

# INSTALLATION INSTRUCTIONS



## TGI-309047 (INSTALLATION INSTRUCTIONS FOR 96-02 4RUNNER REAR TUBE BUMPER, TGI-309046)

	<p><b>NOTICE</b></p> <p>Read instructions completely before installing this product. Refer back to the instructions frequently during installation.</p>		<p><b>CAUTION</b></p> <p>Flying Object Hazard. Fluid Splash Hazard. Wear safety glasses at all times when working on vehicle.</p>
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 **WARNING**  
Cancer and Reproductive Harm – [www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov)



TGI-309047

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## STEP 1

Remove the factory rear bumper and any associated brackets. Plug any open bolt holes into the cab with the original bolts with some silicone on the threads to prevent any moisture from entering the cab. Before installing the new bumper we recommend painting or powder coating the bumper to prevent corrosion in the future.



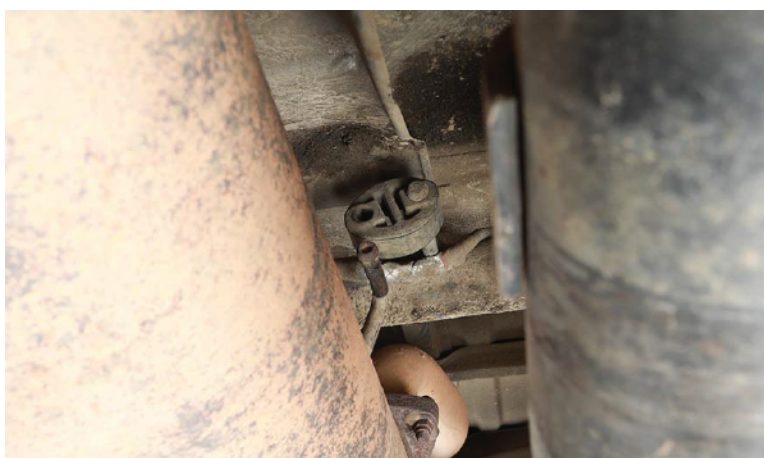


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## STEP 2

If your exhaust system hangs below either of the frame rails remove the rubber exhaust isolators as shown so the exhaust system can be moved out of the way during the bumper installation.



## STEP 3

You may need to clearance the body seams so they do not contact the front bumper support tubes. In our case we measured 4.25" back from the front of the body seam and sanded the body as shown in the pictures on both sides of the vehicle. This step may not be necessary but it can save you from having to take off the bumper and clearance the body seams in future steps.





## STEP 4

If your frame rails are bowed out at the bottom use a hammer to push the rails inward so the outer edge is straight.



## STEP 5

Using a jack or a helper lift the bumper into place and install one of the provided M12 bolts into a threaded hole on each frame rail to temporarily hold the bumper in place. The bumper should be installed in a straight upwards direction to clear the body mounts and rear cross member.



## STEP 6

With the bumper temporarily installed check to make sure there is clearance between the lower body seams and the front support tubes on each side of the vehicle. If the support tubes touch the body seams, sand down the body seam until there is about  $\frac{1}{4}$ " of clearance.



## STEP 7

After enough clearance is achieved between the body seams and the front support tubes reinstall the bumper (if applicable) and bolt in (2) provided M12 bolts with washers into the threaded frame holes on each frame rail.

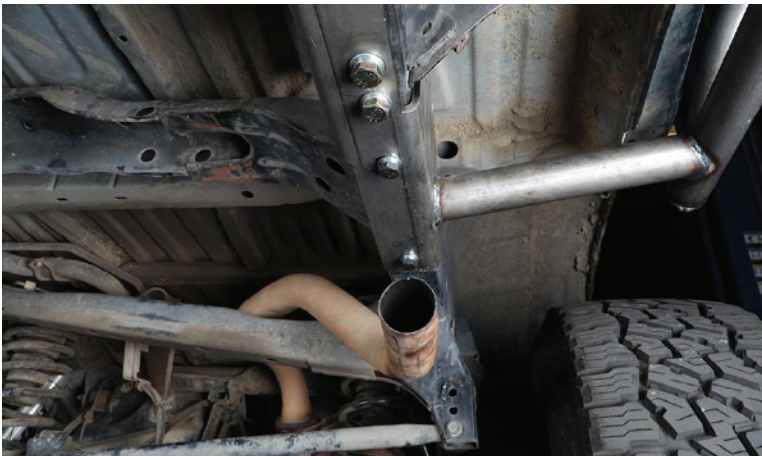


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## STEP 8

Insert a provided secondary mounting bracket into each frame rail and align the holes in the secondary mounting bracket with the front two holes on each side of the bumper mounting brackets. Install (2) of the provided M10 bolts with washers through the holes on each mounting bracket and tighten.





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## STEP 9

Once all the bolts installed on the bottom of the bumper are tight, use a paint pen or sharpie and mark the hole locations on both sides of frame rails.

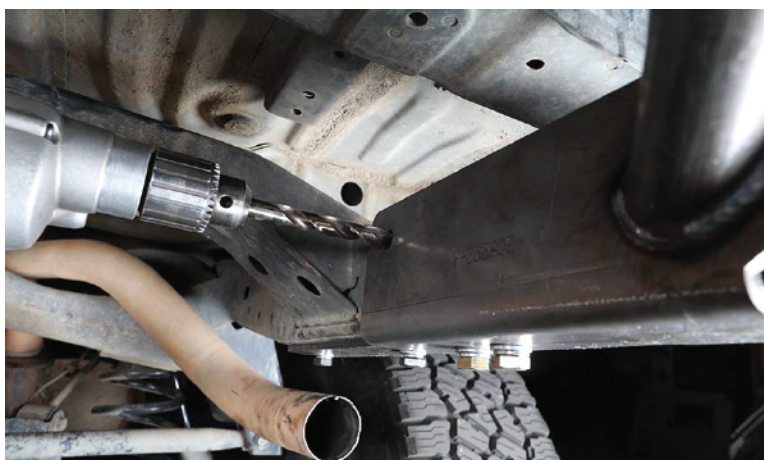


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## STEP 10

Using a ½" drill bit and the holes in the bumper mounting brackets as a guide, drill through the frame rails. It may be necessary to remove the bumper and use the drilled holes in the outside edges of the frame rails as a guide to drill the front inner holes.



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## STEP 11

Install the provided 1/2" hardware and tighten. The shorter 1/2" bolts are used in the rear most holes.



## STEP 12

Reinstall any exhaust isolators that were previously removed.