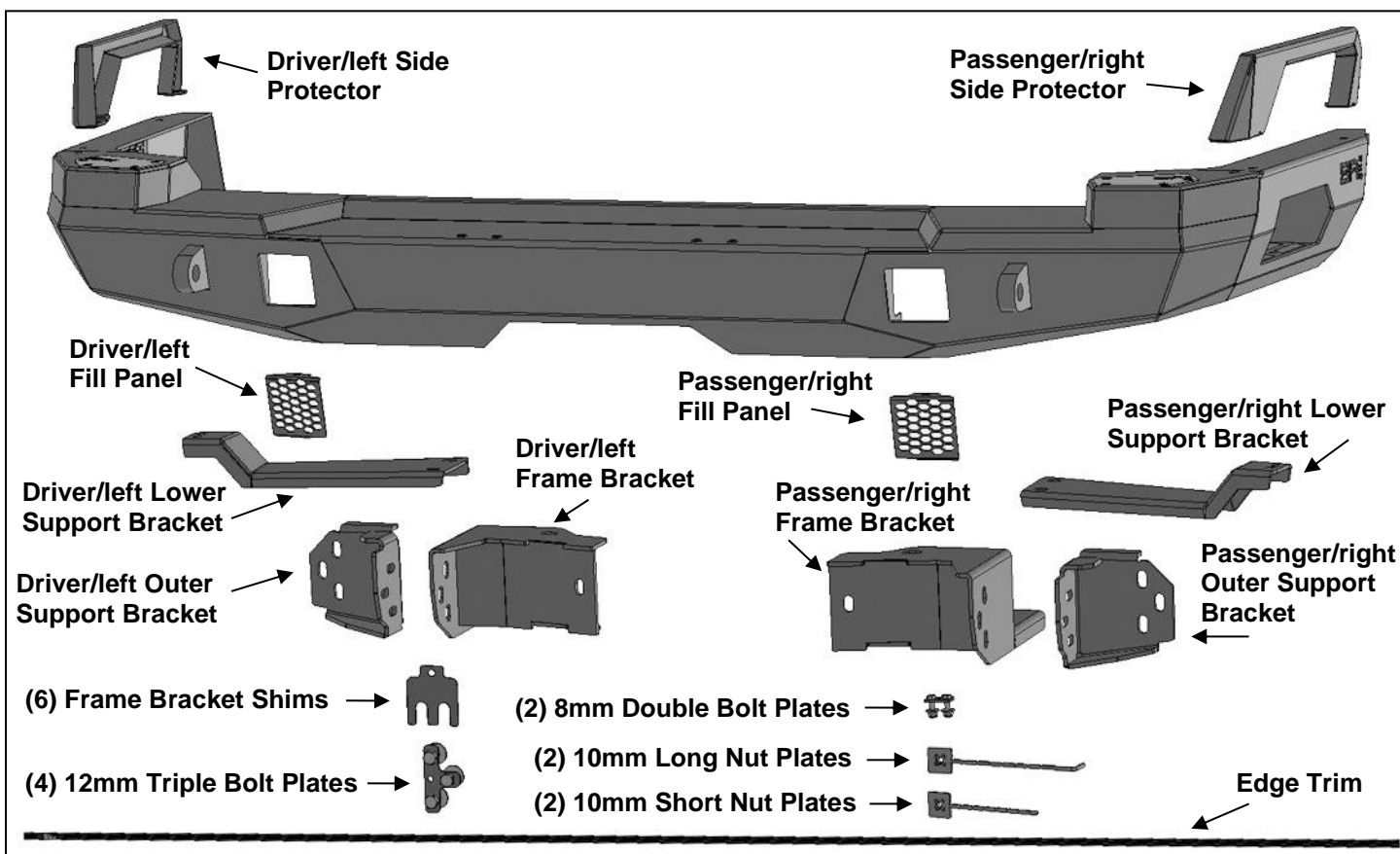


10-24 TOYOTA 4RUNNER PRO SERIES II REAR BUMPER PART #TR-2965

PARTS LIST:

1	Rear Bumper Assembly	2	10mm Nut Plates (Long Handle)
1	Driver/left Side Protector	2	10mm Nut Plates (short Handle)
1	Passenger/right Side Protector	4	10-1.5mm x 45mm Hex Bolts
1	Driver/left Frame Mounting Bracket	4	10mm x 30mm x 2.5mm Flat Washers
1	Passenger/right Frame Mounting Bracket	4	10mm Lock Washers
1	Driver/left Outer Support Bracket	2	8mm x 30mm Double Bolt Plates
1	Passenger/right Outer Support Bracket	4	8-1.25mm x 25mm Hex Bolts
1	Driver/left Bottom Support Bracket	6	8-1.25mm x 25mm Button Head Bolts
1	Passenger/right Bottom Support Bracket	8	8mm x 22mm x 2mm STD Flat Washers
1	Driver/left Outer Mesh Fill Panel	12	8mm x 16mm x 1.6mm Small Flat Washers
1	Passenger/right Outer Mesh Fill Panel	4	8mm Lock Washers
6	2mm Frame Bracket Shims	10	8-1.25mm Nylon Lock Nuts
4	12mm x 40mm Triple Bolt Plates	4	6mm x 20mm Button Head Combo Bolts
4	12-1.25mm x 55mm Hex Bolts	4	6-1.0mm Flange Nuts
16	12mm x 32mm x 3mm Flat Washers	1	5mm Wrench
16	12mm Lock Washers	1	4mm Wrench
12	12mm Hex Nuts	1	3048mm Edge Trim





