

# Installation Instructions



16-20 Toyota Tacoma Rear Bumper  
Part # S/B61448W



For Technical Support / Warranty Information please call 800-776-0767 EXT 1317  
or Email at [info@smittybilt.com](mailto: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](http://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

10, 11, 17, 19 mm Wrench	Non Marring Pry Bar Set
10, 12, 13, 17, 19 mm socket	4mm Hex Bit Sockets
Ratchet	6mm Hex Bit Sockets
T30 Torx Socket	Phillips Head Screwdriver
Torque Wrench	

### WARNING

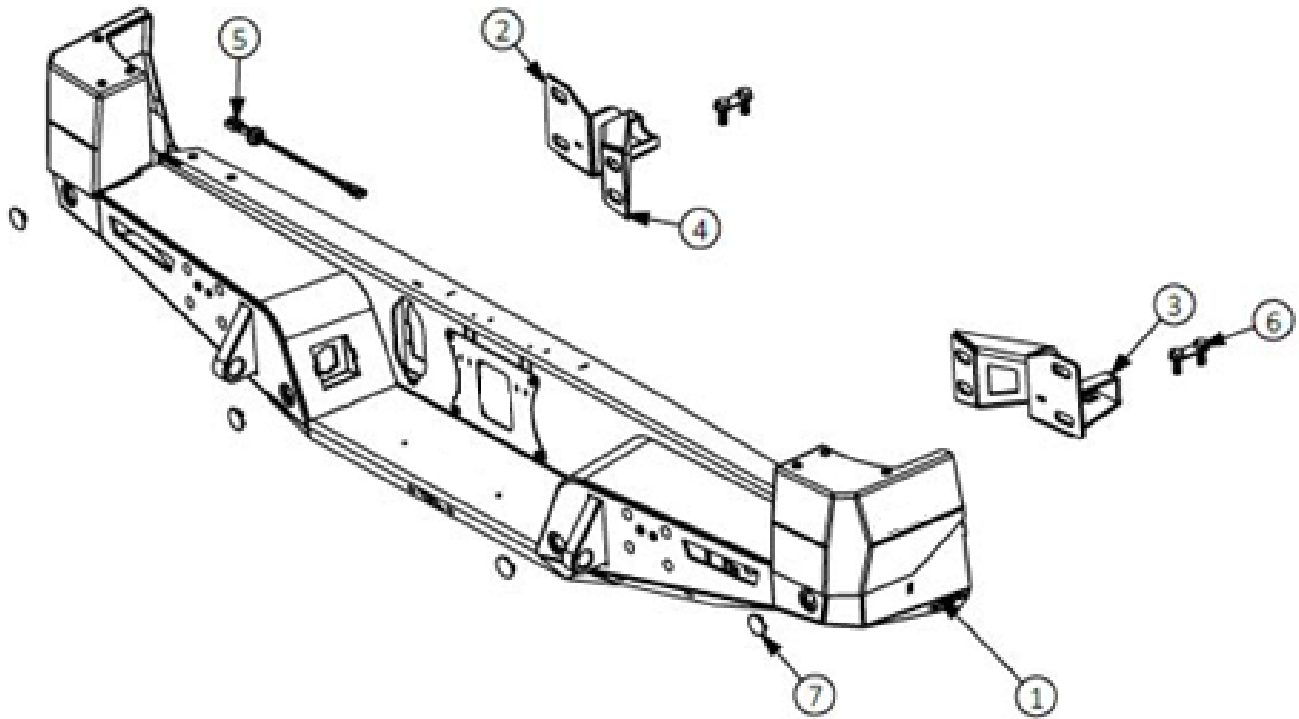
Serious injury can occur when working on vehicles alone.

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



## SB61448W BOX CONTENTS

ITEM NO.	PART NO.	DESCRIPTION	QTY
1	1040AA100	BUMPER ASSEMBLY	1
2	1040AA200	FRAME MOUNT—DRIVER	1
3	1040AA200-M	FRAME MOUNT—PASSENGER	1
4	1040AA300	D-RING REINFORCEMENT BKT	2
5	1040AA800	BSM SENSOR 10X 20AWG WIRE EXT.	1
6	1040AA1100	M8 BOLT PLATE	2
7	1040AA1200	SENSOR HOLE PLUG TACOMA	4



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## Hardware Packs

### SB61448W-01: REAR CAMERA & ROCKLIGHT HARDWARE

QTY	PART NO.	DESCRIPTION
6	91263A464	M6X1X18 FHCS GR12.9 CZ
2	94645A205	M6X1 NYLOCK GR10.9 CZ
2	91100A150	M6 OVERSIZED FLAT WASHER CZ
1	84-1040AA1400	R CAMERA RELOCATION BRACKET
2	84-1040AA1300	ROCKLIGHT MOUNT WELDMENT
4	2958N13	3/8 RUBBER SEALING PLUG
8	90221A507	6 MM BLACK PUSH IN RIVET PLUG

### SB61448W-02: BSM SENSOR INSTALL HARDWARE

QTY	PART NO.	DESCRIPTION
4	1040AA1600	M6X1X14 BHCS GR8.8 CZ
4	91455A120	M6 FLAT WSHR GR10.9 CZ
1	90-1040AA100AB	WIRE PROTECTOR GROMMET

### SB61448W-03: BUMPER INSTALL HARDWARE

QTY	PART NO.	DESCRIPTION
6	90576A119	M12X1.75 NYLOCK GR8.8 CZ
4	91310A712	M12X1.75X30 HHCS GR10.9 CZ
4	90576A118	M10X1.5 NYLOCK GR8.8 CZ
4	91166A280	M10 FLAT WSHR GR8.8 CZ
12	1040AA2200	M12 OVERSIZED FLAT WASHER CZ
2	90180A647	M12X1.75X35 HHCS GR10.9 CZ



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# Installation Instructions

## ! IMPORTANT NOTE

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

## ! 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: Disconnect Vehicle Battery

Remove both terminals from the battery to protect sensors and wire harness during install.

## ! IMPORTANT NOTE

Failure to disconnect battery prior to sensor disconnect can lead to sensor failure and/ or may require re-calibration at vehicle dealership.

