



# INSTALLATION INSTRUCTIONS

<b>PART #</b>	<b>074ST17A89B</b>
<b>Product:</b>	<b>FRONT BUMPER T17</b>
<b>Vehicle:</b>	<b>Toyota TACOMA 2016 / ON (Third Gen)</b>

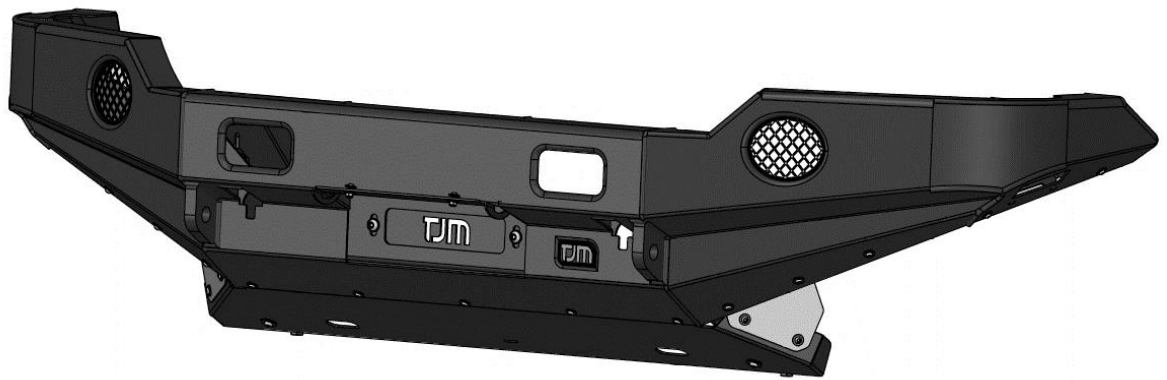
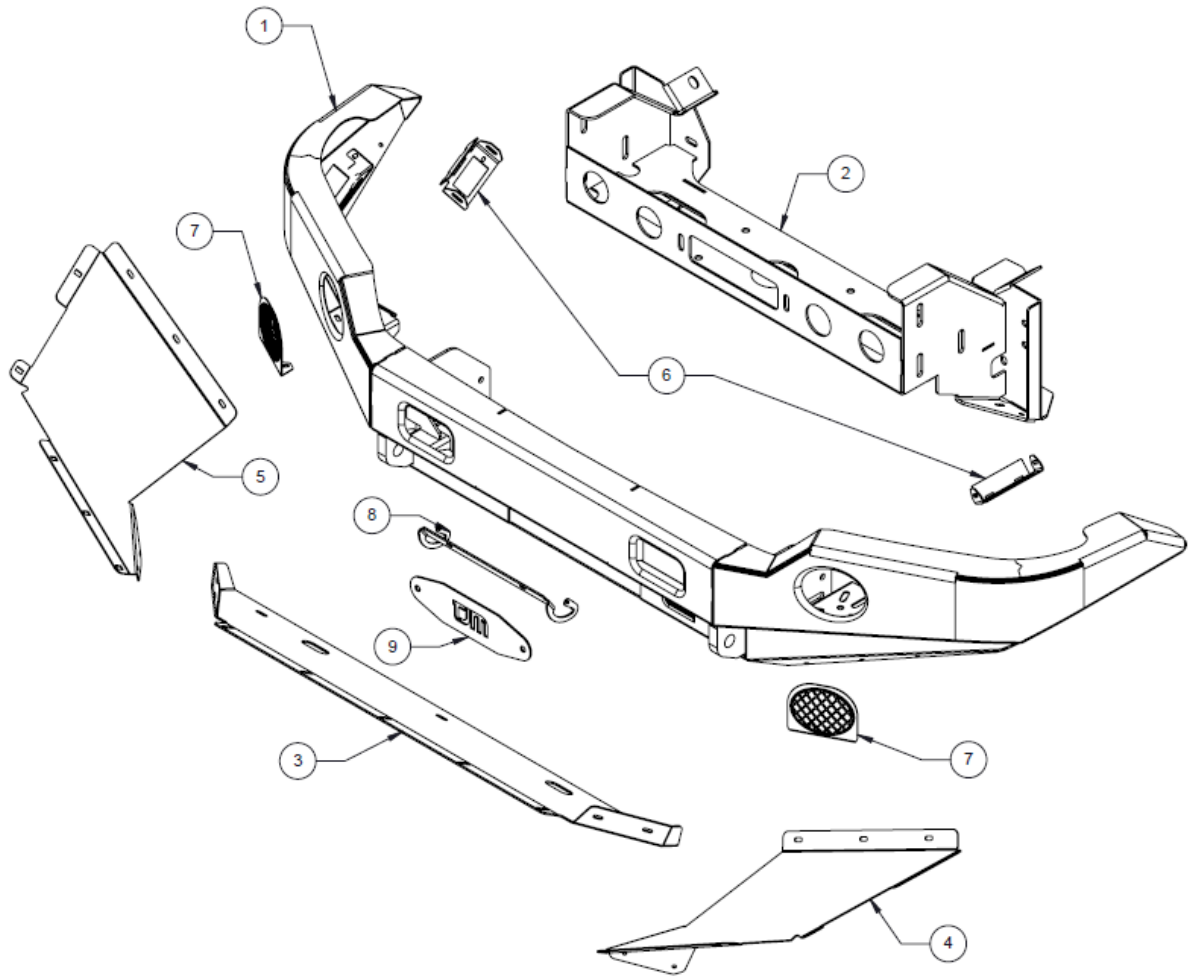
## WARNING

