



INSTALLATION INSTRUCTIONS

Hardware:

12M x 40M hex head bolts	Qty: 4
12M flat washers	Qty: 8
12M lock washers	Qty: 4
12M Ny-lock hex nuts	Qty: 4
Extension bracket with bolt	Qty: 2
8M Ny-lock hex nuts	Qty: 2
8M Lock washer	Qty: 2
8M flat washers	Qty: 2

Installation instructions for Desert Series Tacoma Front winch bumper

2016-2018 Toyota Tacoma TC-19337

** Remove the winch plate and hardware from the box behind the foam block

**The installation of this bumper requires cutting of the factory front bumper cover. Body Armor 4x4 is not responsible for errors or mistakes in cutting of the bumper.

Cutting the factory bumper cover:

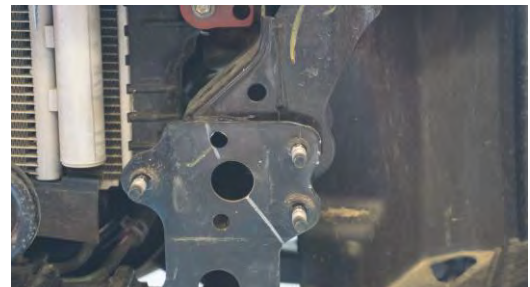
1. You will need to mark the area of the bumper that will be the trim line for cutting the bumper cover. Start at the front of the bumper just under the top of the fog light pocket and run around the bumper to the fender. Note the flare and bumper clips in the wheel opening. The trim line should be just below the clip in the fender. See the image below:



2. Make sure the line from the fog light pocket lines up at the fender below where the clip is on the fender flare. The lowest clip will be discarded with the bumper. The easiest method to mark the bumper is by using masking tape. The bottom edge of the tape is the cut line. Be careful when removing the tape so that the paint does not get damaged. Use a fine hacksaw blade or a utility knife to cut the polyurethane material.
3. It is preferable to cut the bumper cover while it is installed on the vehicle. If the vehicle is equipped with fender flares they will need to be trimmed as well. Later the inner will also need to be trimmed. Note the line on the inner fender in the image below.
4. Now remove the lower material of the bumper under the grille area. Be sure to retain the flat section that attaches the ends of the bumper.
5. Using a socket wrench remove the six bolts that attach the aluminum bumper and remove the aluminum bumper. Retain the six nuts as they will be reused when installing the Body Armor winch plate.
6. The front of the vehicle should look like the image below except with the trimmed factory bumper installed.



Driver side frame mount

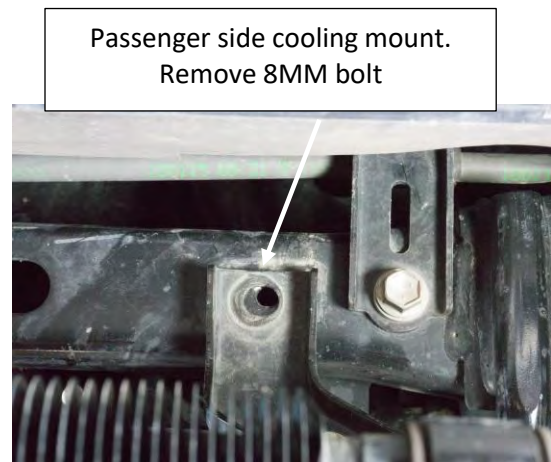
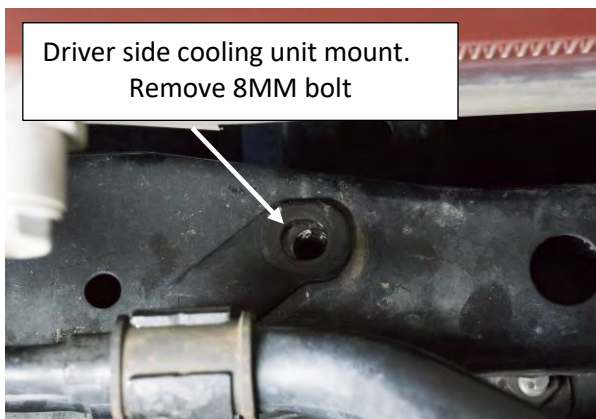


Passenger side frame mount

7. If the vehicle is a TRD Pro, or has the extra cooling fins mounted to the lower radiator core support you will need to remove the hardware attaching the fins (DO NOT REMOVE THE UNIT FROM THE VEHICLE). It is being moved up and back to make room for the winch plate.



8. Remove the 8MM bolts that attach the cooling unit to the frame.



9. Reattach the cooling unit using the extension brackets and the factory supplied bolts. These brackets have a welded bolt on one end of metal bar with a hole on the opposite end. Attach the cooling unit to the welded stud on both brackets of the cooling unit by using the supplied washer and nut. Reuse the factory 8MM bolt to attach the extension bracket back to the frame. This step moves the cooling unit up and back out of the way.



Installing winch plate:

1. Lift the winch plate on the frame horns. Center the studs on the frame horns by using the factory nuts. Leave finger tight at this time.



2. Install winch at this time. Use the hardware that was supplied by the winch manufacturer.



Pre-installation Desert Series front bumper:

1. Install Body Armor 4x4 40021 dual row in the center section of the bumper.
2. Install Body Armor 4x4 cubes in the wings of the bumper.
3. Install the fairlead supplied the winch manufacturer, using their hardware.

Attach the Desert Series bumper:

Carefully lift the bumper and slide it over the winch plate. Use the 12M x 40M hex bolts and hardware attach the bumper to mounting face on the winch plate. As with all hardware the order of the hardware is bolt head-flat washer- through bracket material-flat washer-lock washer then nut. Keep hardware finger tight until satisfied with alignment of the bumper. Once satisfied with alignment tighten hardware to the appropriate torque specs.