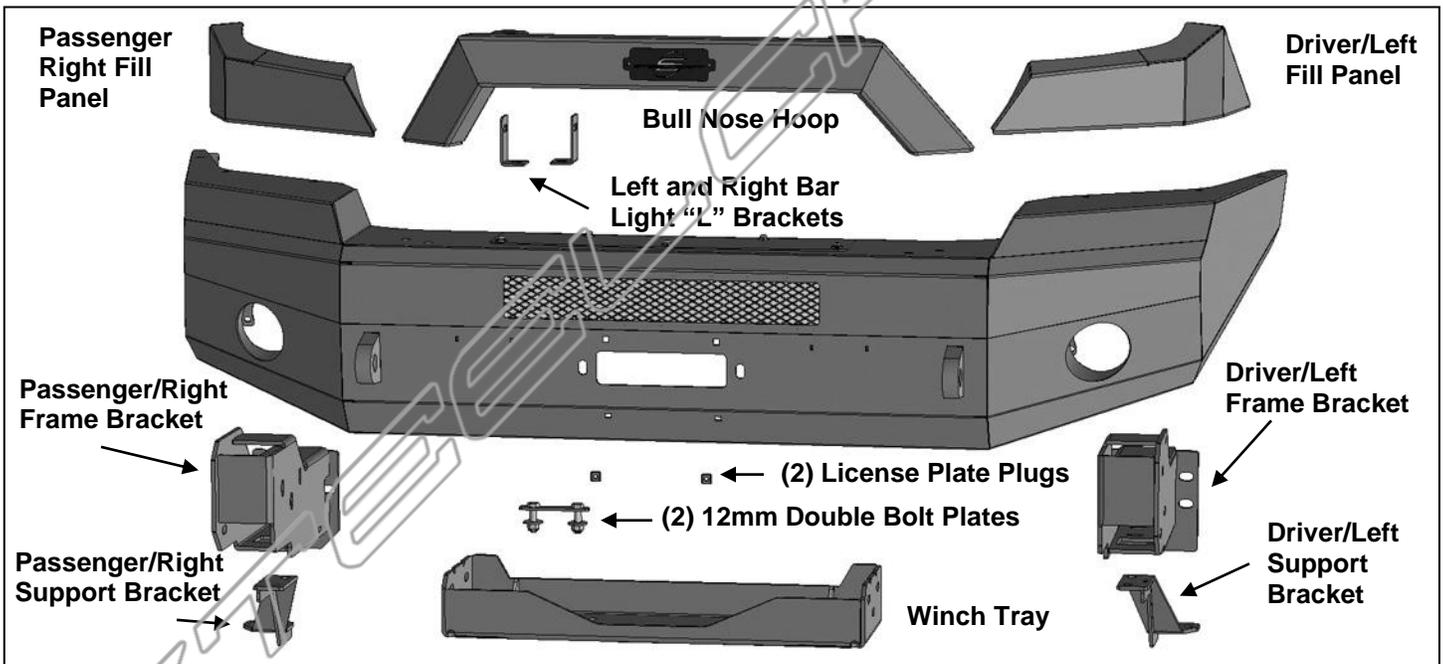


**ELEVATION BULL NOSE FRONT BUMPER  
2016-17 TOYOTA TACOMA**

**PARTS LIST:**

1	Front Bumper	14	12mm Nylon Lock Nuts
1	Bull Nose Hoop	2	10mm Double Bolt Plates
1	Winch Tray	4	10-1.5mm x 25mm Hex Bolts
1	Driver/left Frame Mounting Bracket	8	10mm x 30mm x 2.5mm Flat Washers
1	Passenger/right Frame Mounting Bracket	4	10mm Lock Washers
1	Driver/left Lower Support Bracket	4	10mm Nylon Lock Nuts
1	Passenger/right Lower Support Bracket	2	8-1.25mm x 16mm Hex Bolts
1	Winch Access Cover	2	8-1.25mm x 25mm Hex Bolts
1	Driver/left Filler Panel	6	8mm x 24mm x 2mm Flat Washers
1	Passenger/right Filler Panel	4	8mm Lock Washer
2	Plastic Plugs for License Plate	2	8mm Hex Nut
1	"L" Light bracket driver side	5	6mm Combo Bolts (access cover)
1	"L" Light bracket passenger side	1	4mm Wrench
2	12-1.75mm x 120mm Hex Bolts	14	6mm x 20mm Hex Bolts
12	12-1.75mm x 40mm Hex Bolts	28	6mm x 12mm x 1.6mm Flat Washers
28	12mm x 32mm OD x 3mm Flat Washers	14	6mm Nylon Lock Nuts



**PROCEDURE:**

**REMOVE CONTENTS FROM BOX. VERIFY ALL PARTS ARE PRESENT. READ INSTRUCTIONS CAREFULLY BEFORE STARTING INSTALLATION. BUMPER IS HEAVY, ASSISTANCE IS HIGHLY 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 the plastic grille, **(Figure 2)**. Remove the air dam from the bottom of the bumper.
2. 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.
3. Carefully pull the front leading end of the fender flares to release the plastic flare from the bumper cover, **(Figure 3)**. The flares do not need to be fully removed, simply release the front portion and leave the rest of the flare attached.
4. 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.

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Remove the plastic bumper mount from below the passenger/right side headlight, **(Figure 3)**. 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.

5. Remove the aluminum inner bumper assembly with brackets from the end of the frame, **(Figures 4 & 5)**. Next, remove the plastic splash guards from both sides, **(Figure 5)**.
6. Select the driver/left Frame Bracket, **(Figure 6)**. Reuse the (3) factory hex nuts to attach the Bracket to the frame, **(Figures 6 & 7)**.
7. Insert (1) 12mm x 120mm Hex Bolt with (1) 12mm Flat Washer through the lower mounting hole in the bracket and through the end of the frame channel. Use the included (1) 12mm Flat Washer and (1) 12mm Nylon Lock Nut to secure the Bracket to the lower mounting hole, **(Figures 6 & 7)** Snug but do not fully tighten hardware at this time.
8. Select (1) 10mm Double Bolt Plate. Insert the Bolt Plate into the end of the Frame Bracket and down through the (2) holes in the bottom of the Bracket, **(Figure 8)**.