INSTALLATION INSTRUCTIONS

PROCEDURE:

REMOVE CONTENTS FROM BOX. VERIFY ALL PARTS ARE PRESENT. READ INSTRUCTIONS CAREFULLY BEFORE STARTING INSTALLATION. BUMPER IS HEAVY, ASSISTANCE IS RECOMMENDED TO AVOID POSSIBLE INJURY OR DAMAGE TO THE VEHICLE. CUTTING IS REQUIRED. IMPORTANT: EXCLUDES MODELS WITH BLIND SPOT MONITORING AND LIMITED MODELS WITH REAR PARKING ASSIST OPTIONS.

1. Start installation at the driver/left rear wheel opening. Remove the hardware attaching the cover to the rear bumper, **(Figure 1)**. Next, from below the vehicle, remove the bolts attaching the cover to the inner body panel and remove the cover, **(Figures 2—4)**.
2. Next, measure 7-1/2" (188mm) down from the joint between the side of the body and the bumper cover, **(Figure 5)**. Use masking tape to protect the finish on the bumper. Draw a straight line on the tape parallel to the joint from the tire opening back to the rear of the vehicle, **(Figure 6)**. At the corner, follow the base of the body where it meets the protruding molded corner bumper, **(Figures 7—9)**.
3. Repeat **Steps 1 & 2** to remove the wheel opening cover, measure and lay the guide lines on the passenger/right side of the bumper cover.
4. Open the rear tail gate. Locate the plastic cover on the top of the bumper cover, **(Figure 7)**. Using the masking tape, create a guide 1/2" in front of the bottom of the raised ridge separating the inner and outer sections of the top cover, **(Figure 7)**. Connect the side guide lines to the rear guideline, **(Figures 8 & 9)**. **NOTE:** All cutting guidelines are meant to leave approximately 1/4" or more of extra material. Cut sections will require additional trimming for a proper fit.
5. Cut plastic rear bumper cover along guidelines, **(Figures 10—13)**. Remove clips/hardware along bottom of bumper cover and with assistance, remove cut section of bumper cover, **(Figures 14 & 15)**.
6. From below the vehicle, remove the tow hooks from the bottom of the frame, **(Figure 16)**.
7. Select the driver/left Frame Mounting Bracket, **(Figure 17)**. Place the Bracket over the end of the frame. Select (1) 10mm Long Handle Nut Plate. Insert the Nut Plate into the hole in the frame. Line up the Nut Plate with the hole in the top of the Bracket and the frame, **(Figure 18)**. **NOTE:** Bend handle on Nut Plate to properly line up the Nut Plate with the inside of the frame. Attach the Bracket to the Nut Plate with (1) 10mm x 45mm Hex Bolt, (1) 10mm Lock Washer and (1) 10mm Flat Washer, **(Figure 19)**. Leave hardware loose.
8. Select (1) 10mm Short Handle Nut Plate, **(Figure 17)**. Insert the Nut Plate into the hole in the frame. Line up the Nut Plate with the hole in the rear facing side of the Bracket and the frame, **(Figure 20)**. Attach the Bracket to the Nut Plate with (1) 10mm x 45mm Hex Bolt, (1) 10mm Lock Washer and (1) 10mm Flat Washer, **(Figure 21)**. Leave hardware loose at this time.
9. Attach the front mount on the Frame Bracket to the bottom of the frame with the included (2) 12mm x 55mm Hex Bolts, (2) 12mm Lock Washers and (2) 12mm Flat Washers, **(Figure 22)**. Slide (3) Bracket Shims between the bottom of the frame and Bracket. Leave hardware loose, **(Figure 23)**. **NOTE:** Shims are used to level and adjust the Bumper to the vehicle.
10. Select the outer Support Bracket, **(Figure 24)**. Attach the Support Bracket to the Frame Bracket with (1) 12mm Triple Bolt Plate, (3) 12mm Flat Washers, (3) 12mm Lock Washers and (3) 12mm Hex Nuts, **(Figure 25)**. Snug but do not fully tighten hardware at this time.
11. Repeat **Steps 7—10** to install the passenger/right Frame and Outer Support Brackets.
12. Carefully unwrap the Bumper. Attach the driver/left Side Protector to the top of the Bumper with the included (3) 8mm x 25mm Button Head Bolts, (6) 8mm x 16mm Small Flat Washers and (3) 8mm Nylon Lock Nuts, **(Figure 26)**. Fully tighten hardware. Repeat this **Step** to attach the passenger/right Side Body Protector.
13. Determine if accessory lights, (not included), or Screen Fill Panels will be installed at this time.
IMPORTANT: It may be easier to install Fill Panels or lights before installing Bumper.
Outer Screen Fill Panel Installation (do not install fill panels if installing lights).
 - a. Select the driver/left Fill Panel, **(Figure 27)**.

