

Installation Instructions



16-20 Toyota Tacoma Front Bumper
Part # S/B61248W



For Technical Support / Warranty Information please call 800-776-0767 EXT 1317
or Email info@smittybilt.com

Introduction

Thank you for choosing Smittybilt accessories for your Toyota Tacoma. If you would like to view our full range of available accessories, please visit us at www.smittybilt.com



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Important Notes Before Starting



IMPORTANT NOTE

Carefully read through this entire instruction manual thoroughly before attempting to install this part.

The following tools will be required to complete the installation of this part:

TOOLS REQUIRED	
Metric Socket & Wrench Set	Non Marring Pry Bar Set
Torque Wrench	Allen Wrench Set



WARNING

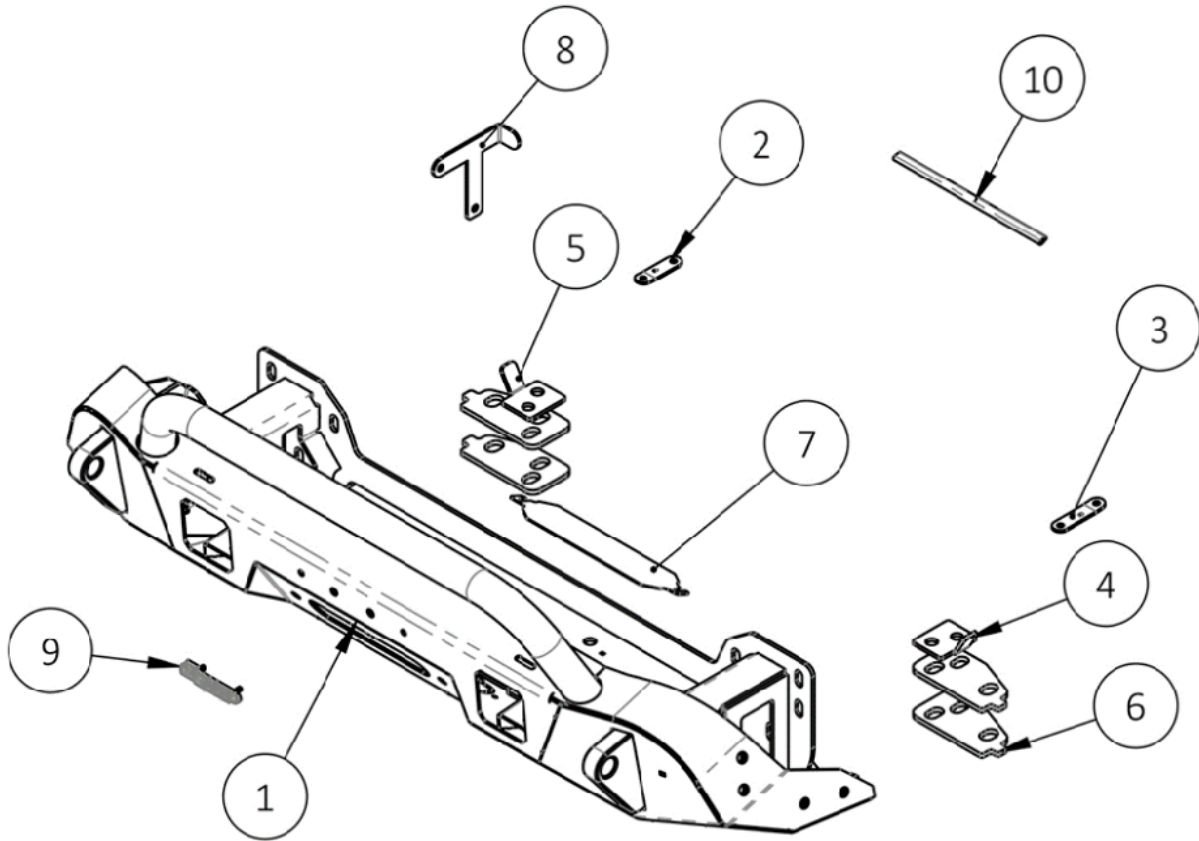
Serious injury can occur when working on vehicles alone.

When possible, work with another person to reduce risk of injury from strain or other dangers that can occur when working alone.



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Box Contents



SB61248W BOX CONTENTS

ITEM NO.	PART NO.	DESCRIPTION	QTY
1	84-SB61248-A	TACOMA FB-MAIN BUMPER	1
2	84-SB61248-32	TACOMA FB-PASSENGER OIL COOLER MOUNT	1
3	84-SB61248-33	TACOMA FB-DRIVER OIL COOLER MOUNT	1
4	84-SB61248-B	MOUNTING NUT PLATE	1
5	84-SB61248-C	MOUNTING NUT PLATE PASSENGER	1
6	84-SB61248-36	BUMPER SHIM	1
7	84-SB61248-20	TACOMA FB-LOGO PLATE	1
8	84-SB61248-42	POWER STEERING COOLER LINE BRACKET	1
9	BADGE RE4	BADGE RE4	1
10	SB61248-44	EPDM RUBBER TRIM	1