9. Next, select the driver/left Support Bracket, **(Figure 9)**. Remove the factory hex bolt from the bottom of the cross member, **(Figure 10)**. Reuse the factory hex bolt to attach the inner end of the Support Bracket to the bottom of the cross member. Attach the Support Bracket to the Double Bolt Plate with (2) 10mm Flat Washers and (2) 10mm Nylon Lock Nuts, **(Figures 9 & 10)**. Snug but do not fully tighten hardware at this time.
10. Repeat **Steps 6—9** to install the passenger/right Frame Bracket and Support Bracket.
11. **Optional Winch Tray and Winch installation (winch sold separately):**
  - a. Select the Winch Tray. With assistance, slide the Winch Tray between the Frame Brackets. Attach the Winch Tray to the Frame Brackets with (6) 12mm x 40mm Hex Bolts, (12) 12mm Flat Washers and (6) 12mm Nylon Lock Nuts, **(Figures 11 & 12)**. Snug but do not fully tighten all hardware.  
**IMPORTANT: LED bar style light cannot be installed with Winch Tray. If installation of LED bar style light is desired, do not install the Winch Tray and skip to Step 12.**
  - b. If installing winch, follow manufacturer's instructions to attach the winch to the Winch Tray. Winch must be installed before Bumper is placed in position against Brackets. Attach winch cable guide, (not included), to Bumper assembly. Follow manufacturer's instructions to properly wire the winch to the electrical system.
12. **Optional Center LED light installation (sold separately). NOTE:** Light must be installed before Bumper Assembly is attached to the Frame Brackets. **IMPORTANT: Winch Tray cannot be installed with LED bar style light assembly.**
  - a. Select the L/R "L" Brackets, **(Figure 13)**. **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 13)**. Adjust light position and tighten hardware.
  - c. Follow light manufacturer's instructions to wire the light once Bumper has been fully installed.
13. **Optional "Bull Nose" bolt on Hoop.** Bull Nose Hoop must be installed before installing Bumper. Attach Bull Nose Hoop to top of Bumper with (4) 10mm Hex Bolts, (4) 10mm Lock Washers and (4) 10mm Flat Washers, **(Figure 14)**. Fully tighten 10mm hardware at this time only.
14. Select the driver/left Bumper Upper Fill Panel, **(Figure 15)**. Attach the Fill Panel to the top of the Bumper with (3) 8mm x 20mm Hex Bolts, (6) 8mm Flat Washers and (3) 8mm Nylon Lock Nuts. Line up the edges of the Fill Panel with the Bumper and full tighten the hardware. Repeat this Step to install the passenger/right Fill Panel.
15. 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.
16. 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) 12mm x 40mm Hex Bolts, (6) 12mm