- Read instructions completely before commencing fitment.
- Always use personal safety equipment while cutting or operating tools.
- Left hand & Right hand components are determined as seated in the vehicle.
- Check & remove any build up in all captive nuts, if fitted to the product.
- Check scale on bumper template before cutting if applicable.
- After installation, place these instructions in the glove compartment of the vehicle.

**Torque all hardware to the following settings unless stated otherwise;**

	Metric			Standard		
	Bolt Dia. (mm)	Nm	ft. lb	Bolt Dia. (inch)	Nm	ft. lb
<b>TORQUE SETTINGS</b>	5	5	4	1/4"	9	7
	6	9	7	5/16"	22	15
	8	22	16	3/8"	33	27
	10	44	32	7/16"	55	43
	12	77	57	1/2"	86	66

- Do not attach this product using hardware not intended for this product.
- Only use hardware supplied by the TJM and specified in the instructions.
- Do not use this product for any vehicle make or model other than those specified by TJM.
- Do not remove any plaques or labels from the product.
- Modifying this product in any way may void any / all warranties.

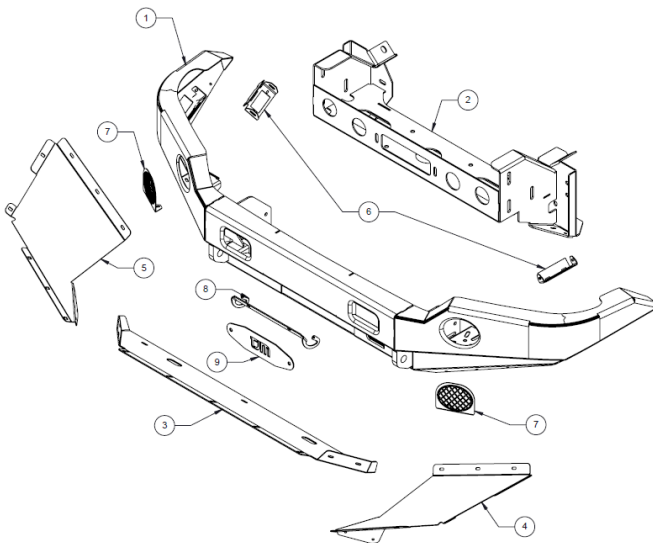


ITEM No.	Description	Qty.	Part #
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PARTS LIST			
1	BUMPER T17 WELD ASSY	1	F-12352
2	WHINCH FRAME WELD ASSY	1	F-12360

