



# Installation Instructions

<b>PART #</b>	<b>081ST37A89B</b>
<b>Product:</b>	<b>REAR BUMPER</b>
<b>Vehicle:</b>	<b>Toyota TACOMA 2016 + (Third Gen)</b>

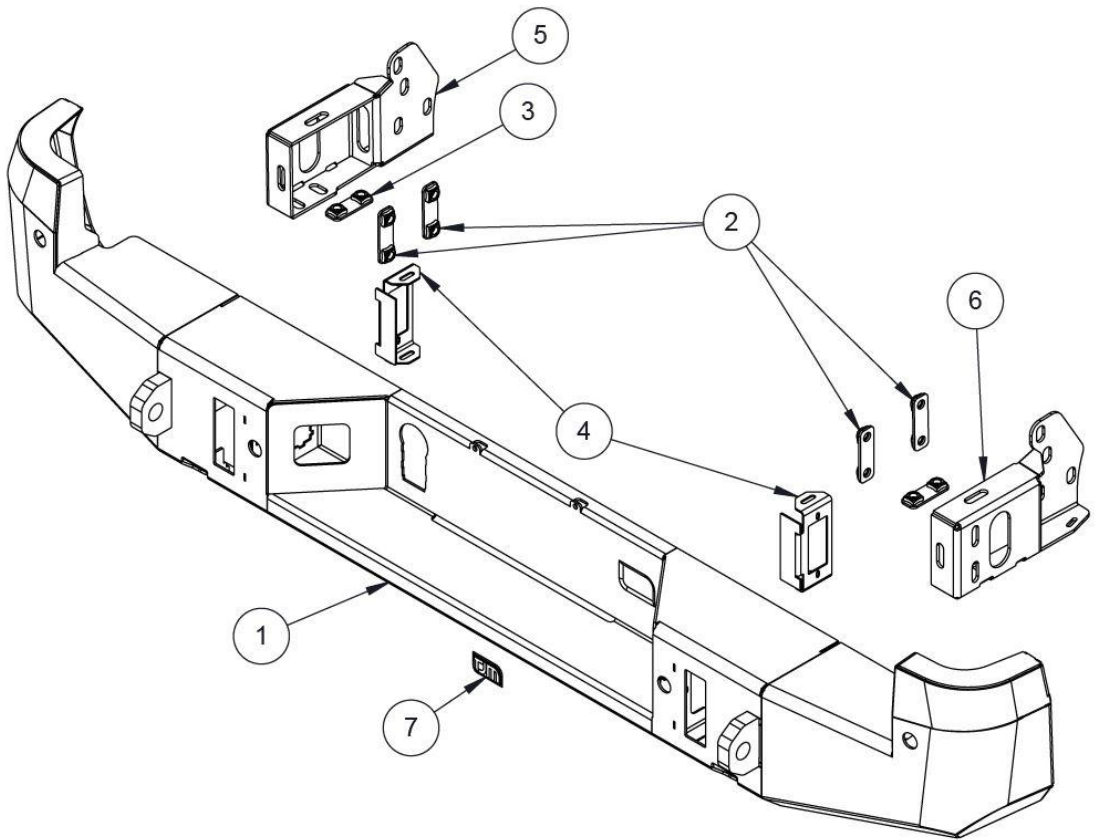
## WARNING

- 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
TORQUE SETTINGS	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	REAR BUMPER WELD ASSY	1	F-13347