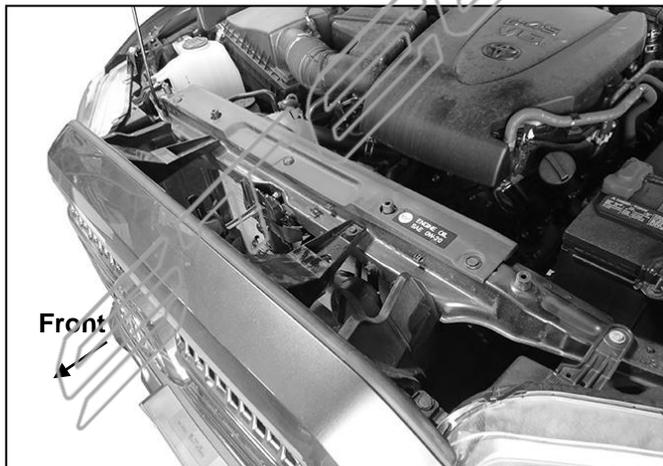
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Flat Washers and (3) 12mm Nylon Lock Nuts, **(Figures 16 & 17)**. Do not fully tighten hardware at this time. Repeat this Step to attach the passenger/right side of Bumper.

17. Level and adjust the bumper and fully tighten all 12mm hardware to 65-70ft-lbs. Remove access cover on the top of the Bumper to reach hardware if necessary. **NOTE:** It may be necessary to temporarily remove the outer bumper assembly to shift the inner Winch Tray/Bracket assembly left or right for more adjustment. Once properly adjusted, fully tighten the Winch Tray to Frame Bracket hardware first, then Frame Bracket to frame, Support Bracket to Frame Bracket then reinstall the outer Bumper assembly and fully tighten the Bumper mounting hardware.
18. 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 18)**. 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.
19. **Models with factory fog lights:**
  - a. Remove the driver/left light assembly from the back of the bumper.
  - b. Attach the light assembly to the tabs on the back of the Bumper with (4) 6mm x 20mm Hex Bolts, (8) 6mm Flat Washers and (4) 6mm Nylon Lock Nuts. **IMPORTANT:** to avoid damage to the plastic tabs on the fog light, do not overtighten the hex bolts, **(Figure 19)**. **NOTE:** Mounting tabs may shift during shipping, adjust location of mounting tabs to line up properly with light assembly.
  - c. Repeat to install the passenger/right fog light.
  - d. Reattach the wiring harness. Adjust lights as necessary and tighten all fog light bracket hardware.
20. 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 20)**.
21. Do periodic inspections to the installation to make sure that all hardware is secure and tight.

