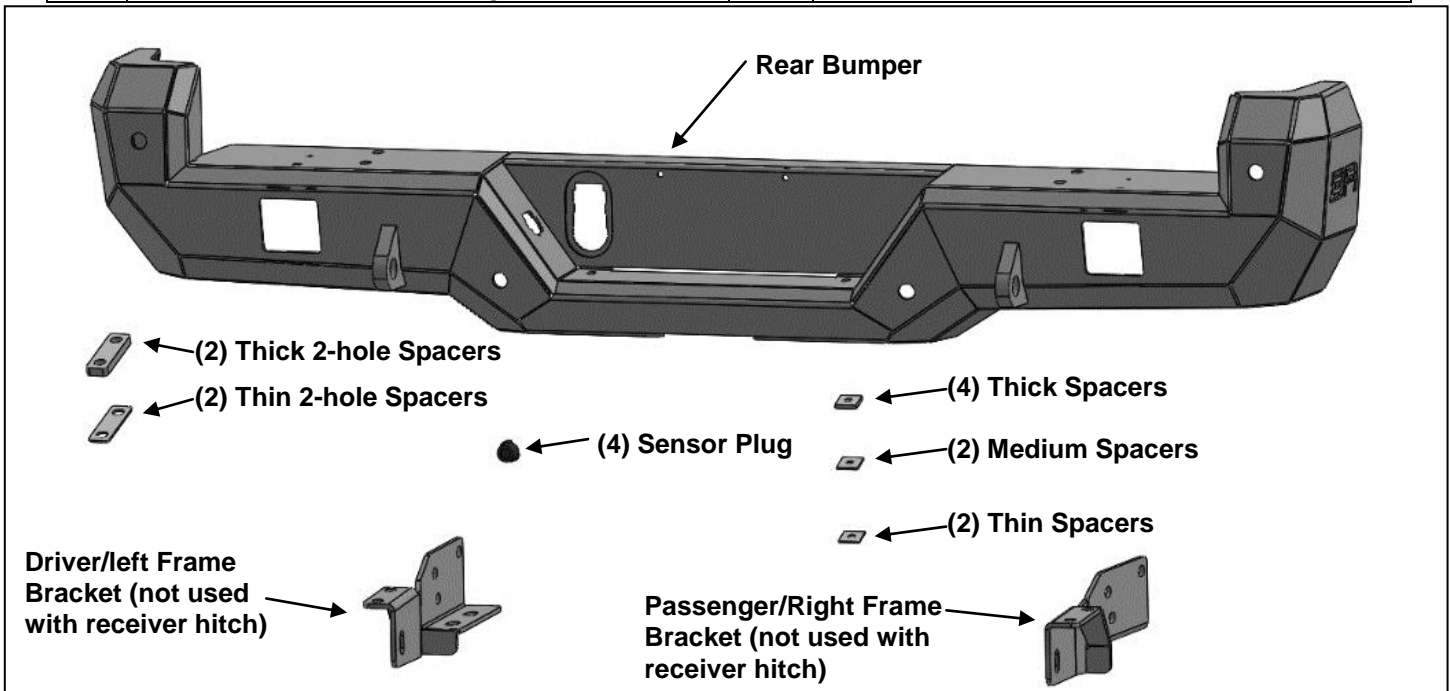


## 2016-2023 TOYOTA TACOMA PRO SERIES REAR BUMPER PART #TC-2963

### PARTS LIST:

1	Rear Bumper Assembly	2	12mm Lock Plates
1	Driver/Left Mounting Bracket	6	12mm x 37mm OD x 3mm Flat Washers
1	Passenger/Right Mounting Bracket	6	12mm Lock Washers
2	100mm x 30mm x 12mm 2-hole Spacers	2	12mm Hex Nuts
2	100mm x 30mm x 3mm 2-hole Spacers	6	8mm x 40mm Button Head Bolts
4	30mm x 30mm x 6mm Square Spacers	10	8mm x 24mm OD x 2mm Flat Washers
2	30mm x 30mm x 3mm Square Spacers	6	10mm Lock Washers
2	30mm x 30mm x 2mm Square Spacers	4	8mm Hex Nuts
2	License Plate Plugs	8	4mm x 10mm Button Head Bolts
1	Sensor Cover Kit	10	Wire Ties
4	Sensor Plugs	1	5mm Hex Wrench
4	12-1.25mm x 45mm Fine Thread Hex Bolts	1	2.5mm Hex Wrench
2	12-1.75mm x 45mm Carriage Bolts		



### 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 Fine Thread Hex Bolts**, (2) 12mm Lock Washers and (2) 12mm Flat Washers, **(Figure 3)**. Repeat this Step to attach the Passenger/Right Frame Mounting Bracket.

