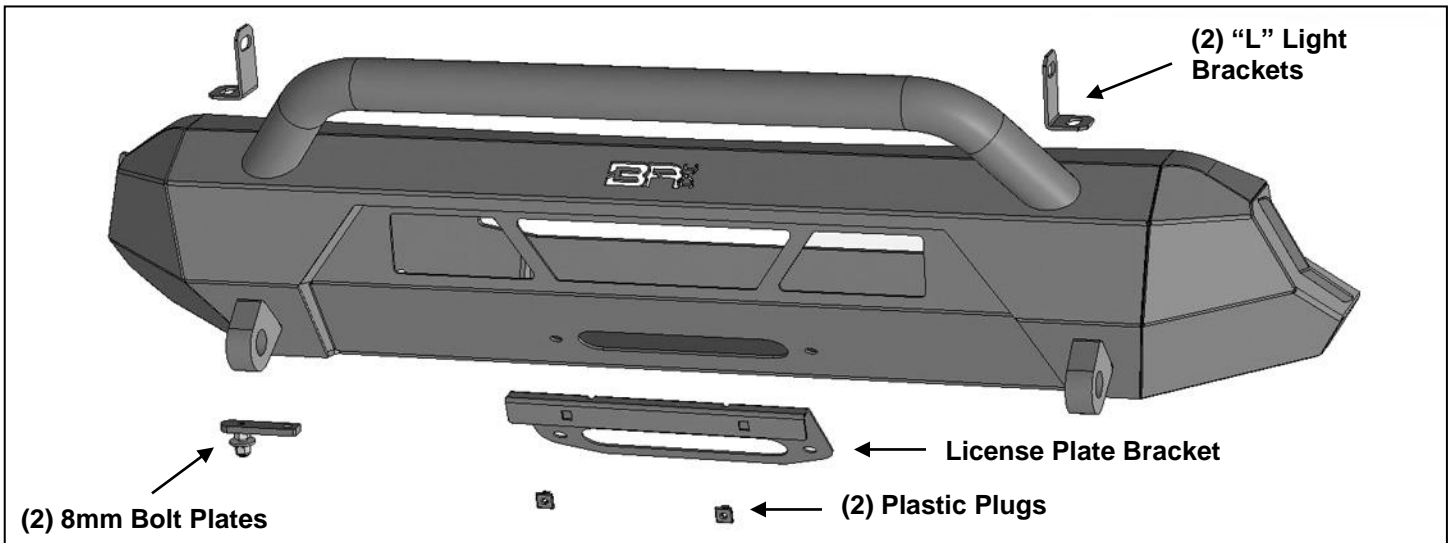


## 2016-2019 TACOMA HILINE FRONT WINCH BUMPER PART#TC-19339

### PARTS LIST:

1	BA Front Center Section Winch Bumper	4	10mm x 20mm x 2mm Flat Washers
2	LED Center Light Bar L-Brackets	2	10mm Nylon Lock Nuts
1	License Plate Bracket	2	8mm Bolt Plates
2	Plastic Plugs	2	8-1.25mm x 25mm Hex Bolts
1	Edge Trim (2m length cut to fit)	6	8mm x 24mm x 2mm Flat Washers
2	12-1.75mm x 120mm Hex Bolts	4	8mm Nylon Lock Nuts
4	12mm x 32mm x 3mm Flat Washers	2	8mm Hex Nuts
2	12mm Nylon Lock Nuts	1	6mm Wrench
2	10-1.5mm x 25mm Button Head Bolts		



### PROCEDURE:

**REMOVE CONTENTS FROM BOX. VERIFY ALL PARTS ARE PRESENT. READ INSTRUCTIONS CAREFULLY BEFORE STARTING INSTALLATION. ASSISTANCE IS RECOMMENDED TO AVOID POSSIBLE INJURY OR DAMAGE TO THE VEHICLE. CUTTING OE FRONT BUMPER IS REQUIRED.**

1. Remove the air dam from the bottom of the bumper and remove the skid plate, if equipped, **(Figure 1)**.
2. Open the hood and remove the plastic cover from the top of the radiator and grille, **(Figure 2)**. Next, carefully remove the plastic grille, **(Figure 3)**.
3. Use removable tape (masking tape for example) to cover the top and sides of the bumper cover in the approximate areas that will be cut, **(Figure 3—5)**. Move to the top of the bumper and locate the approximate center of the bumper. Measure and place a mark 19-20mm (3/4") from the license plate bracket back toward the grille, **(Figures 6 & 7)**. If there is no front license plate, measure from the bumper pad toward the grille. With a long straight edge, draw a straight line across the top of the bumper, **(Figure 6)**. **NOTE:** Use a marking pen and draw onto the tape, not the painted finish.
4. Next, move to either side of the bumper and mark along the contour/bend line in the bumper to the top of the bumper, **(Figures 8 & 9)**. Draw a short angled connecting line from the contour line to the long line across the top of the bumper. Repeat this Step to mark the remaining side of the bumper.
5. Remove the factory bolts along the inside of the driver/left front side of the wheel well to release the end of the fender flare, **(Figure 10)**. Pull the flare straight out to release from the clips. **NOTE:** The fender flare does not need to be completely removed, only the front end of the flare attached to the bumper cover needs to be released to remove cover.

