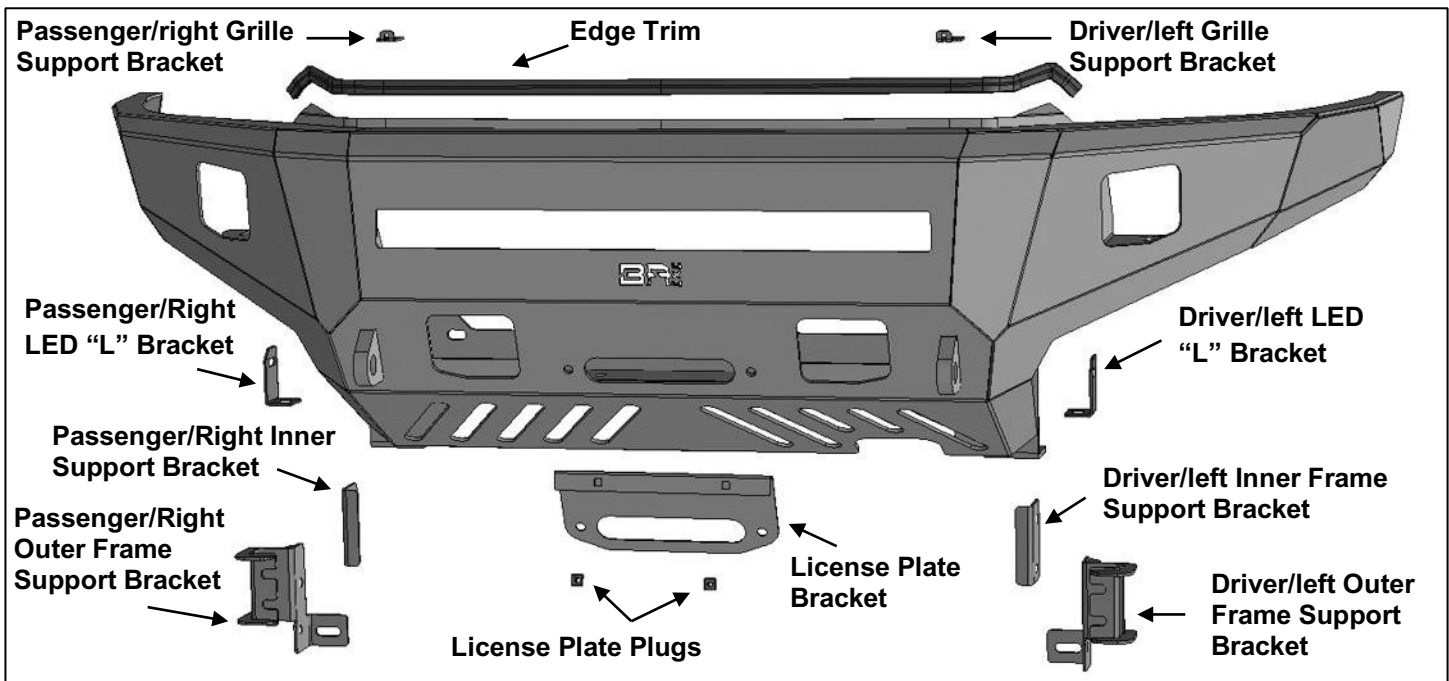


2005-2015 TOYOTA TACOMA PRO SERIES FRONT WINCH BUMPER PART #TC-19341

PARTS LIST:

1	Pro Front Bumper Assembly	6	12mm x 32mm x 3mm Flat Washers
1	Driver/Left Outer Bumper Reinforcement	4	12mm Lock Washers
1	Passenger/Right Outer Bumper Reinforcement	4	12mm Hex Nuts
1	Driver/Left Inner Bumper Reinforcement	4	10-1.5mm x 90mm Hex Bolts
1	Passenger/Right Inner Bumper Reinforcement	2	10-1.5mm x 30mm Button Head Bolts
1	Driver/Left Grille Support Bracket	12	10mm x 20mm OD x 2mm Flat Washers
1	Passenger/Right Grille Support Bracket	6	10mm Nylon Lock Nuts
1	Driver/Left LED "L" Bracket	4	8mm x 25mm Hex Bolts
1	Passenger/Right LED "L" Bracket	2	8mm x 16mm Hex Bolts
2	License Plate Plugs	8	8mm x 24mm OD x 2mm Flat Washers
1	License plate bracket	4	8mm Lock Washers
2	12-1.75mm x 120mm Hex Bolts	2	8mm Flange Hex Nuts
2	12-1.75mm x 40mm Hex Bolts	2	8mm Hex nut
4	12mm x 44mm x 4mm Spacer Flat Washers	1	6mm Hex Wrench



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.

1. Remove the skid plate from below the bumper if equipped, (Figure 1).
2. Open the hood and remove the plastic cover from the top of the grille and radiator. Carefully remove the plastic grille, (Figure 2).

