



# FRONT STEEL HYBRID SLIMLINE BUMPER INSTALLATION

2016+ Tacoma

Version 2.1 - 2017

Thank you for purchasing the Southern Style Speed Toyota Tacoma Hybrid Slimline series for the SR5 and Trail Edition Models.

Included Content:

- 1-piece steel bumper with/without light cut outs.
- Hardware
  - 8 - 3/8" flange head bolts w/ washers
  - 2 - m12 flange head bolts
  - 8 - m10 flange head bolts
- Optional Accessories
  - Light bar, winch, etc.
  
- Additional tools required:
  - 17,14,12,10 mm socket/impact
  - 3/8" extension
  - 1/2" and 3/8" drive ratchet wrench
  - Flat and Phillips screwdriver
  - 1 inch wide blue painters tape
  - Dremel style rotary tool with rip saw blade or high speed cutting disk

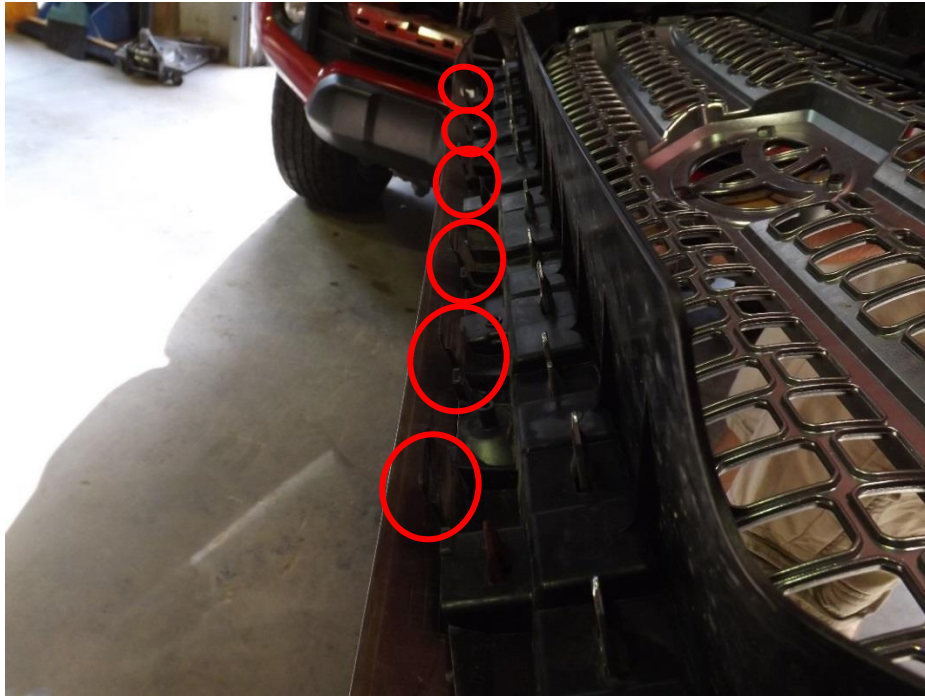
Begin installation by carefully unpacking the bumper from the box and removing protective materials. Verify all required hardware and optional accessories are included.



First, remove two the 10mm bolt heads holding the upper portion of the grille to the body of the truck. Also, remove the push pins near each headlight with a flat head screw driver by pulling up on the center section first, then pulling the clip out completely



After removing the upper fasteners, you will also need to remove the remaining lower push in clips holding the grille cover onto the truck. You will find these clips all along the bottom of the grille. With a little finesse and steady but gentle pulling and maneuvering you should be able to work the grille free. Pull and wiggle from the bottom to unseat these clips. You could also reach from behind the grille to unseat each of them individually.



After removing the grille, remove the remaining push pin clips holding the bumper onto the truck from the front.



There is also a plastic clip near each headlight that was hidden by the grille. Remove these.



Remove every 10mm bolt on the underside of the OEM bumper cover.





Remove the remaining clips and fasteners connecting the fender liner to the front bumper cover, using a 10mm ratchet for the top screw and a flat head screwdriver to turn and pull out bottom plastic clip



You also need to gently detach the fender trim from the front bumper. Don't pull to hard to far back, it is 3M taped further back and will **NOT** re stick.