## ! IMPORTANT NOTE

If **SB61449DW-PW Swing Gates** will be installed, refer to both instructions sets in parallel: Swing Gates require components to be installed while bumper is off-vehicle. Installing bumper first may lead to unnecessary removal.

### Step 2: Check Box Contents

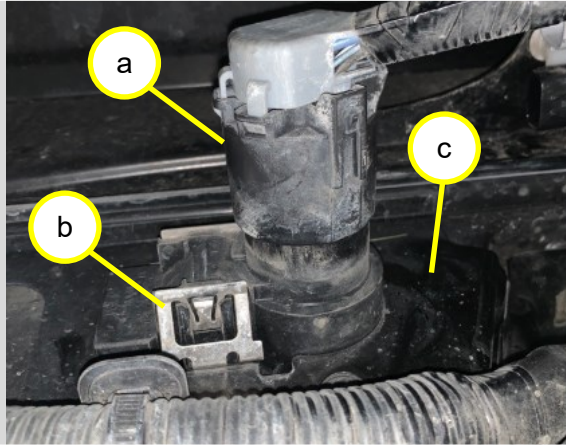
Open the box containing your Toyota Tacoma Rear Bumper, check all parts against the Bill of Materials outlined in the first pages of these instructions.

**If anything is missing, contact Smittybilt Technical Support immediately.**



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## Installation Instructions: Centre of Rear Bumper

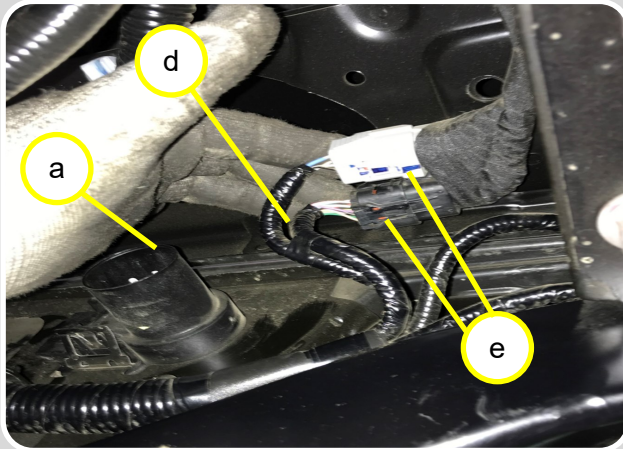


### Step 3: Remove Trailer Plug Connector

At the Driver side of the rear bumper, locate the trailer plug connector (*a*) behind rear bumper.

Unplug by pressing the tab on the top side of the connector and pull outwards. To remove the trailer plug from the bumper, press the metal tabs (*b*) and push outwards.

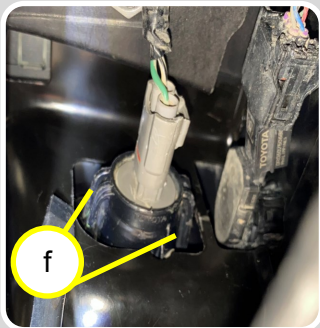
(*c* shows rear bumper back section)



### Step 4: Disconnect Bumper Wire Harness

Keeping at the rear bumper Driver side, disconnect bumper wire harness (*d*) from frame, by pressing tab on the connector/s (*e*) and pulling outwards.

*Depending on the model, your vehicle will have one or two connectors (*e*). Wire harness connectors are located next to the trailer plug connector (*a*) previously removed in Step 3.*



### Step 5: Disconnect License Plate Lights

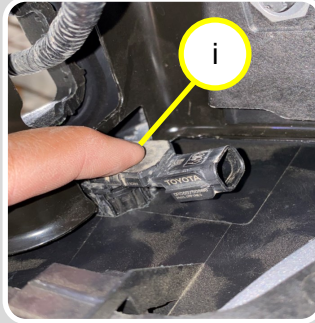
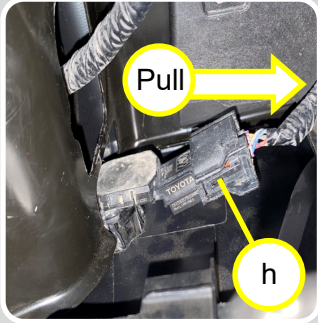
Inside the rear bumper, disconnect and remove the two license plate lights by pressing the two tabs on the back of light housing and pushing outwards from the bumper (*f*).

Then disconnect the light from the wire harness by pressing the connector tab (*g*) and pulling outwards.



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## Installation Instructions: Centre of Rear Bumper



### Step 6: Disconnect Parking Sensors (If Equipped)

Inside the rear bumper, remove the 2 center parking sensors.

Disconnect the wire harness by pressing the connector tab (*h*) and pulling outwards.

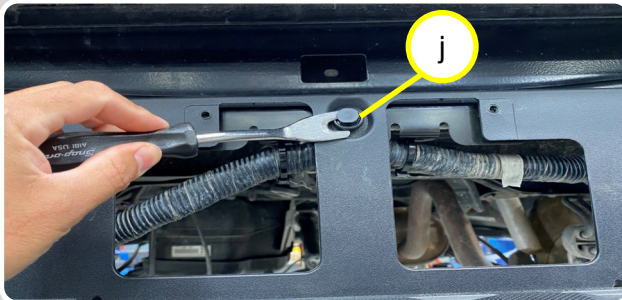
Remove the 2X sensors by carefully pushing from the inside out (*i*). The retaining tabs on the sensors may need to be depressed with a flat head tool.

### ! IMPORTANT NOTE

Note: if your vehicle is NOT equipped with parking sensors, skip to Step 7.

### Step 7: Remove License Plate From Bumper

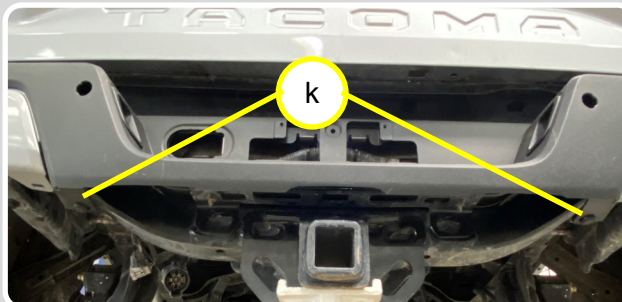
Using a Philips screwdriver or a 10mm socket (depending on the hardware of license plate), remove the license plate from the bumper.