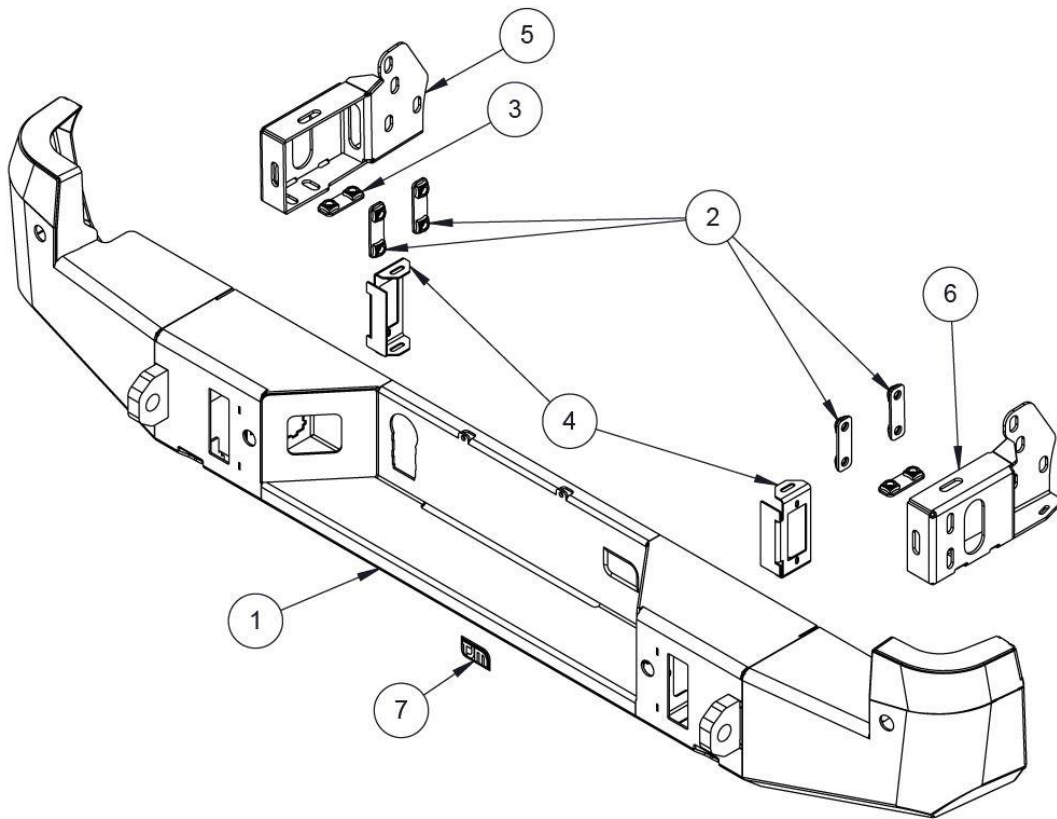
F-13357 FITTING KIT			
2	NUT PLATE M10x1.5x55MM ZP	4	F-14630
3	NUT PLATE M10x1.5x42MM ZP	2	F-14652
4	LED ROCK LIGHT / BLANKING BRKT	2	F-12448
5	CHASSIS BRACKET RIGHT HAND	1	F-13354L
6	CHASSIS BRACKET LEFT HAND	1	F-13354R

REVERSE / ROCK LIGHTS (OPTIONAL)			
-	ROCK LIGHT LED (PAIR)	1	92465

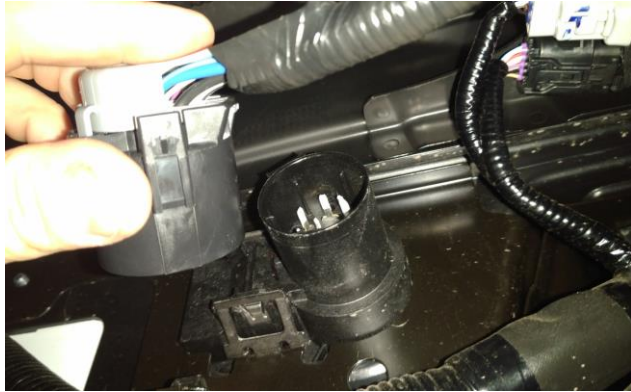
ITEM No.	Description	Qty.	Part #
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F-13358 BOLT KIT			
8	M6 x 1.0 - NUT NYLOC SS304	6	-
9	M6 x 1.0 x 16 BUTTON HEAD SCREW - SS304	6	-
10	M6 x 12.5 x 1.2 - WASHER FLAT SS304	12	-
11	M10 x 1.5 x 30 HEX BOLT - ZP	12	-
12	M10 x 30 x 3.0 WASHER FLAT - ZP	12	-
13	M10 x 3.5 x2.2 SPRING WASH ZP	12	-
14	BLANKING PLUG PLASTIC 22.3MM	4	-
15	CABLE TIE (BLACK) 200MM	8	-