Disconnect your oem fog light harness near the center of the truck circled in the picture below.

Before continuing, be certain that all plastic clips, screws, and bolts securing the OEM bumper cover onto the truck have been removed. Holding on to the top corner of the bumper near the fender, disengage the bumper cover from around the screw locations by pulling out and around. You'll also need to disengage a hidden clip near the fender and headlight on each side. This may take more force than anticipated. The OEM bumper is designed to latch to the fender even without any hardware holding it. Stop once you have achieved this on both sides. With the help of another, remove the bumper cover slowly ensuring there is no longer anything attached to the body of the truck. After removing the front bumper cover your truck should look like this:

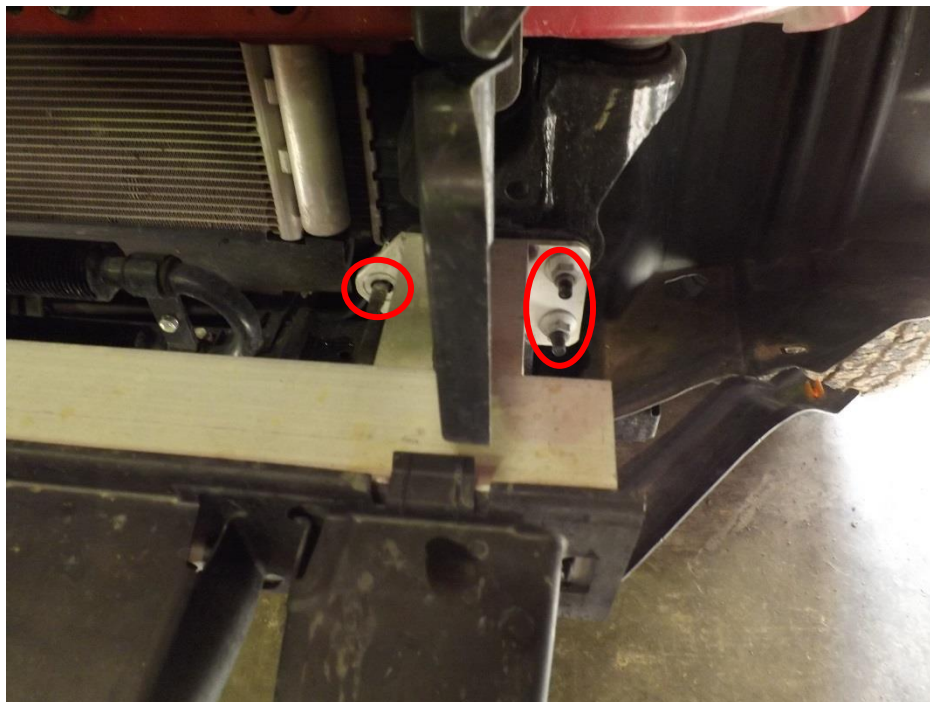




When the OEM bumper has been removed, you'll expose the cross beam that joins the frame rails together. Loosen one leg of the aluminum cross section (14mm), but do not remove.



Remove the 8 - 14mm flange head nuts holding this section to the frame rails.



Remove this center frame rail from the truck.