3. Remove the plastic covers between the top of the factory bumper and bottom of the headlights, (**Figure 3**).
4. Remove the factory hardware attaching the front bumper to the driver/left wheel opening, (**Figure 4**). Move along the bottom of the bumper and remove the hardware attaching the bottom of the bumper, (**Figure 5**). Continue to the passenger/right wheel opening and remove the hardware to release the bumper cover.
5. Remove the hardware attaching the top of the bumper to the vehicle, (**Figure 6**). Carefully remove the plastic bumper cover.
6. Remove the impact crossbar and brackets from the end of the frame, (**Figures 7 & 8**).
7. Determine if LED Bar style light will be installed (light not included).
 - a. Select the driver/left LED "L" Bracket. Attach the Bracket to the back of the bumper with (1) 8mm x 25mm Hex Bolt, (2) 8mm Flat Washers, (1) 8mm Lock Washer and (1) 8mm Hex Nut, (**Figure 9**). Repeat this **Step** to attach the remaining passenger/right "L" Bracket.
 - b. Attach the light to the "L" Brackets with the included (2) 8mm x 16mm Hex Bolts, (2) 8mm Lock Washers and (2) 8mm Flat Washers.
8. Determine if winch will be installed (winch not included)
 - a. Attach cable guide to front of bumper. Models with front license plate, select the License Plate Bracket. Attach the Bracket to the front of the bumper between the cable guide and the bumper.
 - b. Models without cable guide, attach the License Plate Bracket to the front of the Bumper with the included (2) 10mm x 25mm Button Head Bolts, (4) 10mm Flat Washers and (2) 10mm Nylon Lock Nuts, (**Figure 10**).
 - c. Insert the (2) License Plate Plugs into the Bracket to attach the License Plate, (**Figure 10**).
 - d. Follow manufacturer's instructions to attach the winch to the Winch Tray.
9. Push the included Edge Trim onto the top edge of the Bumper. Cut the Edge Trim to fit, (**Figure 11**).
* use thin edge trim material for 2005-2011 models.
10. **2005-2011 models ONLY**: Locate and remove 4 bolts securing factory core support. Remove core support and set aside for later.
 - The core Support mount slightly interferes with the angle mount on the bumper leading to the frame. For clearance and install ease, use a pair of pliers to slightly bend the sheet metal core support mounting tab upward to prevent rubbing.
11. With assistance, reuse the (6) factory hex nuts to attach the Bumper to the end of the frame, (**Figures 12 & 13**). Leave hardware loose at this time.
12. Attach the lower mounting tab on the back of the driver/left side of the bumper to the bottom of the crossmember with the included (1) 12mm x 40mm Hex Bolt, (2) 12mm STD Flat Washers, (1) 12mm Lock Washer and (1) 12mm Hex Nut, (**Figure 14**). Repeat to attach the passenger/right side of the bumper to the crossmember. Snug but do not fully tighten the hardware at this time.
13. Select the driver/left outer Support Bracket. Slide the slots on the outer Support Bracket under the outer (2) factory hex nuts attaching the Bumper to the frame, (**Figure 15**). Attach the Bracket to the side of the frame with (2) 10mm x 90mm hex Bolts and (2) 10mm Flat Washers, (**Figure 16A**). Hold the Inner Support Bracket up to the back of the frame. Secure the inner Bracket to the side of the frame with (2) 10mm Flat Washers and (2) 10mm Nylon Lock Nuts, (**Figure 16A & B**). Do not fully tighten hardware at this time.
14. Select (1) 12mm x 120mm Hex Bolt and (1) 12mm x 32mm STD Flat Washer. Insert the Bolt and Washer in from the front of the mounting plate on the bumper, through the crossmember and out the Outer Support Bracket, (**Figure 17**). Slide (1) 12mm x 44mm Flat Spacer Washer onto the Hex Bolt.