b. Attach Fill Panel to the mounting holes in the back of the Bumper with the included (2) 6mm Button Head Combo Bolts and (2) 6mm Flange Nuts, **(Figure 27)**. Fully tighten Fill Panel hardware at this time.

c. Repeat previous **Steps** to install the passenger/right Fill Panel.

Outer LED cube style light installation (light not included).

a. Attach lights to mounting tabs on back of the Bumper, **(Figure 27)**.

14. With assistance, position the Bumper up to the bumper brackets on the ends of the frame. Temporarily support the weight of the Bumper Assembly. **WARNING:** To avoid possible injury or damage to the vehicle, do not proceed until the Bumper is fully and safely supported. Cut/trim any of the plastic bumper cover interfering with Bumper installation.

15. Line up the (3) mounting holes in the back of the driver/left side of the Bumper with the Outer Support Bracket. Insert (1) 12mm Triple Bolt Plate up and through the Bumper first then the Support Bracket, **(Figure 28)**. Secure the Bumper to the Triple Bolt Plate with the included (3) 12mm Flat Washers, (3) 12mm Lock Washers and (3) 12mm Hex Nuts, **(Figure 29)**. Snug but do not fully tighten hardware at this time. Repeat this **Step** to attach the passenger/right side of the Bumper to the Support Bracket. Leave hardware loose at this time.

16. Select the driver/left Bottom Support Bracket, **(Figure 30)**. Hold the Support Bracket up to the bottom of the tab on the inside of the Bumper. Insert (1) 8mm Double Bolt Plate down through the Bracket and tab. Secure the Support Bracket to the Bolt Plate with the included (2) 8mm x 22mm STD Flat Washers and (2) 8mm Nylon Lock Nuts, **(Figure 30)**. Attach the inner end of the Support Bracket to the threaded holes in the bottom of the frame with the included (2) 8mm x 25mm Hex Bolts, (2) 8mm Lock Washers and (2) 8mm x 22mm STD Flat Washers, **(Figure 31)**. Repeat this **Step** to attach the passenger/right Bottom Support Bracket.

17. Level and adjust the Bumper, (add or remove Spacers on Frame Brackets), and fully tighten all hardware attaching Frame Brackets to frame only. **IMPORTANT:** Cut/trim any of the plastic bumper cover interfering with Bumper installation. Temporarily remove the Bumper assembly, **(Figure 32)**.

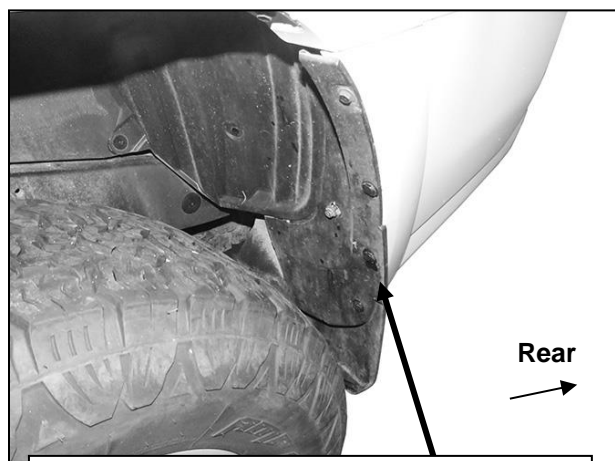
18. Clean up the cut edge of the plastic bumper cover. Attach the included Edge Trim to the cut edge of the bumper cover, **(Figure 32)**. Cut Edge Trim to fit.

19. Reinstall Bumper assembly and fully tighten all hardware, **(Figure 33)**.

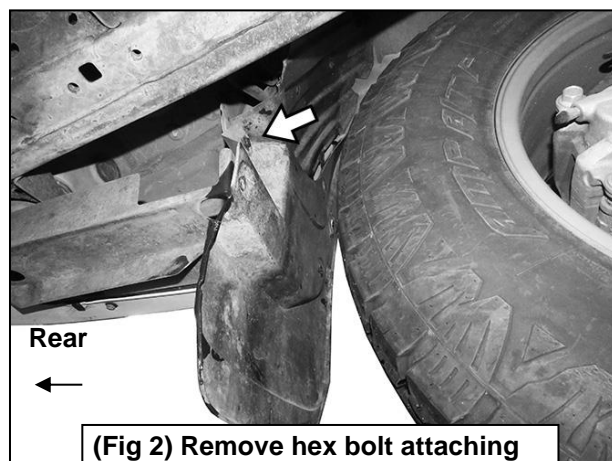
20. Do periodic inspections to the installation to make sure that all hardware is secure and tight.

