



**2016+ Tacoma Stage 2 High
Clearance Protection Installation**

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Figure 01. Overview

2016+ Tacoma Stage 2 High Clearance Protection Installation



Figure 02. Right Side



Figure 03. Center



Figure 04. Left Side



Figure 05. Bolt

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Figure 06.

2016+ Tacoma Stage 2 High Clearance Protection Installation

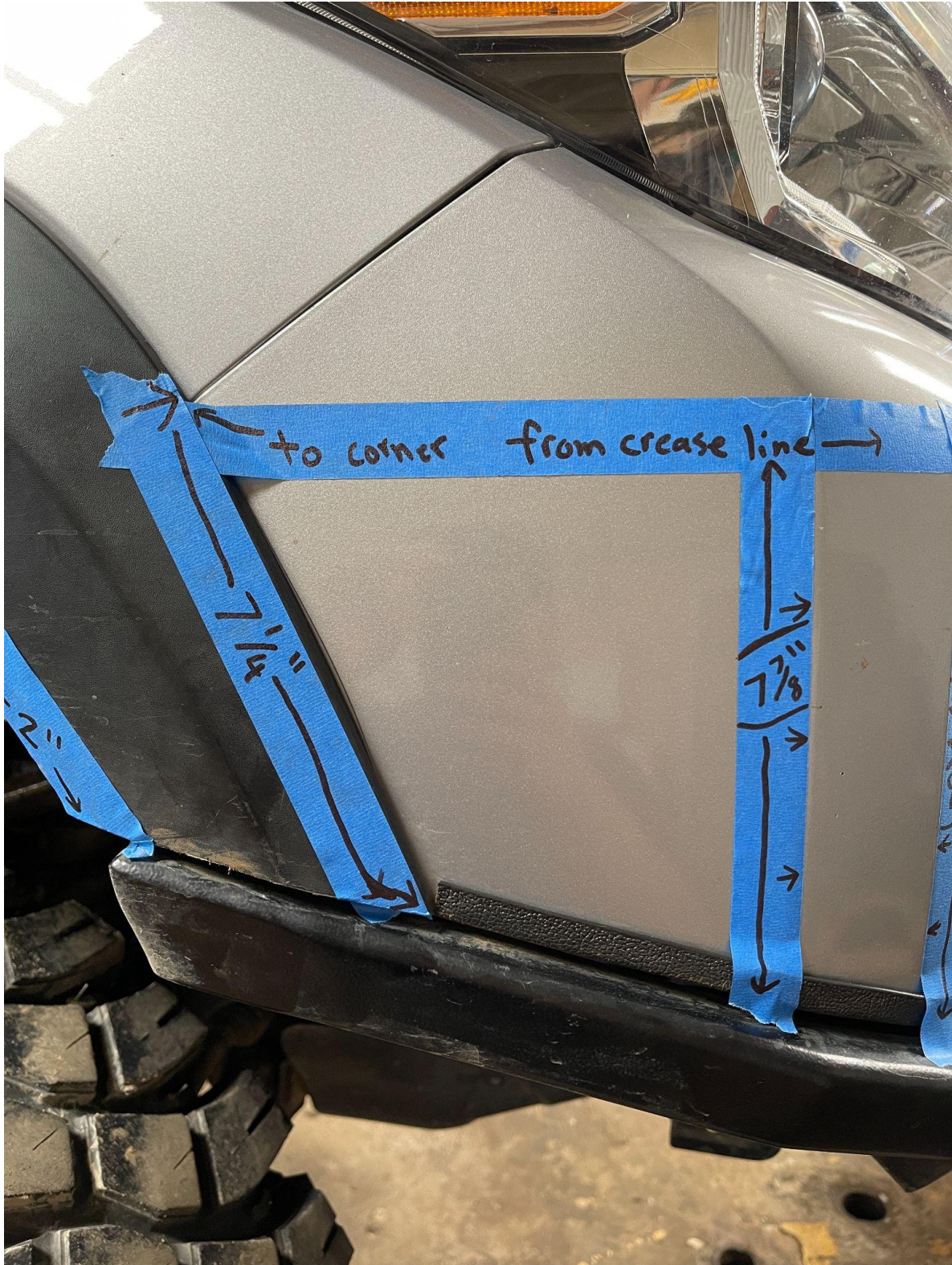


Figure 07.



