

TIME FOR INSTALLATION

1-2 HOURS



ADVANCED



ADVANCED SKILLS
REQUIRED

05-15 Toyota Tacoma Arapaho Front Bumper Installation Guide

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(970) 797-3089

Part Number	Description	Qty:
	05-15 Tacoma Arapaho Front Bumper	
HK-00095	Kit: 16+ Tacoma Front Bumper Hardware	1
HW-00131	1/2 - 13 x 4 1/2" Zinc Hex Head Screw	2
HW-00022	1/2" USS Flat Washer	4
HW-00133	1/2" - 13 Nylock Nut	2
HW-00061	5/16-18 x 1" Carriage Bolt GR-5	3
HW-00037	5/16" USS Flat Washer Zinc	3
HW-00062	5/16" - 18 Nylock Nut	3
HW-00134	Tacoma Power Steering Cooler Relocation Tab	3



Caution: Use hand tools, impact wrenches may cause damage if over torqued.

Read the entire notes and instructions before installation.

DISCLAIMER:

The products sold by RCI Metalworks are intended for off-road use only, should not be modified, and are for use only on the vehicle(s) specifically stated. RCI Metalworks makes no warranties express or implied, including of fitness for a particular purpose or merchantability. RCI Metalworks will not be liable for any damages arising out of the use or misuse of its products. It is the customers' responsibility to ensure the products are safely and properly attached to the vehicle, and all products should be installed by trained professionals. We strive to maintain extremely high-quality standards; however, all RCI Metalworks products are individually handcrafted, may vary slightly, and may contain minor imperfections. Due to the nature of raw aluminum, the material may have minor scratches and other blemishes caused by the manufacturing process, especially on the back side of the product. RCI Metalworks is constantly seeking to improve its products and reserves the right to make changes to any product.

Installation of an RCI bumper requires removal of factory-installed components such as crash bars and foam impact absorbers. These components are designed for vehicle safety and impact absorption, and their removal may negatively impact occupant protection in a crash. RCI is not responsible for the removal of these components, and the owner/installer assumes all risks associated with their removal and any resulting consequences. It is the owner/installer's sole responsibility to understand the implications of removing these components before proceeding with installation. The installation of this RCI bumper, improper installation of this RCI bumper, and use or misuse of this RCI bumper with other components or failure to use it in conjunction with other components, could result in or cause serious personal injury, property damage or death.

RCI bumpers are not crash-tested and are intended for off-road use only. Vehicle owners are responsible for testing and recalibrating any affected sensors after bumper installation. While RCI may conduct preliminary sensor functionality checks during product development, this does not constitute testing to Original Equipment Manufacturer (OEM) specifications. RCI is not responsible and does not accept liability, for breakage or failure of parts as a result of rugged off-road use or reckless and/or improper installation. Modifications to your vehicle are done at your own risk and RCI does not accept liability or responsibility arising from damage caused by installing parts or doing modifications.

RCI performs off-road testing on its bumpers, including winch pulls, static and dynamic recovery pulls, and general off-road use. However, RCI is not liable for any damages arising from the use or misuse of its products. Customers are responsible for ensuring products are safely and properly attached to their vehicle, and professional installation is strongly recommended. After installing any off-road product, customers should test and recalibrate all safety sensors to ensure proper functionality. Do not rely on any safety sensor functionality until this verification is complete.

RCI Offroad bumpers with receiver hitches are not load rated. Using a receiver hitch for towing or other heavy-duty tasks is not recommended unless explicitly stated by the manufacturer. The bumper and receiver hitch are intended for off-road recovery use and not designed for sustained towing or load-bearing applications. Any misuse, such as towing or overloading, may result in bumper failure, vehicle damage, or personal injury. RCI is not responsible for any damages or injuries resulting from the use of the bumper with a receiver hitch beyond its intended purpose.

If an RCI product is purchased by a third party, such as a dealer, wholesaler, or installer, it is the third party's responsibility to inform the end customer of this disclaimer.

Installation Notes

Installation Notes:

RH refers to the passenger side of the vehicle.

LH refers to the driver side of the vehicle.

Always use the proper torque specifications.

If applicable to this installation, torque specifications will be listed throughout the document.