INSTALLATION INSTRUCTIONS

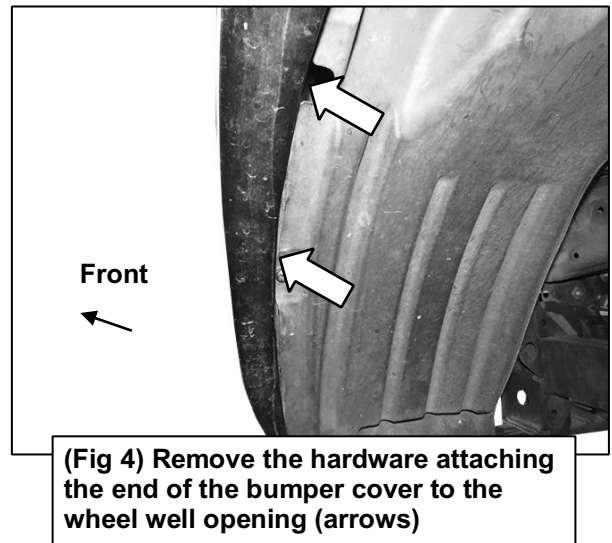
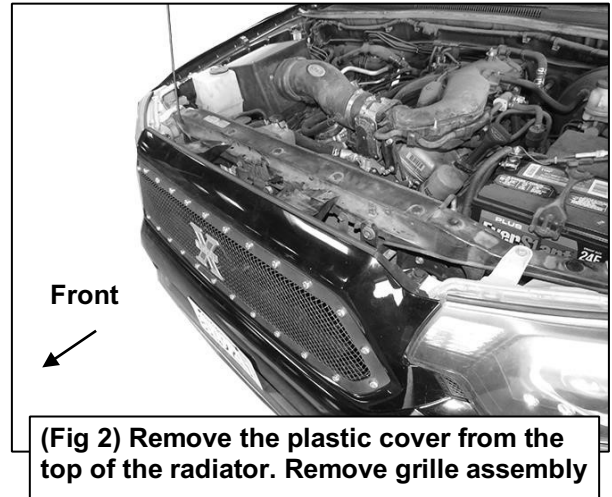
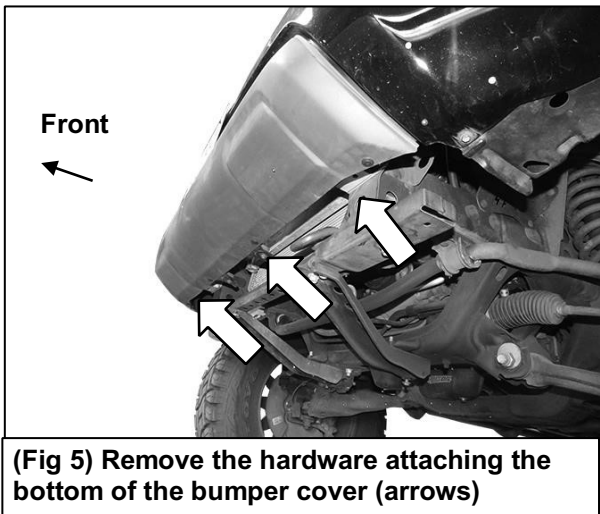
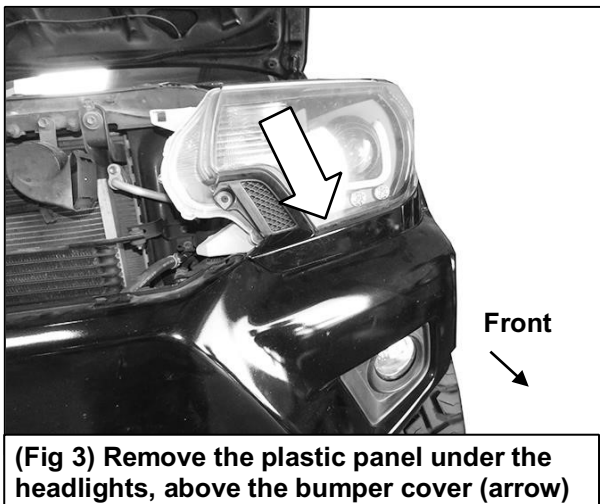
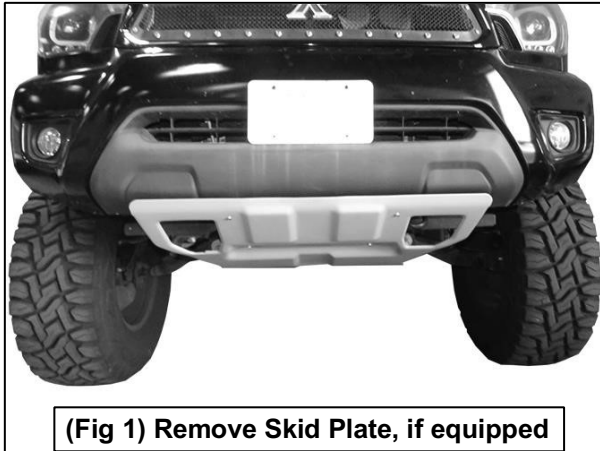
Secure the Bracket to the crossmember with (1) 12mm Lock Washer and (1) 12mm Hex Nut, (**Figure 18**). Do not tighten hardware at this time.

15. Repeat **Steps 12 & 13** to attach the passenger/right Outer and Inner Support Brackets to the frame.
16. Level and adjust the Bumper and tighten all hardware. **IMPORTANT:** To adjust the Bumper down slightly, loosen the mounting hardware and slide the included (2) 12mm x 44mm Flat Spacer Washers (use 1 per side), between the lower mounting tab and the bottom of the crossmember, (**see Step 11 Figure 14**). Once level and adjusted, fully tighten all hardware.
17. Next, select the driver/left Grille Support Bracket. Attach the Bracket to the bottom outer mounting screw on the back of the grille, (**Figure 19**). Repeat this **Step** to attach the passenger/right Support Bracket.
18. Reinstall the Grille. Attach the driver/left Grille Support Bracket to the top of the sheet metal panel with (1) 8mm x 25mm Hex Bolt, (1) 8mm Flat Washer and (1) 8mm Flange Nut, (**Figures 20 & 21**). Repeat this **Step** to attach the passenger/right Grille Support Bracket. Reinstall the plastic cover.

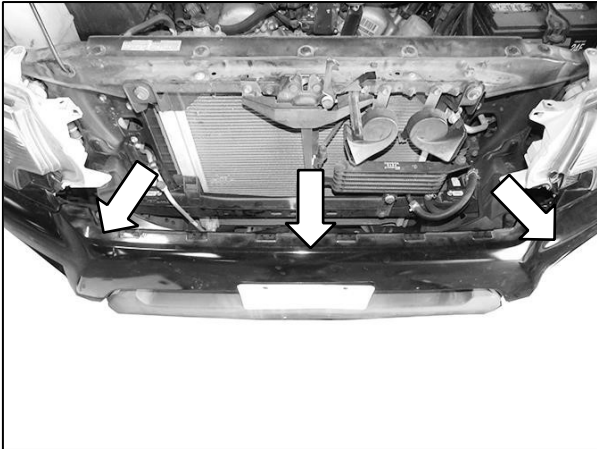
19. Reinstall the skid plate, if equipped. Do periodic inspections to the installation to make sure that all hardware is secure and tight.

