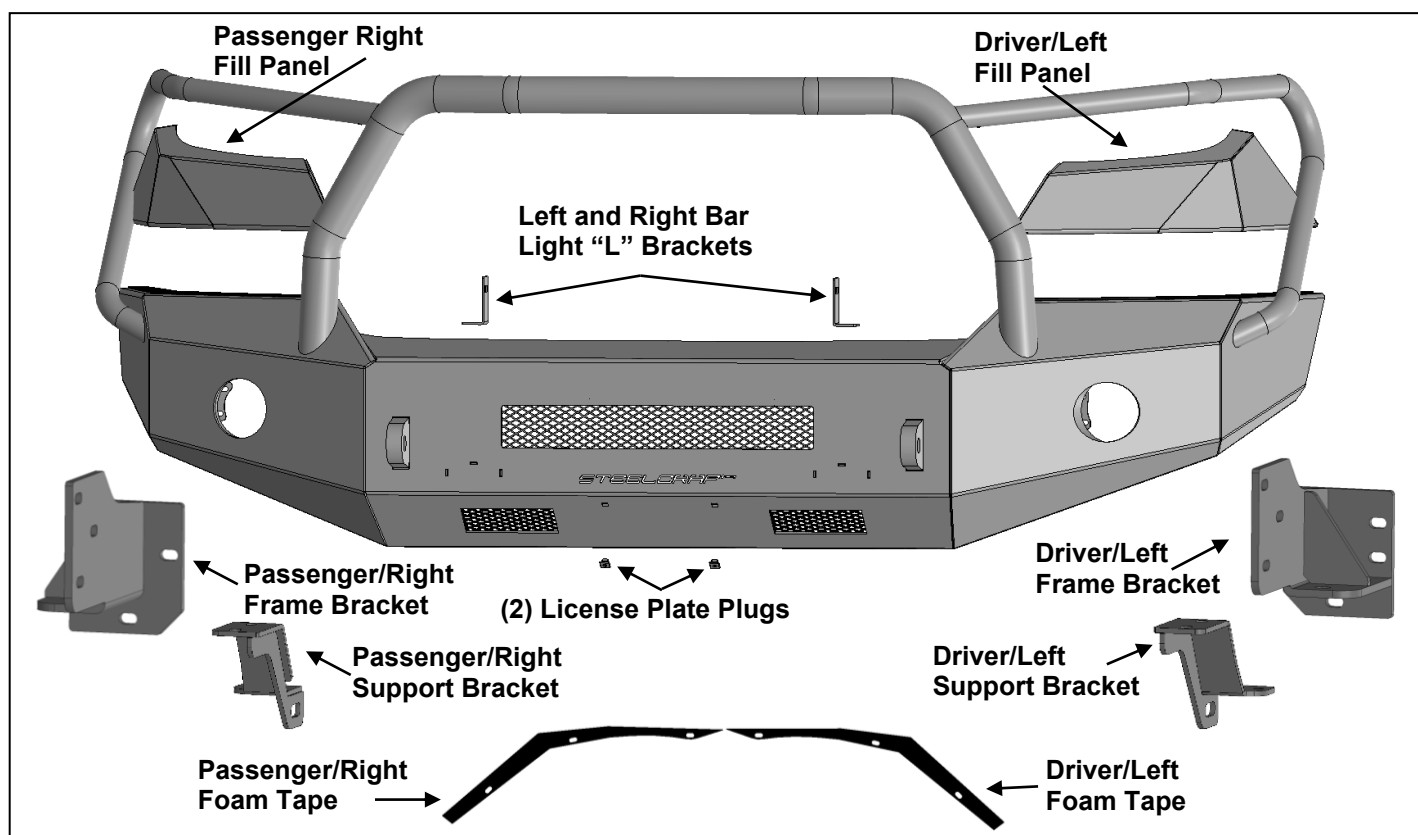


STEELCRAFT FORTIS MAXX FRONT BUMPER 2016-23 TOYOTA TACOMA

PARTS LIST:

1	Fortis Max Front Bumper	2	12-1.75mm X 120mm Hex Bolts
1	Driver/left Mounting Bracket	10	12-1.75mm X 45mm Hex Bolts
1	Passenger/right Mounting Bracket	24	12mm X 32mm OD X 3mm Flat Washers
1	Driver/left Support Bracket	12	12mm Nylon Lock Nuts
1	Passenger/right Support Bracket	2	8-1.25mm X 25mm Hex Bolts
1	Driver/left Filler Panel	2	8-1.25mm X 16mm Hex Bolts
1	Passenger/right Filler Panel	6	8mm X 24mm OD X 2mm Flat Washers
1	Driver/left LED light Bracket	4	8mm Lock Washers
1	Passenger/right LED light Bracket	2	8mm Hex Nuts
2	Plastic Plugs for License Plate	16	6-1mm x 25mm Hex Bolts
1	Allen Wrench	2	6-1mm x 20mm Button Head Bolts
1	Rubber Trim	20	6mm X 18mm Large Flat Washers
1	Driver/left Foam Tape	16	6mm X 12mm Small Flat Washers
1	Passenger/right Foam Tape	18	6mm Nylon Lock Nuts



PROCEDURE:

REMOVE CONTENTS FROM BOX. VERIFY ALL PARTS ARE PRESENT. SOME SMALL PARTS WILL BE HIDDEN IN WRAPPINGS. READ INSTRUCTIONS CAREFULLY BEFORE STARTING INSTALLATION. ASSISTANCE IS RECOMMENDED TO AVOID POSSIBLE INJURY OR DAMAGE TO THE VEHICLE. CUTTING IS REQUIRED.

1. Remove the license plate and bracket. Open the hood and remove the plastic cover from the top of the radiator and grille, (**Figure 1**). Next, carefully remove hardware and the plastic grille. **IMPORTANT:** Models with grille mounted sensor, unplug sensor before removing grille, (**Figures 2 & 3**).
2. Remove the air dam from the bottom of the bumper.
3. On models with factory fog lights, unplug both lights. Unplug the wiring harness leading to the bumper and move the harness out of the way.