Please read all of these instructions and familiarize yourself with the complete process **BEFORE** you begin.

General Safety:

Park your car in a safe, well lit, level area.

Shut the engine off and remove the key from the ignition switch.

Make sure any remote start devices are properly disabled.

ALWAYS wear safety glasses.

Make sure the parking brake is applied until the vehicle is safely lifted and supported.

Whether lifting a vehicle using an automotive lift or a hydraulic jack, utilize the factory specified lift points.

Lifting a vehicle in an incorrect location can cause damage to the suspension/running gear.

ALWAYS support the vehicle with properly rated jack stands.

ALWAYS read and follow all safety information and warnings for the equipment you are using.

Required Tools:

1/4", 3/8" & 1/2" Socket Sets & Ratchets

Combination Wrench Set

Floor Jack

Jack Stands

Plier Set

Panel Clip Removal Tool

Screwdriver set

Torque Wrenches

Trim Removal Tool

Section 1: Remove the Stock Front Bumper

Step #1	Required tools
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Remove all of the components and hardware from their packaging, then verify that all of the required components and hardware are present.

For 05-11 Tacoma's skip ahead to step #4:



Step #2	10mm Socket & Ratchet
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For 12-15 Tacoma's only: Open the hood, then remove the plastic clips (arrows) and screws (circled in **RED**) that secure the front grille to the upper radiator core support.



Section 1: Remove the Stock Front Bumper

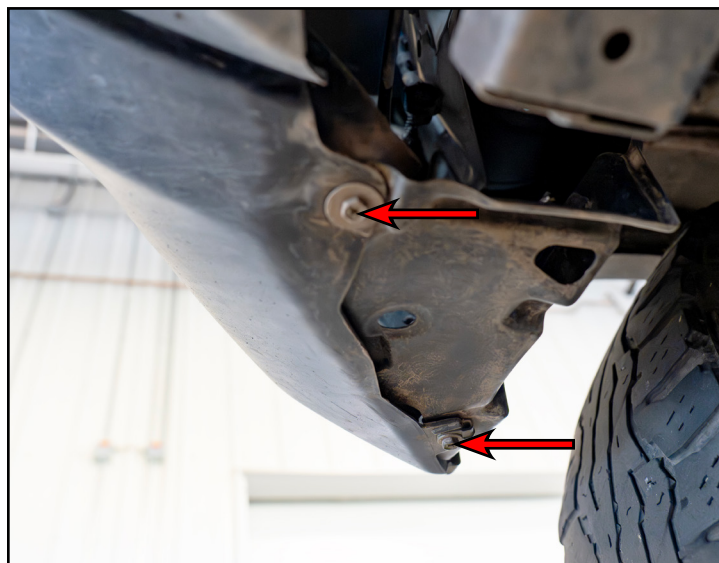
Step #3

For 12-15 Tacoma's only: Gently pull the front grille away from the vehicle starting at the lower grille at the corners, then remove the grille from the vehicle.



Step #4 10mm Socket & Ratchet

Remove the bolts that secure the lower fender liner to the front bumper on both sides.



Section 1: Remove the Stock Front Bumper

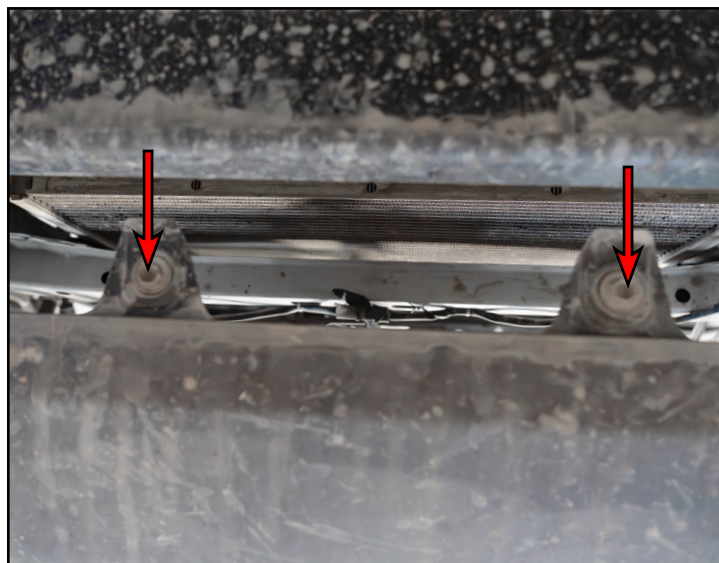
Step #5 Flathead Screwdriver

Remove the clips (**RED** circles) that secure the fender liners to the front bumper cover.