F-13002 FITTING KIT			
3	Centre Guard	1	F-12365
4	Wing Under Guard LH	1	F-12367L
5	Wing Under Guard RH	1	F-12367R
6	LED Rock light / blanking bracket	2	F-12448
7	Fog light Grille Cover	2	F-12820
8	License plate flip up bracket	1	F-12866
9	TJM Winch hole cover plate	1	F-12927

ROCK LIGHTS (OPTIONAL)			
1	ROCK LIGHT LED (PAIR)	1	92465



ITEM No.	Description	Qty.	Part #
F-13001 BOLT KIT			
1	M5 x 0.8 ZP NYLOC NUT	2	-
2	M5 x 15 x 1.2 ZP WASHER FLAT	4	-
3	M5X0.8X25 SOCKET HEAD CAP BOLT ZP	2	-
4	M6 x 1.0 - Flange Nut ZP	5	-
5	M6 x 1.0 Cage Nut (1.7mm - 2.5mm Panel) - SS304	10	-
6	M6 x 1.0 x 20 BUTTON HEAD SCREW - SS304	29	-
7	M6 x 1.0 SS304 - NUT HEX NYLOC	14	-
8	M6 x 12 x 1.6 SS304 - WASHER FLAT	48	-
9	M8 x 1.25 - NUT HEX NYLOC SS304	2	-
10	M8 x 24 x 2.0 - SS304 WASHER FLAT	4	-
11	M8 X 25 X 1.25 SS304 BUTTON HEAD SCREW	2	-
12	M10 x 1.25 x 35 HEX SCREW - ZP	4	-
13	M10 x 1.25 ZP - NUT NYLOC	4	-
14	M10 x 1.5 SS304 - NUT NYLOC	2	-
15	M10 x 20 x 2.0 - SS304 Washer Flat	4	-
16	M10 x 30 x 2.5 ZP - WASHER FLAT	8	-
17	M10 X 25 X 1.5 BUTTON HEAD SCREW SS304	2	-
18	M12 x 1.75 x 35 HEX BOLT ZP	12	-
19	M12 x 1.75 ZP - NUT NYLOC	12	-
20	M12 x 37 x 3.0 ZP - WASHER FLAT	22	-
21	M12 x 44 x 4.0 ZP - WASHER FLAT	2	-
22	Number-Plate Hinge Bush	2	-
23	BUMPER TRIM PINCH WELD 1 X 300MM LENGTH	1	-
24	Cutting Template #1 L & R	1	F-12551

### FOG LIGHT / LED FITMENT.

Bumper has been designed to work with most available 3" round or square aftermarket lights.

## VEHICLE PREPERATION



Right hand side of vehicle shown.

1. Remove license plate (if fitted) and discard fitting hardware.
2. Cut out and apply bumper cutting templates (**Part # F-12251**) to vehicle as shown.
3. Follow instructions shown on bumper cutting templates.



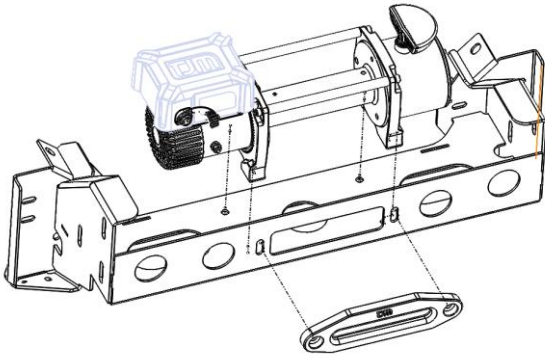
Right hand side of vehicle shown

4. Along the dashed edge of the template, mark on the bumper and then cut using an air saw.
5. Repeat the previous four steps for the opposite side of the vehicle.
6. Apply glue or silicon inside the pinch weld and fit to bumper cut as shown. Clean up any excess glue or silicon.
7. Remove (& discard) the front intrusion beam & mounting brackets from the front of the chassis. Retain O.E. fasteners.