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

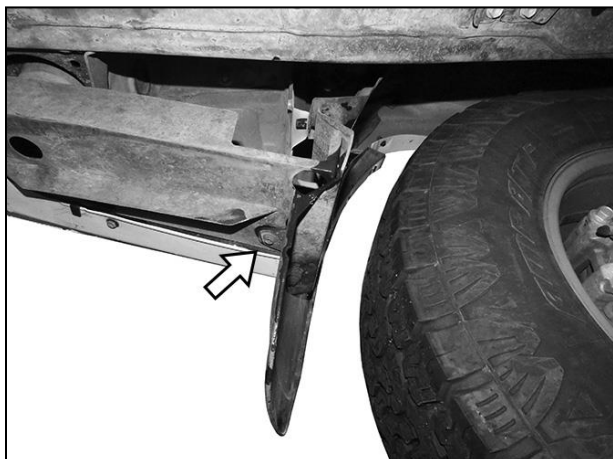


(Fig 1) Remove hardware attaching plastic wheel well cover to outer bumper cover



(Fig 2) Remove hex bolt attaching plastic mud flap to body (arrow-driver/left side pictured from below)

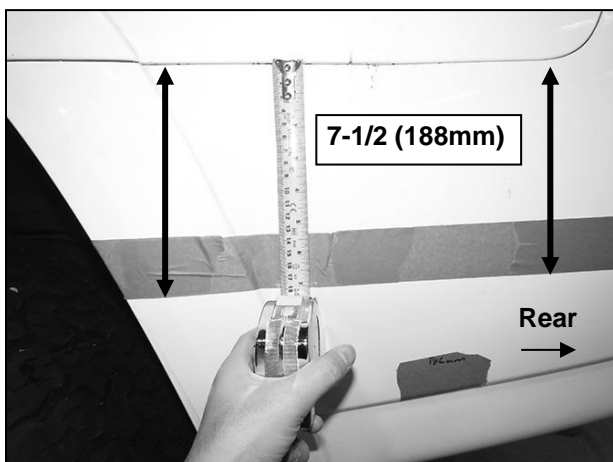
Driver/left Side Installation Pictured



(Fig 3) Remove hex bolt attaching back of plastic mud flap to bottom of body, (arrow-driver/left side pictured from below)



(Fig 4) Plastic cover and mud flap removed

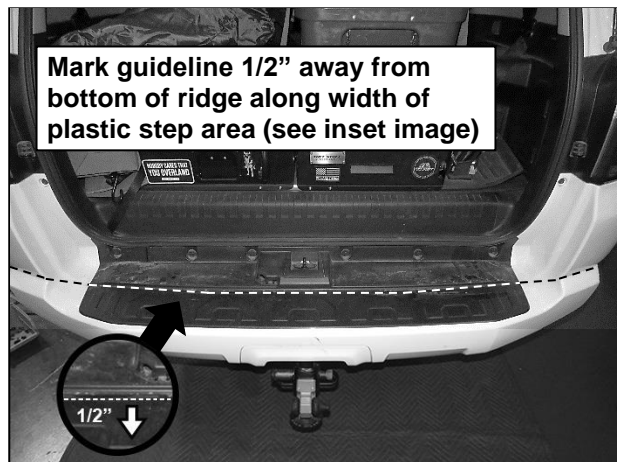


(Fig 5) Use masking tape for a guideline. Draw a line 7-1/8" down from the joint, parallel to the joint line between bumper and body (driver/left end of bumper pictured)