Step #6 10mm Socket & Ratchet

Remove the bolts that secure the lower bumper tabs to the core support.



Section 1: Remove the Stock Front Bumper

Step #7

If equipped: disconnect the wiring harness (highlighted in **RED**) from the both fog lights.



Step #8 Trim Removal Tool

Remove the plastic clips (arrow).

Remove the headlight trim by pulling the inside corner of the headlight trim outward to free it from the mounting tab, then rotate the trim away from the vehicle and remove the trim by pulling it inward from the headlight.



Section 1: Remove the Stock Front Bumper

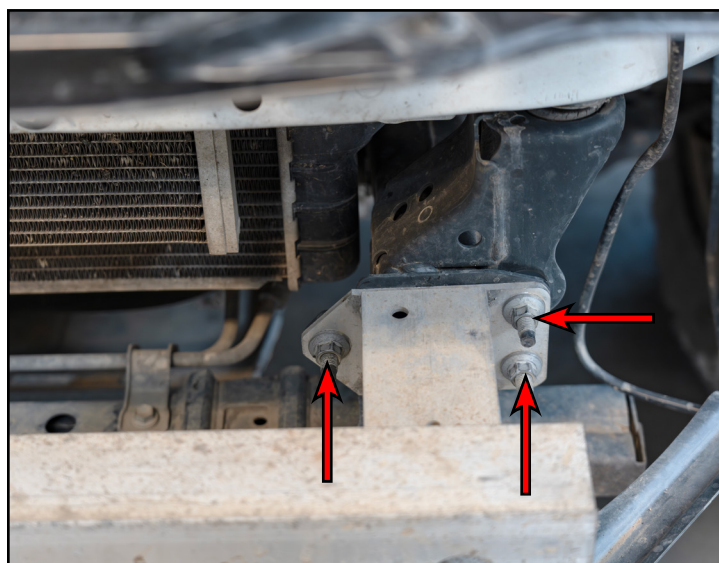
Step #9 Trim Removal Tool

Starting at the outside corners, working inward towards the center of the bumper, release the tabs that secure the bumper and remove the bumper from the vehicle.



Step #10 14mm Socket & Ratchet

Remove the nuts (arrows) that secure the bumper reinforcement brace, then remove the brace from the vehicle.



Section 1: Remove the Stock Front Bumper

Step #11 17mm Socket & Ratchet

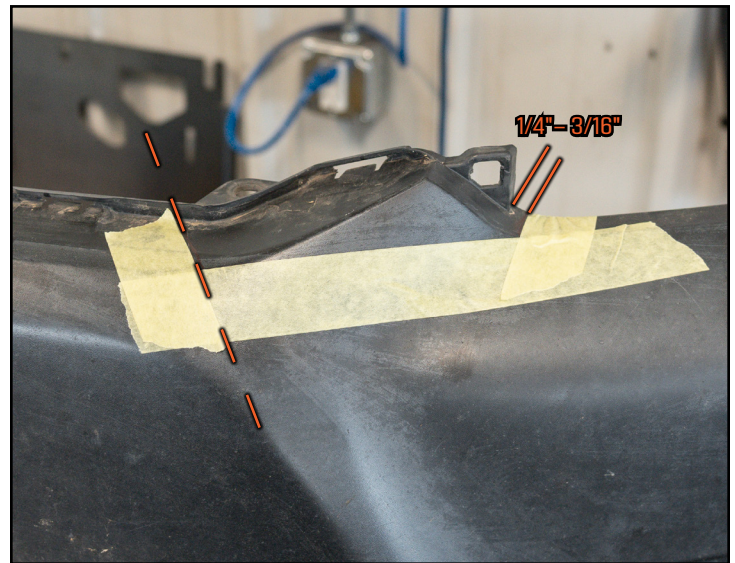
Optional: Remove the bolt (arrow) that secure the cross-member extension (highlighted in **RED**) from both sides to the front cross-member, then remove them from the vehicle.