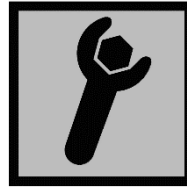


Always wear personal protective equipment while operating hand tools.

## BUMPER PREPERATION

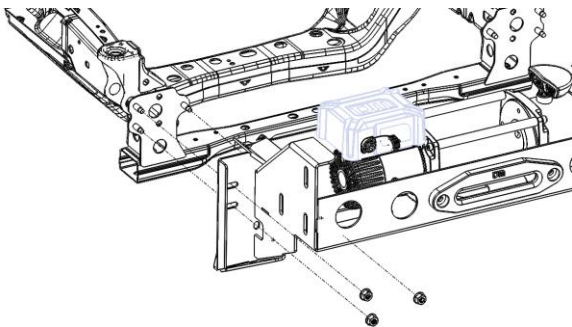


8. Install winch to frame using hardware supplied by winch manufacturer.
9. Install hawse / fairlead using manufacture supplied hardware.
10. Winch and hawse kit shown (optional); **Part # 947TQBLK95DDS.**
11. If no winch is to be installed, fit the TJM fairlead cover plate using M12 stainless steel hardware.



See manufactures instructions for winch bolts.

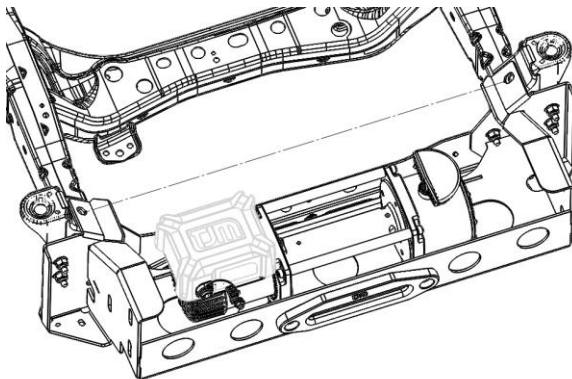
M12 – 77 Nm.



12. Install winch frame to chassis using factory hardware finger tight only.



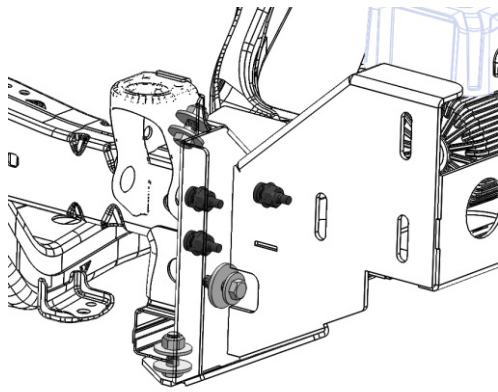
M10 – 44 Nm.



13. Centre the winch frame to the vehicle.
14. Torque forward facing chassis bolts installed in previous step to specification.
15. Reinstall factory M12 bolts if removed previously. If captive nuts in end caps are not available, fasten lower flanges using M12 hardware supplied.



M12 – 77 Nm.

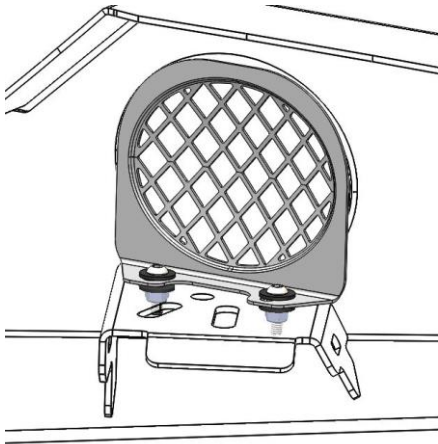


16. Install center chassis bolt as shown Using M12 hardware. Use larger M12 (44mm) washer on inside of chassis. Torque to specification.

