

TIME FOR INSTALLATION

3-4 HOURS



MODERATE

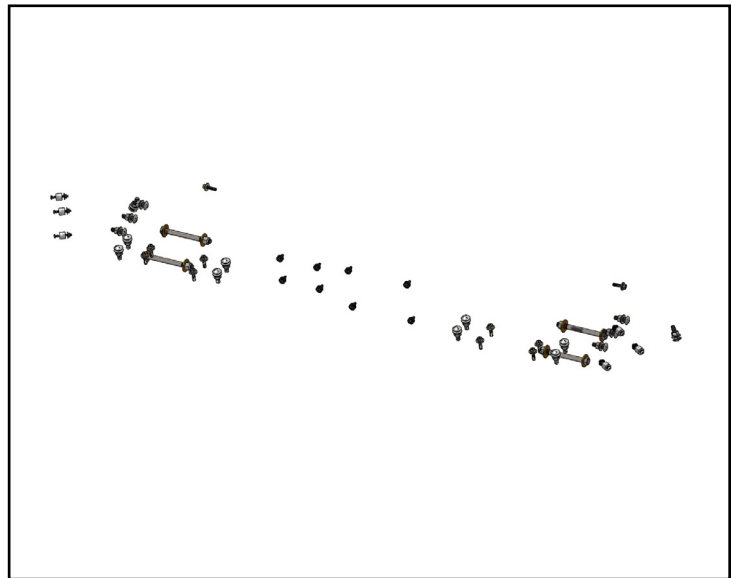
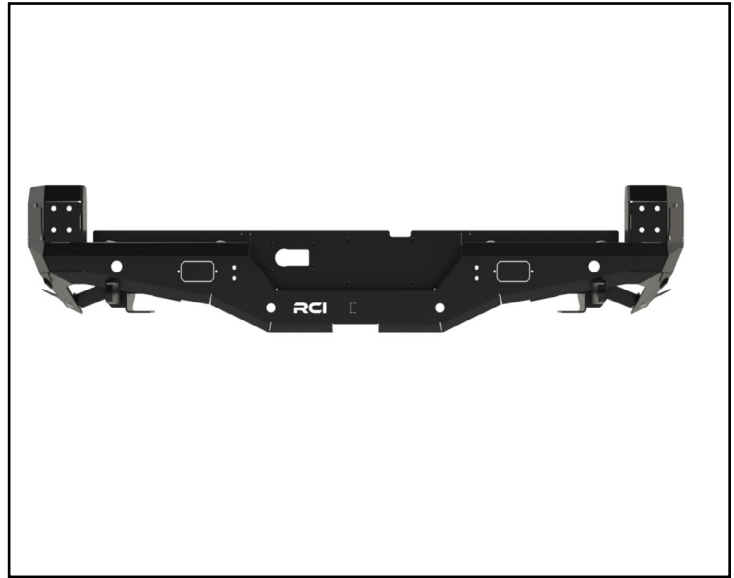


SOME EXPERIENCE RECOMMENDED

# 24+ Toyota Tacoma Rear Bumper Installation Guide

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(970) 797-3089

Part number	Description	Qty:
SM-01152	24+ Tacoma Rear Bumper	1
3P-00311	24+ Tacoma Rear Bumper BSM Cover	2
SM-01164	24+ Tacoma Rear Top Mount Driver	1
SM-01165	24+ Tacoma Rear Top Mount Passenger	1
SM-01166	24+ Tacoma Rear Frame Bracket Driver	1
SM-01167	24+ Tacoma Rear Frame Bracket Passenger	1
SM-01157	24+ Tacoma Rear Support Bracket Driver	1
SM-01158	24+ Tacoma Rear Support Bracket Passenger	1
SM-01149	24+ Tacoma Rear Trailer Plug Mount	1
HK-00160	KIT: 24+ Tacoma Rear Bumper Hardware	1
HW-00205	1/2-13 x 5.5 Hex Screw	4
HW-00022	1/2 USS Flat Washer Thru Hard	8
HW-00017	1/4-20 x 7/8 Button Soc Cap Screw	8
HW-00019	1/4 USS Flat Washer Black Zinc	22
HW-00031	1/4-20 Keps Nut 18-8 S.S. Black Zinc	14
HW-00133	1/2-13 Nylock Nut	4
HW-00188	7/16-14 x 1/5 Carriage Bolt GR-5	16
HW-00044	7/16 USS Flat Washer Zinc	16
HW-00045	7/16 Split Lock Washer Zinc	16
HW-00047	7/16-14 FIN Hex Nut GR-5 Zinc	16
HW-00206	1/4-20 x 1.75 Button Soc Cap Screw	6
HW-00025	M8-1.25 x 30mm Hex Flange Bolt	10
HW-00037	5/16 USS Flat Washer Zinc	10
HW-00207	LDPE Unthreaded Spacer	6