**To protect your investment**, wax this product after installing. Regular waxing is recommended to add a protective layer over the finish. 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) Remove grille, air dam from below bumper and license plate. Remove plastic bumper cover**

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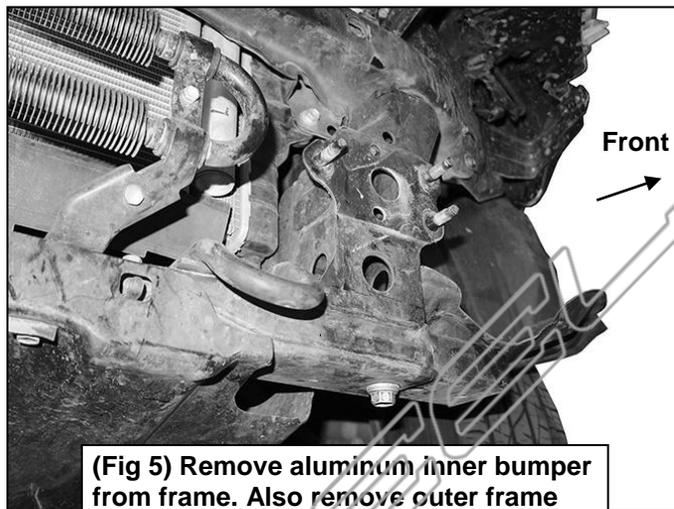
Driver/left Side Installation Pictured



(Fig 3) Remove plastic block (arrow) from front edge of fender. Reinstall hardware to secure headlight

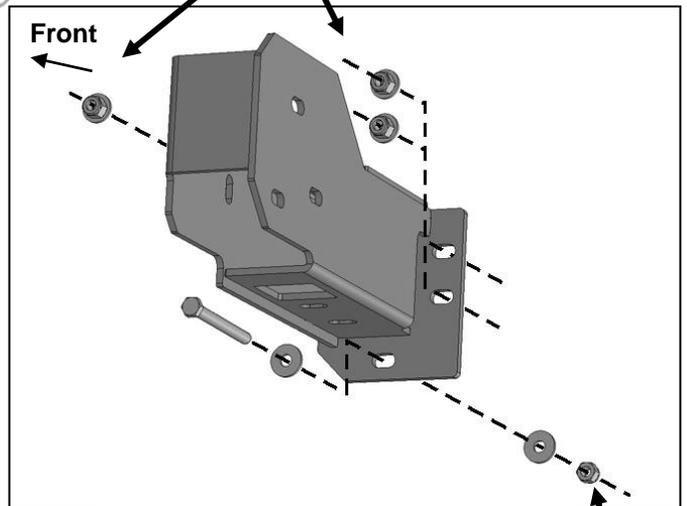


(Fig 4) Remove plastic impact bumper and aluminum crossbar from bumper brackets



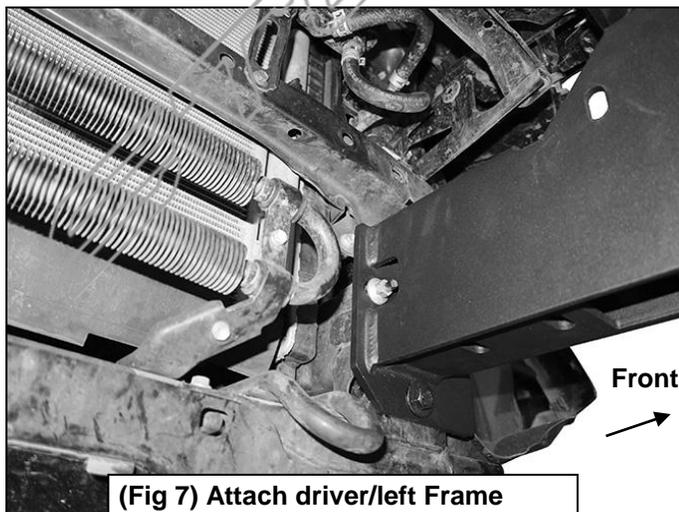
(Fig 5) Remove aluminum inner bumper from frame. Also remove outer frame ends from crossmember, (arrows).