17. Install top chassis bolts using M12 hardware supplied. Torque to specification.



M12 – 77 Nm.

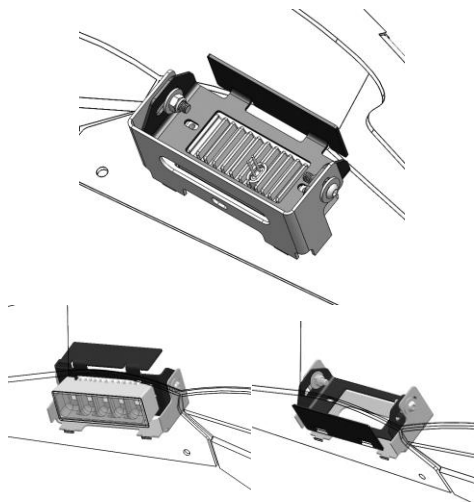


18. Align to front of bumper and install fog light cover grille using M6 hardware as shown.

19. Install (optional) fog lights / LED to bracket using hardware supplied by lighting manufacturer (purchased separately).



M6 – 9 Nm.



*Rock light installed.*

*Blanking plate installed.*

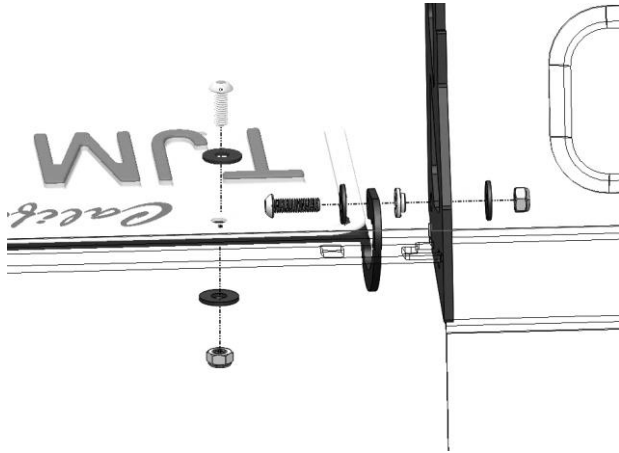
20. Install rock lights (**OPTIONAL, PART # 92465**) to mounting brackets as shown using hardware supplied with rock light kit. Position and install rock lights and align level to face of wing. Toque M6 hardware to specification.

21. Install blanking plug using M6 hardware if no rock lights are to be fitted.



M6 – 9 Nm.





- 22. Install license plate to bracket as shown if removed in prior steps.
- 23. Install license plate flip up bracket to bumper as shown using M5 hardware.  
**Note:** Nylon washer K1292 placement as shown.
- 24. Tighten until the number plate and bracket hold their upright position while maintaining movement without excessive force.



M5 – 5 Nm.



**NOTE:**  
The following option is only available if the bar is **NOT** fitted with a license plate and/or winch.

- 25. Slots have been provided to install a small light bar (purchased separately) as shown in the winch access hole.

**Note: Slot width for light bar is 9" (229mm).**

- 26. Use light bar manufacture hardware to install.