FACTORY FITTED			
7	TJM STICKER SML	1	K3183



## VEHICLE PREPERATION



1. Remove trailer plug loom from the rear of the plug as shown.

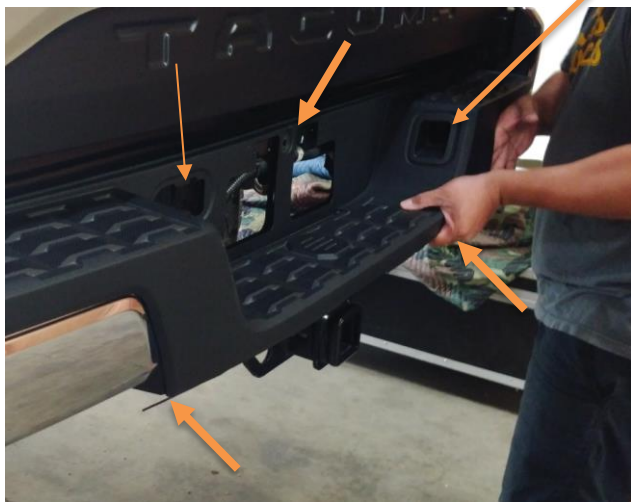


2. Remove the license plate light plug and parking radar loom if fitted at the connectors shown.
3. Remove number plate lights as shown.



**Hint:**

*Use a screw driver / pry bar to press in retaining clips from the inside of the bar while pushing unplugged light towards center of vehicle.*



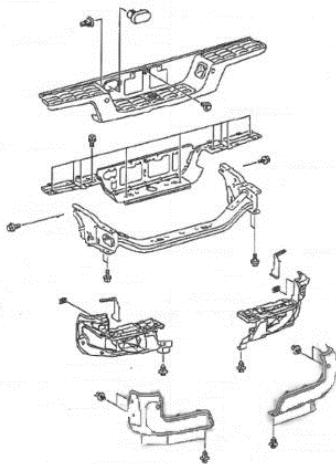
4. Remove license plate as shown and retain for re-fitment.
5. Remove upper center clip behind license plate and two lower clips as shown.
6. Carefully remove trailer plug connector and 4 x parking sensors if fitted. Retain for re-fitment.





**Note:**

Parking sensor location shown.



7. Remove the top step by pulling up and back on the top section.

**Note:**

Plastic clips retaining the factory bumper usually break when removing. The bumper and clips can be discarded once removed.



8. Remove the lower and upper bumperette retaining bolts as shown and remove the outer bumperettes as shown.



Left hand chassis bracket shown.

## CHASSIS BRACKET FITMENT



*Left hand chassis bracket shown.*

9. Remove the 4 rear bolts retaining the tow bar from the vehicle.
10. Position TJM chassis bracket and reuse factory hardware, finger tight only, allowing the bracket to be moved into position in the following step.

11. Insert a small (42mm Nut Plate) inside the chassis bracket as shown and fasten using M10 hardware finger tight only.

**Note:**

*M10 hardware, Use an M10 Bolt, M10 spring Washer and M10 flat Washer as shown.*



*Left hand chassis bracket shown.*



*Left hand chassis bracket shown.*

12. Repeat bracket installation on other side of vehicle.

**Note:**

**All hardware should be loose enough to allow chassis bracket adjustment for the following steps.**

## BUMPER PREPARATION



13. Install the trailer connector as shown.

**HINT:**

*A small amount of material may need to be bend using pliers or removed from the light bracket to achieve a firm fitment. Trim vehicle light bracket as required.*



*Always wear personal protective equipment while operating hand tools.*

14. Install license plate using M6 SS bolt, M6 washers and M6 nyloc nut as shown.



M6 - 9Nm.