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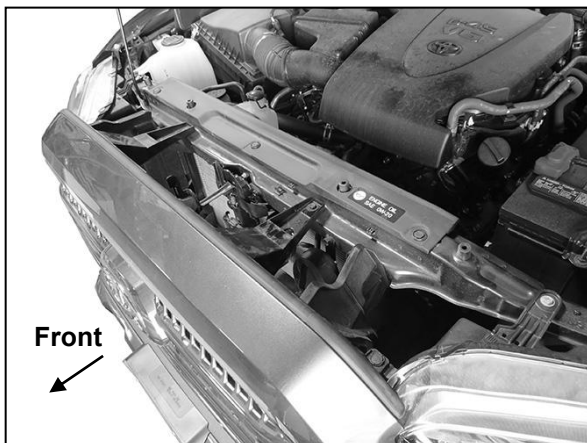
4. Carefully pull the front leading end of the fender flares, if equipped, to release the plastic flare from the bumper cover, **(Figure 4)**. The flares do not need to be fully removed, simply release the front portion and leave the rest of the flare attached.
5. Remove the hardware attaching the plastic bumper cover at the ends, the top and the bottom. With assistance, pop the ends off of the inner clip and pull the bumper off and away from the vehicle. Remove the plastic bumper mount from below the passenger/right side headlight, **(Figure 4)**. Reinstall the factory hardware to secure the headlight to the vehicle. Repeat to remove the bumper mount from the driver/left side of the vehicle.
6. Remove the aluminum inner bumper assembly with brackets from the end of the frame, **(Figure 5)**. Next, remove the bolt on the bottom of the frame for the frame extensions, **(Figure 6)**. Set the nuts and bolts aside for re-use.
7. Re-attach grille. Replace the OE plastic pushpins on each side with the included (2) 6mm x 25mm Hex Bolts, (4) 6mm x 18mm Large Flat Washers, and (2) Nylon Lock Nuts, **(Figure 7)**. **NOTE:** Use a wire tie, (not included), to secure the bottom of the grille to the inner crossmember under the grille, **(Figure 8)**. Plug wire harness into sensor/camera if equipped, **(Figure 2)**. Reattach radiator cover.
8. Select the driver/left Frame Bracket, **(Figure 9)**. Reuse the (3) factory hex nuts to attach the Bracket to the frame, **(Figures 9—11)**.
9. Insert (1) 12mm x 120mm Hex Bolt with (1) 12mm Flat Washer through the lower mounting hole in the Bracket and through the frame. Use the included (1) 12mm Flat Washer and (1) 12mm Nylon Lock Nut to secure the Bracket to the lower mounting hole, **(Figures 10, 11 & 12)** Snug but do not fully tighten hardware at this time.
10. Repeat **Steps 8 & 9** to install the passenger/right Frame Bracket.
11. Using the bolt removed in **Step 6**, attach the driver/left Support Bracket to the bottom of the frame. Then, attach the Support bracket to the Frame Bracket using (2) 12mm x 45mm Hex Bolts, (4) 12mm Flat Washers, and (2) 12mm Nylon Lock Nuts, **(Figure 13)**.
12. Repeat **Step 11** to the passenger/right side of the vehicle.
13. **Models equipped with fog lights:**
 - a. Select the driver/left fog light assembly. Attach the assembly to the (2) mounting tabs on the back of the Bumper with (4) 6mm Hex Bolts, (6) 6mm x 12mm Small Flat Washers and (4) 6mm Nylon Lock Nuts, **(Figure 14)**. Repeat this Step to attach the passenger/right fog light assembly.
 - b. Plug in the fog light harness to the lights and secure it to the Bumper.
14. **Optional Center LED light installation (sold separately).**
 - a. Select the L/R “L” Brackets, **(Figure 15)**. **NOTE:** “L” Brackets are offset for universal fitment for most LED bar style lights. Attach the LED light assembly to the “L” Brackets with the included (2) 8mm x 16mm Hex Bolts, (2) 8mm Lock Washers and (2) 8mm Flat Washers. Do not fully tighten hardware at this time. **NOTE:** “L” Brackets may require modification for hardware larger than 8mm or use brackets supplied with light if possible.
 - b. Attach the light and Brackets to the top of the (2) tabs on the back of the Bumper with the included 8mm x 25mm Hex Bolts, (4) 8mm Flat Washers, (2) 8mm Lock Washers and (2) 8mm Hex Nuts, **(Figure 15)**. Adjust light position and tighten hardware.
 - c. Follow light manufacturer’s instructions to wire the light once Bumper has been fully installed.
15. Apply the supplied foam tape along the bottom of each Fill Panel. Press it down firmly so it sits flat, and make sure the holes in the tape line up with the mounting holes in the panel, **(Figure 16)**.
16. Select the driver/left Bumper Upper Fill Panel, **(Figure 17)**. Attach the Fill Panel to the top of the Bumper with (3) 6mm x 25mm Hex Bolts, (6) 6mm Flat Washers and (3) 6mm Nylon Lock Nuts. Line up the edges of the Fill Panel with the Bumper and leave loose so adjustments can be made later. Repeat this Step to install the passenger/right Fill Panel.
17. Optional: Press the Rubber Trim firmly along the inside edges of the Bumper for paint protection during install. **(Figure 18)**. Snip off excess as necessary.
18. With assistance, position the Bumper Assembly up to the outside of the Frame Brackets. Temporarily support the weight of the Bumper. **WARNING:** To avoid possible injury or damage to the vehicle, do not proceed until the Bumper is fully and safely supported.