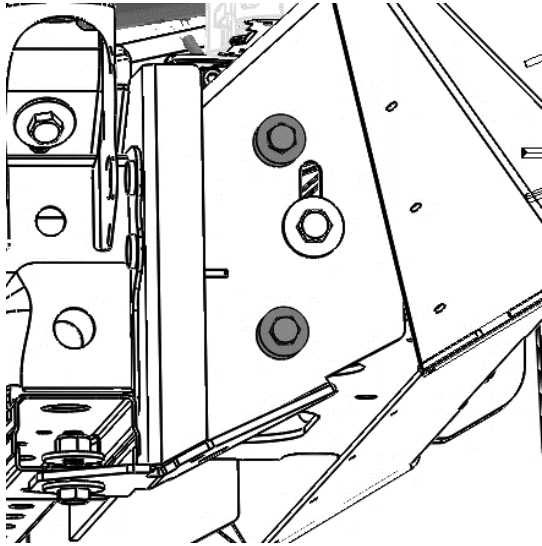


- 27. Install bumper to winch frame. Finger tight M12 hardware from bumper to winch frame and align to vehicle.
- 28. Loosen and adjust winch frame **only if** sideways adjustment is further required from previous step.

- 29. Once aligned, torque all M12 hardware to specification.



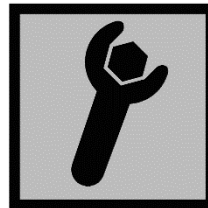
M12 – 77 Nm.



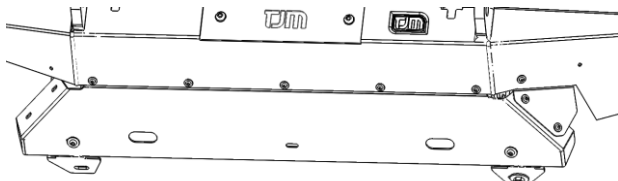
30. Using an M10 (3/8<sup>th</sup>) drill bit, drill pinning bolts, apply paint to drilled holes and then fasten using M10 hex bolts and m10 hardware as shown.



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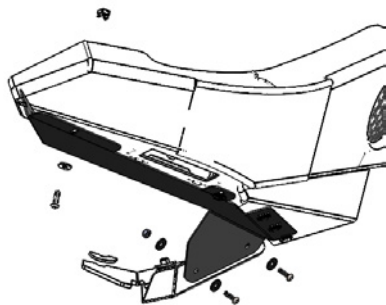
M10 – 44 Nm.



31. Install M6x1.0 (LARGE 3mm plate) cage nuts into the center stone shield.  
32. Fit to vehicle as shown using M6 SS hardware. Install M8 hardware to secure rear to chassis brackets.



M6 – 9 Nm,  
M8 – 22 Nm.

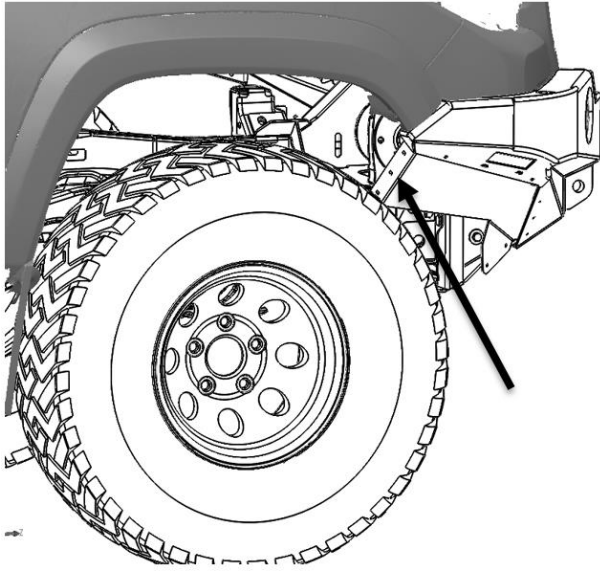


33. Install M6 x 2.5mm plate cage nuts into the left and right stone shields.  
34. Fit to bumper using M6 hardware as shown.  
35. Use Nyloc nuts to attach center stone shield.



M6 – 9 Nm.





36. Trim inner wheel guards and fit inside left and right stone shields. Install cable ties (not included) to secure inner guard to under panels only if required.



Always wear personal protective equipment while operating hand tools.



**074ST17A89B fitted to vehicle.**

Sliders shown are purchased separately (Part # 735STSSA89B).