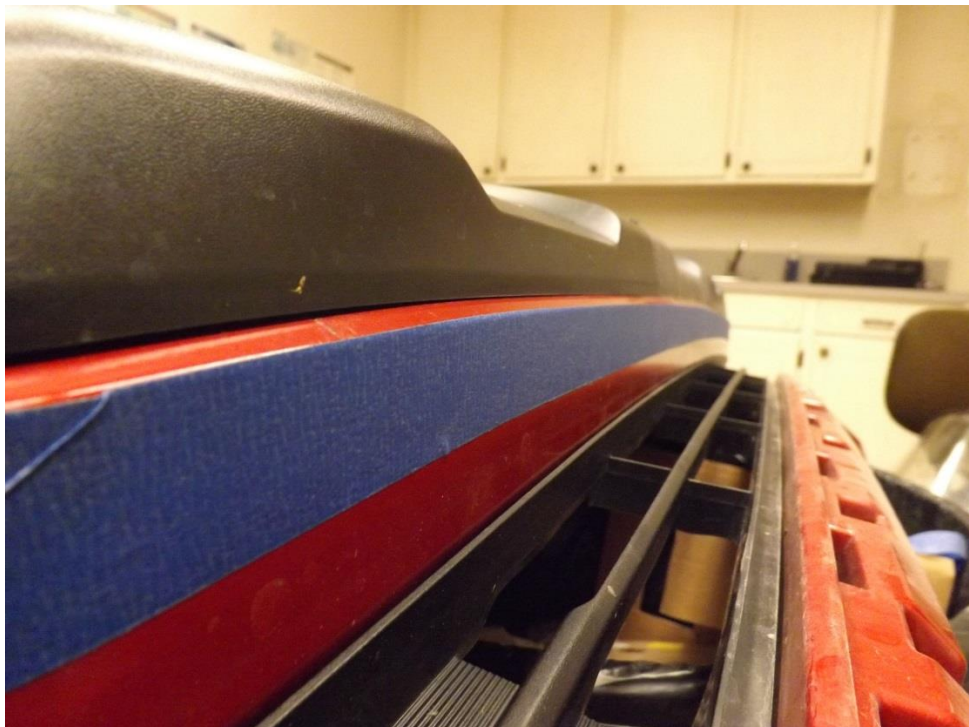
Remove the oem hook as well as the 12mm bolt securing the lower radiator crash protection. The crash protection bolt will be upgraded to a class 10.9 later. Leave the crash protector, also circled in red, in its place for now.



Now we focus again on the front bumper cover. We will be marking the outline of the center section cutout. The next series of pictures will detail the application of painters tape to mark your cut line. Begin by placing the edge of the painters tape onto the leading edge of the first bend before the black plastic cap.



Follow this line all the way down the center section of the bumper.





After rounding each corner downwards, trail it straight down onto the black plastic lip. Use a new piece of tape to now connect the previous piece of tape laid to a bend line indicated below. It will taper to less than an inch at this point from the original edge.

The bend line will also serve as the cut line.







**V 2.1 UPDATE:**

**It has come to our attention that forum members have had success with a clean gapless install by modifying our instructions slightly. After initially applying the tape, please follow this cut line for the best fit:**

**From Tacoma World member Wildpeak**

"...and here's what I recommend instead, as I successfully executed a cut line modification and achieved a "gap-less" install on a friend's truck (simply taper the cut line about 1/4" back from the SSO instructions on each side of the lip before it angles/curves down to the ground as shown by the black marker"



















**READ THIS SECTION ENTIRELY AND WEAR SAFETY GLASSES OR FACE SHIELD WHEN CUTTING. SEVERE INJURY TO EYES CAN OCCUR FROM MELTED PLASTIC FLUNG DURING CUT.**

Use a dremel tool with a rip saw wheel or a high speed cutting disk and CAREFULLY make the cut on the long horizontal line first. The high speed cutting disk has a high likelihood of melting plastic rather than a sharp cut. Use a rip saw blade to ensure accuracy and control. Take your time and keep repositioning your hands and body to maintain as much control as possible while cutting down the line. It is alright to stop, reposition, and then begin cutting again.





After making the initial long cut, cut down each side following the outside edge of the painters tape, but leaving enough oem bumper to install the supplied edge trim. You should now be left with a piece like this:





Remove black plastic air flow ducting on either side of the radiator.