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Hardware Packs

61248-01 MOUNTING HARDWARE

QTY	PART NO.	DESCRIPTION
10	22UH22	M12 FLATWSHR DIN125-1ACZ
2	42GH78	M12X1.75 NYLOCK GR10.9 CZ
2		M12X1.25 NYLOCK GR10.9 CZ
4	SB61248-38	M12X1.25X40 HHCS GR10.9 CZ
2	SB61248-39	M12X1.75X110 HHCS GR10.9 CZ

61248-02 POWER STEERING COOLER HARDWARE

QTY	PART NO.	DESCRIPTION
1	SB61248-40	M8X1.25X18 HHCS GR10.9 CZ
2	SB61248-41	M8X1.25X25 HHCS GR10.9 CZ
1		M8X1.25X25 BHSS GR10.9 CZ
4	42GK82	M8 FLAT WSHR CZ
3	42GH76	M8X1.25 NYLOCK GR10.9 CZ

61248-03 LOGO MOUNTING HARDWARE

QTY	PART NO.	DESCRIPTION
4	6EY59	M6 FLAT WSHR CZ
4	42GH75	M6X1 NYLOCK GR 10.9 CZ

61248-04 LP HARDWARE

QTY	PART NO.	DESCRIPTION
2	6EY59	M6 FLAT WSHR CZ
2	92095A240	M6X1X20 BHCS SS
2	42GH75	M6X1 NYLOCK GR 10.9 CZ



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! IMPORTANT NOTE

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! WARNING

Check all four wheels and make sure parking brake is engaged before starting this install. Failure to do so could result in serious injury.

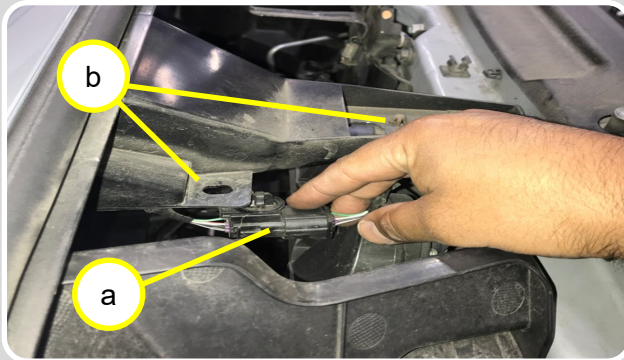
Step 1: Check Box Contents

Open the box containing your Toyota Tacoma Front Bumper, check all parts against the Bill of Materials outlined in the first pages of these instructions.

If anything is missing, contact Smittybilt Technical Support immediately.

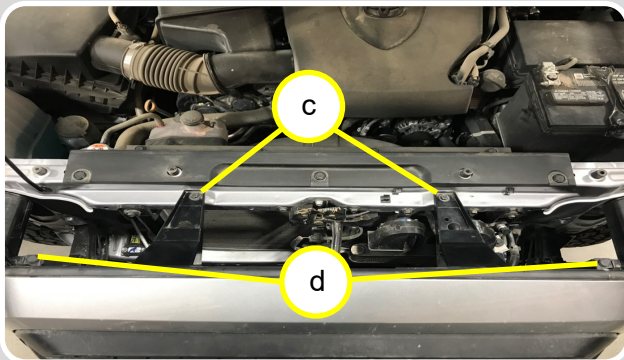
Step 2: Disconnect Car Battery

Open hood and disconnect car battery. Refer to the Tacoma User Manual for battery disconnection.



Step 3: Disconnect Cruise Control Monitor

If the vehicle is equipped with Cruise Control Monitor (a), disconnect by pushing plastic clips on the Driver side as shown (b).



Step 4: Remove Grille Bolts and Unclip

Using a **10mm Socket**, remove bolts at the top of the grille (c), then pop the two clips (d).



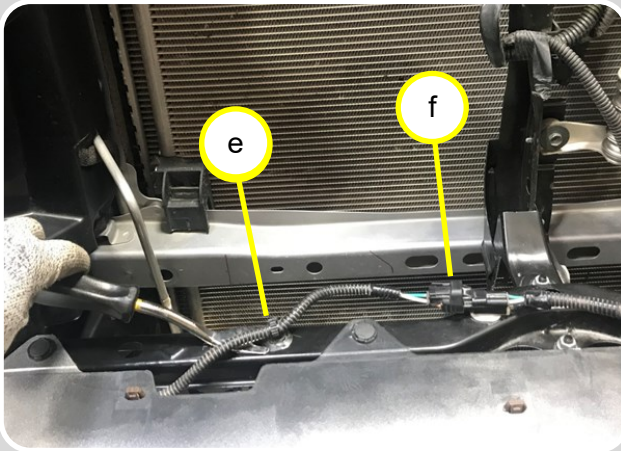
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Installation Instructions



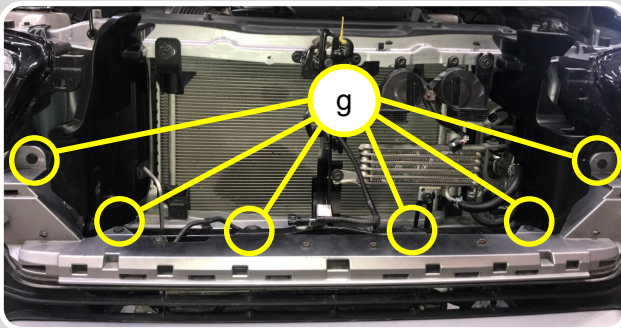
Step 5: Remove Grille

Pull front Grille out by removing it first from Driver side and then the Passenger side.



