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2005 - 2015 Tacoma Rear Bumper Install Guide

Congratulations on purchasing your new 4x Innovations Tacoma Rear Bumper. Included in this manual are package contents, surface coating recommendations, and installation guide. This document consists of a guide and is not an absolute instruction manual. Professional installation and attention to details is required for best finished results. If you have any questions please call us at 1-608-348-4880.

Package Contents:

1 x Rear Bumper	10 x 1/2" Flat Washers
2 x White LED Bolt Lights w/ Bullet Quick Connect	2 x 5/16x1 Hex Bolts
2 x 5/16 Nylon Nuts	2x 1/4x1 Hex Bolts and Nuts
2 x 5/16 Zinc Plated Nuts	1x Trailer Wire Harness Mount Bracket
10 x M12x1.25x35mm Hex Bolts	

Caution:

1. This installation should be performed by a qualified professional.
2. Always wear proper Personal Protective Equipment, including but not limited to Closed Toed or Safety Shoes, Safety Glasses, Hearing Protection, Face Shield, and Gloves.
3. Always have a fire extinguisher in reach while working in and around your vehicle. Interior panels are made from vinyl and other plastics which burn VERY easily; under carriages can be covered in oil and road grime which also burns easily.
4. Working around vehicles is inherently dangerous. You and the installer are responsible for your actions. Take general care while working on a vehicle.

Coatings: Note: Note: ALWAYS check fitment BEFORE painting parts, painted parts are NOT returnable for any reason! For optimum coating performance follow coating manufacturer's instructions.

- A. On the cheap, quick and easy: Simple spray paint.
This method is an economical method to coat your new Rear Bumper. Any top quality spray paint rated for metals can be used. In our shop we use Rustoleum Professional Metal paint.
- B. POR-15, KBS Coatings or similar moisture cured polymers:
These professional coatings are highly durable and can be touched up if scratched. Most are formed as multi part primer, color, and top coats that are abrasion, and heat resistant. They are available online, usually directly from the manufacturer.
- C. Powder Coating:
Powder coating consists of spraying a powdered paint onto the parts and baking the powder to the part. This process must be performed by a qualified business to have proper adhesion. This process is typically costly. Powder Coat is stronger than typical paint but WILL get scratched on a rear bumper and offers little possibility for quality touch up once scratched. 4x Innovations prefers moisture cured polymer paints over powder coat because of this fact.

List of Required Tools:

White or Silver Permanent Marker	2x C-Clamp
Tape Measure	File
Ratchet with 10mm, 19mm, 7/16" and 1/2" Socket	Anti-Seize
1/2" Box Wrench	A friend, forklift and jack stands to help lift heavy stuff
#2 Phillips Head Screwdriver	
2x 12" long 2x4 or other material with equal thickness	

Removing Factory Rear Bumper



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1. Using a 10mm socket, remove the Brake Light housing assembly by removing the two bolts located inside the tailgate opening.
2. Unplug the license plate and trailer hitch wiring harnesses.
3. Place jack stands under the bumper for support.
4. Using a 19mm socket, remove the 3 bolts on each side of the bumper mounting bracket. Leave one in place on each side to help hold the bumper.
5. If you have the stock hitch, use a 19mm socket to remove the 2 bottom bolts on the bottom of each frame rail.
6. Check to ensure all wiring is free and clear of the bumper.
7. While holding the bumper in place, remove the remaining bolt, lift up and slide the bumper back to disengage the pins that are holding it up, and then slide the bumper straight down to the ground.
8. Put your C-clamps under the back of the truck.

Installing 4x Innovations Rear Bumper

9. Lift the Style 1 Bumper to the frame, and clamp from the bottom frame flange to the bottom of the hitch support gusset to hold the bumper in place. Ensure the gusset plates are parallel with the bottom of the frame.
10. Inspect the all around fit of the bumper, if happy with fitment proceed to step 11.
11. Lightly coat the 10x M12x1.25x35mm bolts with anti-seize. Place bolts and 1/2" washers under the back of the truck.
12. Lift the bumper into position and attach with the bolts and washers, with the washer between the head of the bolt and the mounting plate of the bumper.
13. Check the final fitment of the bumper and ensure you are happy with the final result.
14. Once happy with the fitment, tighten all bolts to 90ft-pounds.
15. If using the RV trailer wire harness socket, insert the socket into the bracket and secure using 2 or 4 1/4inch hex bolts and nuts.
16. Secure mounting bracket to bumper using 2x 5/16 hex bolts, using the mounting location provided on the inside face of the hitch support tube. The bracket can be mounted facing down for a flush to bottom socket location, or mounted facing up for a recessed socket location.
17. Plug RV socket into wire harness.
18. Place 1x 5/16 steel nut on the LED Bolt Lights. Run this nut to the base of the bolt head to use as a spacer.
19. Place the LED Bolt Lights through your license plate, through the mounting plate and thread into the bumper.
20. Secure each LED Bolt Light into place with the Nylon nut on the back side. Do not over tighten!
21. Splice each light into the factory wire harness for the license plate lights.

Congratulations You're done! Enjoy you new Rear Bumper!