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



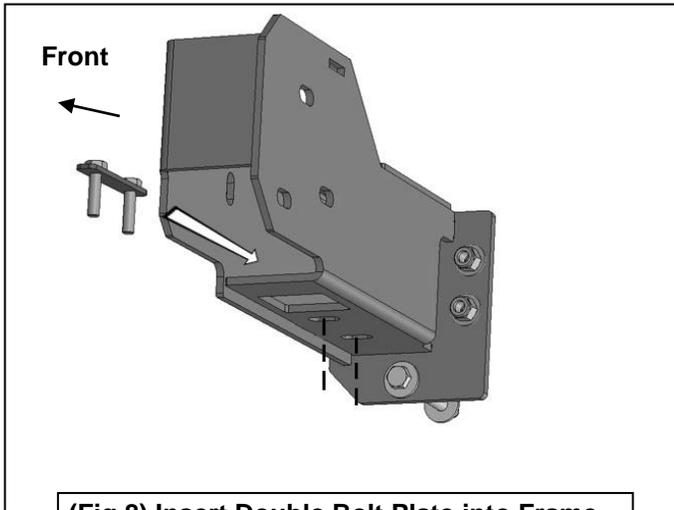
(Fig 6) Attach driver/left Frame Mounting Bracket to crossmember

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



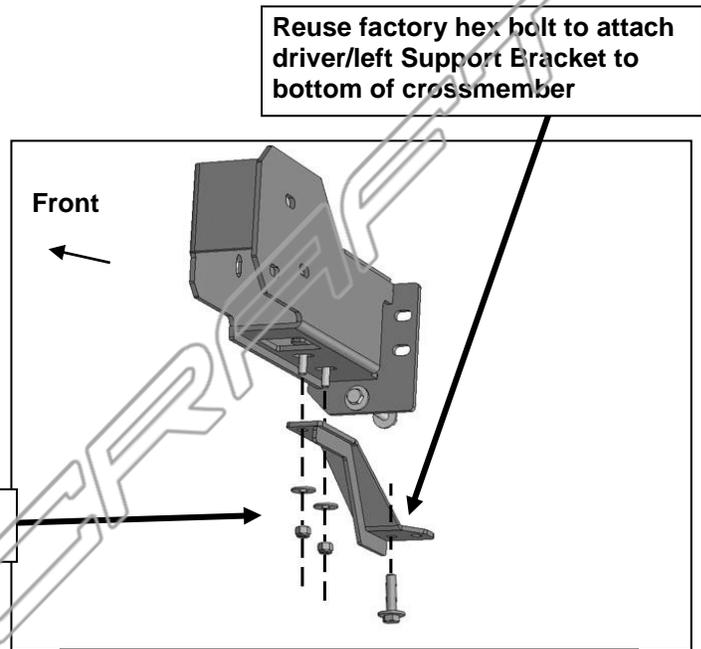
(Fig 7) Attach driver/left Frame Mounting Bracket to crossmember

Driver/left Side Installation Pictured

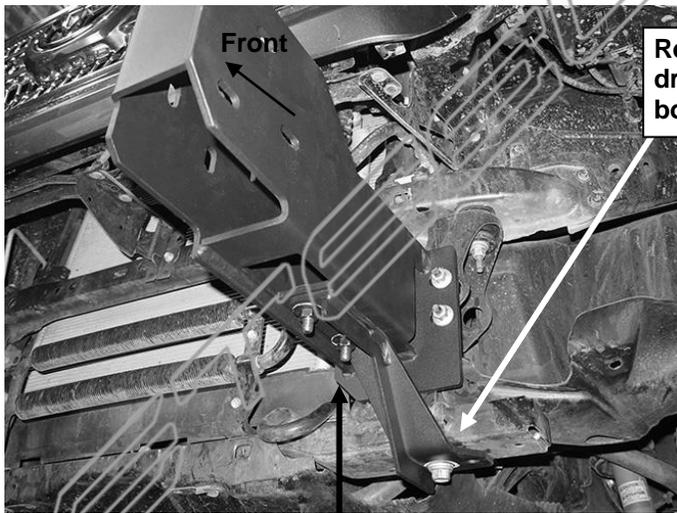


(Fig 8) Insert Double Bolt Plate into Frame Bracket and down through mounting holes

