



2005+ Tacoma Rear Bumper Instructions (Including Wrap-Around Side Pieces & Hitch)

Important notices:

These instructions are intended only as a general guide for installing All-Pro products. For some items, specialized mechanical skills, metal fabrication and/or welding skills may be needed for proper installation. If you have any doubts or questions about installing these or other parts please call us at the shop 951-658-7077 or contact a competent mechanic, fabricator, welder or other appropriate professional.

Aftermarket accessories are intended to modify and/or prepare a vehicle for uses that exceed conditions anticipated by the vehicle manufacturer. These uses may include high performance demands and negotiation of rough terrain. These conditions have extreme variance and cannot be controlled by the vehicle manufacturer or aftermarket accessory manufacturer. Therefore, the safe control of your vehicle is entirely your responsibility. Do not purchase parts from All-Pro Off Road unless you are willing to accept this responsibility. Do not install any All-Pro part that you do not feel competent at installing without causing present or future injury to yourself or others; consult a professional installer.

All parts sold by All-Pro Off Road are for off road racing use only and are not intended for use on the street. Modification of your vehicle to enhance performance with the parts sold by All-Pro Off Road can result in dangerous situations that may result in bodily harm. The buyer hereby assumes all risks associated with any such modifications. All-Pro Off Road will not accept responsibility for personal injury or property damage arising from the failure of any parts manufactured or sold by All-Pro Off Road.

In an effort to provide both durability and safety, All Pro Off Road recommends you carefully read the entire installation procedure before beginning, then rigidly follow these instructions during installation. Also, it is extremely important that you abide by proper safety procedures including the use of jack stands, setting the parking brake, wearing eye protection, etc.

PARTS LIST:

- A. **Main Bumper**
- B. **License Plate Lights (2)**
- C. **Wrap Around Side Pieces w/Braces & Hardware (Optional)**
6) 7/16 x 1 1/4" bolts, each with a lock washer, 2 flat washers, and nut; 6) 3/8 x 1" bolts, each with a lock washer, 2 flat washers, and nut.
- D. **Receiver Hitch w/Hardware (Optional)**
4) 1/2 x 1 1/2" bolts, each with a lock washer, 2 flat washers, and nut; 2) 1/4-20 bolts, each with a lock washer, 2 flat washers, and nut.



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PROCEDURE:

1. CHECK PARTS

Remove All-Pro bumper and hardware from packaging, verifying all components are accounted for before proceeding.

2. PREP NEW BUMPER

If you ordered your bumper unpainted, prep the bumper by cleaning it thoroughly with paint thinner and sand off any surface rust. Apply a coat of primer, followed by a rust-inhibitive paint, like Rust-oleum. Once completely dry, you can install the new license plate lights onto the bumper using the included hardware, feeding the wires through the hole behind the light.

3. REMOVE FACTORY REAR BUMPER

First, disconnect the wire from the factory license plate lights. Then, unbolt the factory rear bumper from the frame, retaining the hardware. TIP: It is a good idea use a ratchet strap around the rear frame rails to keep them from spreading.

4. ASSEMBLE OPTIONAL WRAP-AROUND SIDE PIECES

(If you did not purchase the optional side pieces skip to the next step)
Assemble side piece to the bumper with the 7/16" bolts (3 per side in the top holes), and 3/8 x 1" bolt (1 per side in the bottom hole), all facing the rear as pictured below:



Align flush with the outside of the bumper, and tighten down snug. You do not need to attach the braces yet.

5. INSTALL THE NEW BUMPER

With help, lift the bumper in place, and re-insert all the factory hardware, leaving it loose until aligned. You may need to remove or modify the black plastic trim underneath the taillights if it interferes with the alignment. Measure each side for horizontal and vertical evenness. Once in place, tighten all 6 bolts (3 per side) using a 17mm socket, except if installing side pieces, leave the forward most bolt loose since you will use it to mount the braces. Then, splice the new light wires into the factory wiring. TIP: To keep from scratching your bedsides, cover the rear lower portion with masking tape while fitting.



6. INSTALL THE SIDE PIECE BRACES (If side pieces ordered)

Attach the braces to the side pieces using the 3/8" bolts (2 per side). Then use the front factory bolt (1 per side) to attach the braces to the frame.



7. INSTALL THE RECEIVER HITCH (Optional)

Place the hitch receiver up into the bumper, re-using the 12mm bolts into the rear upward facing holes on bolt sides. You will need a 17mm wrench to tighten. Then use the supplied 1/2-13 bolts with nuts & washers, for the side holes (2 per side), using a 3/4" wrench to tighten. Place the trailer plug onto the mount and use a 7/16" wrench to tighten the 1/4" bolts with nuts. NOTE: The rearmost top hole is not used since the hole in the frame rail is too small, unless you want to drill it out.