**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

Floor Jack

Jack Stands

Combination Wrench Set

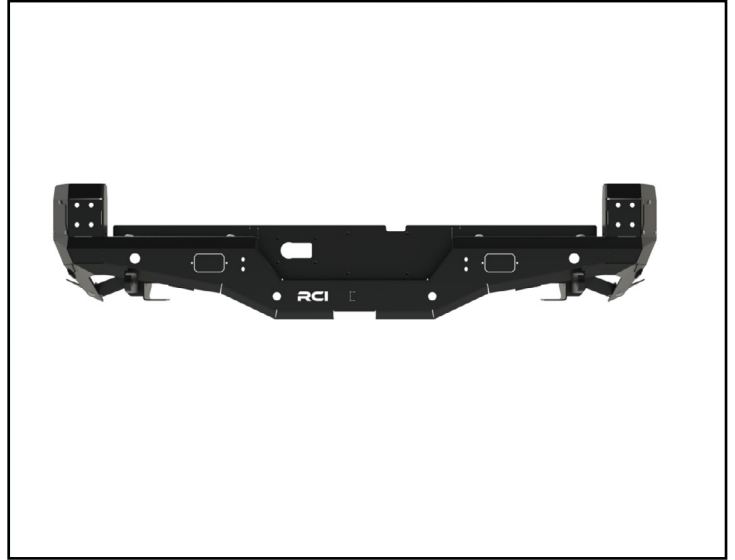
Plier Set

Torque Wrenches

# Section 1: Removing the Stock Bumper

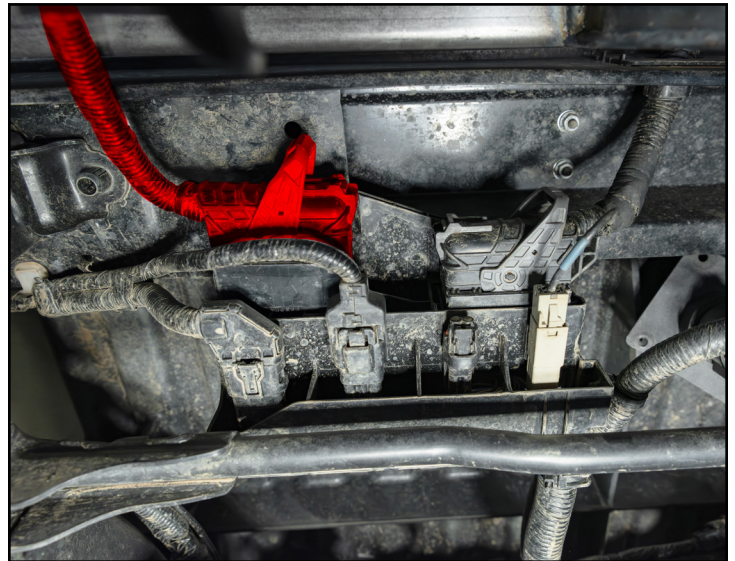
Step #1	Required tools
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Unpack and remove all components and hardware from their packaging and verify that all the components are present.



Step #2	
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Disconnect the connector for the wiring harness (highlighted in **RED**) that attaches the rear bumper parking sensors and blind spot monitors.



## Section 1: Removing the Stock Bumper

### Step #3 Trim Removal Tool

Remove the plastic cap (arrow) protecting the OEM rear bumper mounting locations.



### Step #4 12mm Socket & Ratchet

Remove the bolts (circled in RED) that secure the rear bumper to the vehicle, then remove the bolts (not shown) that secure the rear bumper brackets (arrow in inset photo) to the vehicle.

Remove the nuts (not shown) from on top of the center section of the rear bumper.