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.

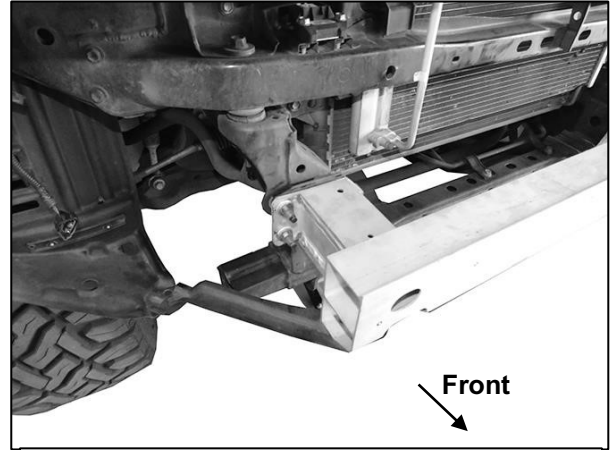
Driver/Left Side Installation Pictured



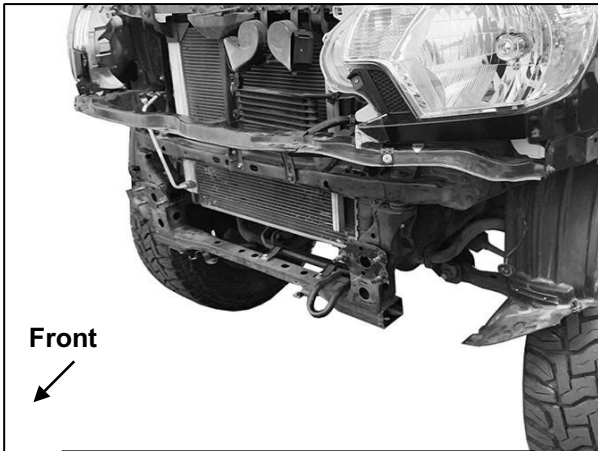
Driver/Left Side Installation Pictured



(Fig 6) Remove the hardware attaching the top of the bumper to the vehicle (arrows)



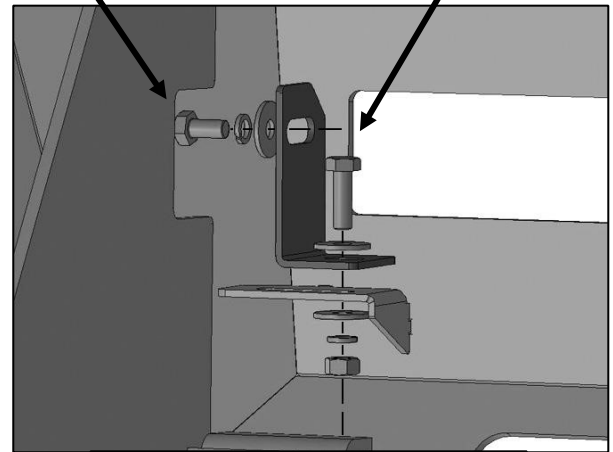
(Fig 7) Remove the crossbar and brackets



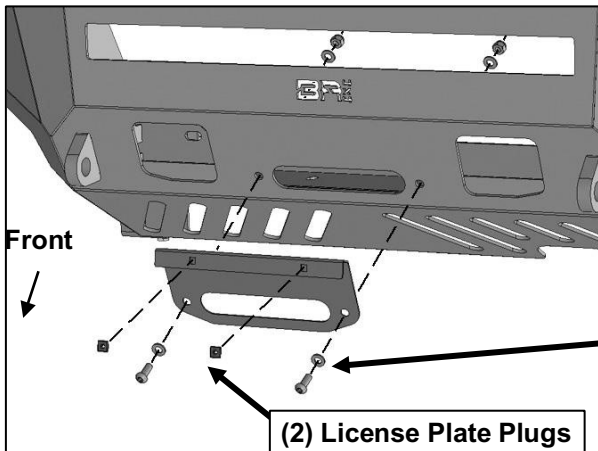
(Fig 8) Bumper assembly removed

8mm x 16mm Hex Bolt
8mm Lock Washer
8mm Flat Washer

8mm x 25mm Hex Bolt
(2) 8mm Flat Washers
8mm Lock Washer
8mm Hex Nut



(Fig 9) Attach driver/left LED "L" Bracket to inside of Bumper



(2) License Plate Plugs

(2) 10mm Button Head Bolts
(4) 10mm Flat Washers
(2) 10mm Nylon Lock Nuts

(Fig 10) Attach License Plate Bracket to front of Bumper. Push Plugs into Bracket for plate