6. On models with factory fog lights, unplug the harness leading to bumper.
7. Remove the hardware attaching the plastic bumper cover at the top, ends and bottom, **(Figure 11)**. With assistance, pop the ends off of the inner clip and pull the bumper off and away from the vehicle, **(Figure 12)**. Set the plastic bumper cover on a soft, clean and flat surface.
8. Remove the plastic impact pad, aluminum cross bar and brackets from the frame, **(Figures 12 & 13)**.
9. Determine if the vehicle is equipped with a power steering cooler, **models without cooler, proceed to Step 10.**

**Models equipped with a power steering cooler:**

- a. Locate the (2) bolts attaching the cooler to the top of the front cross member, **(Figures 14 & 15)**. Temporarily, remove the (2) hex bolts.
  - b. Select (1) 8mm Bolt Plate, **(Figure 16)**. Reuse (1) factory bolt to attach the Bolt Plate to the top of the cross member on the driver/left side with the bolt on the Bolt Plate facing up, **(Figure 17)**. Repeat to install the remaining Bolt Plate on the passenger/right side cooler mounting location.
  - c. Rotate the Bolt Plates so that the bolt on the Bolt Plate is towards the radiator.
  - d. Next, attach the cooler to the Bolt Plates with (2) 8mm Flat Washers and (2) 8mm Nylon Lock Nuts, **(Figures 16 & 17)**. **NOTE:** If needed, use the included (2) 8mm Hex Nuts as spacers to raise the cooler up for additional clearance, **(Figure 16)**.
10. Remove the plastic center pad from the bumper cover, **(Figure 18)**.
  11. Use a sharp knife or hacksaw blade to carefully cut along the previously marked lines, **(Figure 19)**. **IMPORTANT:** For best fit, leave an extra 1/4" – 1/2" of material when cutting to make any adjustments at the end of the installation as necessary.
  12. Reinstall the cut plastic bumper cover. Select the Body Armor Center Bumper. Hold the Bumper up in place to check the fit of the Bumper against the cut plastic bumper cover and trim cover as necessary for best fit. Do not install the Body Armor Bumper at this time, only check the fit against the plastic bumper cover. Once all trimming is completed, cover the cut edge of the bumper cover with the included Edge Trim, **(Figure 20)**. Cut the Edge Trim to fit as required, **(Figure 21)**. Reattach the fender flares and fog light wiring harness at this time.
  13. Next, move the Body Armor Front Bumper to a stable, clean and flat surface.
  14. **Center LED light installation** (sold separately).
    - a. Select (2) "L" Light Brackets, **(Figure 22)**. Use the provided (2) 8mm x 25mm Hex Bolts, (4) 8mm x 24mm Flat Washers and (2) 8mm Nylon Lock Nuts to attach the "L" Brackets to the mounting tabs on the back of the Bumper. Leave hardware loose.
    - b. Attach the LED light assembly to the "L" Brackets.
    - c. Adjust the light as necessary and tighten hardware.
    - d. Follow the instructions included with the light to connect the wire harness to the vehicle.
  15. **Winch installation** (sold separately).
    - a. Attach the winch to the center mounting plate on the back of the Bumper.
    - b. With assistance, hold the Bumper with winch up in position on the vehicle to check for clearance. Adjust or modify vehicle for clearance as necessary but do not install Bumper.
    - c. Attach cable guide (sold separately) to front of Bumper. **NOTE:** If front license plate is required, insert the included License Plate Bracket between the Bumper and the cable guide. Insert (2) Plastic Plugs into the square holes in the Bracket for license plate.
    - d. Follow instructions packaged with winch to install winch and connect electrical system.
  16. **License Plate Bracket alone**, (Bumper install without winch).
    - a. Attach License Plate Bracket to Bumper with the included (2) 10mm Button Head Bolts, (4) 10mm Flat Washers and (2) 10mm Nylon Lock Nuts, **(Figure 23)**.
    - b. Insert (2) Plastic Plugs into the square holes in the Bracket for license plate.
  17. With assistance, position the Bumper Assembly up to the frame bracket studs. Temporarily support the weight of the Bumper. **WARNING:** To avoid possible injury or damage to the vehicle, do not proceed until the bumper is fully and safely supported.

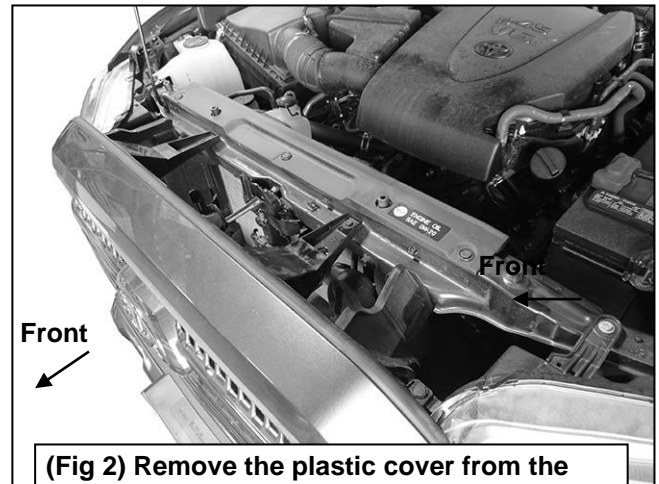
18. Reuse the (6) factory flange nuts to attach the Bumper Assembly to the studs, **(Figures 24 & 25)**.  
Leave hardware loose at this time.
  - a. Check fitment of Bumper and the trimmed plastic bumper cover. Trim plastic cover as required.  
Level and adjust the Bumper as needed and tighten all (6) factory hex nuts.
19. Next, attach the driver/left corner of the winch tray to the hole in the frame with (1) 12mm x 120mm Long Hex Bolt, (2) 12mm Flat Washers and (1) 12mm Nylon Lock Nut. , **(Figure 26—28)** Repeat to attach the passenger side of the winch tray to the frame. Fully tighten hardware at this time.
20. Reinstall the Grille and top plastic cover, **(Figure 29)**.
21. Reinstall the skid plate, if equipped.
22. Do periodic inspections to the installation to make sure that all hardware is secure and tight.