Step 6: Disconnect Fog Light Plug

Remove push-in retainer from frame (*e*), and disconnect Fog Light plug (*f*).



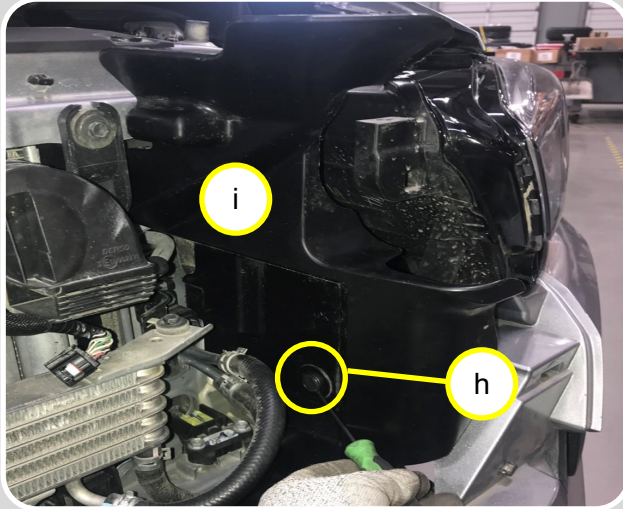
Step 7: Remove Clips

Remove the 6X clips at the front of Bumper as shown (*g*).



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Step 8: Remove Radiator Support Deflector

Starting from the Driver side, remove the clip shown at (h). Then remove the radiator support deflector (i) by pulling out (you may need to angle this to do so).

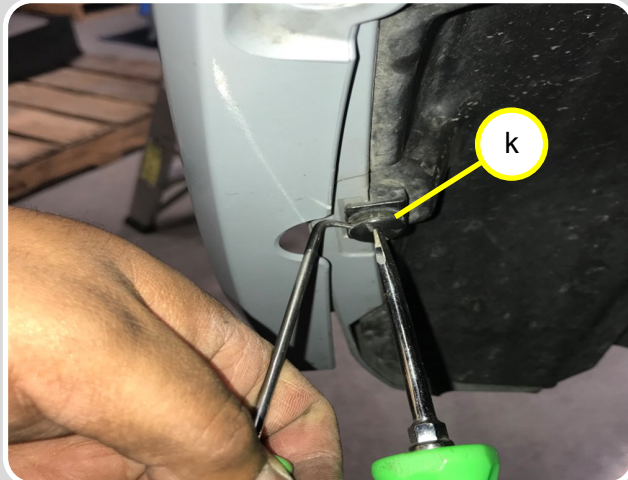


Step 9: Remove OE Fender Bolt

Starting from the Driver side Inner Fender, remove the OE bolt (Shown at j).

Then unlock the push clip below the bolt (k) with a screwdriver and remove it.

Repeat this step on the Passenger side.



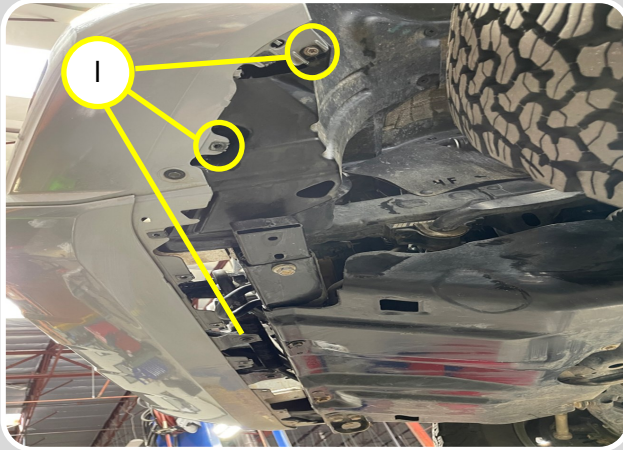
! IMPORTANT NOTE

The 2X bolts and clips (1x Driver side & 1X Passenger side) will be re-used. Set aside for re-installation at a later step.