Driver/Left Side Installation Pictured

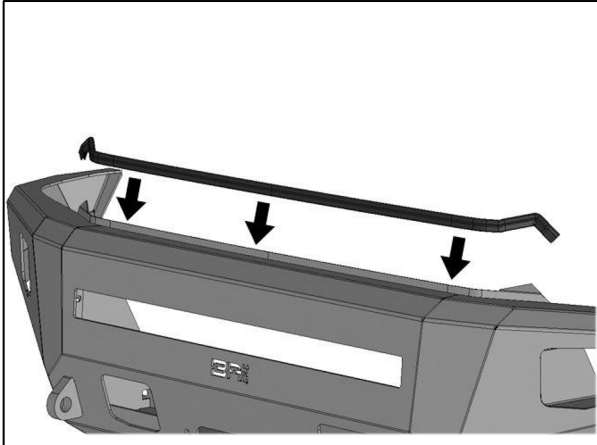
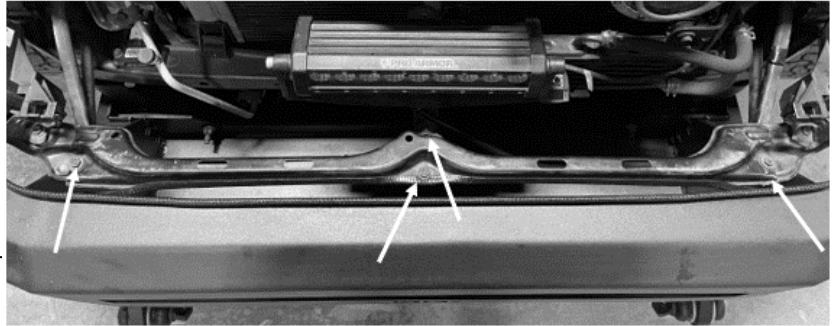


Fig 11) Push Edge Trim onto edge of Bumper. Cut Edge Trim to fit

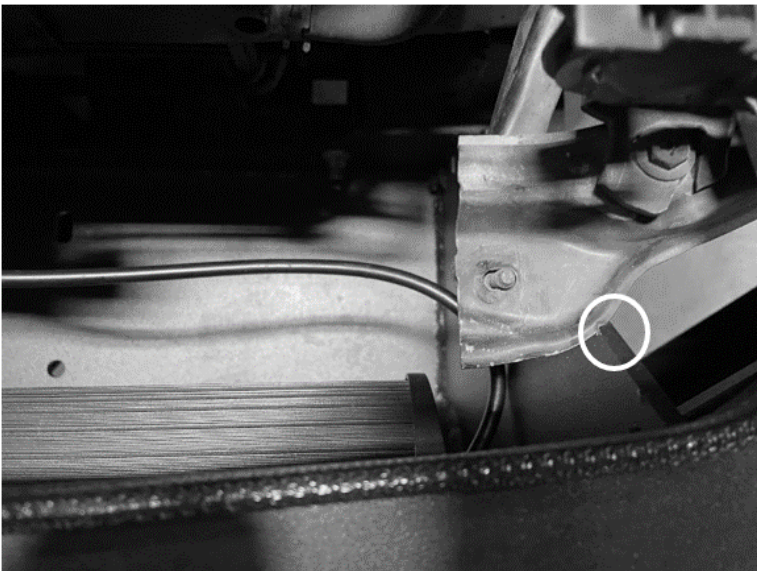
NOTE: If desired for 2005-2011 models, a thin edge trim (not provided) maybe used instead of the provided thick material trim.

******2012-2015 continue to figure 12******

2005-2011 Specific step.



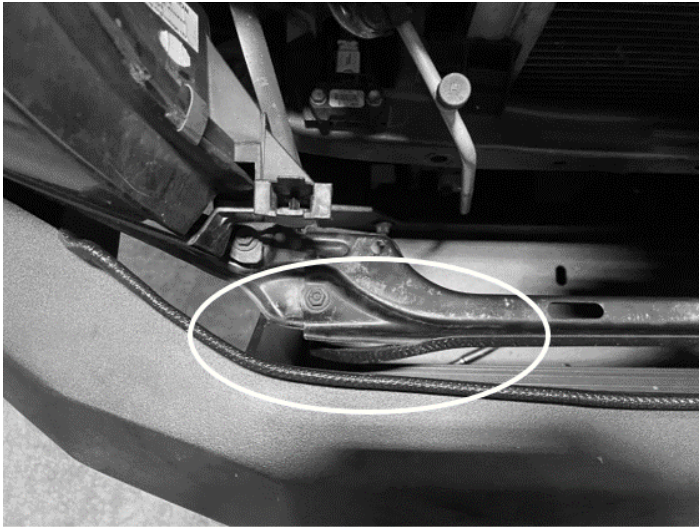
Locate and remove 4 bolts securing factory core support. Remove core support and set aside for later.