**To protect your investment,** Do not use any type of polish or wax that may contain abrasives that could damage the finish. Mild soap may be used to clean the Bumper assembly.

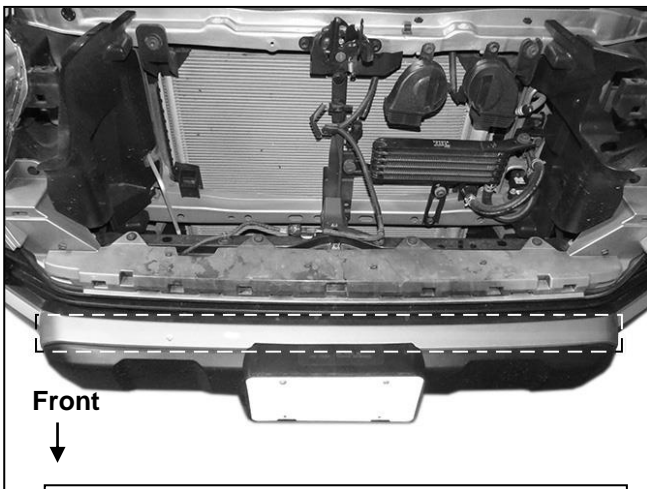
## Driver/left side Installation Pictured



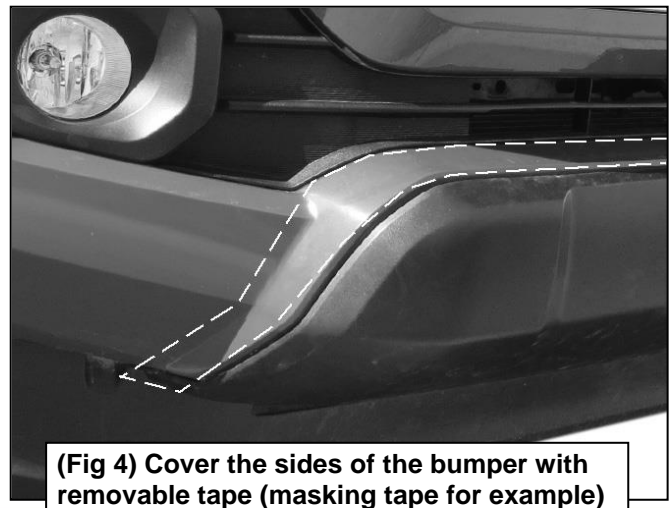
**(Fig 1) Remove Skid Plate and air dam, if equipped**



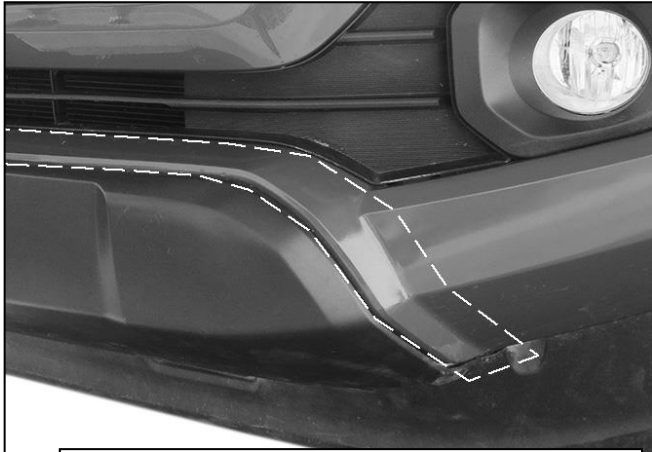
**(Fig 2) Remove the plastic cover from the top of the radiator. Remove grille assembly**



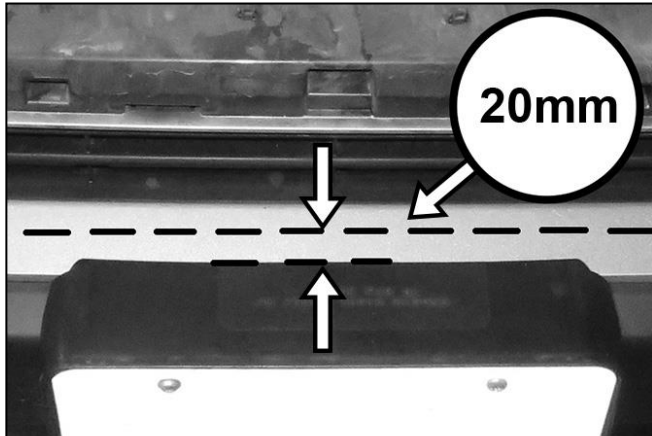
**(Fig 3) Cover the top of the bumper with removable tape (masking tape for example)**