Step #12 Angle Grinder –OR– Reciprocating Saw

Measure at the base of the headlight trim mounting location outward 1/4"– 3/16" and make a mark at this location, then make a mark that aligns with the front bumper cover line (dashed **ORANGE** line). Connect those two marks, then cut just outside of the marks to remove the front bumper cover pieces. Clean and deburr the edges of the cut pieces by sanding up to where the marks were made.

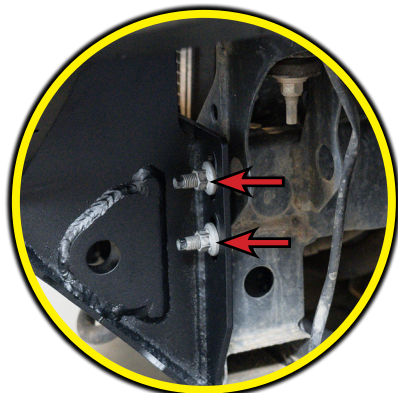
Tech tip: Verify the cut locations by loosely reinstalling the bumper cover prior to cutting.



Section 2: Installing the New RCI Front Bumper

Step #1 14mm Socket & Ratchet

Lift the new Arapaho front bumper onto the existing studs and hold the bumper in place by loosely reinstalling the OEM nuts (arrows in inset photo) for the stock bumper reinforcement brace.



Step #2 11/16 SAE Socket & Ratchet

Install the provided 1/2" hardware (arrow) into its mounting location as shown.

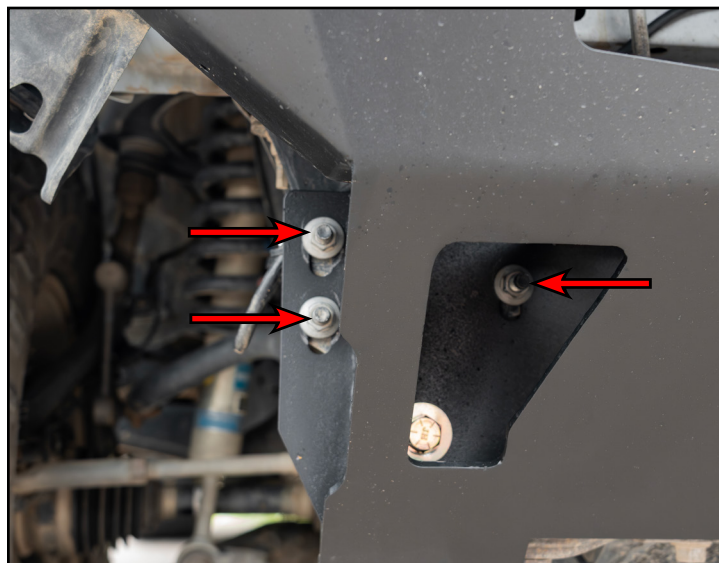
NOTE: If installing an RCI reinforcement bracket, now would be the time to install the bracket.



Section 2: Installing the New RCI Front Bumper

Step #3 14mm, 11/16 SAE Sockets & Torque Wrench

Adjust for proper fitment and ensure the gaps on both sides near the fender are even, once achieved torque the nuts (arrows) to 43 ft-lbs (58 Nm) and torque the 1/2" hardware (circled in **YELLOW**) to 70 Ft-lbs (95 NM).



Step #4

Install the modified front bumper cover piece (highlighted in **GREEN**) and secure it in place by reinstalling the OEM plastic clip (arrow). Repeat for the opposite side.



Section 2: Installing the New RCI Front Bumper

Step #5

Reinstall the headlight trim (highlighted in **GREEN**) into place.



Step #6

Ensure that the modified front bumper cover pieces (arrows) are clearanced to desired fitment, if need be, remove the modified pieces and trim to desired fitment.