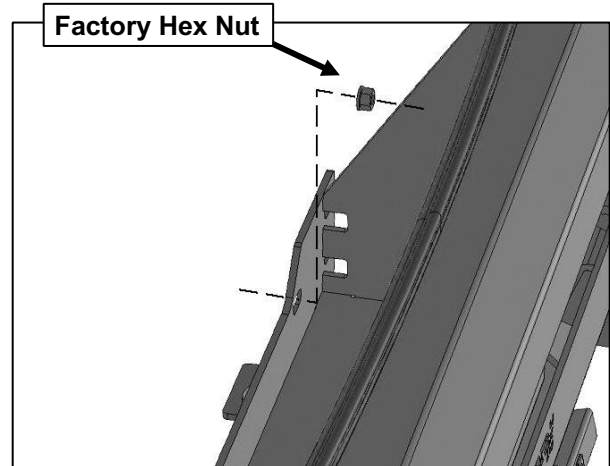
Core Support mount slightly rests on bumper mount angles. With a pair of pliers, slightly bend the sheet metal core support mounting tab upward so it doesn't rub/interfere with bumper mounting.



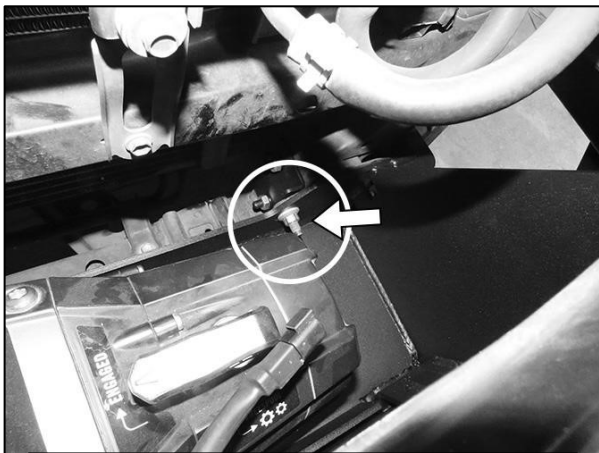
Bend mount tab location in same spot on both driver/passenger side.



2005-2011 note: Use leftover trim edge on core support mounting tabs.



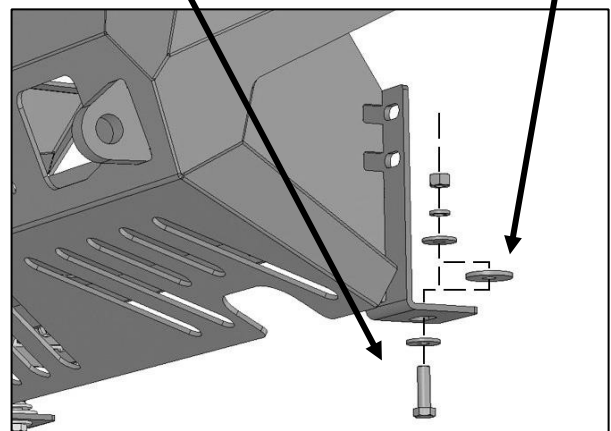
(Fig 12) Reuse factory hex nuts to attach Bumper to end of frame



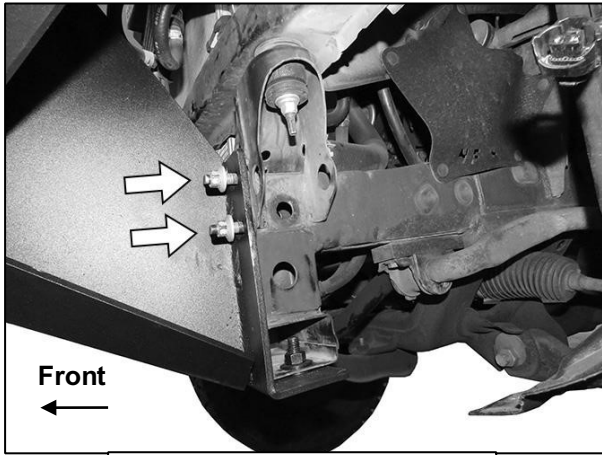
(Fig 13) Driver/left side of Bumper Winch Tray attached to end of frame (arrow)

- 12mm Hex Bolt
- (2) 12mm Flat Washers
- 12mm Lock Washer
- 12mm Hex Nut

- 12mm x 44mm
Spacer Washer

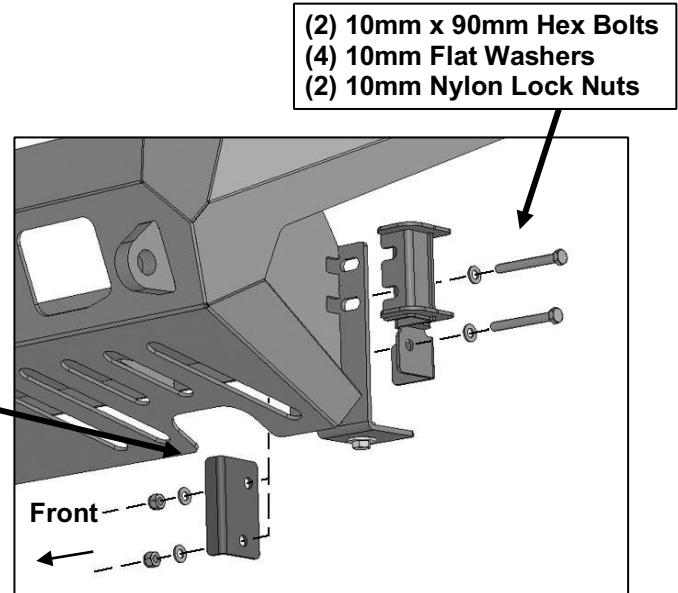


(Fig 14) Attach lower mounting tab on back of Bumper to bottom of crossmember. Insert 12mm x 44mm Spacer Washer between tab and crossmember as needed to level Bumper