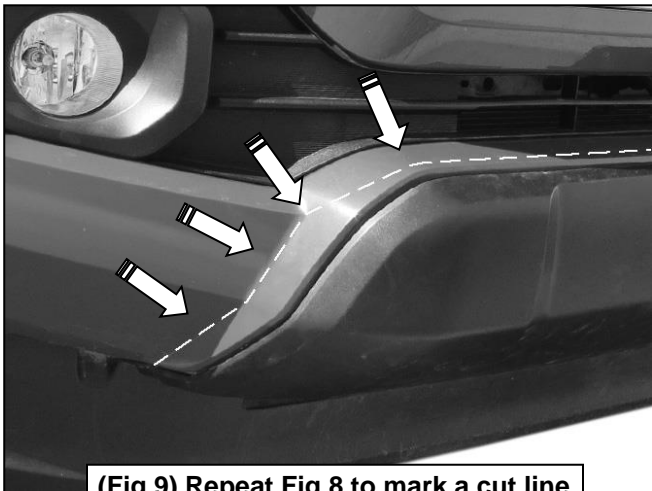
**(Fig 4) Cover the sides of the bumper with removable tape (masking tape for example)**



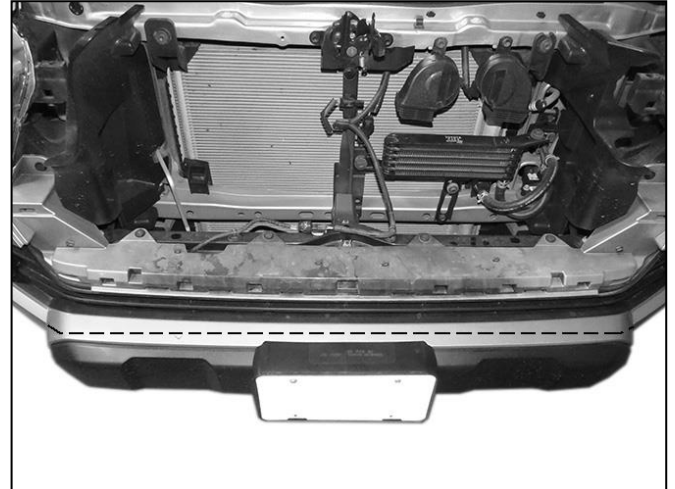
(Fig 5) Cover the sides of the bumper with removable tape (masking tape for example)



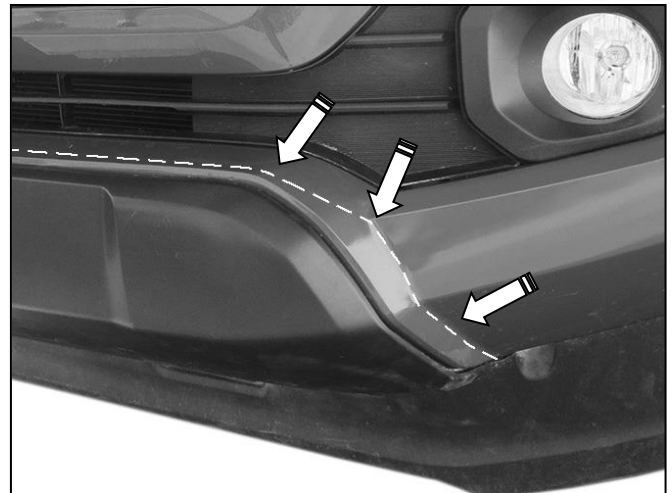
(Fig 7) Measure 3/4" (20mm) from the front edge of the bumper to the center (see Fig 6). Draw a straight line from side to side across the top of the bumper



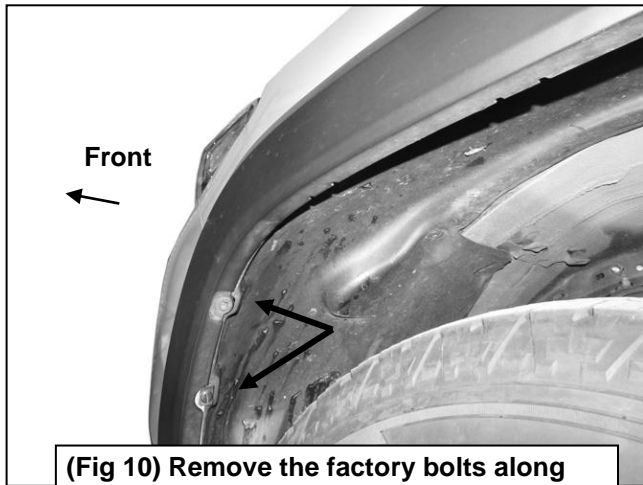
(Fig 9) Repeat Fig 8 to mark a cut line along the bend lines in the bumper. Passenger/right side pictured