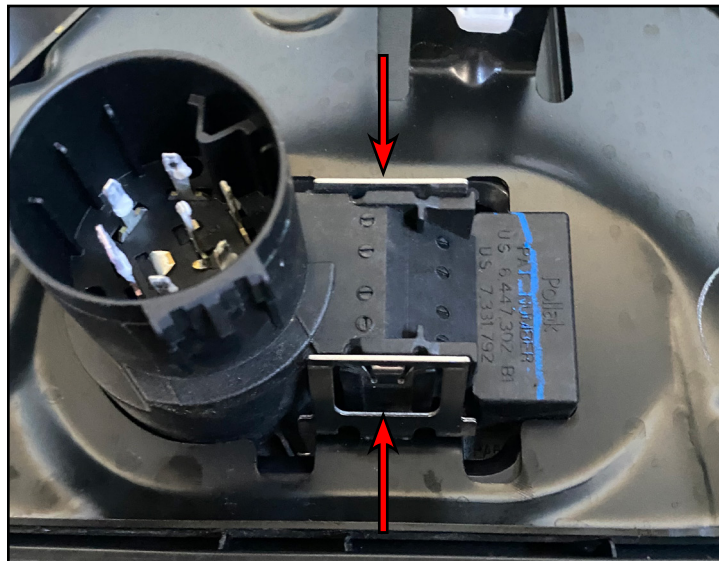
Remove the factory bumper from the vehicle and set it aside.



## Section 1: Removing the Stock Bumper

### Step #5

Press the tabs (arrows) inward, then press the connector downward to release the connector from the OEM rear bumper.



### Step #6 Panel Clip Removal Tool

Release the panel clips to remove the bumper covers to access the blind spot monitors.



## Section 1: Removing the Stock Bumper

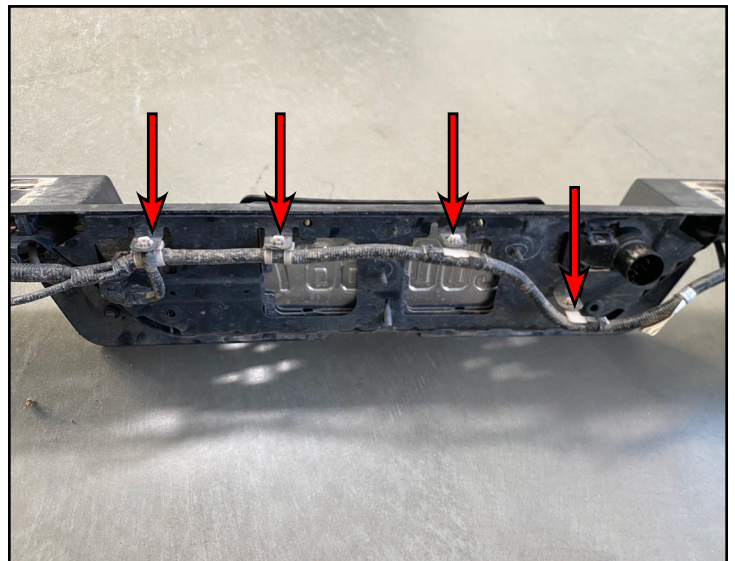
### Step #7 10mm Socket & Ratchet

Remove the nuts that secure the blind spot monitors to the OEM rear bumper, then remove the blind spot monitor from its factory location. Repeat for the opposite monitor.



### Step #8

Release the clips that secure the wiring harness to the rear bumper.



## Section 1: Removing the Stock Bumper

### Step #9 | Non-Marring Trim Removal Tool

Use a non-marring tool to free all of the rear parking sensors (arrow) from the OEM rear bumper.

Remove the wiring harness from the rear bumper.

**Tech tip:** The sensors are secured to the bumper with double sided adhesive, patience will be key when removing the sensors to ensure that they remain intact.



### Step #10 | Razor Blade

If the double sided adhesive was damaged during the removal process, remove the adhesive from the sensors.

