

2010 to 2013 Toyota 4runner Rear bumper installation instructions:

***Note: This is one of the most difficult bumpers we product to install. The installation of this bumper requires cutting of the current plastic bumper cover and reinstallation of the upper portion. Additional trimming of the mud flaps and relocation of accessories is required.***

***Step 1:*** Carefully unwrap the pallet being careful not to scratch the powder coat. Please make sure that all pieces arrived in good condition.

***Step 2:*** It is much easier to assemble the accessory arms while the new bumper is off of the truck. The installation is identical on both swing arms.

- Included with each arm is the following.
- (1) 7/8" Hinge Bolt.
- (1) 7/8" fender washer.
- (1) 7/8" Nylock Nut
- (2) Nylon washers
- (1) Spring Pin
- (1) Rubber bumper

To install the arm into the bumper you must slide it into the opening from the side. Once the arm is in place, insert the Hinge bolt from the top of the bumper using the provided fender washer. The (2) nylon washers sit stacked between the bottom of the swing arm and the bumper. Install the lock nut and tighten to 120 ft lbs.

The rubber bumper slides over the pin in the bumper and the lock pin inserts into the pin to lock the swing arm in place.

Note: We do not provide lug nuts due to varying wheel types. Lug nuts must be provided by the customer.

***Step 3:*** Disassembly: The rear bumper cover and mud flaps must be completely removed from the vehicle. There are several clips and screws that hold it in place. Remove and set aside.



Once the Bumper cover is removed: Remove the hitch (saving the bolts) and the brackets on the under side of the frame. Remove the bracket that holds the trailer wiring but leave it hanging.



Next: Cut off the overhang (about 3") of the foam backer on each side



**Step 4:** Clearance. On each side of the fender there is a bracket that hangs down to attach the factory bumper cover to. Simply bend this bracket up toward the inside of the truck.



**Step 5:** Bumper installation

This typically takes about 3 guys to perform.

- Leave the rear hatch open to prevent damage during installation.
- Remove the diamond plate cover from the new bumper. This will get installed last.
- Holding the bumper in place: start by installing the center bolts loosely. For these we recommend reusing the hitch bolts.
- Adjust the bumper left to right for alignment.
- Using the supplied 12mm bolts, install the lower bolts into the bottom of the frame.
- **NOTE:** *Due to the nature and design of the frame, this bumper is very difficult to get straight on the vehicle. It will take some time to adjust the bumper correctly. If needed use some of the supplied fender washers in between the lower mount and the frame to adjust the pitch of the bumper. Also the bumper is able to twist from side to side. The best method to positioning the bumper is to tighten the bolts slowly. Final tightening should be done once the bumper is positioned to your satisfaction.*

- Once the bumper is positioned, install the diamond plate top and the plastic swing arm rest

### **Step 6:** The Fun Part

***Once the bumper is in its final position it is time to cut and install the top portion of the plastic bumper. Please take your time and measure twice!!***

- ***NOTE: We strongly recommend using masking tape over the plastic bumper for marking and cutting***
- Using the truck and the bumper as a guide, measure at several points between the bumper and the body line (where the plastic bumper attaches) Transfer those measurements to the bumper cover.
- The center of the bumper cover will be cut 1" out from the raised lip. We recommend using 1" masking tape to mark this cut line. Transfer this line up the side to meet with the cut lines on the side of the bumper cover.
- Verify that the measurements on each side are identical...or at least very close.
- Now to mark your actual cut line. The actual cut will be exactly **3/8" above** the marked line. The gap is necessary to allow body flex
- We recommend using a jigsaw or body saw with a fine tooth blade to make the cuts.
- In the corners where the cut lines meet. Drill a 1/2" or larger hole to help with the cut transition. This will greatly improve the final quality.
- We do not include any trim piece as we have found it to become more of an issue because of the shape of the bumper cover. Therefore a strait and clean cut is necessary. Take your time!
- Once the cut is made, loosely install the bumper cover to verify fit. If trimming is needed remove and trim as necessary.
- Lightly sand the cut edges to remove any burrs.
- Do not remove masking tape until the final fit is satisfactory.
- Do Not reattach all the hardware on the bumper cover yet.

### **Step 7:** Finishing touches

At this point the installation is about complete.

- Trim the mud flaps to fit and reinstall. This can be done with a utility knife.
- Install the trailer wiring bracket under the inside of the frame. There is a threaded hole in the frame that a single original mounting bolt will fit. Picture below shows final position.



- Wiring the license plate light: The license plate light is a single wire hot lead. On the inside of the of the passenger side there is an access panel to get to the tail lights. Run the wire up into this compartment. We have fount that running in through the weather stripping is the best access. Its is a pain to get the wire into the compartment!!
- Once the wire is in. Pull the light plug and find the green wire. The single hot lead from the license plate light will get spliced into this wire.
- Make sure to tape up the wire and test the light before reinstalling the light into the housing.
- Now you can attach all the hardware for the plastic bumper cover.
- Install the license plate and you should be done.



Final Installation should look like this: (note: License plate location has been moved due to placement issues)