(Fig 6) Locate the approximate center of the bumper. Measure 3/4" (20mm) from the front edge of the bumper to the center (see Fig 7). Draw a straight line from side to side across the top of the bumper



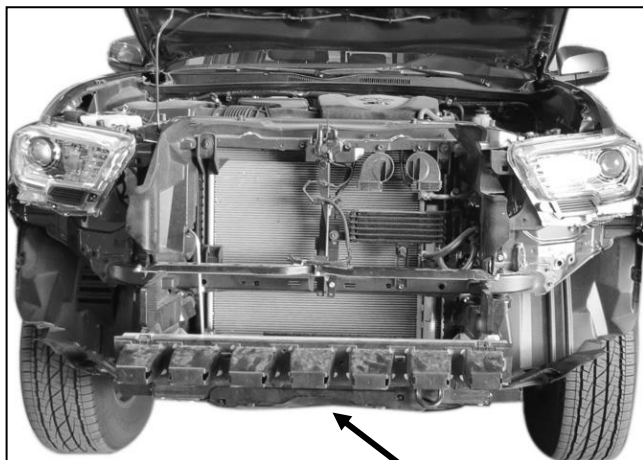
(Fig 8) Mark a cut line along the bend lines in the bumper. Connect the line drawn on the top of the bumper (Figs 6 & 7) with the lines in the bends (arrows). Driver/left side pictured



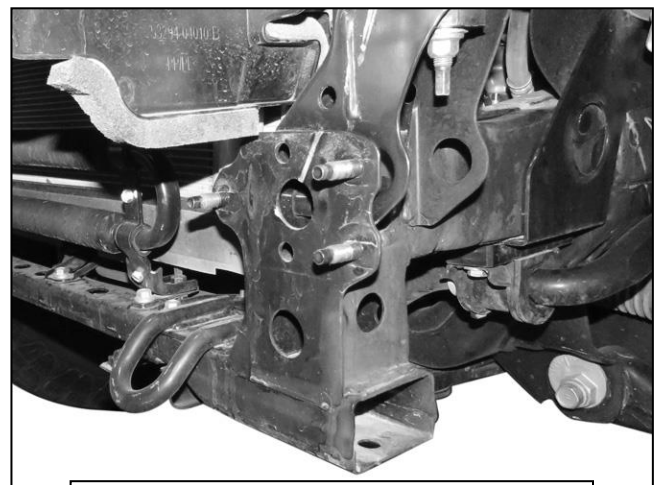
(Fig 10) Remove the factory bolts along the inside of the wheel well to release the driver/left front side Fender Flare



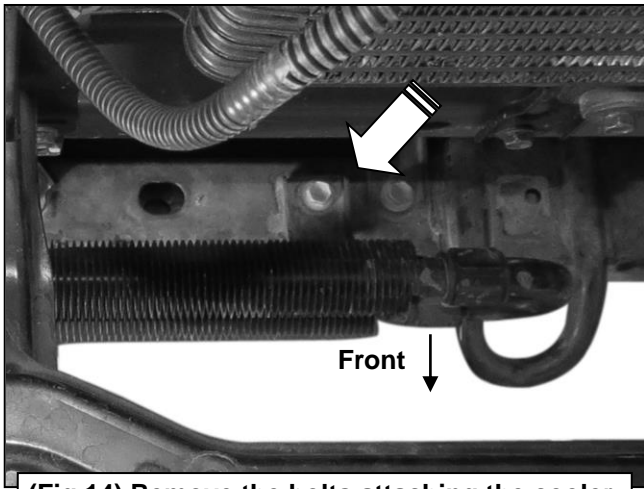
(Fig 11) Grille Removed. Remove factory bumper bolts along the top and bottom of bumper cover



(Fig 12) Remove plastic impact bumper, aluminum crossbar and brackets from the end of the frame.

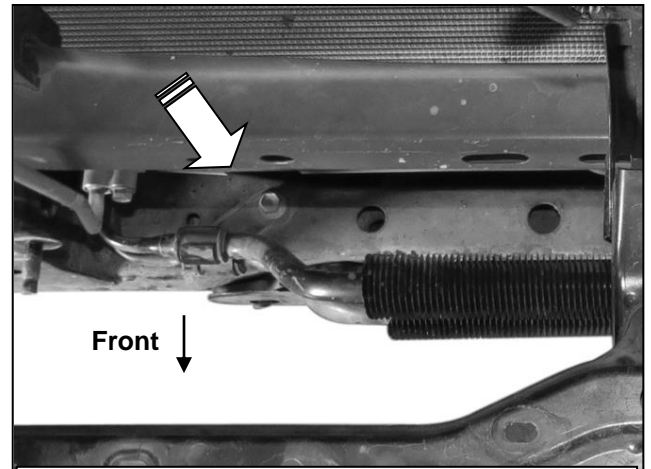


(Fig 13) End of driver/left side of frame.