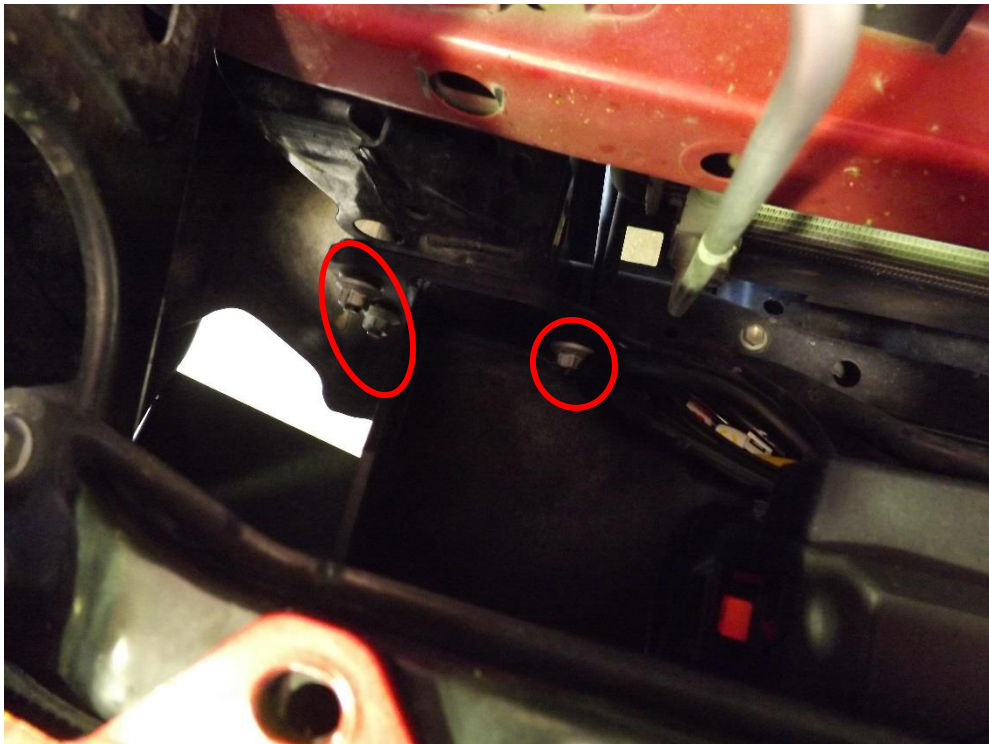
Using 10mm/Phillips screws and pushpins, reinstall the OEM bumper back on to the truck. Some original mounting points will be unavailable, but use as many as possible. Install the grill and all of the pushpins from the top as well as the Phillips head screws into the fender wells and top of grille. **Go in reverse from instructions on pages 3-8.**

**IMPORTANT: Install led lights and the winch before bolting the bumper to the truck. If installing a winch, a minimum of 2 people is required to safely complete the job.**

Line the Slimline bumper up to the whole opening in the OEM bumper cover. Notice that the mounting pads on the frame of the truck match up with the mounting pads on the Slimline bumper. The leg with a single bolt hole is for additional strength by connecting the lower radiator support to the main frame rails through the bumper.

With a team of 2 to 3 people CAREFULLY install the bumper to the truck by first locating bolts to the appropriate bumper bolt hole. With 3 people, 2 will carry the weight of the bumper and accessories while the third has the job of ensuring bolt hole alignment, frame bolt tightening, and that the truck/bumper is not damaged during installation.

After the bumper has been slid into place, start threading as many frame bolts until hand tight. If you secure a top and bottom frame bolt on each side, you will be able to begin releasing the bumper so that the truck is supporting all of the weight. There is also 1 bolt on each side located to the inside of the bumper which are accessed through the top of the engine bay.



Also install the supplied m12 bolts into the radiator support through the leg on each side of the Slimline bumper. The crash bar houses the captive nut for this bolt. Be certain it is in place.



Use this opportunity to adjust the bumper slightly so that all body lines match before tightening down.





Install the remaining brackets from under the truck on both sides. These brackets are to reinforce the oem bumper cover by providing a rigid surface to mount. Install the short portion of the L bracket to the slimline hybrid bumper using the supplied flange head 1/4" bolts and washers. Align the single hole on the oem bumper wing to the newly installed bracket and finger tighten down with the supplied flange head 3/8" bolt. Repeat on other side. **Driver side bracket shown below.**



With all bolts still relatively loose, align the Slimline Hybrid as well as oem plastic bumper cover for best fitment. Once fitment has been found, slowly tighten all m10, m12 and also the wing bracket bolts. Tighten m10 nuts to 75 ft/lbs and m12 bolt to 110 ft/lbs.



**CONGRATULATIONS! You've just successfully installed your Southern Style OffRoad Slimline Hybrid Tacoma bumper. Below are some included photographs of proper alignment and fitment to the body of the truck.**