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Installation Instructions



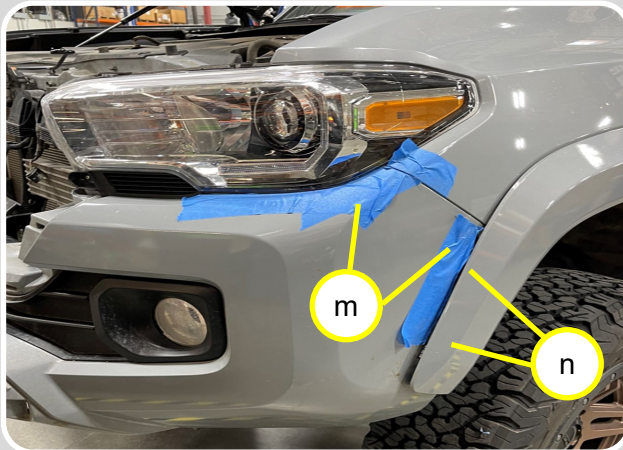
Step 10: Remove OE Bumper Bolts

Starting from the Driver side, on the underside of the front bumper remove 3X OE screws (*l*).

Repeat this step on the passenger side.

! IMPORTANT NOTE

Save the 2X circled outer bolts for re-use.

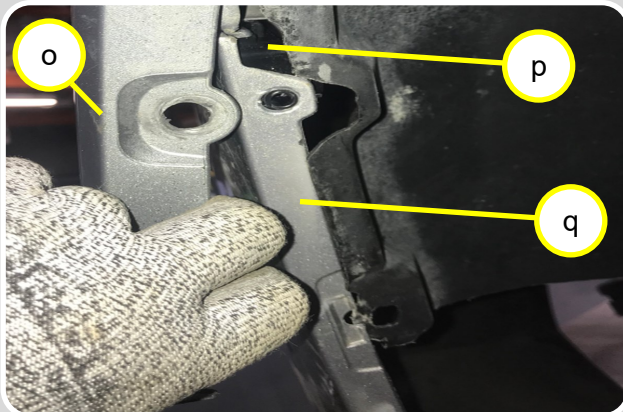


Step 11: Begin Bumper Removal

Starting from the Driver side, mask where shown (*m*). Pull fender flare outward slightly for bumper removal.

To avoid damage to fender unclip 2X clips securing bumper to fender (*n*) using a **non-marring pry bar** to avoid paint damage where masked.

Repeat on Passenger side.



Step 12: Pull Bumper Out From Retainer

From the Driver side inner fender, pull out bumper from Bumper retainer.

Repeat process on Passenger side.

Image shows:
(*o*) Fender Flare
(*p*) Bumper Retainer
(*q*) OE Bumper



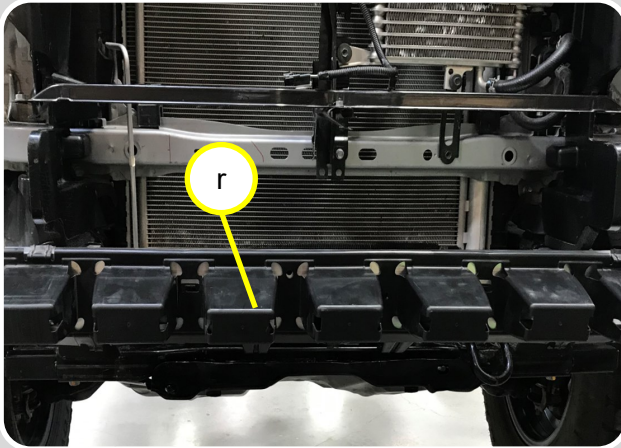
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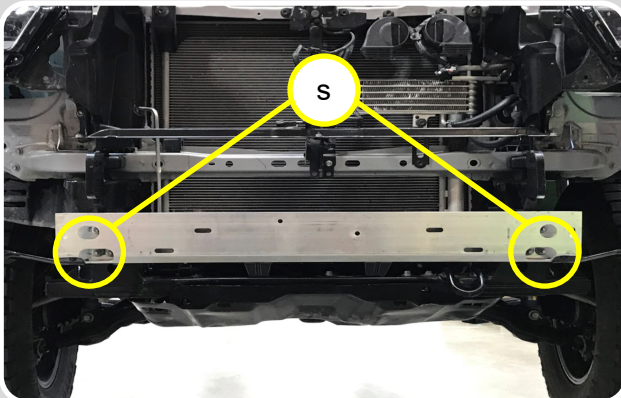
Step 13: Remove Bumper

Starting from the Driver side, carefully pull bumper out as shown. Then repeat on Passenger side.



Step 14: Remove Impact Absorber

Unclip and Remove Bumper impact absorber (*r*).



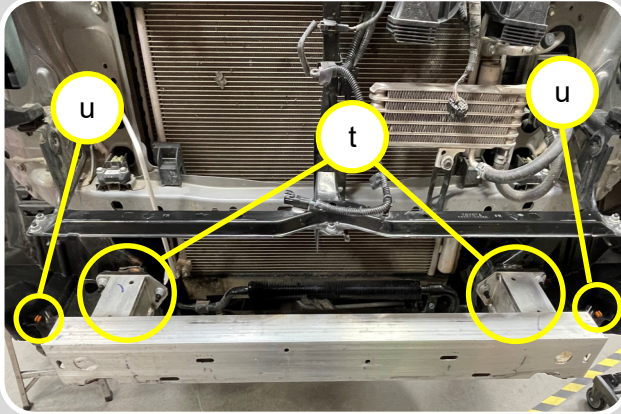
Step 15: Loosen Nuts

Loosen 6X M10 nuts from front bumper reinforcement bracket (*s*).