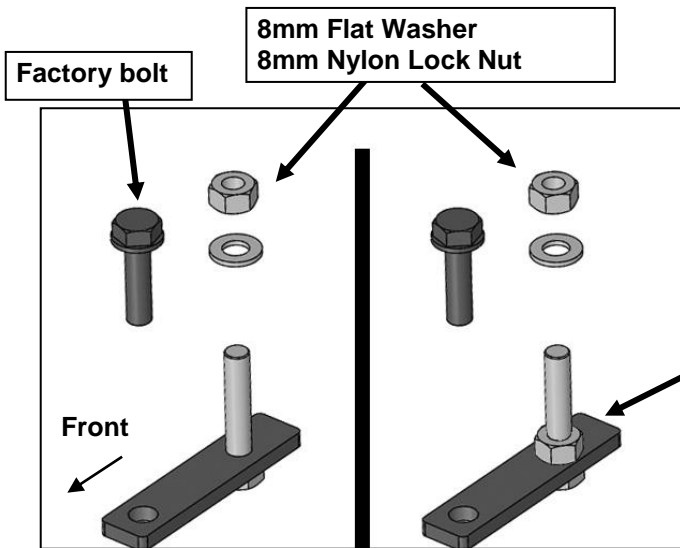


(Fig 14) Remove the bolts attaching the cooler to the top of the crossmember, if equipped

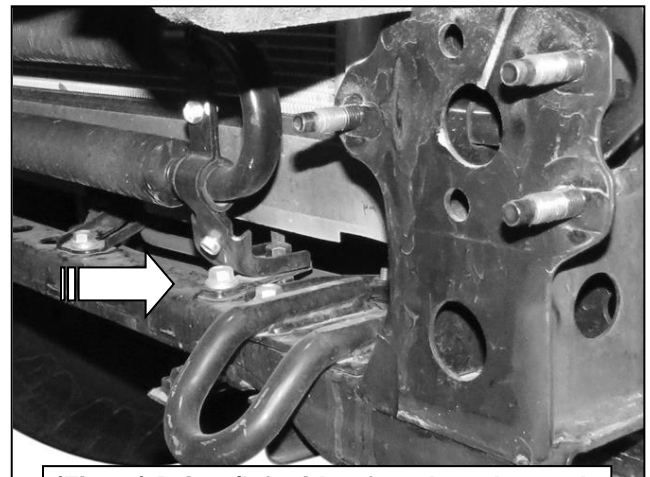
**NOTE:** Bolt Plates are used to relocate the cooler, if equipped, towards the rear of the vehicle to increase clearance for the winch mounting plate on the back of the Bumper.



(Fig 15) Remove the bolts attaching the cooler to the top of the crossmember, if equipped



(Fig 16) Insert the factory bolt through the hole in the Bolt Plate to attach Bolt Plate to the cross member. Slide the cooler over the bolt on the Bolt Plate and secure with provided hardware

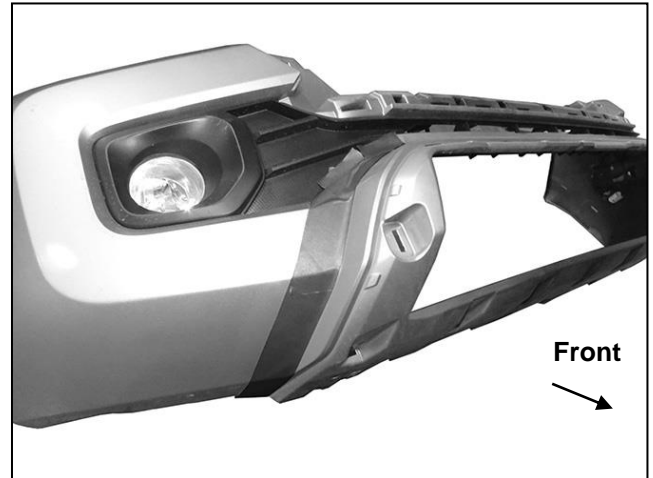


(Fig 17) Driver/left side of cooler relocated towards the rear of the vehicle (arrow)

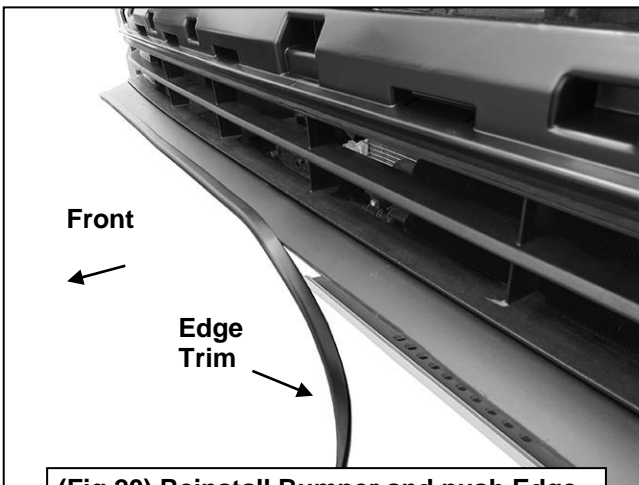
Driver/left side Installation Pictured



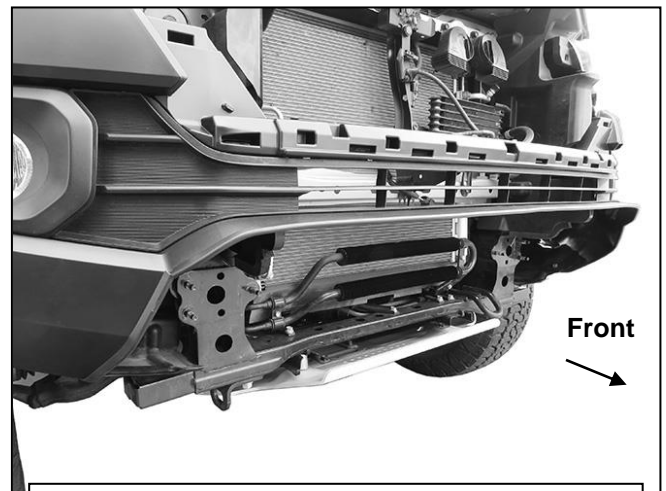
(Fig 18) Remove center pad from bumper cover