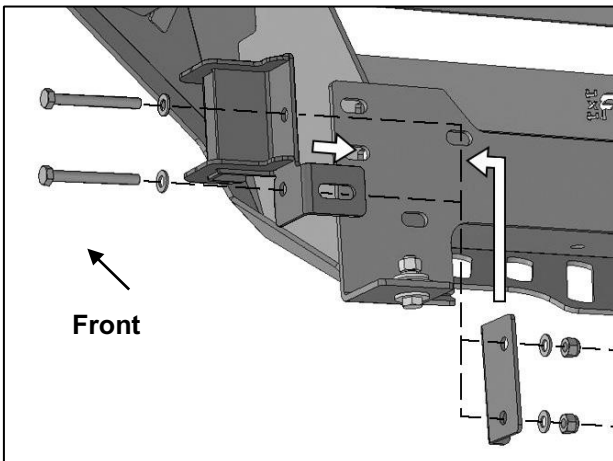


(Fig 15) Loosen the outer (2) factory hex nuts (arrows)

Inner Support Bracket

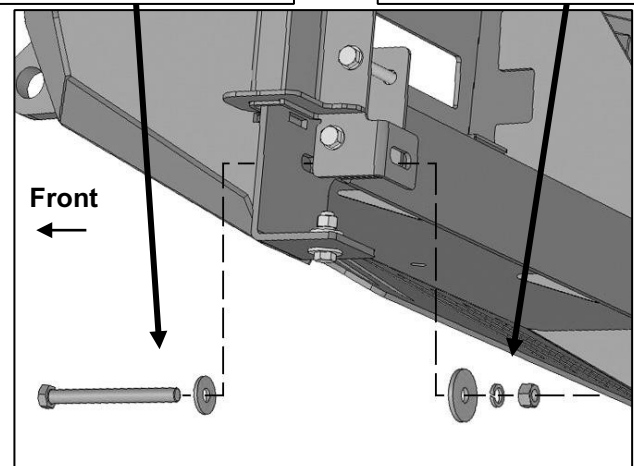


(Fig 16A) Slide the Outer Bumper Support Bracket under the (2) factory hex nuts. Attach Inner Support Bracket to frame and Outer Bracket (Driver/Left illustrated)



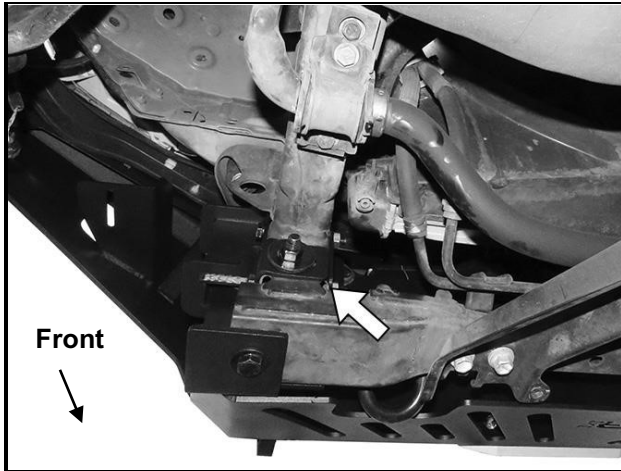
(Fig 16B) Slide the Outer Support Bracket under the (2) factory hex nuts. Attach Inner Support Bracket to frame and Outer Bracket (Driver/Left illustrated from behind Bumper)

- 12mm x 120mm Hex Bolt
- 12mm x 32mm STD Flat Washer
- 12mm x 44mm Spacer Washer
- 12mm Lock Washer
- 12mm Hex Nut



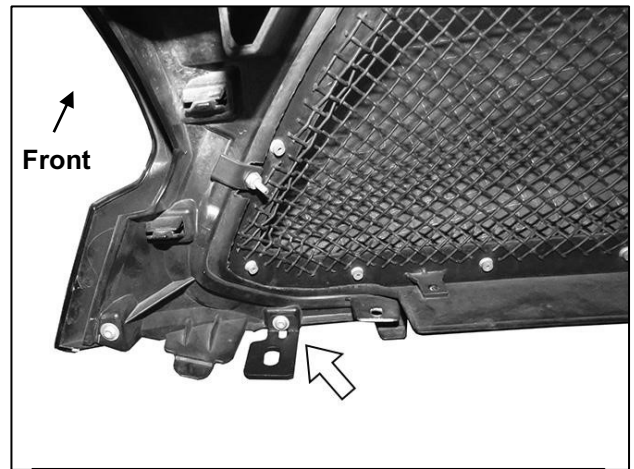
(Fig 17) Insert Long Hex Bolt with STD Flat Washer through Bumper Mount, frame crossmember and out through Support Bracket