#### Models with factory receiver hitch:

- a. Remove the plastic cover from the top of the bumper, **(Figure 4)**. **NOTE:** Cover is attached at top, back and bottom by several plastic clips. Use a flat blade screwdriver to carefully release each clip.
- b. 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 and bottom of the receiver hitch and remove the bumper, **(Figures 5 & 6)**. **NOTE:** Leave hitch attached to vehicle.

### 4. Remove the clips securing the license plate 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 7)**.
- 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. Repeat the previous step for remaining light installation.
- c. Repeat the previous step 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. Depending on tow package, it may be necessary or easier to install sensors at this time, (if equipped)

#### Models without bumper sensors:

- a. Select (4) Rubber Plugs.
- b. From behind bumper, push plugs into sensor mounting holes, **(Figure 8)**.

#### Models with bumper mounted back-up sensors:

- a. Remove sensors and wiring harness from the back of the factory bumper.
- b. Select (1) sensor. Insert the sensor into the mounting sleeve in the back of the bumper.
- c. Secure sensor to the sleeve with (2) 4mm x 10mm Button Head Screws, **(Figure 9)**.  
**IMPORTANT:** Sensors fit snug in sleeves. The 4mm Bolts 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.

### 7. Select the correct installation for your model.

#### Models without factory receiver hitch only:

- a. With assistance, hold the Bumper assembly up to the 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.

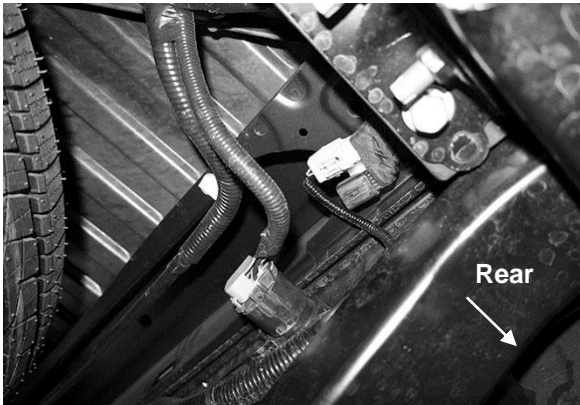
- b. Select (1) 12mm x 45mm Carriage Bolt, (1) 12mm Lock Plate. **(Figure 10)**. Insert the Carriage Bolt through the Plate first, then insert the assembly through the Driver/Left mounting plate on the back of the Bumper and through the Bracket. **(Figure 11)**. Secure the Bumper to the Carriage Bolt with (1) 12mm Flat Washer, (1) 12mm Lock Washer and (1) 12mm Hex Nut. Snug but do not fully tighten hardware. Repeat this **Step** to attach the Passenger/Right side.
- c. Carefully lift up the bumper and insert (1) Thick 2-hole Spacer and (1) Thin 2-hole Spacer between the top of the Driver/Left Mounting Bracket and the Bumper. **(Figure 12)**. Line up the holes with the holes in the Bumper. Attach the Bumper to the Spacers and the top of the Bracket with the included (2) 8mm x 40mm Button Head Bolts, (4) 8mm Flat Washers, (2) 8mm Lock Washers and (2) 8mm Hex Nuts. Do not tighten hardware at this time. 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 hitch. **(Figure 13)**. 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 45mm Carriage Bolt, (1) Lock Plate. Insert the Carriage Bolt through the Plate first, then through the Driver/Left mounting plate on the back of the bumper and through the Bracket. **(Figure 14)**. Secure the Bumper to the Carriage Bolt with (1) 12mm Flat Washer, (1) 12mm Lock Washer and (1) 12mm Hex Nut. Snug but do not fully tighten hardware. Repeat this **Step** to attach the Passenger/Right side of the Bumper to the hitch.
  - c. Carefully lift up the Bumper and insert (1) Thick 2-hole Spacer and (1) Thin 2-hole Spacer between the top of the Driver/Left hitch bracket and the Bumper. **(Figures 15 & 16)**. Line up the holes with the holes in the Bumper. Attach the Bumper to the Spacers and the top of the Bracket with the included (2) 8mm x 40mm Button Head bolts, (2) 8mm Lock Washers and (2) 8mm Flat Washers. Leave loose. Repeat this Step to attach the Passenger/Right side.
  - d. With the bumper loosely attached but level, locate the (2) mounting holes in the step area of the bumper. From below, note the gap at the center between the mounting tabs on the rear facing side of the hitch and the underside of the bumper. (3) different thicknesses of small spacers have been included. Select (1) Thick Spacer first and any combination of spacers to fill the gap between the Bumper and the mounting tabs. **(Figures 15 & 16)**. Repeat to attach both sides of the step area to the hitch. Make sure to use the same combination of Spacers for both locations.
  - e. Attach the center of the Bumper to the threaded holes in the hitch with the included (2) 8mm x 40mm Button Head Bolts, (2) 8mm Lock Washers and (2) 8mm Flat Washers. **(Figure 15)**. Insert the Bolts and Washers down through the step area of the Bumper, through the Spacers and into the threaded weld nuts on the hitch. Do tighten hardware at this time.
8. Slowly open tailgate and check for clearance. Level and adjust the Bumper, (add or remove Spacers), and fully tighten all hardware.
  9. Install the license plate lights.
  10. Reattach the towing harness plug (if equipped) into the Bumper, **(Figure 17)**. Use the included Wire Ties to secure the factory wiring harness to the bumper as necessary.
  11. Attach the license plate to the (2) holes in the Bumper with the included (2) 6mm Screws, (4) 6mm Flat Washers, (2) 6mm Lock Washers and (2) 6mm Hex Nuts. **(Figure 17)**.
  12. Do periodic inspections to the installation to make sure that all hardware is secure and tight.