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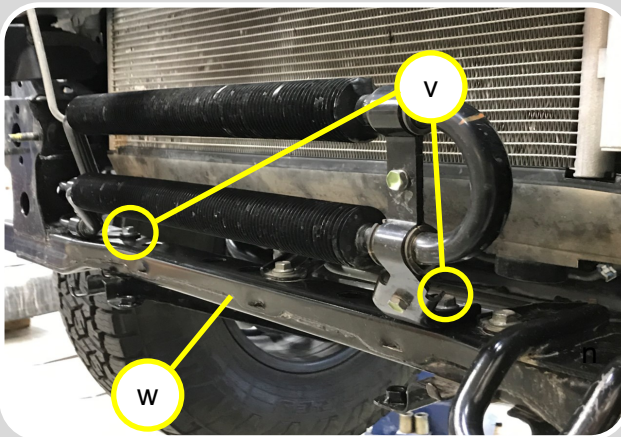


Step 16: Remove Reinforcement Bracket

Remove the 6X OE nuts from bumper reinforcement bracket (*t*). Unclip from inner fender (*u*), and remove reinforcement bracket.

! IMPORTANT NOTE

Save the 6X OE nuts for re-use later.

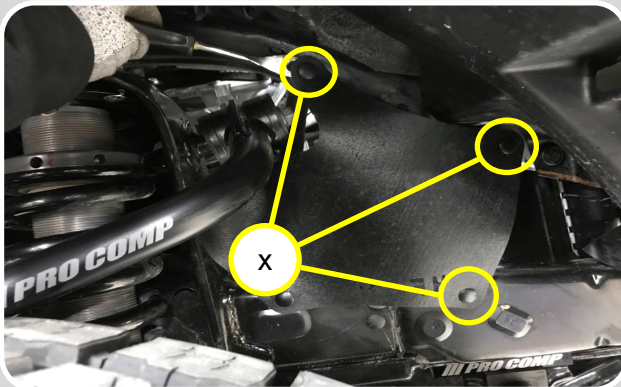


Step 17: Remove Power Steering Cooler Line Bolts

Remove 2X OE bolts from power steering cooler line (*v*). Save one of the OE bolts for re-installation. Leave the power steering cooler line sitting on the crossmember (*w*), for now.

! IMPORTANT NOTE

Save the 1X OE bolts for re-use later.



Step 18: Remove 3X Clips From Fender Liner

From the Passenger side inner fender liner, pop out 3X push-in retainer clips only (*x*).

Peel back fender liner to gain access behind.



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Installation Instructions



Step 19: Unbolt Power Steering Cooler Line Bracket.

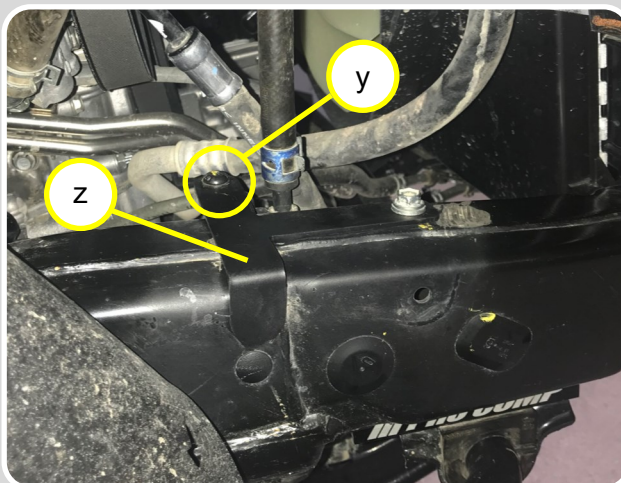
Un-bolt power steering cooler line bracket by loosening and removing 1X M8 OE bolt.



Step 20: Rotate Power Steering Cooler Bracket

Rotate power steering cooler bracket 180 degrees.

Install new bracket (PN: 84-SB61248-42, **Power Steering Cooler Line Bracket**) to power steering cooler OE bracket using 1X M8x18mm Hex Bolt, 1X M8 Nylock Nut and 1X M8 Flat Washer from PN: 61248-02 (**Power Steering Cooler Hardware Pack**) (y).



Bracket will now look like (z).

Re-install the fender liner.