Driver/Left Side Installation Pictured



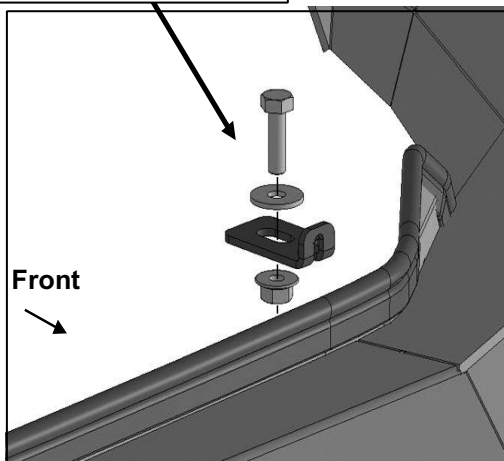
(Fig 18) Insert Long Hex Bolt with STD Flat Washer through Bumper Mount, frame crossmember and out through Support Bracket. Slide Large 12mm x 44mm Spacer Washer onto Hex Bolt. Driver/left side pictured from behind bumper

NOTE: Disregard Fig 19-21) for 2005-2011 models. See Fig) 22.

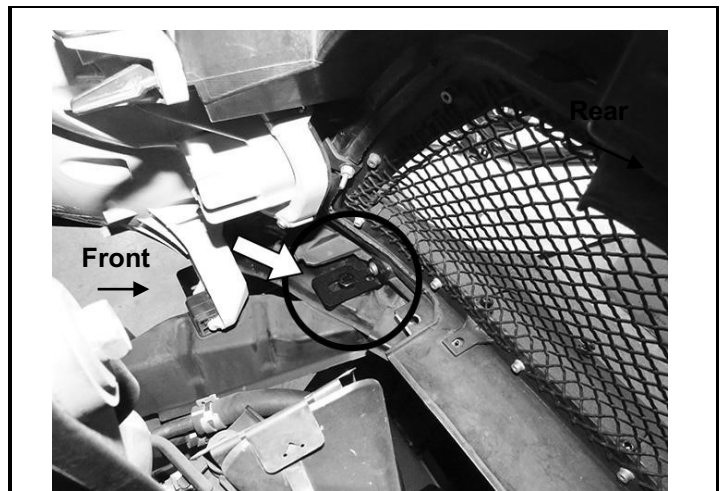


(Fig 19) Reuse the factory screw to attach driver/left Grille Support Bracket to outer mounting point on back of grille (arrow)

8mm x 25mm Hex Bolt
8mm Flat Washer
8mm Flange Nut

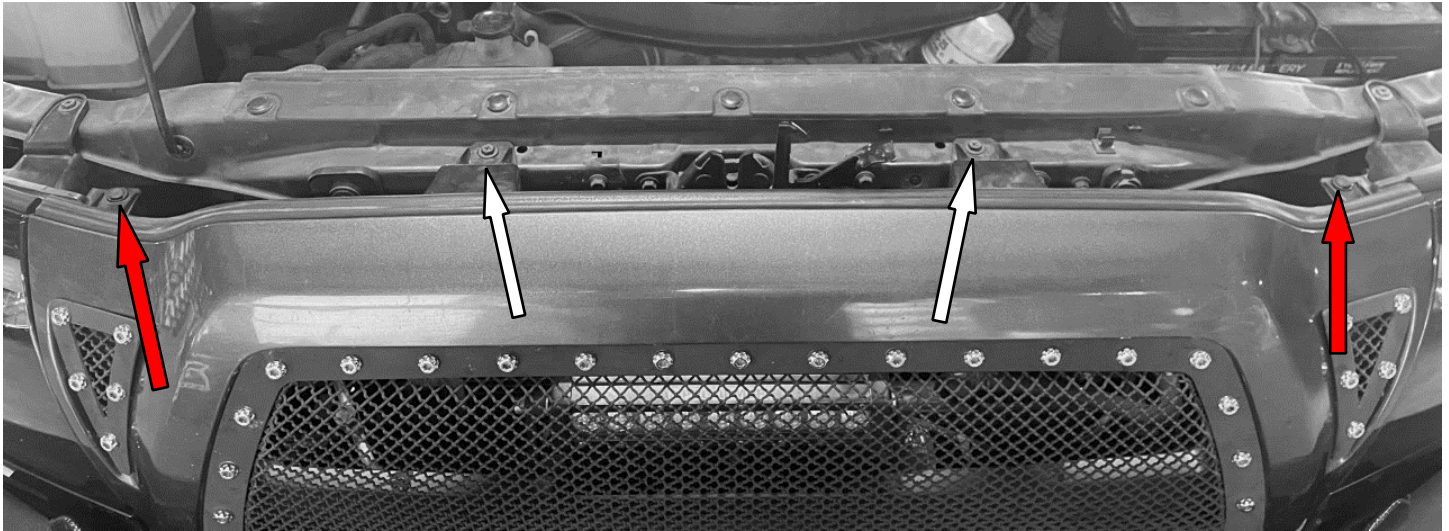


(Fig 20) Reinstall grille. Attach Grille Support Bracket to top of radiator core support



(Fig 21) Reinstall grille. Attach Grille Support Bracket to top of radiator core support (arrow). Reinstall plastic cover (also see Figure 2)

FIG) 22



After fitting the grill back into its snap-in mounting position, reinstall **2 push rivets** and **2 tab screws** to secure grill back to vehicle.



2005-2011 models will have a minor gap of 1.5" between the front of the grill and the top of the bumper. If desired the alternative thin edge trim may be used (not provided).