### Step 8: Pry 3X Plastic Clips

Using a **non-marring pry tool**, pry 3X plastic clips as shown:

1X behind license plate (*j*) and  
2X from the bottom center section of bumper (*k*)



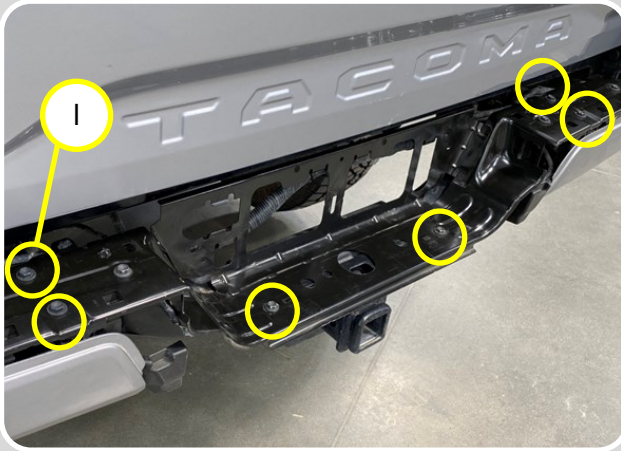
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## Installation Instructions: Rear Bumper



### Step 9: Remove Plastic Step Pad

Pry outside corner of plastic step pad using the **non-marring pry tool**. Pry one corner of plastic step pad and carefully pull out the plastic step pad, removing it from the bumper.



### Step 10: Remove Screws

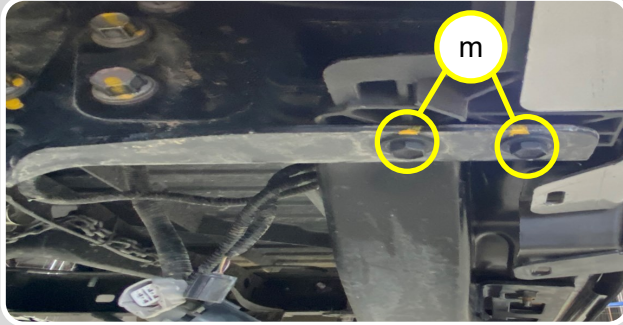
Using a **12mm Socket** remove 6X M8 Hex screws as shown (1). 2X from each top side and 2X from center section.



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## Installation Instructions: Rear Bumper



### Step 11: Remove Bumper From Vehicle

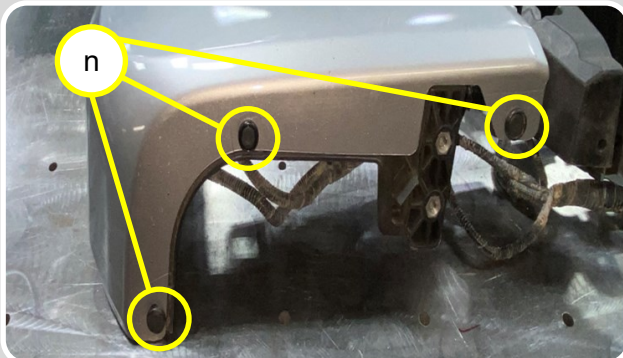
#### ! IMPORTANT NOTE

This step will require 2 people

With the help of another person and using a 12mm Socket, remove 4X M8 Hex screws from under the bumper (2 from each side of frame, *(m)* ). Remove bumper from vehicle and set aside.

#### ! IMPORTANT NOTE

If your vehicle is **NOT** equipped with parking sensors or blind spot sensors, skip to Step 16 and, if you are **NOT** installing swing gates on the bumper, skip to Step 25.

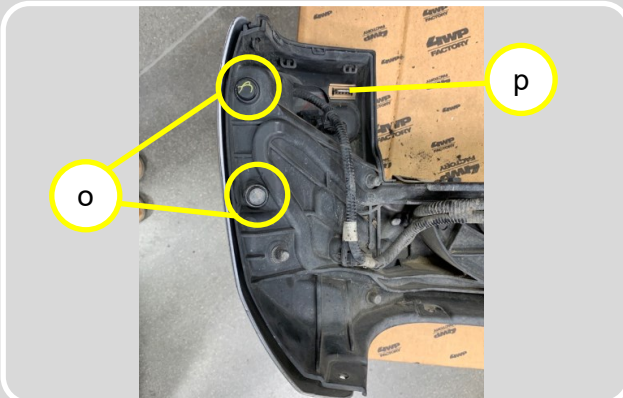


### Step 12: Remove Clips From Driver Side Corner

Using a **non-marring pry tool** pry 5X plastic clips from the rear bumper Driver side corner:

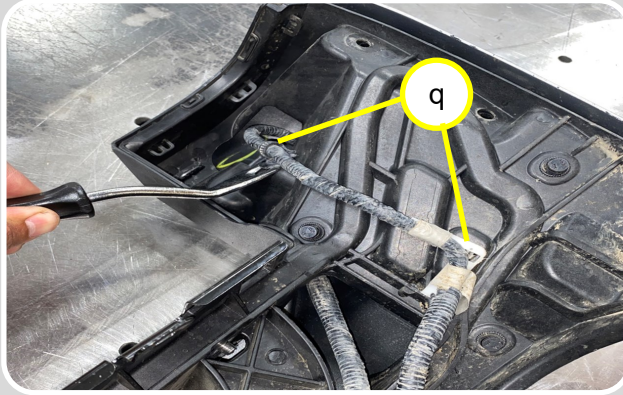
3X from under the bumper corner cover (*n*) and 2X from the inside corner (*o*).

Then, using a pick or flat screwdriver pry out the metal retaining clip from top corner (*p*).