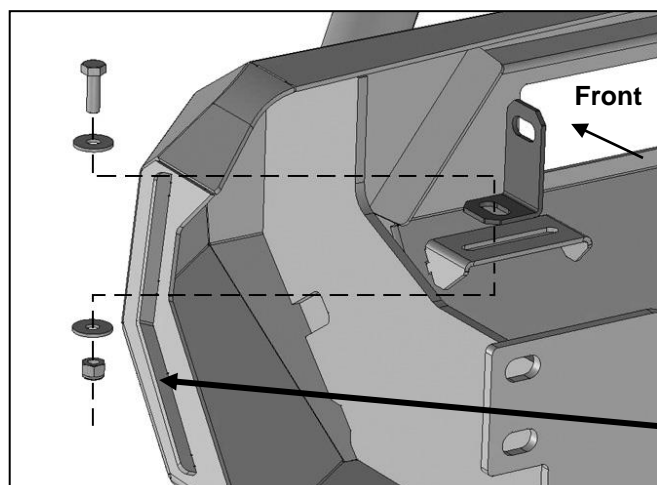
(Fig 19) Bumper prepped for cutting



(Fig 20) Reinstall Bumper and push Edge Trim over cut edge. Cut Trim to fit



(Fig 21) Bumper cut and Edge Trim applied. Hold Bumper up and in place to check fit and trim as necessary before installing Edge Trim

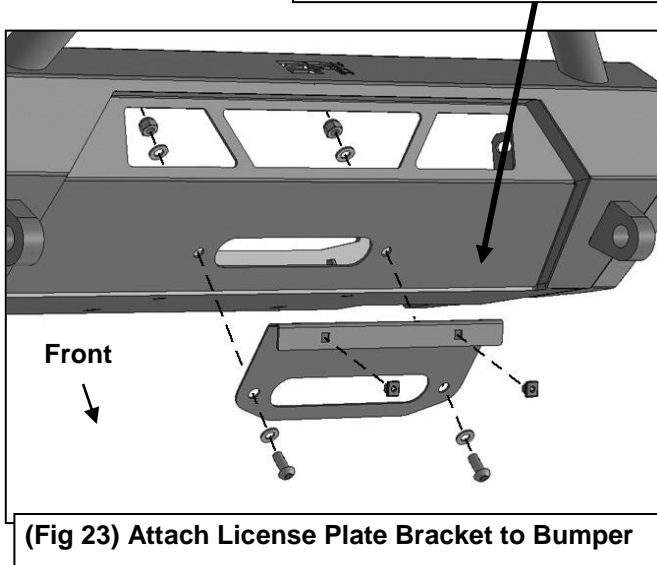


(Fig 22) Attach "L" Light Bracket to tab on back of Bumper (installation optional-light not included)

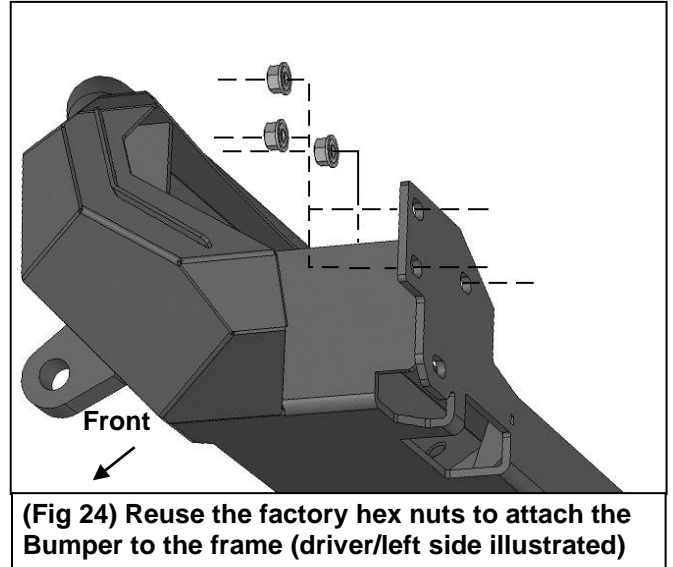
8mm x 25mm Hex Bolt  
(2) 8mm Flat Washers  
8mm Nylon Lock Nuts