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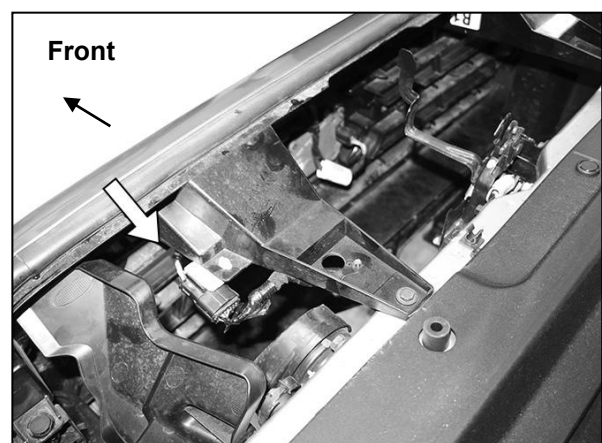
19. Line up the driver/left side mounting plate on the back of the Bumper with the (3) slots in the Frame Bracket. Attach the Bumper to the Bracket with the included (3) 10mm x 40mm Hex Bolts, (6) 10mm Flat Washers, (3) 10mm Lock Washers and (3) 10mm Hex Nuts, **(Figures 19 & 20)**. Do not fully tighten hardware at this time. Repeat this **Step** to attach the passenger/right side of the Bumper.
20. Level and adjust the bumper and fully tighten all 10mm hardware to 35-37ft-lbs. Fully tighten Fill panels from **Step 16**.
21. Use the included (2) push-in plastic nuts to attach the front license plate, (if required), to the (2) holes in the front bumper, **(Figure 21)**.
22. Cover the driver/left plastic fender flare with removable tape, (masking tape for example). Hold the fender flare in position on the fender and over the end of the Bumper. Draw a straight line onto the tape to match where the end of the fender and Bumper meet, **(Figure 22)**. Use a sharp knife or hacksaw blade to carefully cut the leading end off of the flare along the line. Reattach the fender flare to the fender. Repeat to cut the passenger/right fender flare.
23. Secure the fender liner to the bumper by using (2) 6mm x 20mm Button Head Bolts, (4) 6mm Flat washers, and (2) 6mm Nylon Lock Nuts, through the hole, **(Figure 23)**. Trim the fender liner so it sits flush with the bottom of the bumper.
24. Do periodic inspections to the installation to make sure that all hardware is secure and tight.

To protect your investment, Do not use any type of polish or wax that may contain abrasives that could damage the finish. Mild soap may be used to clean the Front Bumper assembly.

Driver/left Side Installation Pictured



(Fig 1) Remove plastic cover from top of radiator



(Fig 2) Models equipped with grille mounted sensor, unplug sensor before removing grille



(Fig 3) Remove grille, air dam from below bumper and license plate. Remove plastic bumper cover



(Fig 4) Remove plastic block (arrow) from front edge of fender. Reinstall hardware to secure headlight

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Driver/left Side Installation Pictured



(Fig 5) Remove plastic impact bumper and aluminum crossbar from bumper brackets



(Fig 6) Remove aluminum inner bumper from frame. Remove bolt (arrow) and set aside for reuse.

**6mm x 25mm Hex Bolt
(2) 6mmx18mm Flat Washers
6mm Nylon Lock Nut**

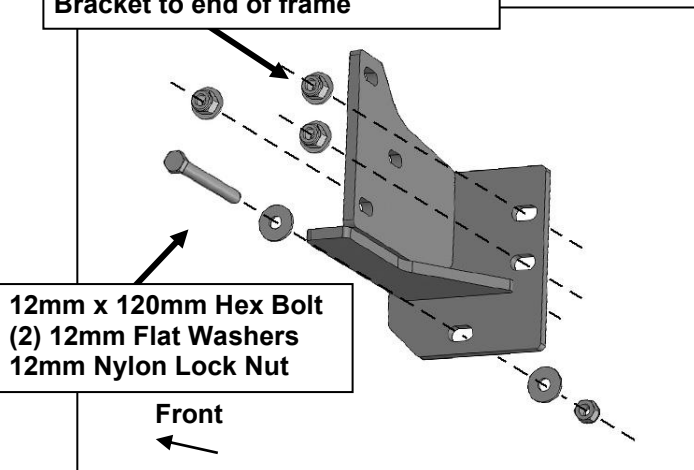


(Fig 7) Replace OE plastic pushpin with supplied hardware



(Fig 8) Use a wire tie (arrow-not included) if needed to attach the bottom of the grille to the inner crossmember