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## Installation Instructions: Rear Bumper

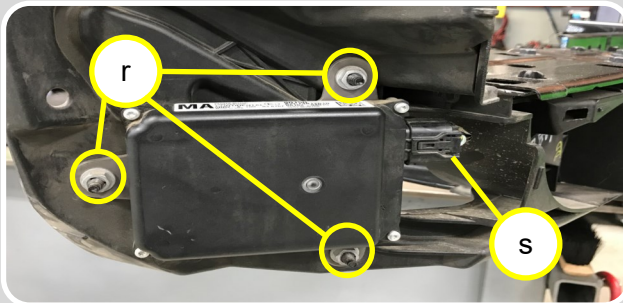
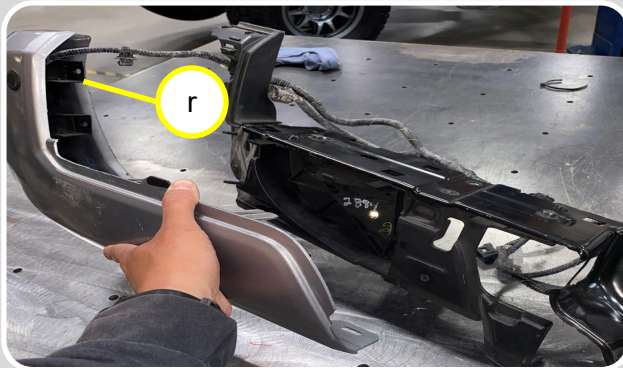


### Step 13: Disconnect Parking Sensor

At the Driver side corner cover of the rear bumper, use a **non-marring pry tool** to pry 2X plastic clips holding the wire harness to the bumper.

Carefully pull the corner bumper cover from bumper and disconnect the parking sensor (*r*).

Repeat Steps 12 & 13 on the Passenger side.



### Step 14: Disconnect Blind Spot Monitoring Sensors

If your vehicle is equipped with Blind Spot Monitor Sensors, disconnect the sensor from the wire harness by pressing the tab of the connector (*s*) and pulling outwards.

Using a **10mm Socket**, remove the 3X nuts securing the sensor to the bumper shell and set aside (*t*). Repeat this step on Passenger side.

## ! IMPORTANT NOTE

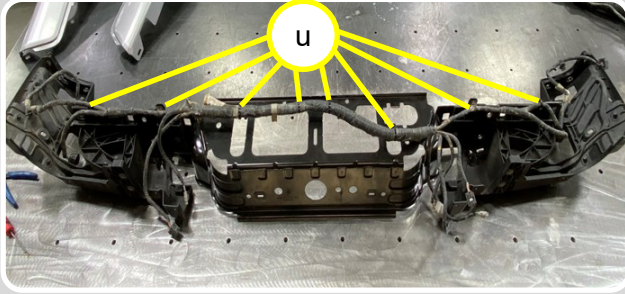
Make note of driver and passenger side sensors. Do not mix sensors upon reinstall-failure to install correctly requires re-calibration at dealership.

BSM Sensors are not compatible with the Smittybilt Swing Gate Package. **If a swing gate will be installed, leave BSM Sensors in the OE Bumper.**



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## Installation Instructions: Tailgate

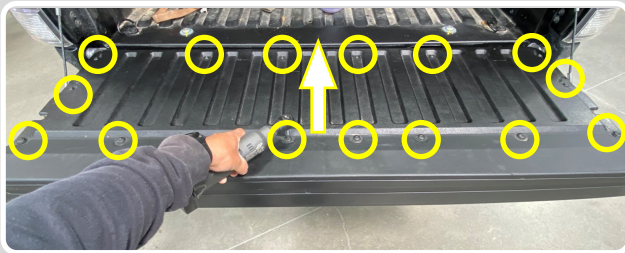


### Step 15: Remove Plastic Clips

Using a **non-marring pry tool** pry the 4X remaining plastic clips that are securing the wire harness to the rear bumper steel shell (or 8X if your vehicle is equipped with parking sensors). Remove wire harness from rear bumper. Set wire harness aside for reuse later.

## ! IMPORTANT NOTE

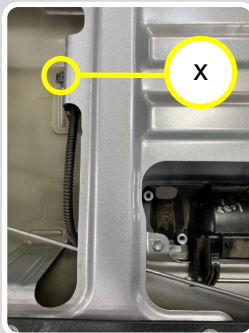
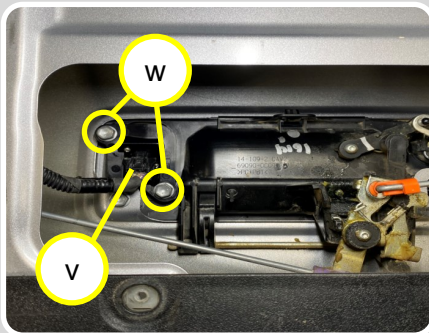
If you are **NOT** installing the rear bumper swing gates continue on to Step 25.



### Step 16: Remove Screws From Tailgate

Using a **T30 Torx Socket**, remove 16X screws securing the tailgate inner panel to the tailgate. Remove plastic panel from tailgate by sliding towards cab of truck.

Save hardware for re-installation later.



### Step 17: Disconnect Camera From Tailgate

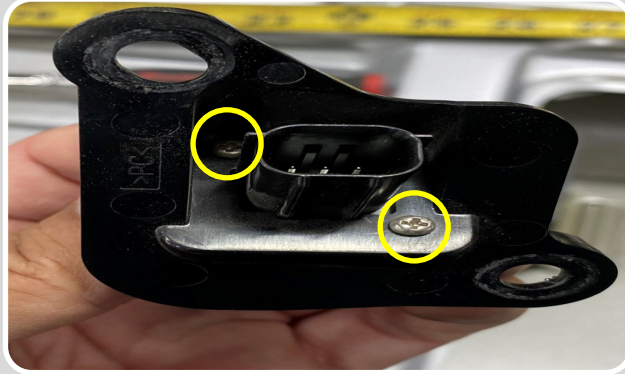
Disconnect the camera from wire harness by pressing the connector tab (*v*) and pulling outwards. Then use a **10mm Socket** remove 2X Hex Screws securing camera to tailgate (*w*).

Using a non-marring pry tool, remove plastic clip retaining wire harness in tailgate (*x*).



