured



(Fig 16) Model without factory receiver hitch: Attach Bumper to side of Brackets. (driver/left side illustrated)

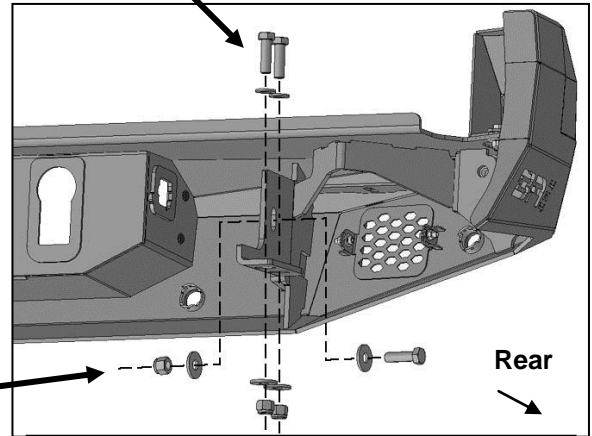


(Fig 15) Driver/left Bumper End Cover installed



(Fig 17) Model without factory receiver hitch: Attach Bumper to inside of Bracket (Driver/Left illustrated)

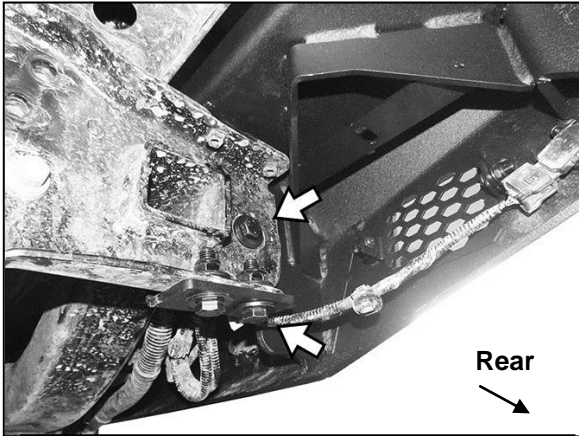
- (2) 12mm x 40mm Coarse Thread Hex Bolts
- (2) 12mm x 24mm Small Flat Washers (top)
- (2) 12mm x 32mm Large Flat Washers (bottom)
- (2) 12mm Nylon Lock Nuts



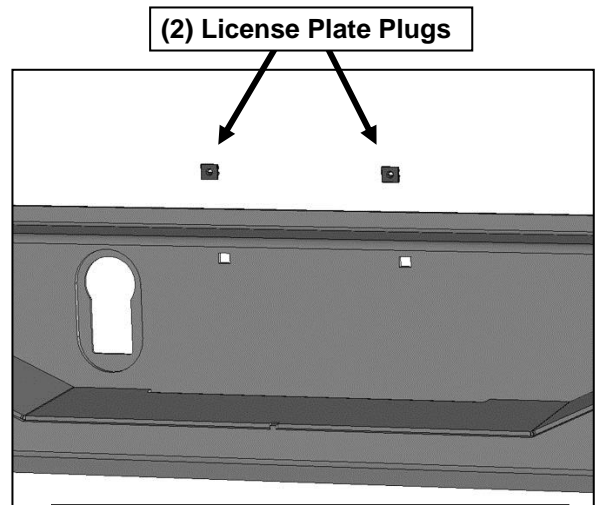
(Fig 18) Model with factory receiver hitch: Attach Bumper to factory hitch

- 12mm x 40mm Coarse Thread Hex Bolt
- (2) 12mm x 32mm Large Flat Washers
- 12mm Nylon Lock Nut

Driver/Left Side Installation Pictured



(Fig 19) Model with factory receiver hitch:
Attach Bumper to side and bottom of
hitch (driver/left side pictured)



(Fig 20) Push Plastic Plugs into square
holes in Bumper for license plate