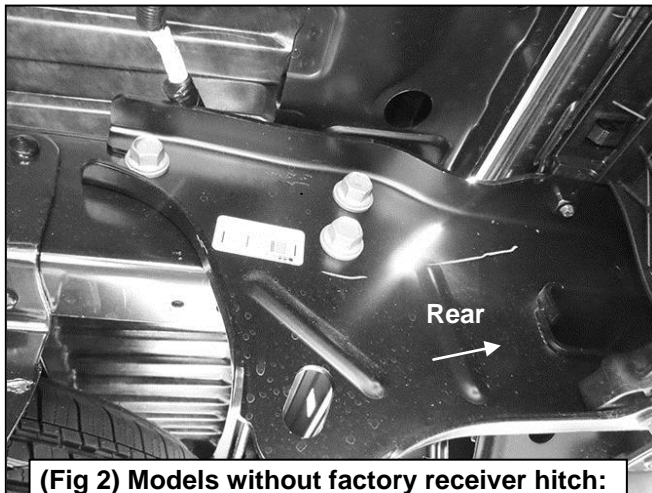
**To protect your investment**, Do not use any type of polish or wax that may contain abrasives that could damage the finish. Mild soap may be used to clean the Bumper assembly.

Driver/Left Side Installation Pictured

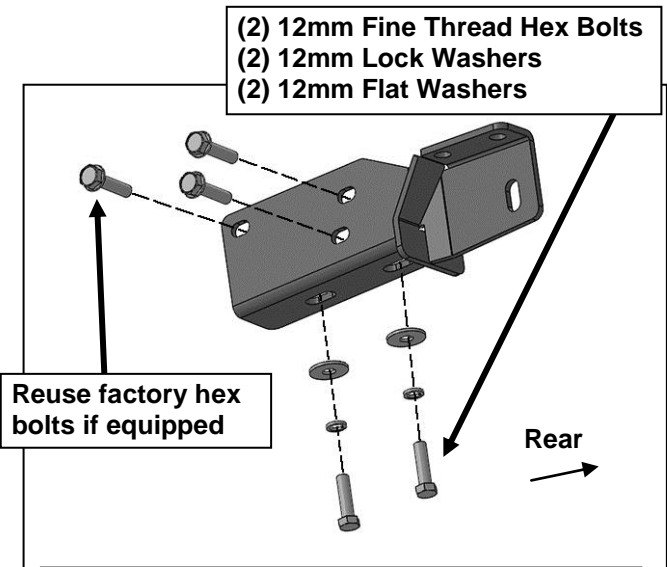


(Fig 1) Unplug and remove 7-wire trailer plug, unplug license plate lights and sensors if equipped