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## Installation Instructions: Backup Camera

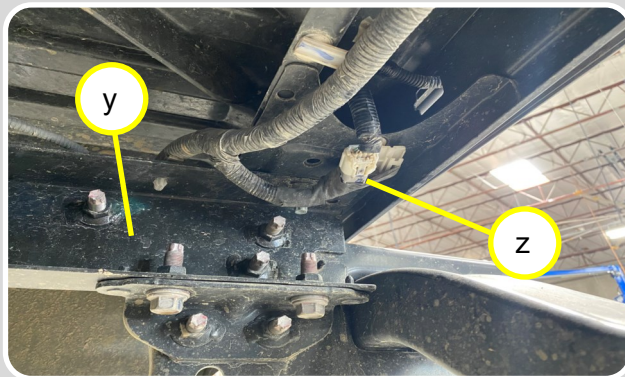


### Step 18: Remove Screws From Back Up Camera

Using a **Philips Head Screwdriver** remove the 2X screws securing camera to plastic bracket.

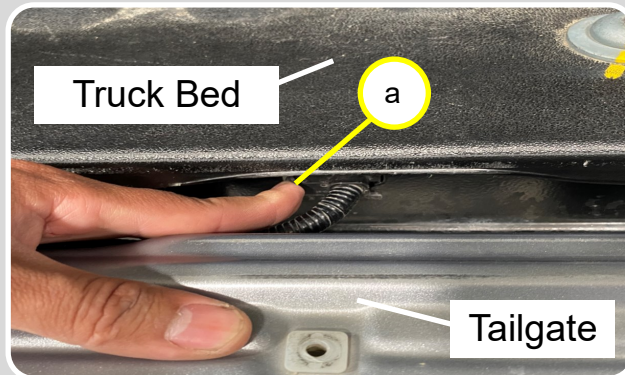
### ! IMPORTANT NOTE

Setscrews aside for re-installation later.



### Step 19: Disconnect Camera Wire Harness

Working at the rear Passenger frame section (y), disconnect the Back Up Camera wire harness from the frame wire harness by pressing the connector tab (z) and pulling outwards.



### Step 20: Unclip Harness From Bed Side

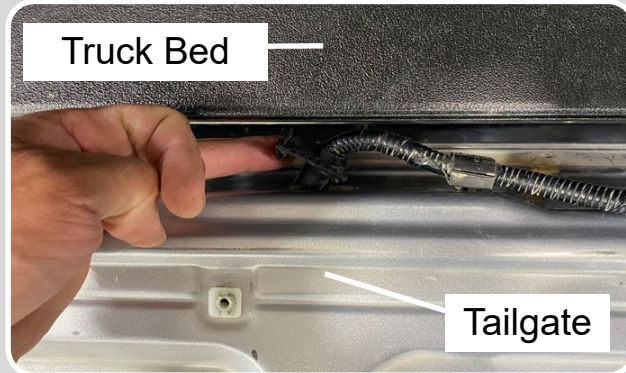
From the outside of the rear bed (passenger side) remove the plastic clips by pressing tab (a) and pulling toward the Passenger side to unclip camera wire harness.

Fish wire harness out of the bed floor.



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## Installation Instructions: Backup Camera



### Step 21: Unclip Harness From Tailgate Side

Unclip camera wire harness from under the tail gate and fish wire harness through tail gate. Remove 1X plastic clip detaining wire harness inside tailgate by pressing the outside section of clip and pushing inwards.

Set wire harness aside for reuse.



### Step 22: Reassemble Tailgate

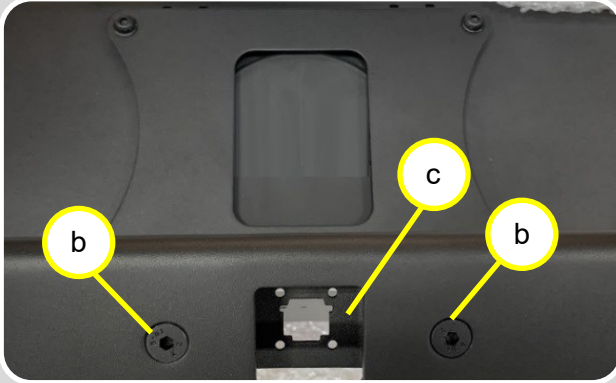
Reinstall plastic camera bracket (removed at Step 17) into tailgate using a **10mm Socket** to replace the hex screws.

Reinstall the tailgate panel (removed at Step 16). Use a **T30 Torx Socket** and 16X screws previously removed to reinstall plastic tailgate cover.



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## Installation Instructions: Backup Camera

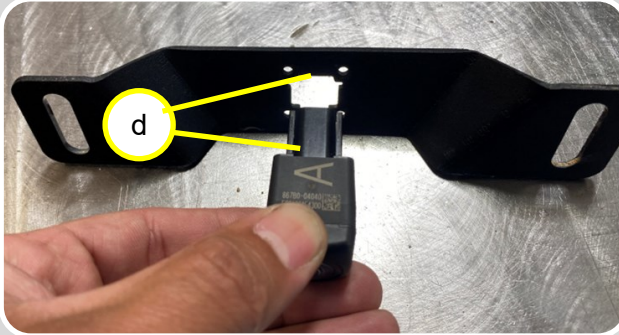


### Step 23: Install Camera to Relocation Bracket

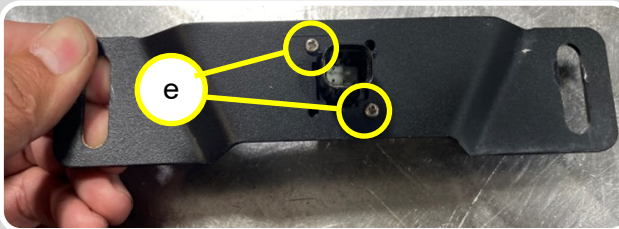
Locate **PN: 1040AA1400 (Camera Relocation Bracket)** installed in the Tacoma rear bumper (c). Use a **4mm hex bit** and **10 mm wrench** to remove 2X flat head screws (b), and remove bracket. Retain bracket and hardware for installation at Step 24.

### ! IMPORTANT NOTE

If your vehicle is a 2019+ the bracket installed in the bumper is compatible with your OE camera. If your vehicle is 2016-2018 the secondary bracket will have to be used. Retain the hardware removed from the bumper for reinstall of the new bracket.



Install camera to bracket by aligning camera ribs with slots on bracket (d), and slide in.



Use 2X OE Philips screws (e) previously removed in Step 18 to secure camera to bracket and tighten.