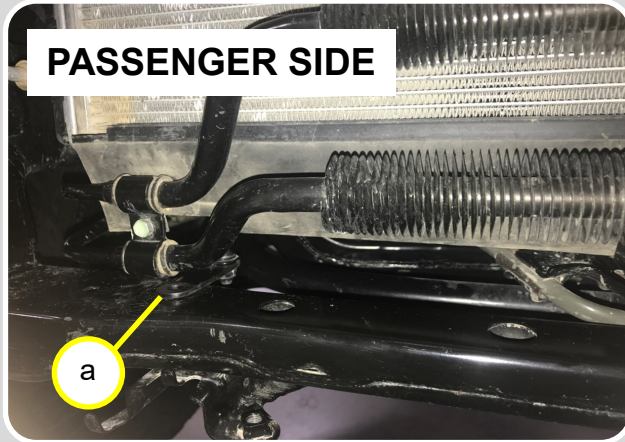
ATTENTION

Ensure all lines have clearance and are not touching any brackets or other items in the engine bay.



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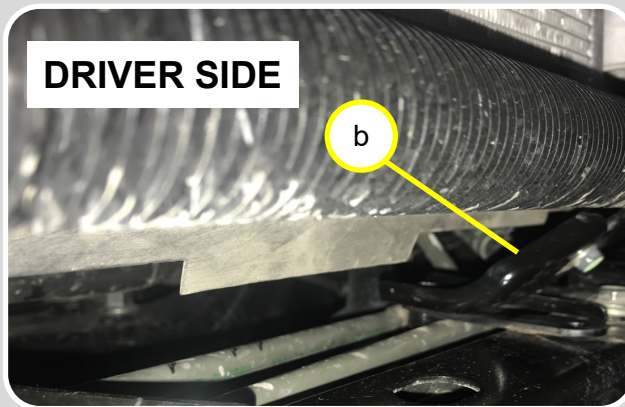


Step 21: Install Power Steering Cooler Brackets

Install power steering cooler bracket **PN: 84-SB61248-32 (Tacoma FB- Passenger Oil Cooler Mount)** labeled "P" for passenger side, with small bends bolted to power steering cooler towards engine bay facing up.

Align with original OE bolt hole located on crossmember (a).

Repeat on Driver side with **PN: 84-SB61248-33**, labeled "D" for driver side



! IMPORTANT NOTE

Ensure the Power Steering Cooler Bracket bend faces up as shown at (b)



Step 22: Secure with Bolts

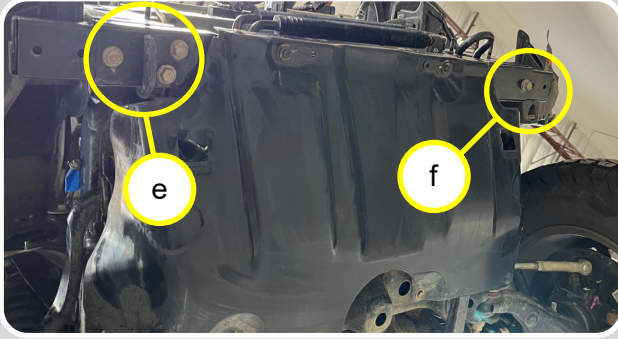
On Passenger side, use M8(1.25) x25mm BHCS from **PN: 61248-02 Power Steering Cooler Hardware Pack** to secure (c).

Re-use OE bolt from Step 17 on Driver side **ONLY** (d).



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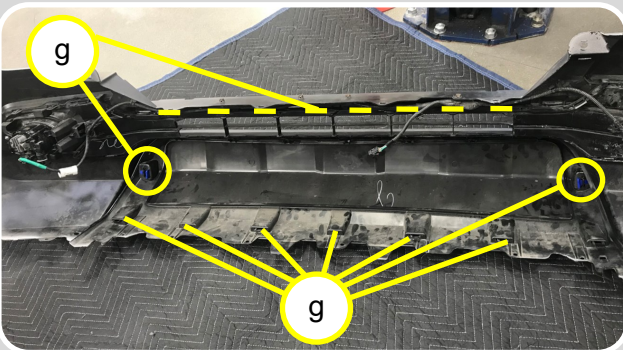
Step 23: Remove Crash Bars

Starting from the Passenger side, unbolt and remove crash bar. If equipped with an OE toe hook, remove this also (*e*).

Remove crash bar on Driver side (*f*).



“Before” image of stock truck provided here for reference.



Step 24: Unclip Valance panel

On the inside of your OE bumper, unclip Valance panel at locations shown (*g*).



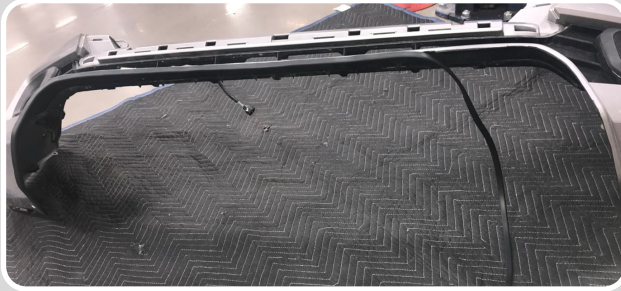
Step 25: Deburr OE Bumper

Using a cut-off wheel, cut alongside the front OE bumper, to deburr excess material, as shown (*h*). Repeat on opposite side of bumper.