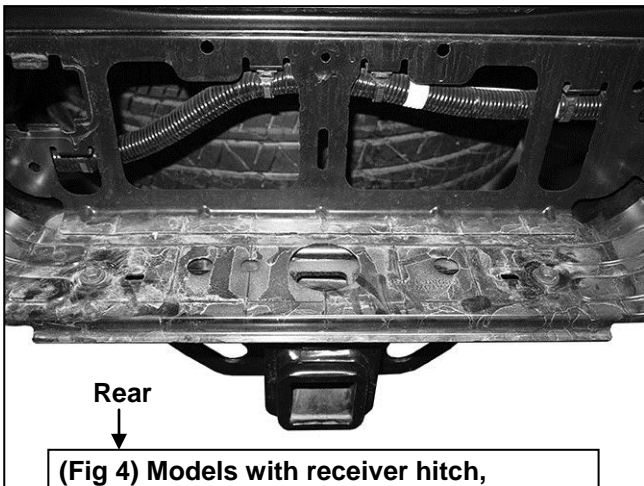
**WARNING!** Do not remove bumper bolts unless the bumper is properly supported on blocks or stands or the bumper may fall.



(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



(Fig 4) Models with receiver hitch, remove plastic cover from top of bumper

# INSTALLATION INSTRUCTIONS

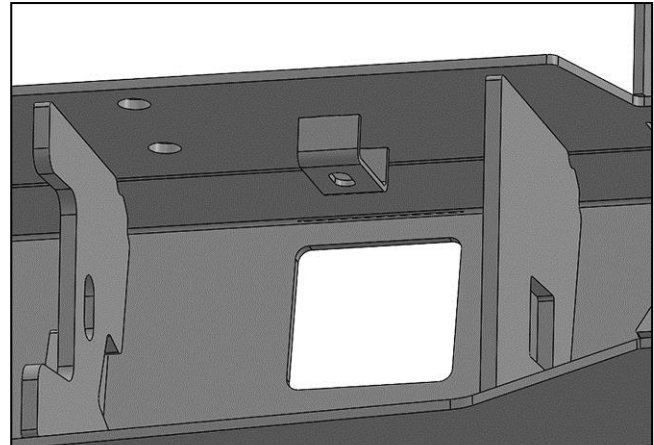
Driver/Left Side Installation Pictured



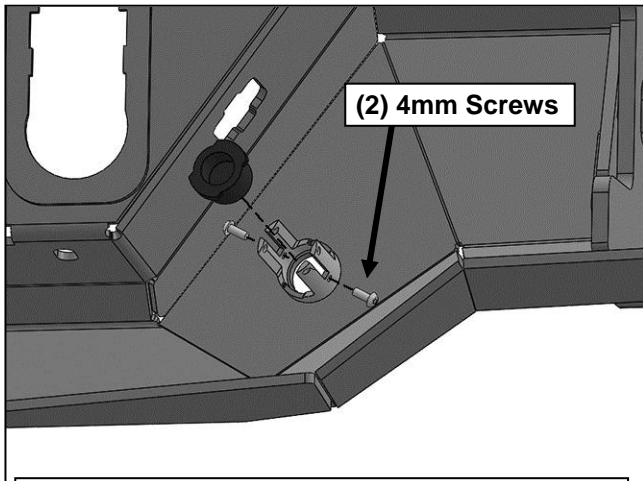
(Fig 6) Models with receiver hitch, remove the hex bolts attaching bumper to bottom of hitch



(Fig 5) Models with receiver hitch, remove the hex bolts attaching bumper to top of hitch