- (2) 10mm Flat Washers
- (2) 10mm Nylon Lock Nuts

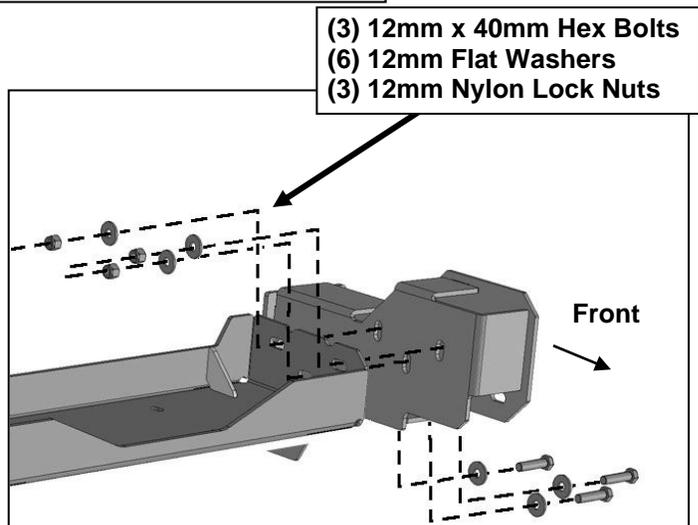


(Fig 9) Attach driver/left Support Bracket to Frame Bracket and bottom of crossmember



(Fig 10) Attach driver/left Support Bracket to Frame Bracket and bottom of crossmember

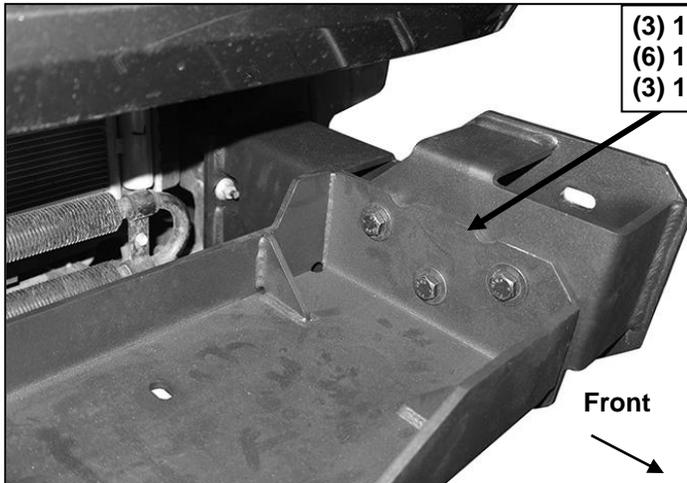
**WARNING!** Do not crawl under bumper unless the bumper is properly supported on blocks or stands or the bumper may fall.



(Fig 11) Attach optional Winch Tray to inside of Frame Brackets (driver/left Bracket illustrated)

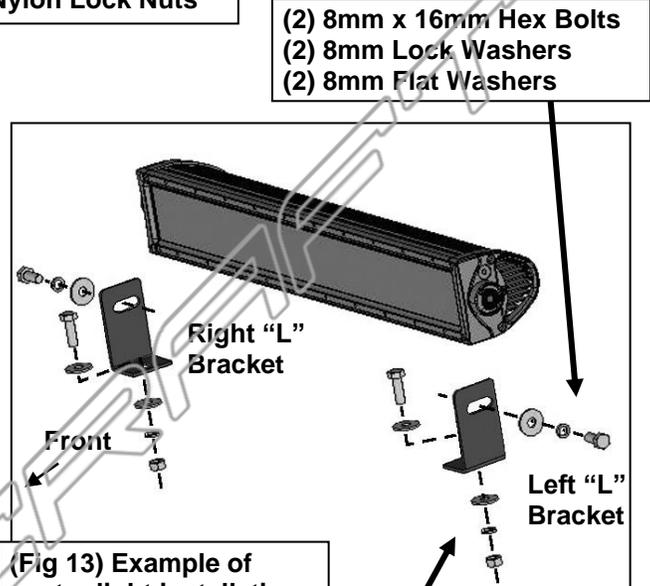
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Driver/left Side Installation Pictured