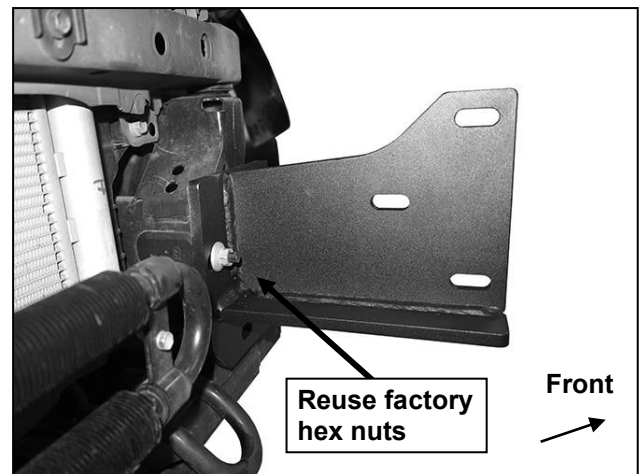
**Reuse (3) factory hex nuts to
attach driver/left Frame Mounting
Bracket to end of frame**



**12mm x 120mm Hex Bolt
(2) 12mm Flat Washers
12mm Nylon Lock Nut**

Front

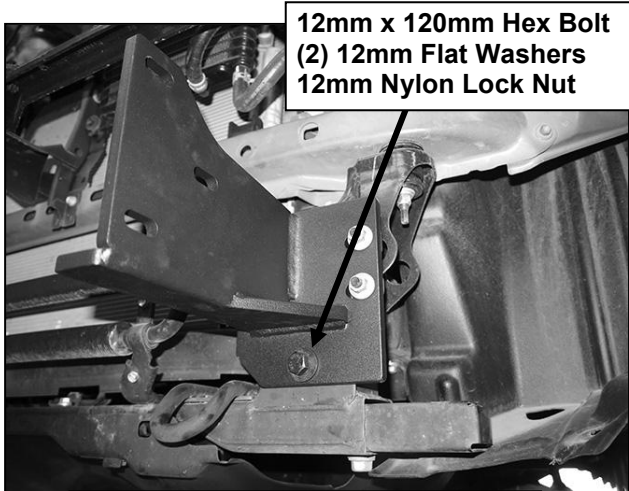
(Fig 9) Attach driver/left Mounting Bracket to end of frame