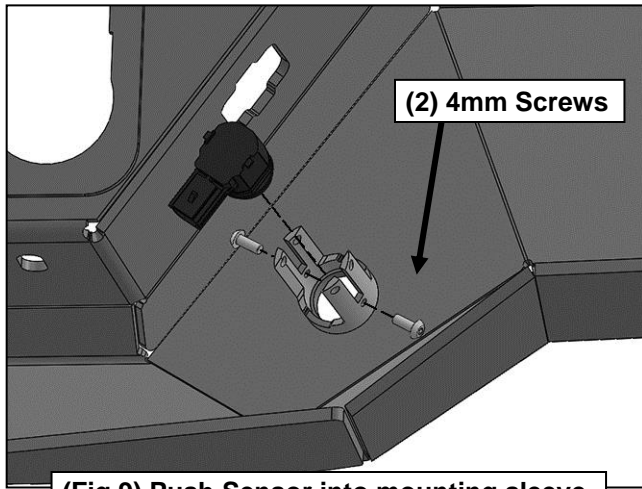


(Fig 7) Light mounting location (light not included). For Flush mount Cube Lights, place the light onto the square hole and line up the light to the hole. Mark the holes on the side of the light. Drill the marked locations and attach the Cube Lights



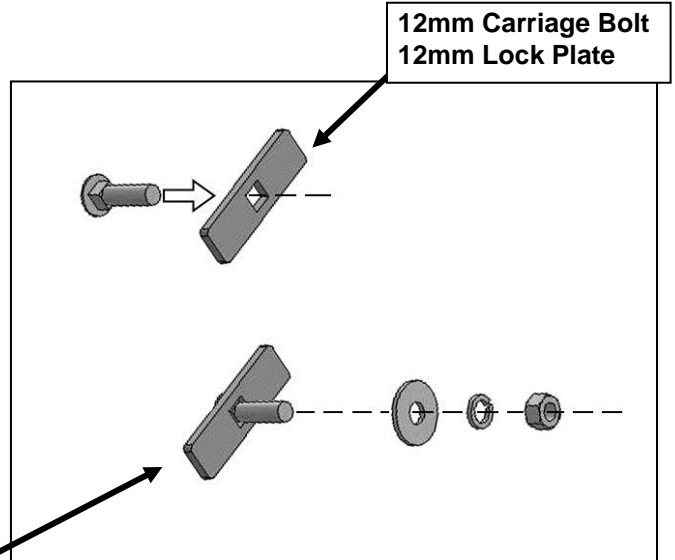
(Fig 8) Push Sensor Plug into mounting sleeve

## Driver/Left Side Installation Pictured



(2) 4mm Screws

(Fig 9) Push Sensor into mounting sleeve. Use 4mm Screws to lock sensor in place

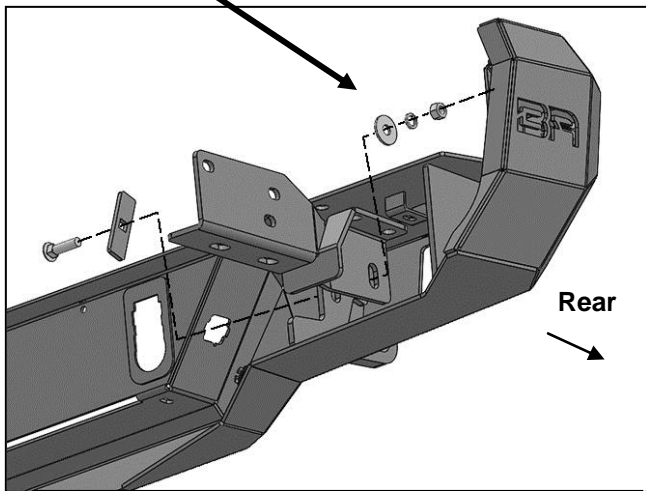


12mm Carriage Bolt  
12mm Lock Plate

(Fig 10) Select (1) 12mm Carriage Bolt and (1) 12mm Lock Plate (top). Insert Bolt through Lock Plate

- 12mm Carriage Bolt
- 12mm Lock Plate
- 12mm Flat Washer
- 12mm Lock Washer
- 12mm Hex Nut