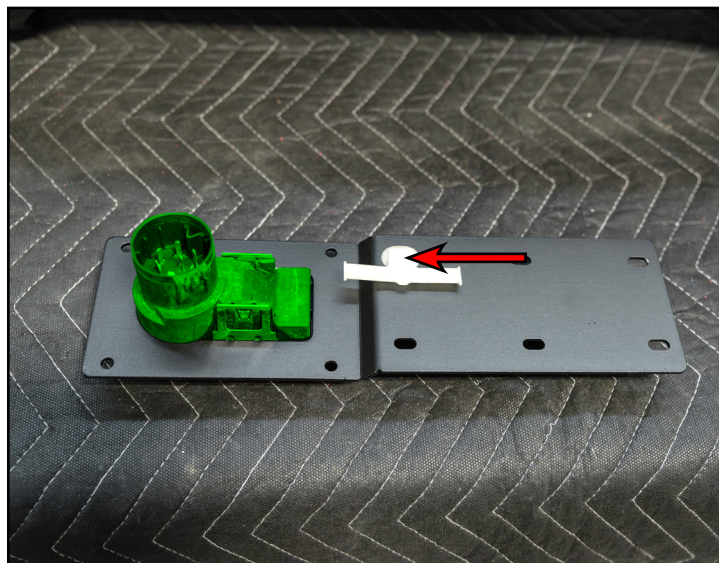


## Section 2: Installing the New Rear Bumper

### Step #1

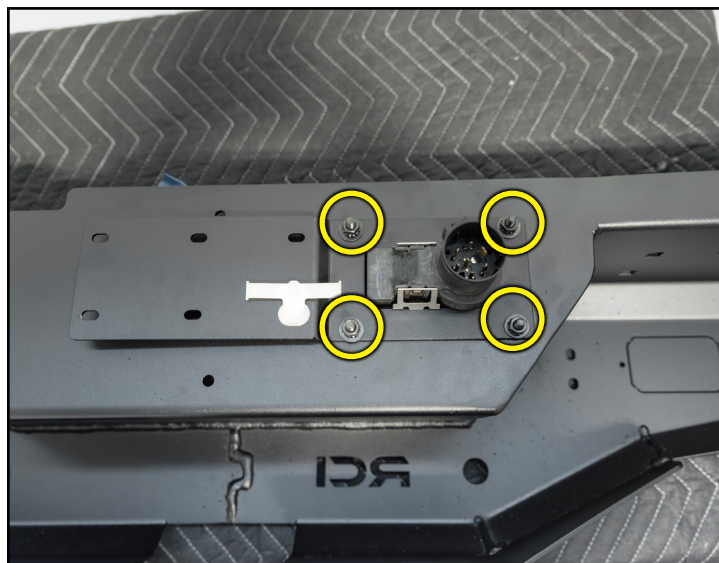
Transfer the 7-pin trailer wiring connector (highlighted in **GREEN**) to the provided mounting plate in the orientation as shown.

Transfer the wiring harness clip (arrow) to the mounting plate as shown.



### Step #2 4mm Hex (Allen) & 7/16 Wrench

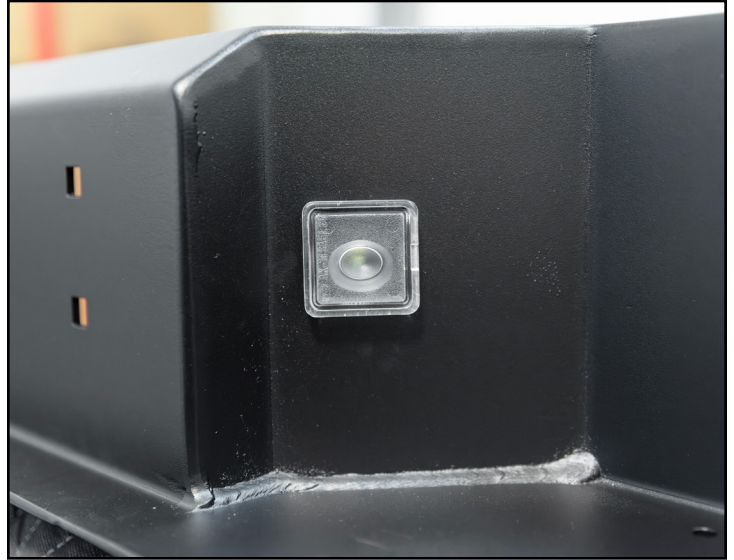
Install the assembled mounting plate onto the new rear bumper, then secure it in place with the provided 1/4" hardware (circled in **YELLOW**) and tighten the hardware until snug.