*(\*Prototype shown, actual part may differ from photo)*



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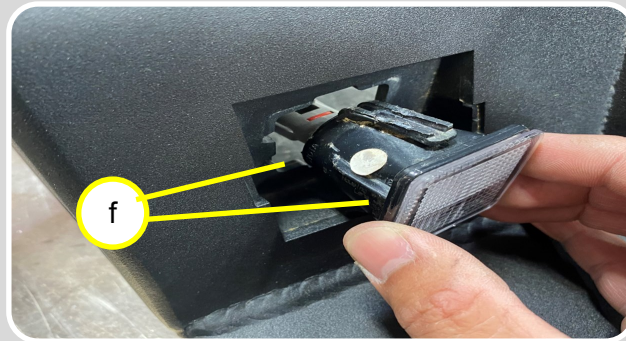
## Installation Instructions: Lights & Sensors



(\*Prototype shown, actual part may differ from photo)

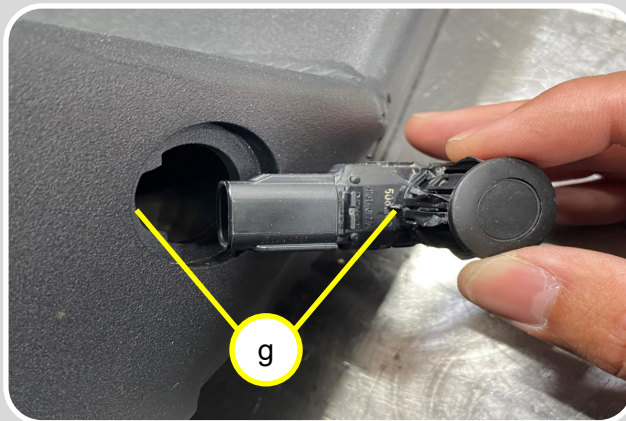
### Step 24: Install Camera Relocation Bracket to Bumper

Below step pad of bumper, install Camera Relocation Bracket to bumper by aligning the 2X slots on camera relocation bracket to studs on the lower center section of bumper. Secure using the 2X M6 Nylock Nuts & 2X M6 Oversized Washers provided in **PN: SB61448W-01 (Rear Camera & Rocklight Hardware Pack)**. Tighten with an **11mm wrench**.



### Step 25: Install OEM License Plate Lights

Install the 2X OEM license plate lights to your new bumper by aligning the license plate light rib (f) to the slot on the license plate light pocket and slide inwards.



### Step 26: Install Backup Sensors (If Equipped)

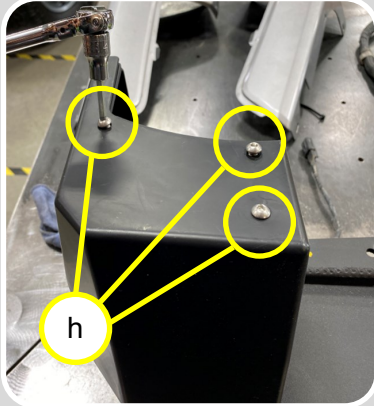
If your vehicle is equipped with backup sensors, install the 4X parking sensors by sliding the sensor through the sensor hole on bumper.

The sensor has a rib that aligns the sensor on the bumper for correct orientation (g).



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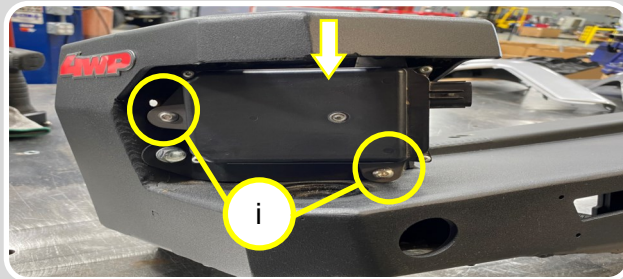
## Installation Instructions: Bumper Driver Side



### Step 27: Remove Screws

*(This step applies if your vehicle is equipped with a blind spot monitor system).*

Remove 3X Button Head Hex Drive Screws (*h*) from top of the plastic corner cover using a **4mm Hex Bit Socket** and slide the plastic corner cover off the bumper. Set aside for re-installation at a later step.



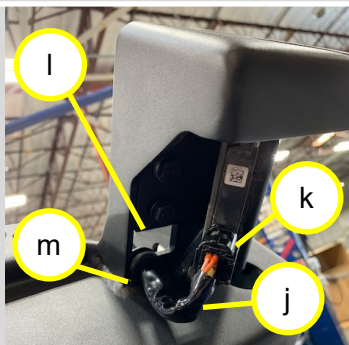
### Step 28: Install Blind Spot Monitor Sensor

Locate Driver side BSM sensor and install with connector facing towards center of bumper. Fish top tab into provided clearance slot (see arrow) then secure using 2X Button Head Hex Drive Screws and 2X M6 Flat Washers (*i*) from **SB61448W-02 (BSM Sensor Install Hardware Pack)**, and tighten with a **4mm Hex Bit Socket**.

\*Repeat step 27-28 on Passenger side.

## ! IMPORTANT NOTE

Driver and passenger side sensors must be installed in same location as OE bumper. Failure to install correctly, or switching sensor sides can lead to sensor failure or may require re-calibration from dealership.



### Step 29: Install Blind Spot Sensor Wire Extension

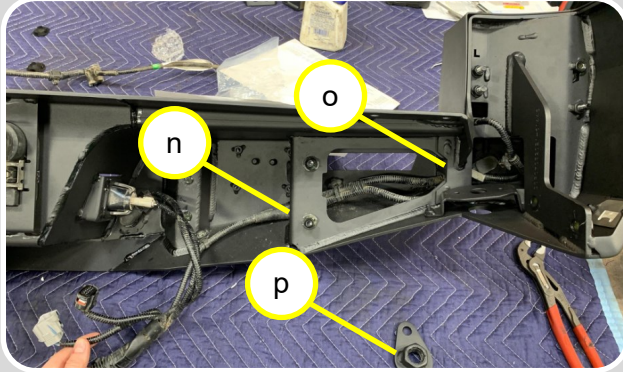
Locate **PN: 1040AA800 (BSM Sensor Wire Ext)** (*j*). At the passenger side corner, plug the female end of the provided wire harness extension into the BSM sensor (*k*). Fish the male end of the wire through the hole provided in the bumper (*l*). Locate the rubber grommet installed on the harness and lock into the notch provided (*m*).