(Fig 6) Open rear tail gate

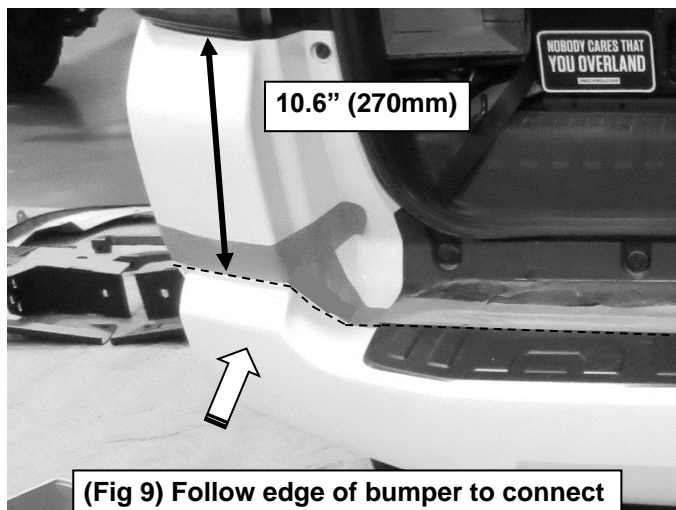
Driver/left Side Installation Pictured



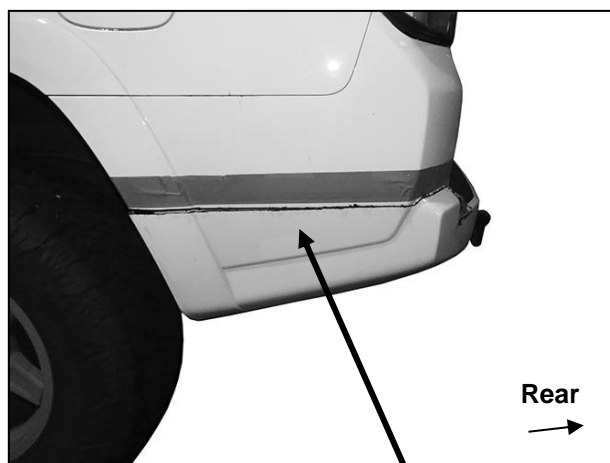
(Fig 7) Use masking tape for a guideline along dashed lines



(Fig 8) Use masking tape for a guideline along dashed lines



(Fig 9) Follow edge of bumper to connect rear and side guidelines (arrow)



(Fig 10) Cut along guidelines (driver/left end of bumper cover pictured)



(Fig 11) Cut along guidelines (driver/left corner of bumper cover pictured)

Driver/left Side Installation Pictured



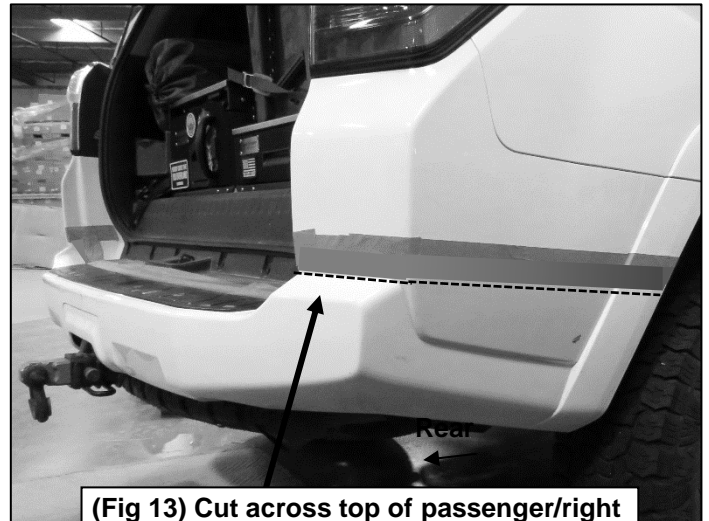
(Fig 12) Cut along guidelines (driver/left corner of bumper cover pictured)



(Fig 14) Remove clips/hardware attaching bottom of bumper cover (driver/left pictured)



(Fig 16) Remove both tow hooks attached to bottom of frame (arrow-driver/left side pictured)



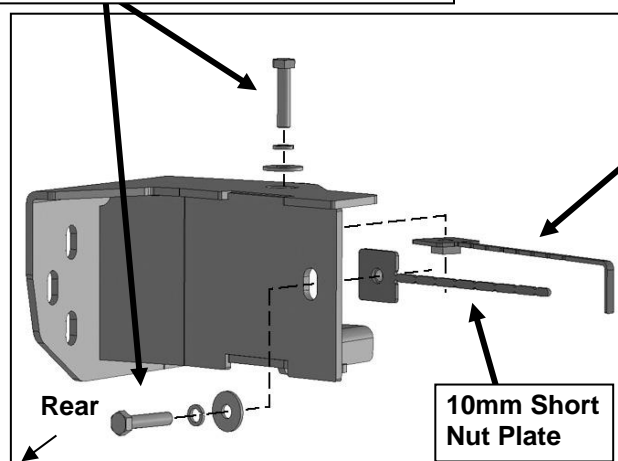
(Fig 13) Cut across top of passenger/right side of bumper cover along guidelines to passenger/right end of bumper cover



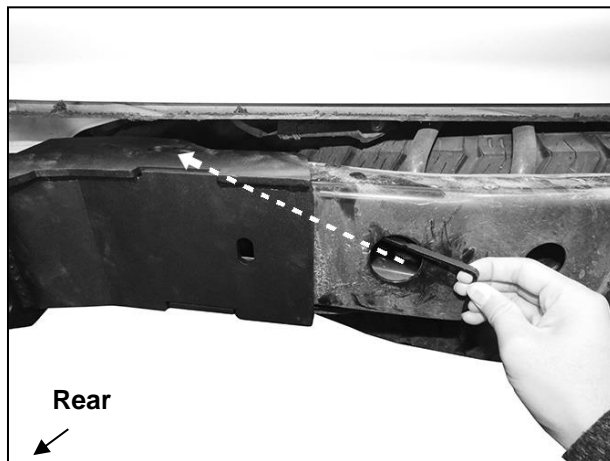
(Fig 15) Remove cut off lower section of bumper cover and white foam pad