Figure 08. Inner Fender

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Figure 09. Driver Side



Figure 10. Driver Side Push

We recommend watching the Installation Video before installing. The link can be found below.

[2016+ Tacoma Stage 2 High Clearance Protection Installation](#)

If you have the old bumper you will need to drill and tap before installing. It will need to be removed from the vehicle. The new models will already have the holes drill and tapped for the Stage 2s. Before you begin, please read the last pages if you have an older version.

Making The Cuts

Note* Refer to images above.

- The small arrows are pointing to the natural crease line on the bumper.
- On the bottom line, covered in edge trim in the images, you want to leave a $\frac{1}{8}$ inch below the crease line. This can be adjusted with more trimming if needed, better too much than too little.

Figure 01 Overview

- This shows an overview of the passenger side of Tacoma. This is where to cut and at what length the cuts should be.

Figure 02. Right Side

- Starting at the bottom right, from crease to crease, the measurement is 2 inches
- The left piece of the tape shows it is 9 inches from crease to crease. Arrows pointing to the right side for the crease.
- The top piece of tape is showing the top crease line to follow. This will extend across the length of the side, as shown in figure 01. This will go from the left corner as shown in figure 04 and follow the crease line as seen in the various figures.

Figure 03. Center

- Starting on the right side, this first piece of tape is the same piece of tape on the left side of figure 02. This is 9 inches crease to crease.

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- The centerpiece of tape is $8 \frac{3}{8}$ inches from crease to crease. Arrows pointing to the left side for the crease.
- The left piece of tape is $7 \frac{3}{8}$ inches from crease to crease. Arrows pointing to the right side for the crease.
- The top piece of tape is showing the top crease line to follow. This will extend across the length of the side, as shown in figure 01.

Figure 04. Left Side

- Starting on the right side, the first piece of tape is the same piece of tape on the left side of figure 03. This is $7 \frac{3}{8}$ inches crease to crease.
- The centerpiece of tape is $7 \frac{1}{4}$ inches from crease to crease. Note the physical bumper line on the top.
- The left piece of the tape shows a 2-inch distance between the bolt on the inner fender to the cut line. The bolt can be seen in figure 05.

Figure 05. Bolt

- This shows the distance between the bolt on the inner fender and the 2-inch length to the cut line.

Figures 06 and 07 are for further back for reference.

Figure 08. Inner Fender

- **Passenger side.** Bolt down is $3 \frac{3}{4}$ inches.
 - As shown in figure 08, a line will be cut from the bottom of the second vent on the inside inner fender across. You can leave a small length below the bumper cut line if wanted as shown in the image.

Figure 09.

- **Driver side.** Bolt down is $3 \frac{3}{4}$ inches.
 - There is no vent to reference on this side.
 - Similar to the passenger side, measure down from the inner fender bolt $3 \frac{3}{4}$ inch.
 - You will then extend the line across, trying to keep it as level as possible.

Figure 10.

- While extending the driver's side inner fender cut, make sure the cut line is below the push pins as shown in this figure.

Installation

1. Use the edge trim along the edge of the bumper where you just cut.
2. Line up the Stage 2 plate to the Slimline Hybrid Plate
3. Insert the bolts, do not tighten down completely (Three 3 $\frac{3}{8}$ " bolts per side)
4. Line the Stage 2 up with the bumper edge trim line
5. Use shims to even the fitment
6. Tighten completely down

Readjust as needed to get the perfect alignment

Note*

- It is possible as you tighten the bolts down there could be a slight variance in the fitment as there have been slight changes over the past five years
- Included in the hardware kit are stainless steel washers and double-sided tape to act as shims
- Roughly 1mm for every washer.

For older versions of the 2016+ Tacoma Slimline Hybrid bumper

- Remove the Slimline Hybrid bumper.
- Line the Stage 2 up with the Slimline Hybrid bumper
- Using a $\frac{1}{4}$ -20 inch button head bolt on the bottom inside most hole, tighten down
 - **Check alignment in the front**
 - **Make sure that the Stage 2 aligns with the Slimline Hybrid bumper**
- Suggest using a clamp to help support and hold the Stage 2 to the bumper
- Take a scribe or something to mark the placement of the holes, trace both the upper holes
- Use a 5\16 inch drill bit to drill out the remaining $\frac{1}{4}$ inch hole
- Tap the previously drilled hole with a $\frac{3}{8}$ inch tap