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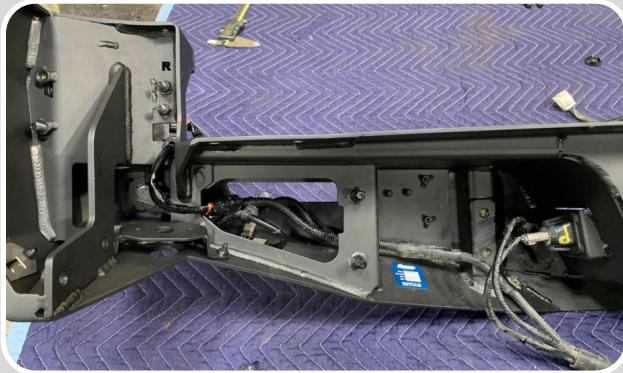


## Installation Instructions: Bumper Driver Side



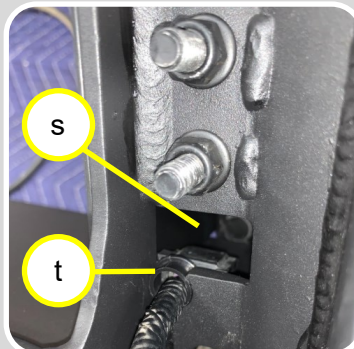
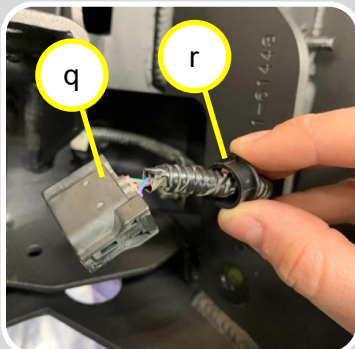
### Step 30: Install OE Wire Harness

Plug in all parking sensors, blind spot sensors and lights where applicable. Wire harness should fish through bottom provided pockets (*n* and *o*). Secure wire harness to rear bumper and frame using zip ties (not provided). Ensure wire harness is clear of frame mounts and light bar locations.



### ! IMPORTANT NOTE

If installing swing gates, the M20 nut plate (*p*) from the swing gate instructions must be installed prior to the wire harness being installed (removal of corner parking sensor is recommended as well).

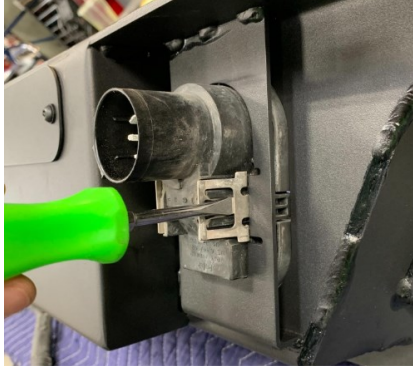


Locate Blind Spot Plug on wire harness (*q*). Attach plastic grommet from **HWPK SB61448W-02** to protect wire (*r*). Fish plug through hole provided in bumper (*s*) and snap plastic grommet into place (*t*).



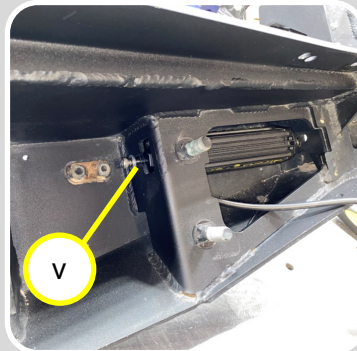
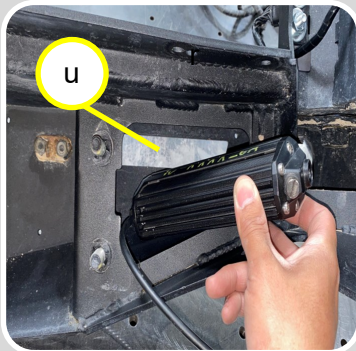
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## Installation Instructions: Trailer Plug & Light Bar



### Step 31: Install Trailer Plug

Install trailer plug removed from OE bumper to your Smittybilt Rear Bumper. Install as shown and use a Flat Head Screwdriver to snap metal retainers into place.



### Step 32: Install Light Bar

Install the 6" light bar by sliding the inside corner in first, then rotating the outside edge into place (*u*). Secure in provided slots on both sides of the light bar.

Secure using the hardware provided with the light bar (*v*). Follow manufacturer's instructions for install information.

### ! IMPORTANT NOTE

Notches provided for ease of lightbar install. If lightbar is not fitting, rotate while installing.



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## Installation Instructions: Rear Bumper



### Step 33: Install Rock Lights

Locate PN: **84-1040AA1300 (Rock Light Mount)** and install rock light to mount using the hardware provided with light.

Then install rock light mount to bumper (Driver side corner), using 2X M6(1.0) x 18mm Flat Head Screws (*w*). Use a **4mm hex bit** and **Torque Wrench** to properly install.

*\*Prototype shown. Provided hardware varies from images.*

### ! IMPORTANT NOTE

Refer to Torque Specification chart on Page 21.

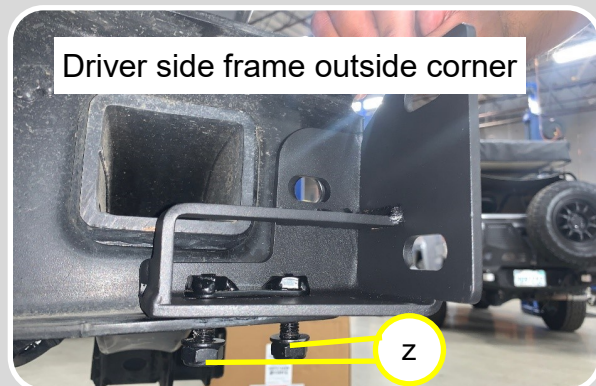


### Step 34: Install Frame Mount Brackets

Locate PN: **84-1040AA200 (Driver Side Frame Mount)**, **84-1040AA1100 (M10 Bolt Plate)** and PN: **SB61448W-03 (Bumper Install Hardware Pack)**.