Driver/left Side Installation Pictured

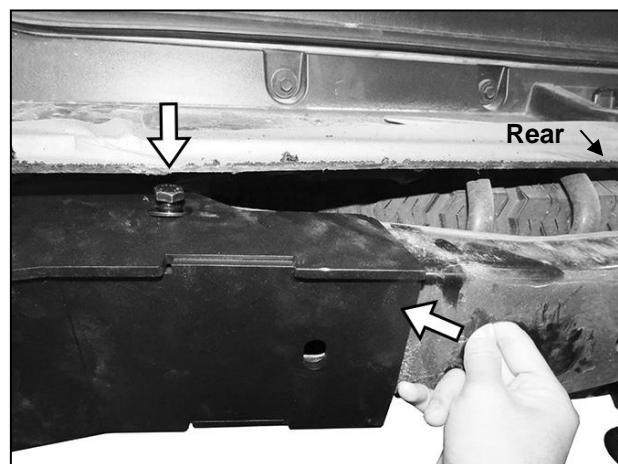
- (2) 10mm x 45mm Hex Bolts
- (2) 10mm Lock Washers
- (2) 10mm Flat Washers



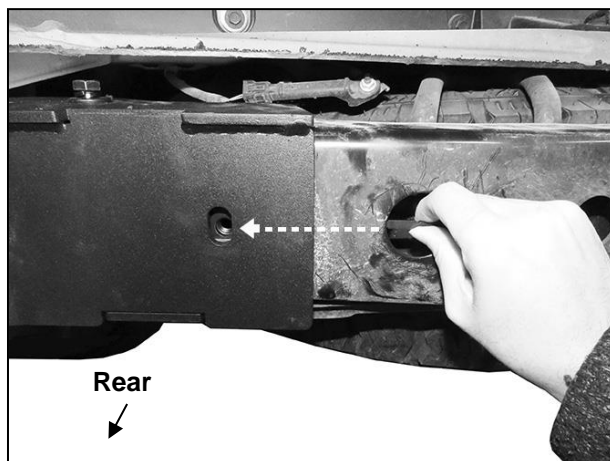
(Fig 17) Insert 10mm Nut Plates into frame. Line up Nut Plates with driver/left Frame Bracket



(Fig 18) Insert 10mm Long Nut Plate into hole in frame. Line up Nut Plate with top hole in frame and driver/left Frame Bracket

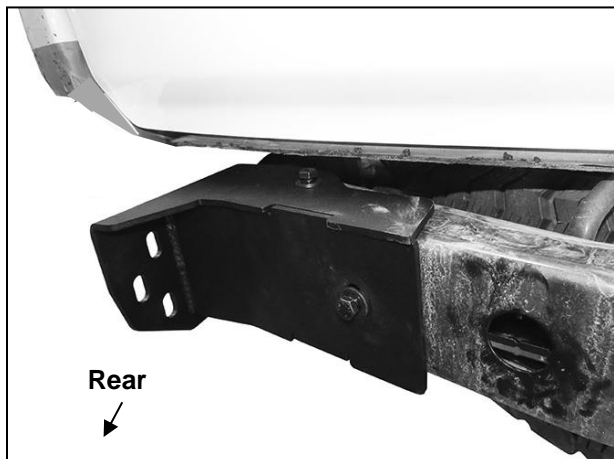


(Fig 19) Insert 10mm x 45mm Hex Bolt, 10mm Lock Washer and 10mm Flat Washer through Bracket and into Long Nut Plate.
NOTE: Bend handle on Nut Plate as needed to line up with mounting hole



(Fig 20) Insert 10mm Short Nut Plate into hole in frame. Line up Nut Plate with rear facing mounting hole in frame and Frame Bracket. Insert 10mm x 45mm Hex Bolt, 10mm Lock Washer and 10mm Flat Washer through Bracket and into Short Nut Plate, (see Fig 20).