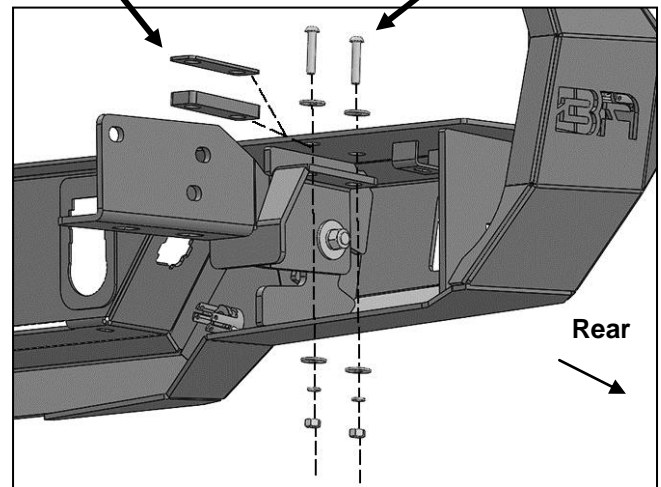
- 12mm Carriage Bolt
- 12mm Lock Plate
- 12mm Flat Washer
- 12mm Lock Washer
- 12mm Hex Nut



(Fig 11) Models without factory receiver hitch: Use Carriage Bolt and Lock Plate to attach Bumper to Bracket, (Driver/Left illustrated)

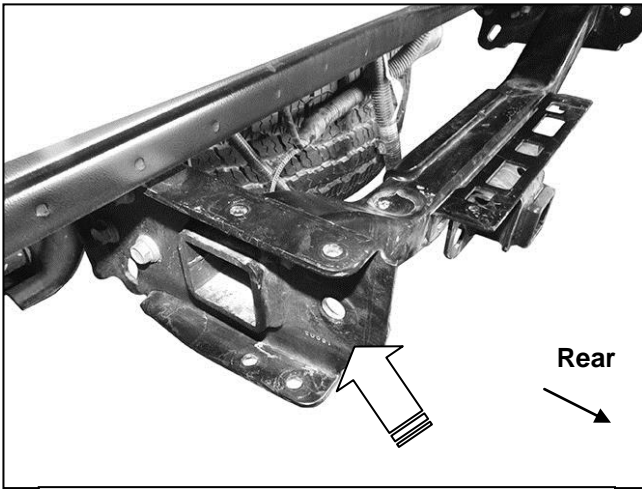
- (2) 8mm Button Head Bolts
- (4) 8mm Flat Washers
- (2) 8mm Lock Washers
- (2) 8mm Hex Nuts

- (1) Thick 2-hole Spacer
- (1) Thin 2-hole Spacer



(Fig 12) Models without factory receiver hitch: Insert (1) Thick and (1) Thin 2-hole Spacer Between top of Bracket and bottom of Bumper (Driver/Left illustrated)

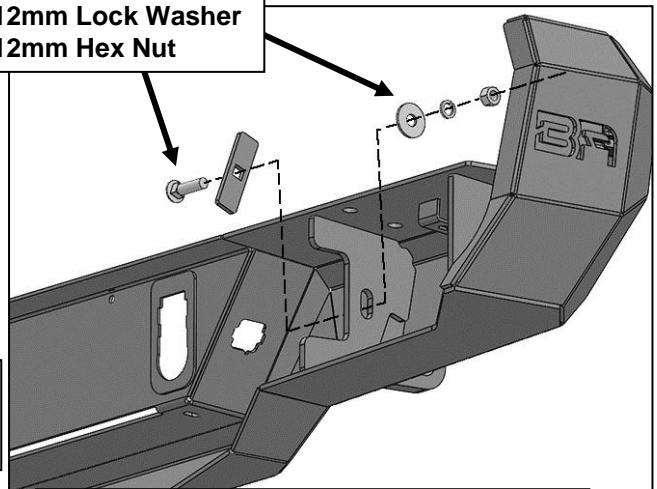
## Driver/Left Side Installation Pictured



(Fig 13) Model with factory receiver hitch: Use Carriage Bolt and Lock Plate to attach Bumper to holes in side plates on factory hitch (arrow). Also see Figures 7 & 8