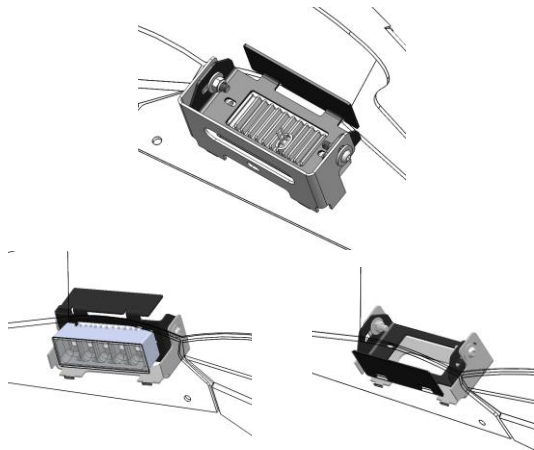
**If removed;**

15. Reinstall parking sensors into holes provided,

**OR**

16. Install parking sensor blanking plugs supplied in fitting kit.

17. Re run factory wiring harnesses to lights and OEM hardware installed.



Rock light installed.

Blanking plate installed.

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

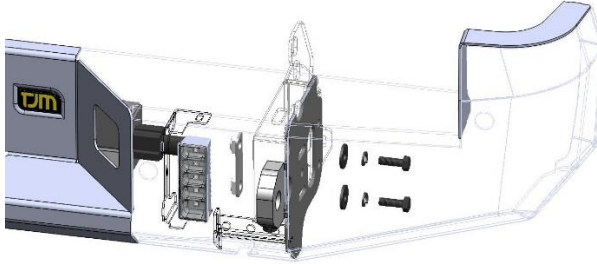


M6 – 9 Nm.

**OR**

19. Install blanking plug using M6 hardware if rock lights are NOT fitted.

## VEHICLE FITMENT



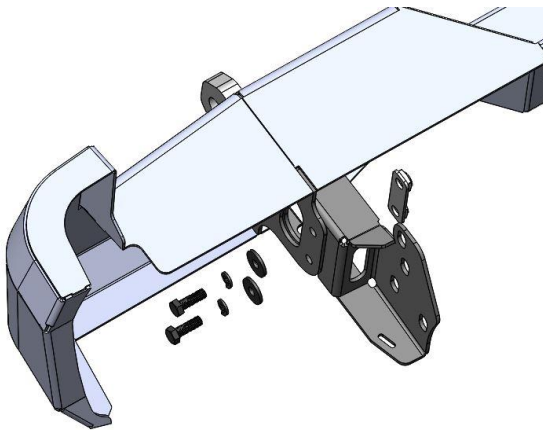
20. Fasten bumper to chassis brackets as shown using M10 hardware, finger tight only.
21. Align the bumper to the vehicle maintaining an even gap between the wings and the side of the vehicle.
22. Repeat steps on the other side of vehicle.
23. Torque all fasteners starting with factory tow hitch bolts to specification while checking clearance and fitment to vehicle.



M10 – 44 Nm.



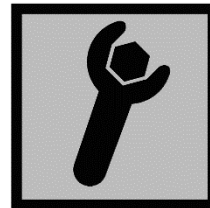
Check factory specification (M12 – 77 Nm).



24. Double check alignment to all bumper surfaces.
25. Using an M10 drill bit, drill pinning bolts, apply paint to drilled holes and then fasten using M10 hardware as shown.
26. Torque to specification.



Always wear personal protective equipment while operating hand tools.



M10 – 44 Nm.

Ensure all electrical leads and connections are secured using cable ties if required (not supplied).





**081ST37A89B**

*Note: Optional LED Lights fitted.*