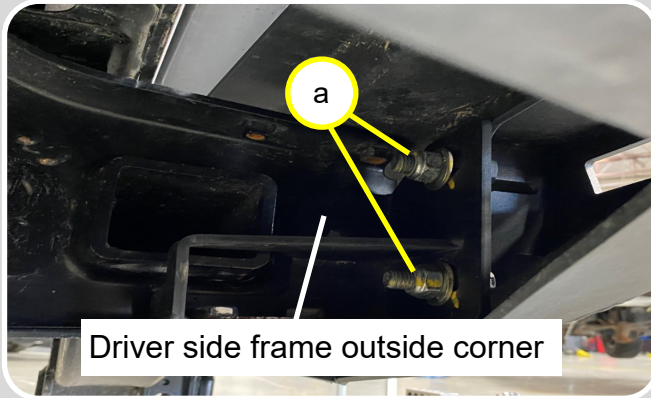
Fish M10 bolt plate (*x*) from outer side of frame bracket. Insert bracket into frame with cutout (*y*) facing frame-side with square tube. Install 2X M10 washers, and 2X M10 Nylock nuts to secure bolt plate to frame (*z*). Thread nylocks onto bolt plate but do not fully torque until after Step 37, to allow adjustment for bumper.

Repeat step on passenger side.



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## Installation Instructions: Rear Bumper

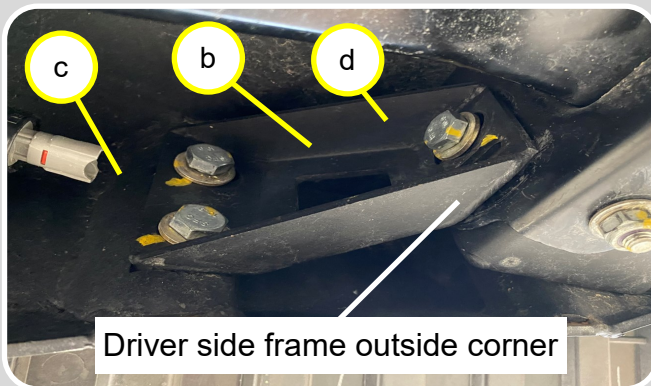


### Step 35: Install Bumper to Frame Mounts

With the help of another person, align the bumper studs to the slots on the Frame Mount brackets previously installed in Step 32.

Using 2X M12 Flat Washers and 2X M12 Nylock Nuts per side, secure bumper to the frame mounts (a).

Use a **19mm Socket** and loosely tighten to allow adjustment in Step 37.



### Step 36: Install D-Ring Reinforcement Bracket

Locate and install PN: **84-1040AA300 (D-Ring Reinforcement Bkt)** (b) to the back section of D-Ring (c). Secure bracket using 2X M12(1.75)x30mm and 2X M12 Oversized Flat Washers from PN: **SB61448W-03 (Bumper Install Hardware)**.

Secure the Reinforcement Bracket to frame (d), passing through the frame and the frame brackets installed in Step 34. Use 1X M12 (1.75)x35mm and 1X M12 oversized flat washer. Use a **19mm Socket** and loosely tighten to allow adjustment in Step 37.

Repeat step on passenger side.



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## Installation Instructions: Rear Bumper

### Step 37: Align Bumper

Carefully open tailgate and align bumper, ensuring at least 12mm of clearance is left between tailgate and bumper. Slide bumper and adjust as necessary to allow clearance between tailgate and vehicle body on corners of bumper.

### Step 38: Plug in wire harness and trailer plug

Plug in OE wire harness and trailer plug. If wire harness is too tight to plug in, follow wire harness back to frame and remove plastic clips securing harness to frame until enough slack is achieved.



### Step 39: Tighten All Hardware

Tighten all hardware, use **Threadlocker** and torque all hardware to spec. Connect bumper wire harness to frame wire harness.

### ! IMPORTANT NOTE

Torque Specification chart on Page 22.

### Step 40: Confirm Sensor Connections

Confirm all sensors are properly connected to wire harness. After confirmation, reconnect vehicle battery and test functionality of all lights and sensors.

**Your installation is now complete.**

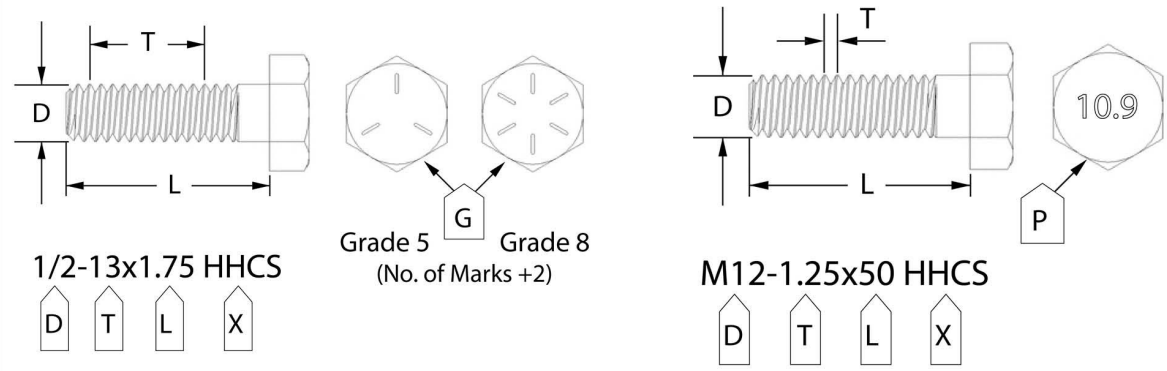


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# Bolt Torque Specifications

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

<b>Bolt Torque and ID</b>						
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



<p>G= Grade (Bolt Strength)</p> <p>D= Nominal Diameter (Inches)</p> <p>T= Thread Count (Threads per Inch)</p> <p>L= Length (Inches)</p> <p>X= Description (Hex Head Cap Screw)</p>	<p>P= Property Class (Bolt Strength)</p> <p>D= Nominal Diameter (Millimeters)</p> <p>T= Thread Pitch (Thread Width, mm)</p> <p>L= Length (Millimeters)</p> <p>X= Description (Hex Head Cap Screw)</p>
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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 was 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 was 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 was 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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