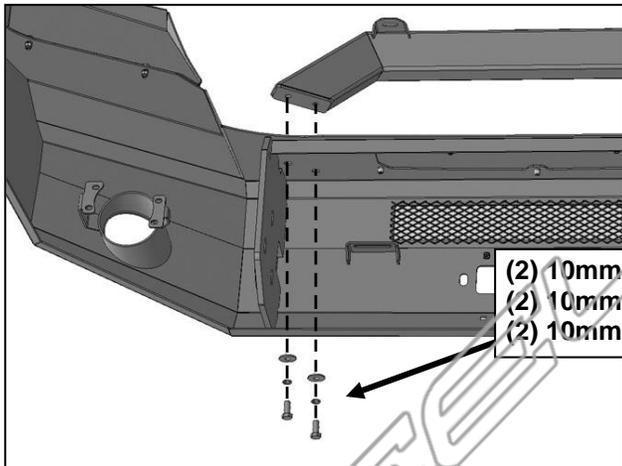
- (3) 12mm x 40mm Hex Bolts
- (6) 12mm Flat Washers
- (3) 12mm Nylon Lock Nuts

(Fig 12) Attach Winch Tray to inside of Frame Brackets



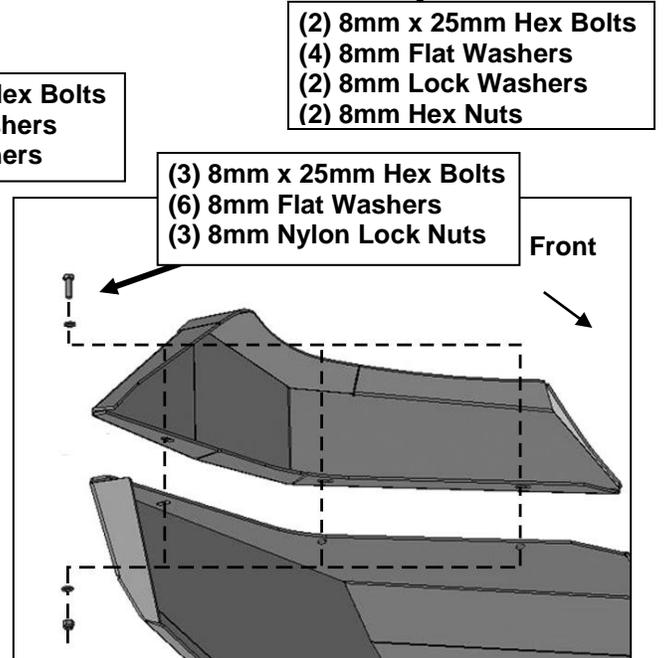
- (2) 8mm x 16mm Hex Bolts
- (2) 8mm Lock Washers
- (2) 8mm Flat Washers

(Fig 13) Example of center light installation



- (2) 10mm x 25mm Hex Bolts
- (2) 10mm Lock Washers
- (2) 10mm Flat Washers

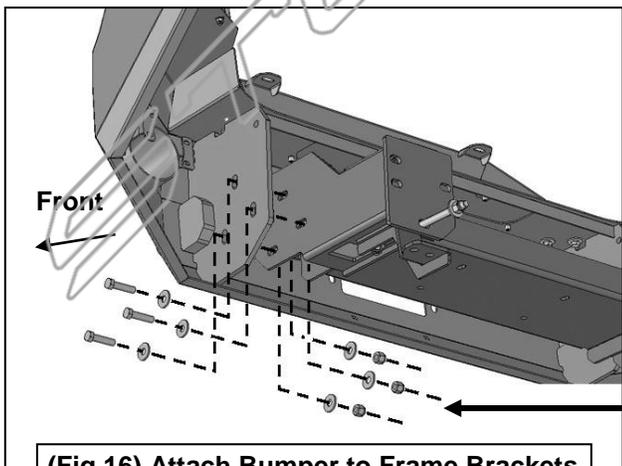
(Fig 14) Attach Bull Nose Hoop to top of Bumper assembly before installing Bumper