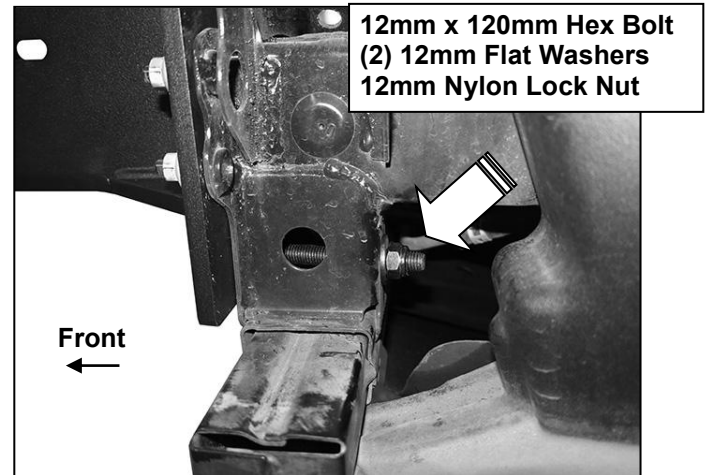
**Reuse factory
hex nuts**

(Fig 10) Driver/left Mounting Bracket attached to end of frame

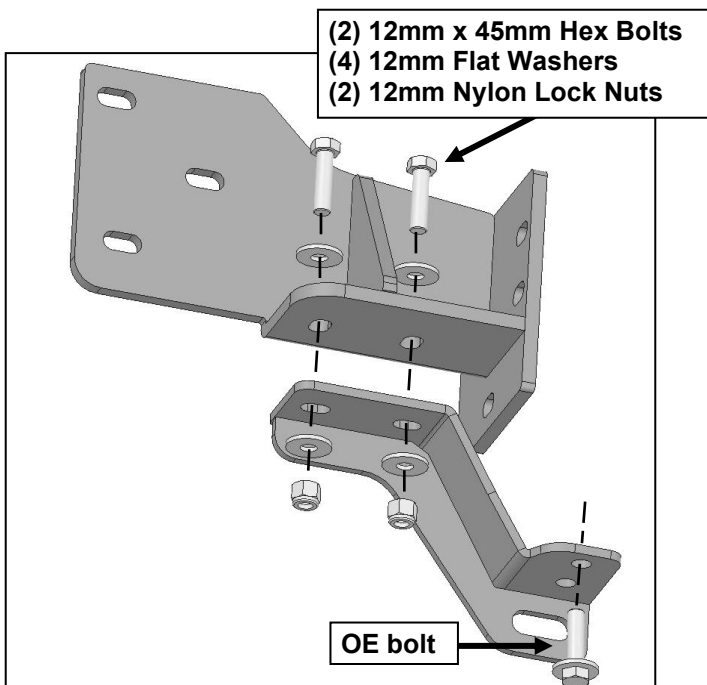
Driver/left Side Installation Pictured



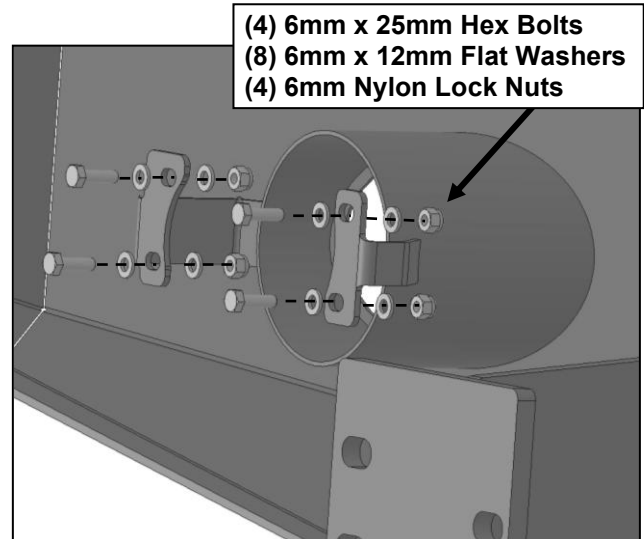
(Fig 11) Driver/left Mounting Bracket attached to end of frame



(Fig 12) Insert 12mm x 120mm Hex Bolt through Bracket and cross member



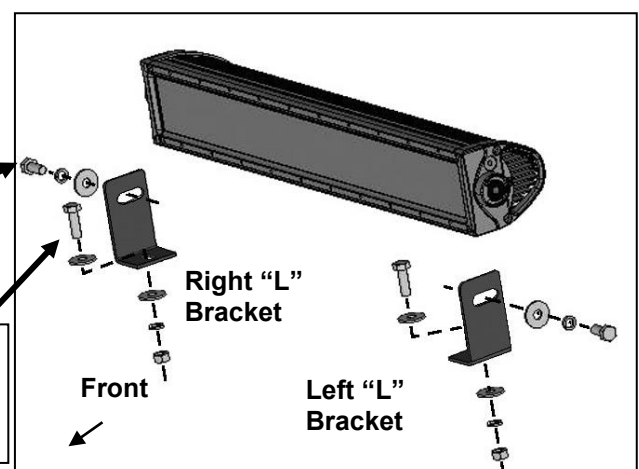
(Fig 13) Attach Support Bracket to Frame Bracket and bottom of frame using OE bolt from (Fig 6)



(Fig 14) Attach fog light to mounting tabs

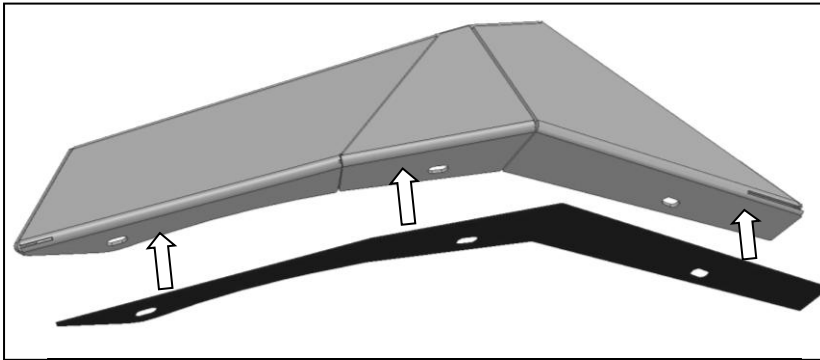
(2) 8mm x 16mm Hex Bolts
(2) 8mm Lock Washers
(2) 8mm Flat Washers

