

RELENTLESS FAB 2005-15 TACOMA HIGH CLEARANCE REAR BUMPER

INSTALLATION GUIDE

THANK YOU FOR YOUR PURCHASE!

Note: we recommend professional installation on all of our products. Please fully read install guide prior to attempting installation to ensure you have a complete understanding and all required tools and procedures. If you are not confident in your ability to complete the procedure please seek professional installation. Be aware that the bumper is heavy! You will need 2-3 people to lift the bumper into position to secure it to the vehicle. **We assume no responsibility for any injury or property damages from installation or use of our bumper.**

TOOLS/PARTS REQUIRED:

- ½" and Drive Ratchet with assortment of Deep/shallow sockets and drive Extensions. 17mm socket needed
- Standard and/or ratchet wrenches: 11/32", 7/16", 10mm, 12mm, 17mm, etc
- Strong scissors/shears, or Razor for cutting plastic fender liners
- Rotary cutting tool: small angle grinder, Pneumatic cutoff saw, etc.
- Masking tape
- Flat and Philips screw drivers
- Wiring tools/connectors/loom/etc for any lights you plan to install.

INCLUDED HARDWARE:

- 2) #12 machine, with 2 nyloc nuts and 2x finish washers for license install
- 2) #10 machine, with 2 nyloc nuts for license lights

We always recommend working on a clean and dry vehicle. We STRONGLY recommend wearing safety glasses throughout the install process to keep debris from within the

bumper/fenders from falling into your eyes while under the truck, as well as for protection when cutting the bed sides.

Read each step of the install procedure fully before beginning that step. With the vehicle parked on level ground, transmission in park, and parking brake securely set begin the install process:

STEP 1:

Original bumper removal and preparation:

While lying on the ground (use a creeper if you have one), disconnect the wiring connector(s) at the driver frame rail for the trailer wiring and license plate light harness.

Next remove the back 4 of the 5 silver zinc bolts on each side frame rail holding the trailer hitch/bumper with your 17mm socket/ratchet. The front-most bolt should be left in place and only loosened half way to free the slotted cut in the mount plate. With 2 people, Lift up on the back of the bumper and pull straight rearward to release the bumper pins from the frame and remove from truck. With the bumper removed, now remove the 2 black plastic trim pieces from under the tail lights/next to the tail gate hinges. There are 3 plastic clips securing them, pop the clips out with a flat screw driver or similar pry tool, and discard the trim pieces and clips.

STEP 2:

Bedside trimming:

To begin preparing for the installation of the new Relentless high clearance bumper we'll need to trim away the bed side.

The best way to mark the cut line is to use masking tape to lay a cut line to follow. The tape line should start at the bottom forward edge of the tail light and go forward parallel to the top of the bed rails. The approximate measurement for this cut is 16 5/8" as measured downward from the lower edge of the plastic bed rail cap, while aligned at the rear edge of the fender flare. See image below. If your truck has aftermarket rail caps or a bed canopy these may interfere with making this measurement. Make adjustments as necessary for your accessories!

After laying the tape line but before making this cut: remove the 2) 10mm head bolts securing the lower bed side brace from the truck bed within the rear fender wells and trim the plastic inner fender liner along the inside of the fender flare up to the approximate finish cut location on both the sides of the bed. We'll adjust the trim of the liners later when bolting up the bumper to keep a clean looking fender well.

Be sure not to cut bed sides too high, we can always remove more material if needed but we can't put material back if too much is cut! With all the prep done double check measurements and then cut away the bed side with your cutting tool. We recommend initially cutting about 1/8" to 1/4" below the tape line to allow for possible adjustment to the cut! The bumper is designed with 1/2" of vertical slot in the mounts to make it possible for fitting and adjustment when mounting.

After both side cuts have been made do a test fit of the bumper to ensure both cuts are parallel before touching up the cut. At this point we'll need to touch up, fine tune and sand down our cuts until smooth. Then paint the cut edge to seal it and prevent rust. We also recommend using a quality edge trim product to help protect the edge and protect against the sharpness of the sheet metal.





STEP 3:

Relentless Bumper install:

We are now nearly ready to bolt on your new bumper!

At this time, transfer over your license plate and the license plate light housings from your old bumper into the new bumper and secure with the included hardware (larger machine screws and finish washers are for license, smaller for license lights). For bumpers with a hidden hitch we recommend using the flip up light bracket sold by Rugged Ridge part number RGG-1123301, which can be purchased on Amazon.com, SummitRacing.com, and other online retailers. Other hinged license brackets may work but will likely need mounting holes drilled for a different pattern.

We're now ready to lift the bumper onto the vehicle for final installation. We recommend you do this with 2 to 3 people or a hydraulic lift and then secure the bumper with the 5 original hitch bolts into each frame rail. Position the bumper ¼ to 3/8" below the cut to allow for movement/frame flex while off-road. Torque mounting bolts to 80ft/lbs. Route and reconnect the license light wiring under the back of the truck inside the bumper and reinstall the bulbs into the housings.

Lastly, if applicable, run your accessory reverse light wiring harness safely and securely along the frame rail away from any sharp edges that could rub through the wire casings, and connect the light wiring per the light manufacturer directions.

Congratulations on completing the installation of your new Relentless Off-Road Fabrication bumper! We hope you enjoy your new bumper for years to come!

Be sure to re-check torque on all bolts after the first 250 miles of use, and periodically thereafter as parts can settle or rattle loose from off-road use. Bumper may shift if not kept properly tightened.

If you have any questions or comments please feel free to contact us Mon-Fri 9am-5PM PST at 775-200-0544 or any time via email: Sales@relentlessfabrication.com