Driver/left side Installation Pictured

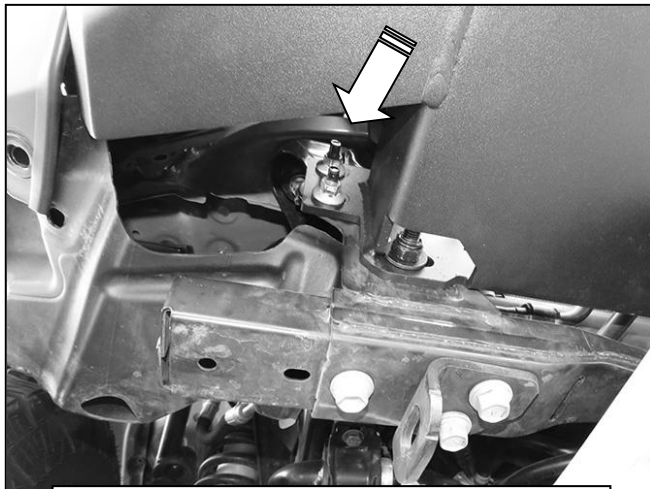
- (2) 10mm Button Head Bolts
- (4) 10mm Flat Washers
- (2) 10mm Nylon Lock Nuts
- (2) Plastic Plugs



(Fig 23) Attach License Plate Bracket to Bumper

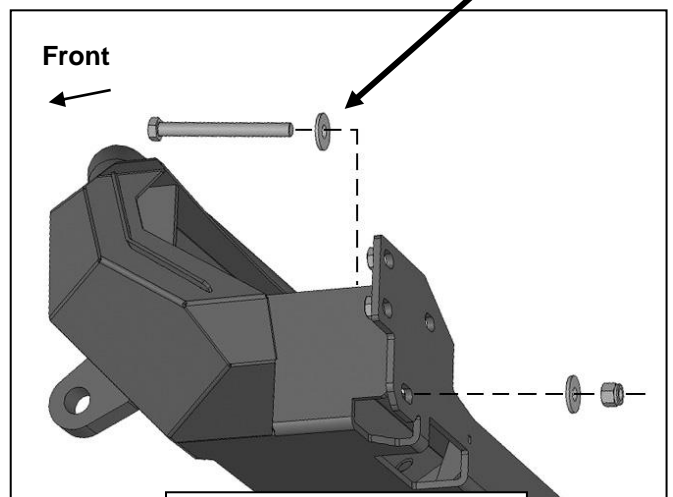


(Fig 24) Reuse the factory hex nuts to attach the Bumper to the frame (driver/left side illustrated)



(Fig 25) Reuse the (3) factory hex nuts to attach the Bumper to the end of the frame (passenger/right pictured)

- 12mm x 120mm Long Hex Bolt
- (2) 12mm Flat Washers
- 12mm Nylon Lock Nut

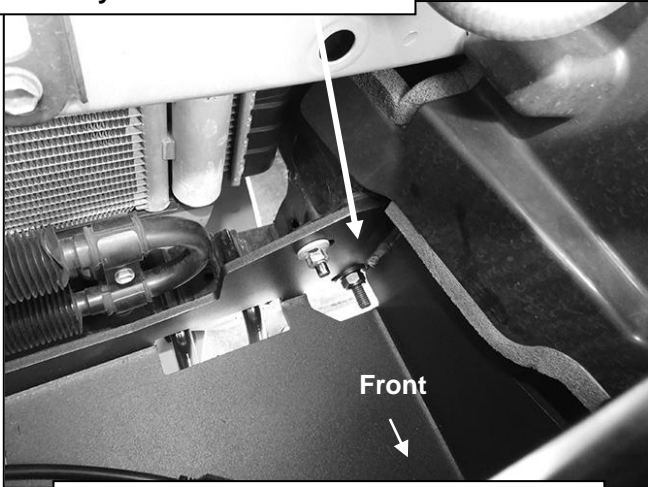


(Fig 26) Attach corner of winch tray to end of frame



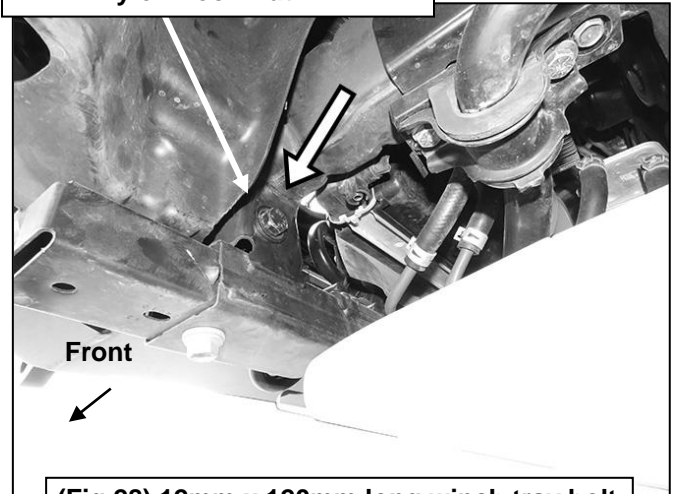
Driver/left side Installation Pictured

12mm x 120mm Long Hex Bolt  
(2) 12mm Flat Washers  
12mm Nylon Lock Nut



(Fig 27) Attach winch tray to end of frame (Driver/left side pictured from above)

12mm x 120mm Long Hex Bolt  
(2) 12mm Flat Washers  
12mm Nylon Lock Nut



(Fig 28) 12mm x 120mm long winch tray bolt (arrow) pictured from below and behind crossmember (Driver/left side pictured)



(Fig 29) Check fit of Bumper to plastic and trim as necessary. Reinstall grille and top cover