(2) 8mm x 25mm Hex Bolts
(4) 8mm Flat Washers
(2) 8mm Lock Washers
(2) 8mm Hex Nuts

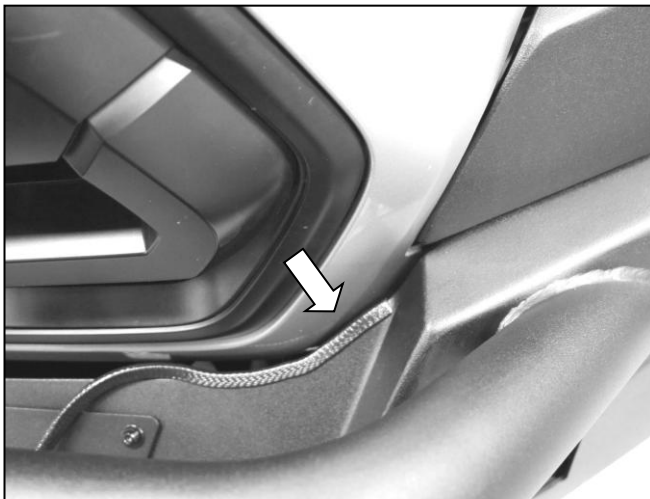


(Fig 15) Example of center light installation

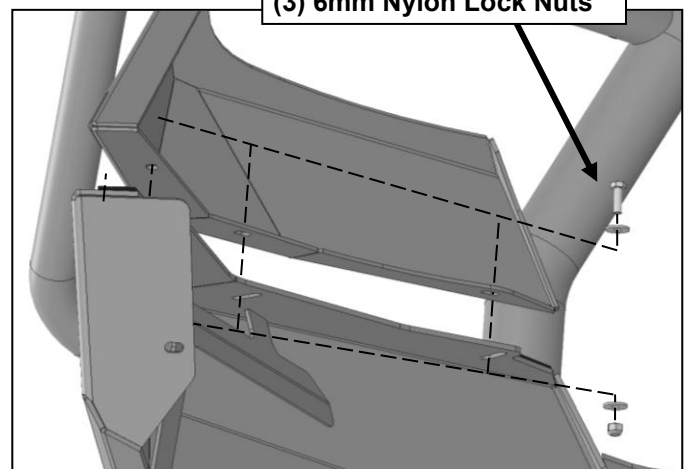
Driver/left Side Installation Pictured



(Fig 16) Apply Foam Tape to the bottom edge of Fill Panel

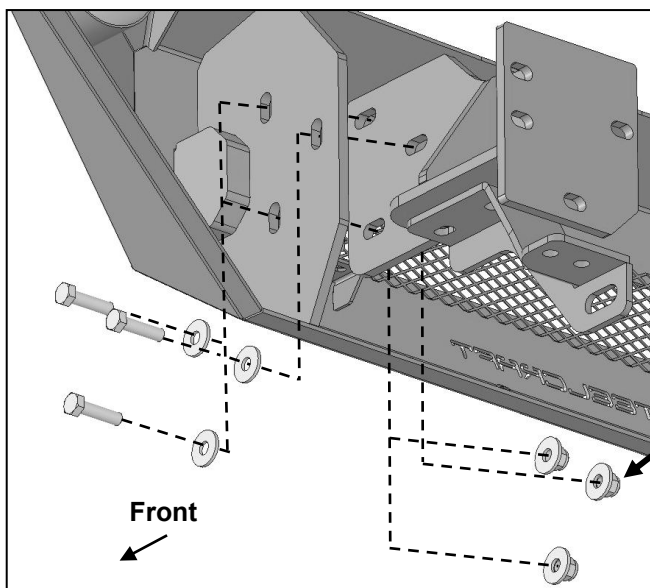


(Fig 18) Press the Rubber Trim along the inside edge of the Bumper and across the top edge of the Fill Panel.