For 05-11 Tacoma's skip ahead to step #9:



Section 2: Installing the New RCI Front Bumper

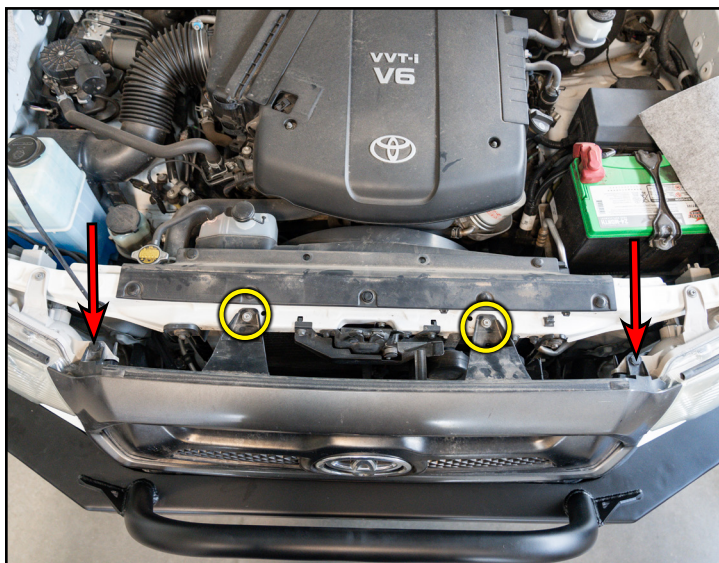
Step #7

For 12-15 Tacoma's only: Align the lower tabs mounting tabs on the front grille into the cut front bumper cover pieces and press inward to install the grille into place.



Step #8 10mm Socket & Ratchet

For 12-15 Tacoma's only: Secure the front grille into place by reinstalling the plastic clips (arrows), then reinstalling the screws (circled in **YELLOW**) that secure the upper mounting tabs to the upper radiator core support.



Section 2: Installing the New RCI Front Bumper

Step #9

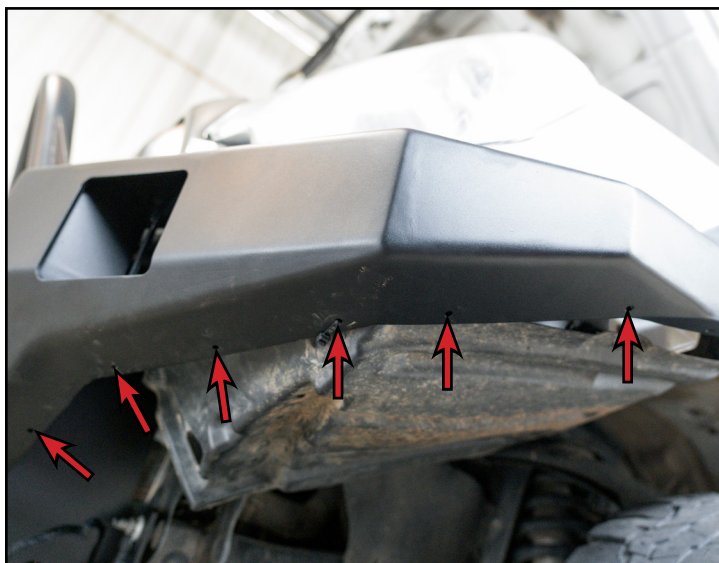
If equipped: secure the fog light wiring harness (highlighted in **GREEN**) out of the way.



Step #10

There are provisions (arrows) in the RCI Arapaho front bumper to attach the excess OE fender liner to keep it out of the way and still in tact.

Optional: the excess fender lines can be trimmed instead of being secured to the New RCI bumper.

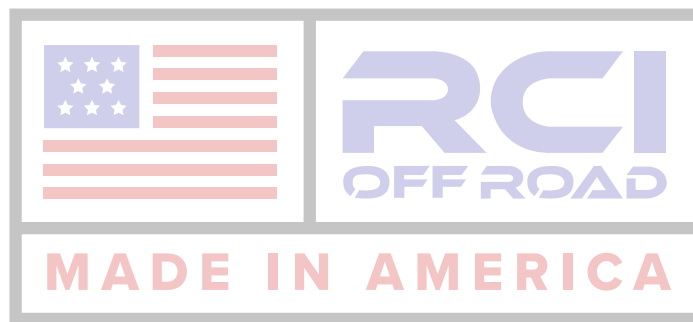


CONGRATULATIONS, YOUR INSTALLATION IS COMPLETE!

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