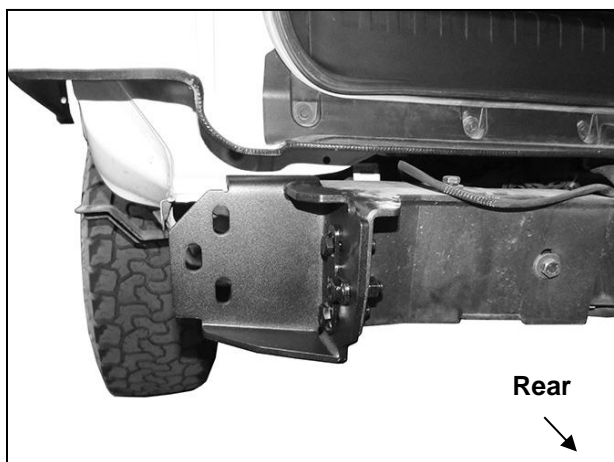
Driver/left Side Installation Pictured



(Fig 21) Driver/left Frame Bracket installed

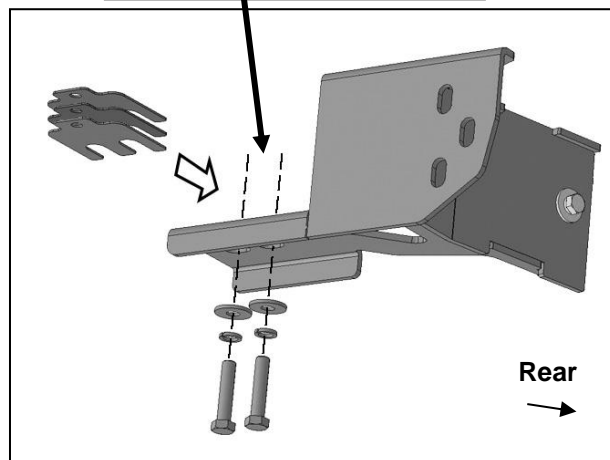


(Fig 23) Insert Shims between frame and Bracket as needed to level/align Bumper to vehicle (see Step 16)



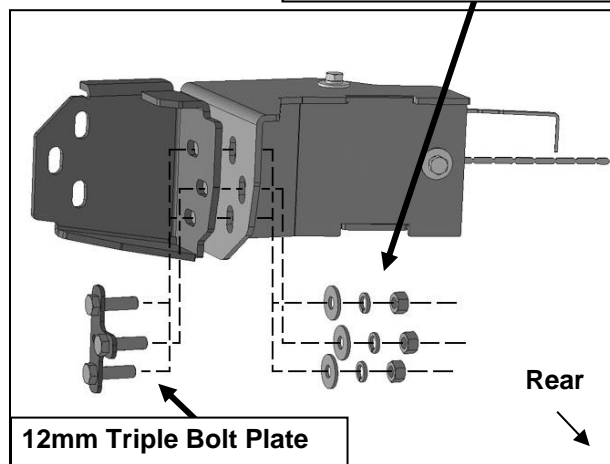
(Fig 25) Driver/left Outer Support Bracket attached to Frame Bracket

- (2) 12mm x 55mm Hex Bolts
- (2) 12mm Flat Washers
- (2) 12mm Lock Washers



(Fig 22) Attach driver/left Frame Bracket to threaded holes in bottom of frame. Insert Shims between frame and Bracket as needed to level/align Bumper to vehicle (see Step 16)

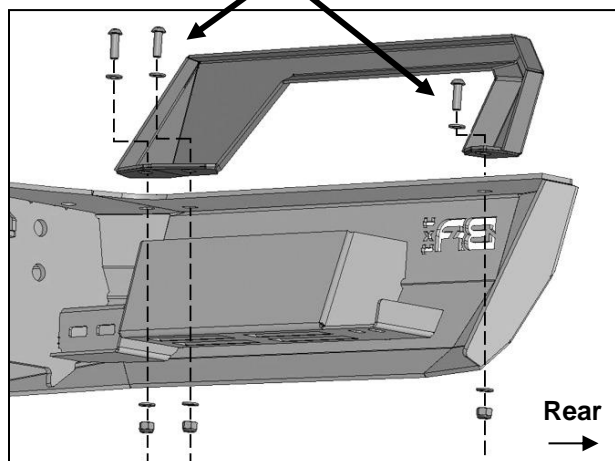
- (3) 12mm Flat Washers
- (3) 12mm Lock Washers
- (3) 12mm Hex Nuts



(Fig 24) Attach driver/left Outer Support Bracket to Frame Bracket

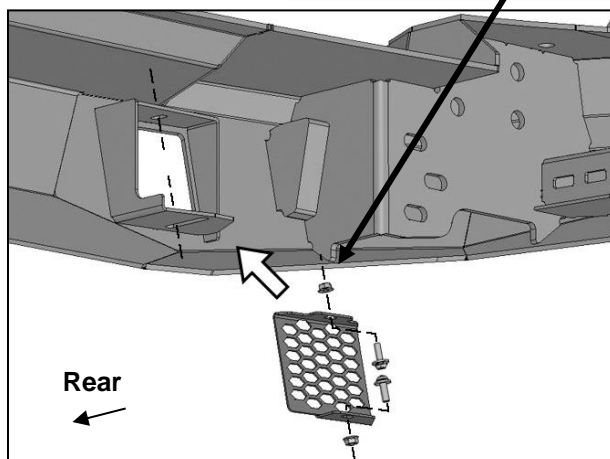
Driver/left Side Installation Pictured

- (3) 8mm x 25mm Button Head Bolts
- (6) 8mm x 16mm Small Flat Washers
- (3) 8mm Nylon Lock Nuts