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

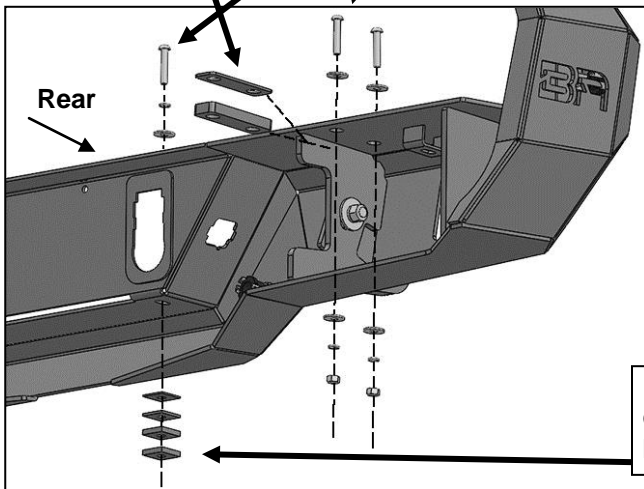
- 12mm Carriage Bolt
- 12mm Lock Plate
- 12mm Flat Washer
- 12mm Lock Washer
- 12mm Hex Nut



(Fig 14) Model with factory receiver hitch: Attach Bumper to side and bottom of hitch (Driver/Left illustrated)

- (1) Thick 2-hole Spacer
- (1) Thin 2-hole Spacer

- (3) 8mm Button Head Bolts
- (3) 8mm Lock Washers
- (3) 8mm Flat Washers

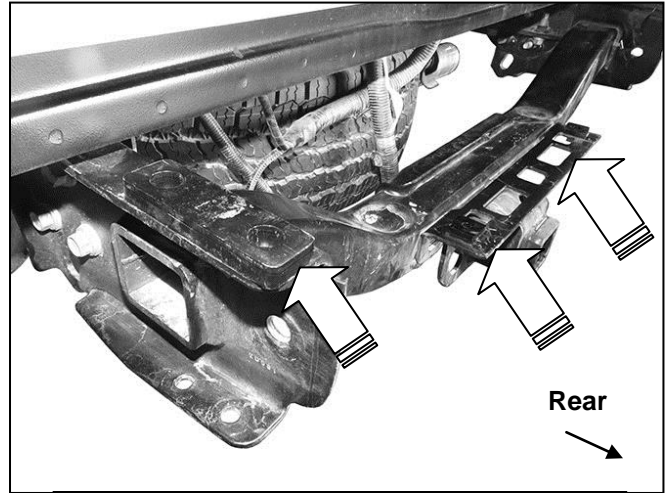


Use Square Spacers to fill gap between center mounting tabs on hitch and bottom of step area on Bumper

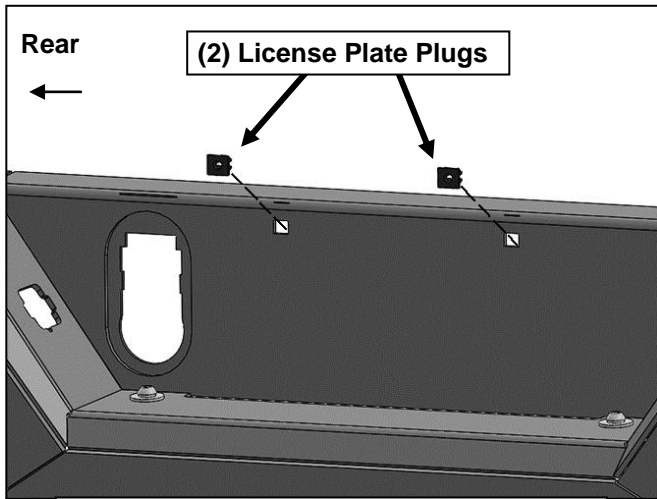
(Fig 15) Models with factory receiver hitch: Insert (1) Thick and (1) Thin 2-hole Spacer Between top of hitch and bottom of Bumper. Use Square Spacers to fill gap between center mounting tabs on hitch and bottom of step area on Bumper (Driver/Left illustrated)

# INSTALLATION INSTRUCTIONS

Driver/Left Side Installation Pictured



(Fig 16) Mounting locations (arrows) pictured with bumper removed for example only to show locations for Spacers



(Fig 17) Attach license plate, license plate lights and tow harness plug to bumper