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Installation Instructions



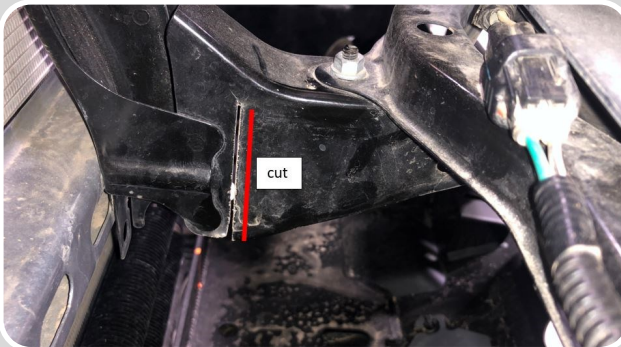
Step 26: Add Trim

Add PN: 84- SB61248-44 (EPDM Rubber Trim) along the edge of the bumper, cutting excess trim if necessary.



Step 27: Re-install OE Bumper

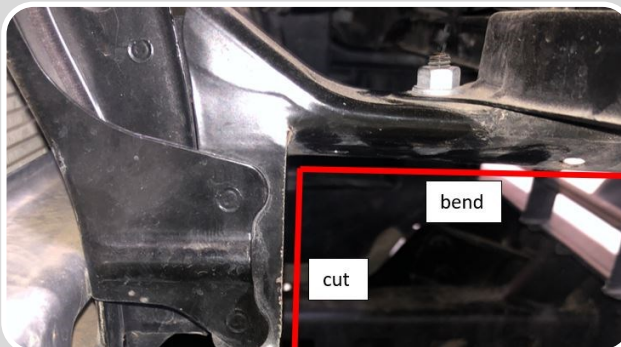
Re-install OE bumper with OE hardware and reconnect fog light.



Step 28: Install Optional Accessories

If installing winch or lights to your Smittybilt Front Bumper, please follow the instructions supplied with the winch or light, or go to your nearest Smittybilt parts reseller for installation.

Some winch installs may require trimming the center bracket that is in front of the radiator to clear your control box if your winch control box cannot be relocated.



Trim vertically as shown (*top image*) then bend the sheet metal up and out of the way (*bottom image*). Deburr and paint the exposed material.



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Step 29: Install License Plate

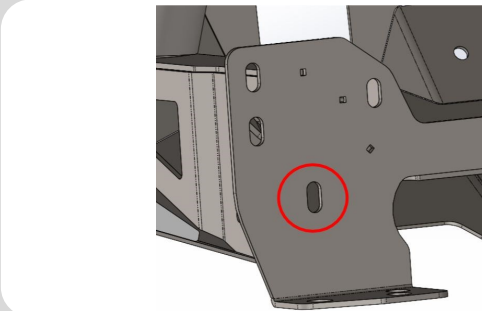
Install license plate using M6 Hardware from **PN: 61248-04 (LP Hardware Pack)**.



Step 30: Install Smittybilt Front Bumper

With the help of another person, install Front Bumper to OE frame horn re-using the OE nuts removed at Step 16.

Adjust height to bumper until satisfied with the fit, and tighten hardware. Do not torque at this time.



Optional Step

1X M12(1.75)x110mm Hex Bolt, 1X M12 Nylock Nut, 2X M12 Flat Washers from **PN: 61248-01 (Mounting Hardware)** can be slid into the bumper and through the frame. It is suggested to install the bolt with the head of the bolt on the bumper side and the nut behind the frame. Add a Washer and Nylock from the backside of the frame and torque to 45ftlb.



Step 31: Drill, Adjust and Tighten

From bottom Driver side crossmember frame, mark the centers and drill 1/2inch holes on Driver side where shown (i). Depending on final vertical position shims have been provided. If your application has a gap between the bumper lower flange and the frame 0, 1 or 2 shims can be installed to take the gap.

! IMPORTANT NOTE

If passenger side is equipped with OE weld nuts there is no need to drill holes.



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Step 32: Insert Mounting Nut Plate

Locate PN: **84-SB61248-B (Driver Side Mounting Nut Plate)**, **2X M12(1.25x40mm Hex Bolts)** and **2X M12 Flat Washers**. Insert mounting nut plate to crossmember and secure bumper to crossmember using the M12 hardware.



Step 33: Complete Installation

Apply thread locker and torque all hardware to spec. Re-install radiator deflector and grille, re-install clips and hardware to grille, re-connect cruise control monitor.

The installation is now complete.

! IMPORTANT NOTE

Torque Specification Chart can be found on page 16.