(Fig 17) Attach Fill Panel to top of Bumper

WARNING! Do not crawl under bumper unless it is properly supported on blocks or stands or the bumper may fall.

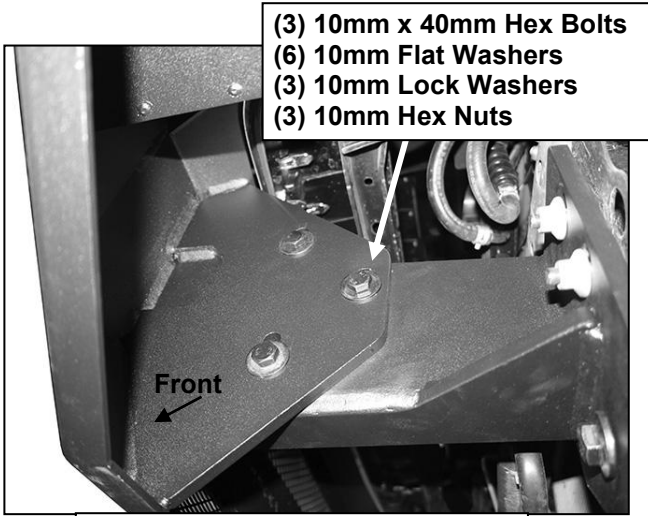


(Fig 19) Attach Bumper to Frame Brackets

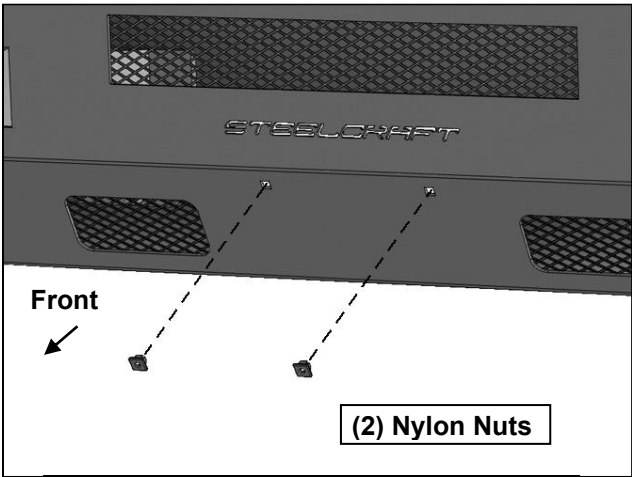
- (3) 10mm x 40mm Hex Bolts
- (6) 10mm Flat Washers
- (3) 10mm Lock Washers
- (3) 10mm Hex Nuts

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Driver/left Side Installation Pictured

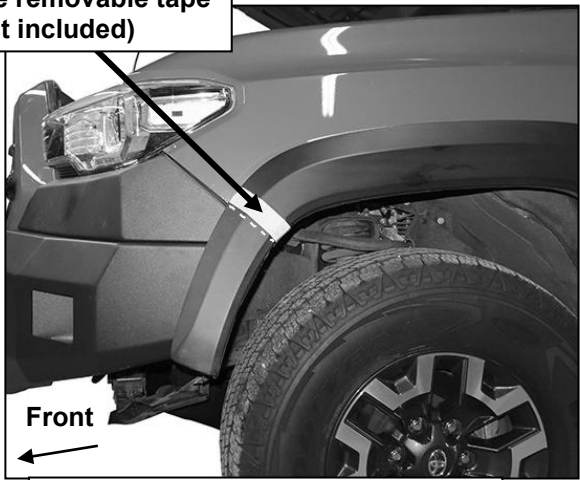


(Fig 20) Driver/left side of Bumper attached to Bracket



(Fig 21) Attach License Plate to Bumper

Use removable tape
(not included)



(Fig 22) Cut front end off of the fender flare to match up to Bumper



(Fig 23) Secure the fender liner to the bumper using the 6mm button head bolt through the mounting hole shown. Trim liner as necessary.