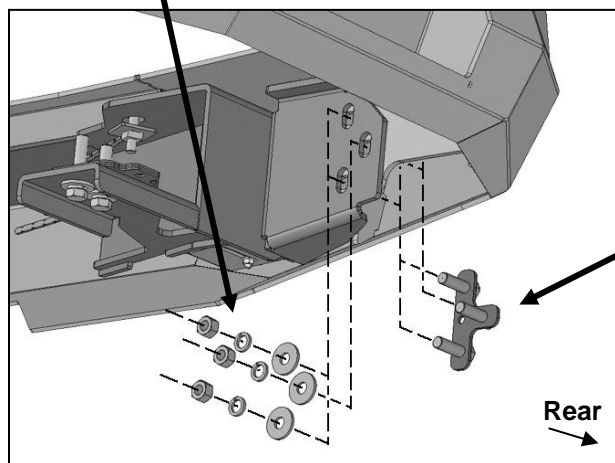
(Fig 26) Attach driver/left Side Protector to top of Bumper

- (2) 6mm x 20mm Button Head Combo Bolts
- (2) 6mm Flange Nuts



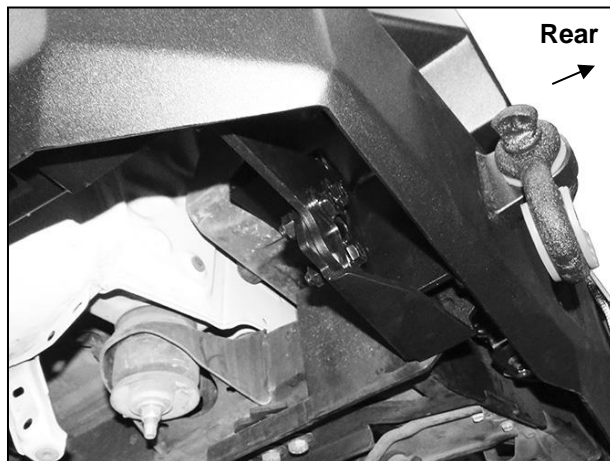
(Fig 27) Attach driver/left Mesh Fill Panel or LED cube light to opening in Bumper. Do not install Fill Panels with lights

- (3) 12mm Flat Washers
- (3) 12mm Lock Washers
- (3) 12mm Hex Nuts



(Fig 28) Attach driver/left of Bumper to Outer Support Bracket

12mm Triple Bolt Plate

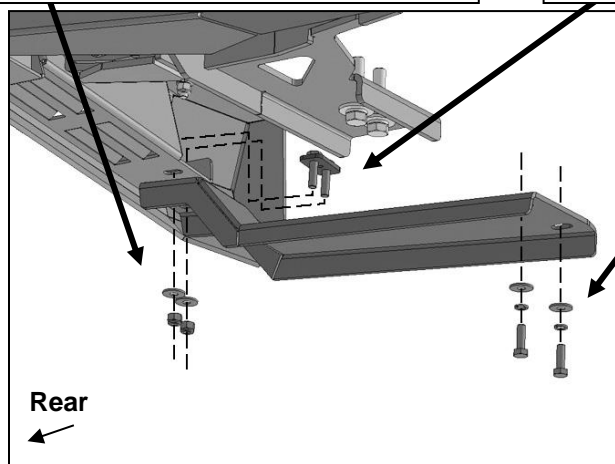


(Fig 29) Driver/left side of Bumper attached to Outer Support Bracket

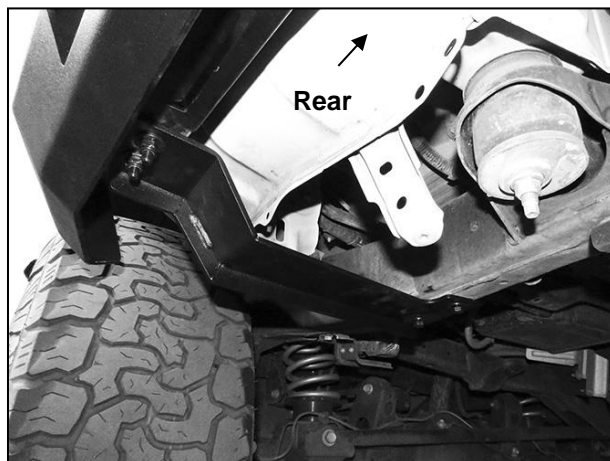
Driver/left Side Installation Pictured

(2) 8mm x 22mm STD Flat Washers
(2) 8mm Nylon Lock Nuts

8mm Double Bolt Plate



(2) 8mm x 25mm Hex Bolts
(2) 8mm Lock Washers
(2) 8mm x 22mm STD Flat Washers



(Fig 30) Attach driver/left Lower Support Bracket to tab on back of Bumper and threaded holes in bottom of frame

(Fig 31) Driver/left Lower Support Bracket attached to tab on back of Bumper and threaded holes in bottom of frame



(Fig 32) Trim plastic bumper cover as necessary to clear Bumper. Once all adjustments have been made to cover and Bumper, temporarily remove Bumper. Clean up edge of plastic cover. Apply Edge Trim to cut edge of bumper cover. Cut Edge Trim as needed and reinstall Bumper assembly



(Fig 33) Reinstall Bumper assembly