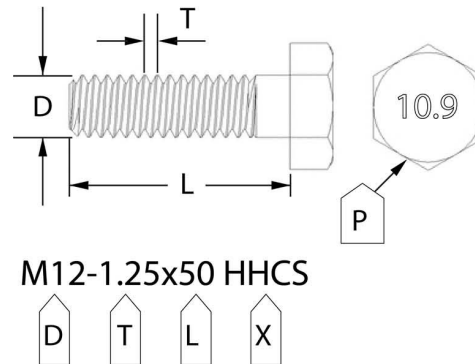
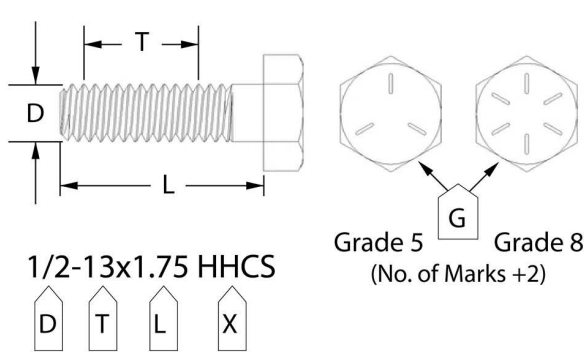


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Bolt Torque Specifications

Use this only as a guide for hardware without a called out torque specification in the instruction manual.

Bolt Torque and ID						
Decimal System			Metric System			
<i>All Torques in Ft. Lbs. Maximums</i>						
Bolt Size	Grade 5	Grade 8	Bolt Size	Class 9.8	Class 10.9	Class 12.9
5/16	15	20	M6	5	9	12
3/8	30	45	M8	18	23	27
7/16	45	60	M10	32	45	50
1/2	65	90	M12	55	75	90
9/16	95	130	M14	85	120	145
5/8	135	175	M16	130	165	210
3/4	185	280	M18	170	240	290



G= Grade (Bolt Strength)
 D= Nominal Diameter (Inches)
 T= Thread Count (Threads per Inch)
 L= Length (Inches)
 X= Description (Hex Head Cap Screw)

P= Property Class (Bolt Strength)
 D= Nominal Diameter (Millimeters)
 T= Thread Pitch (Thread Width, mm)
 L= Length (Millimeters)
 X= Description (Hex Head Cap Screw)



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Notes and Disclaimers

Product cleaning and maintenance instructions

Stainless Steel Finish – Aluminum polish may be used to polish small scratches and scuffs on the finish. Mild soap, window or glass cleaner may be used to clean the finish. Dual state powder coat finish – Mild soap, window or glass cleaner may be used to clean the finish. In order to protect the finish, you may wax your product on a regular basis with pure carnauba automotive wax. Do not use any types of soap, polish or wax that contains abrasive that could damage the finish. Textured coated finishes should be cleaned with a mild soap on a damp sponge. Do not apply polish or wax that requires to be removed by means of buffing. This type of wax is commonly used at car wash facilities. Chrome Finish – Mild soap, window or glass cleaner may be used to clean the finish. In order to protect the finish, you should wax your product on a regular basis with pure carnauba automotive wax. Do not use any types of soap, polish or wax that contains abrasive that could damage the finish.

Limited Warranties

Smittybilt's products are covered under the following limited warranties only. Note that the duration of the limited warranty differs according to the material and finish of the product purchased. Subject to the duration and conditions of the limited warranty stated below, Smittybilt warrants to the original retail purchaser that its products are free from defects in material and workmanship. All other warranties and representations express or implied, are hereby disclaimed, including fitness for merchantability and buyer's intended use or purpose. All parts are sold "AS IS" except for the limited warranties granted herein. Buyer assumes all risks as to the selection, suitability and performance of all goods and products selected. This limited warranty does not cover damage or impairment in any part due to misuse, improper installation, accident or contact with on-road or off-road hazards, product modification, improper or inadequate cleaning and/or maintenance. Smittybilt is not responsible for items damaged during shipping. This warranty is not transferable from the original buyer. For the original Buyer to be eligible for the limited warranty coverage, the Buyer must provide proof of purchase. Smittybilt strongly recommends returning the warranty registration card. Customer's remedy hereunder shall be limited only to repair or replacement (at Smittybilt's option) of any defective part(s) returned to Smittybilt at customer's expense. The determination of whether or not a returned part is defective or subject to coverage under the limited warranties stated herein shall be made at Smittybilt's sole discretion. To assure product quality, Smittybilt reserves the right to change product design, material, specification and finishes without prior notice to customers. This limited warranty gives you specific legal rights and you may also have other rights, which may vary from state to state. Some states do not allow limitations on how long an implied warranty lasts, so the above limitations may not apply as to you. Also, some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitations or exclusions may not apply to you. Smittybilt reserves the right to discontinue product lines and substitute products or provide other remedies than those listed in this limited warranty for those discontinued products.

Warning

Rollover and other types of vehicle accidents may result in serious injury or death to you, your passengers and others sharing the road. Smittybilt accessories are decorative and are not intended to reduce or avoid injury or damage in the event of an accident. The weight and location of Smittybilt accessories may affect your vehicles' handling, stability and performance, creating an increased risk of accident or rollover. Before installing any accessory, check state laws and assure that the accessory will not obscure any lights or interfere with proper operation on your vehicle's safety equipment. Consult your owner's manual and the Smittybilt instructions, or additional safety information. Smittybilt products, nor the warnings contained herein, are not a substitute for your safe driving. Don't drink and drive, always use seat belts and don't drive faster than conditions permit.



WARNING: Cancer and Reproductive Harm
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