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

- (3) 8mm x 25mm Hex Bolts
- (6) 8mm Flat Washers
- (3) 8mm Nylon Lock Nuts

(Fig 15) Attach Fill Panel to top of Bumper



- (3) 12mm x 40mm Hex Bolts
- (6) 12mm Flat Washers
- (3) 12mm Nylon Lock Nuts

(Fig 16) Attach Bumper to Frame Brackets

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

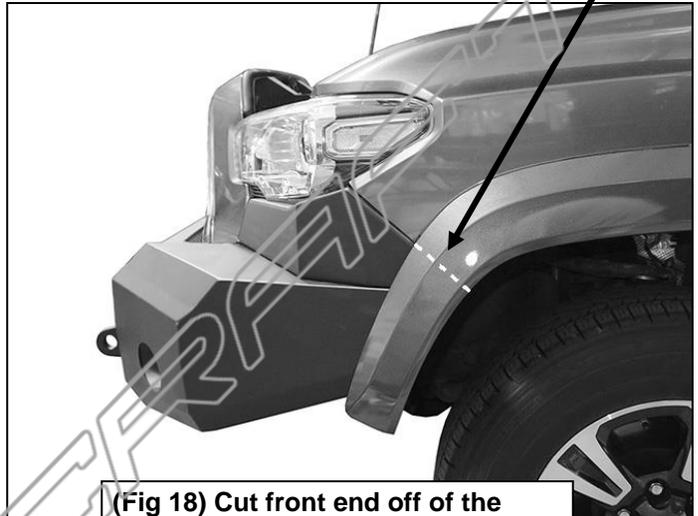
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Driver/left Side Installation Pictured



- (3) 12mm x 40mm Hex Bolts
- (6) 12mm Flat Washers
- (3) 12mm Nylon Lock Nuts

Use removable tape  
(not included)

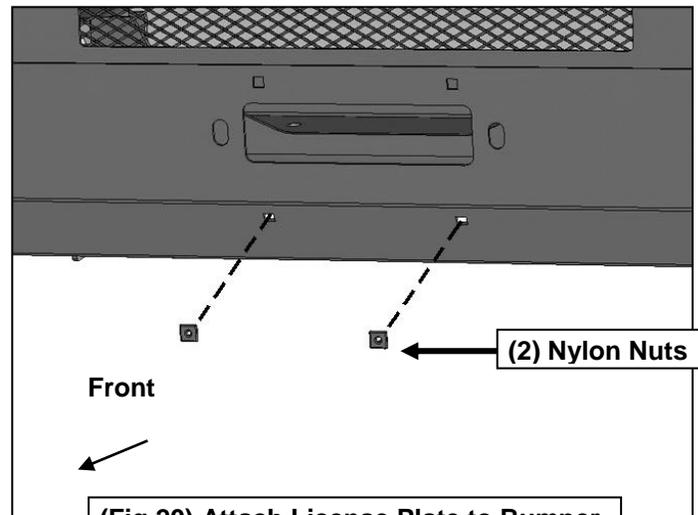


(Fig 18) Cut front end off of the  
fender flare to match up to Bumper



(Fig 19) Attach factory fog light (if equipped)  
to mounting tabs on back of Bumper

- (4) 6mm x 20mm Hex Bolts
- (8) 6mm Flat Washers
- (4) 6mm Nylon Lock Nuts



(2) Nylon Nuts

(Fig 20) Attach License Plate to Bumper



Complete Installation (accessories  
pictured available separately)