## Section 2: Installing the New Rear Bumper

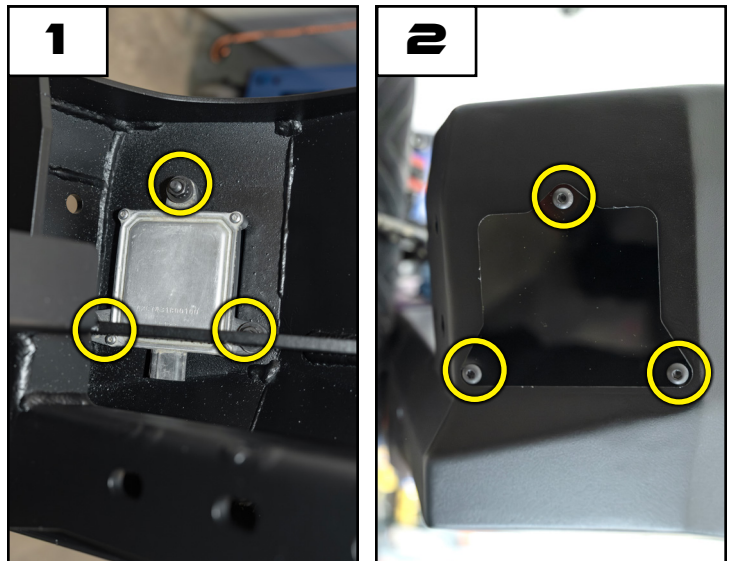
### Step #3

Transfer the license plate light (arrow) to the new rear bumper.



### Step #4 4mm Hex (Allen) & 7/16" Wrench

Install the blind spot monitor sensor into place (**photo #1**) with the provided blind spot monitor cover (**photo #2**) and secure them in place with the provided 1/4" hardware (circled in **YELLOW**).



## Section 2: Installing the New Rear Bumper

### Step #5

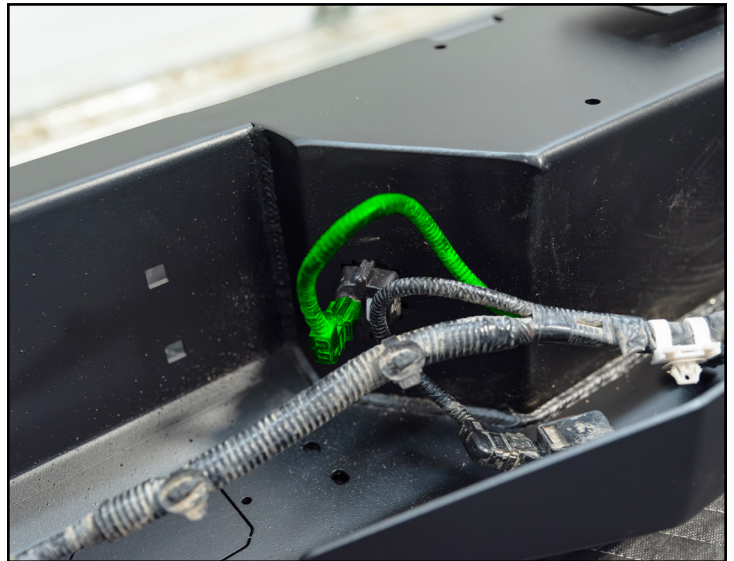
Install the wiring harness into place and secure the sensors into their perspective mounting locations.

**Tech tip:** It is recommended to replace any damaged or ineffective double sided adhesive with new double sided adhesive before installing the sensors into the new bumper.



### Step #6

Connect the wiring harness (highlighted in **GREEN**) to the license plate light connector.



## Section 2: Installing the New Rear Bumper

### Step #7 | 4mm Hex (Allen) & 7/16" Wrench

Install the vehicle's license plate to the new bumper using the provided 1/4" hardware (circled in **YELLOW**), then tighten the hardware until snug.

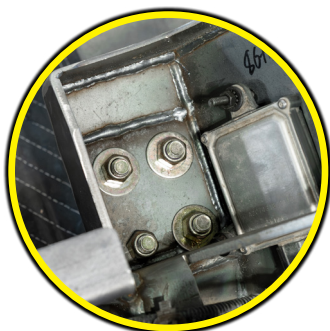
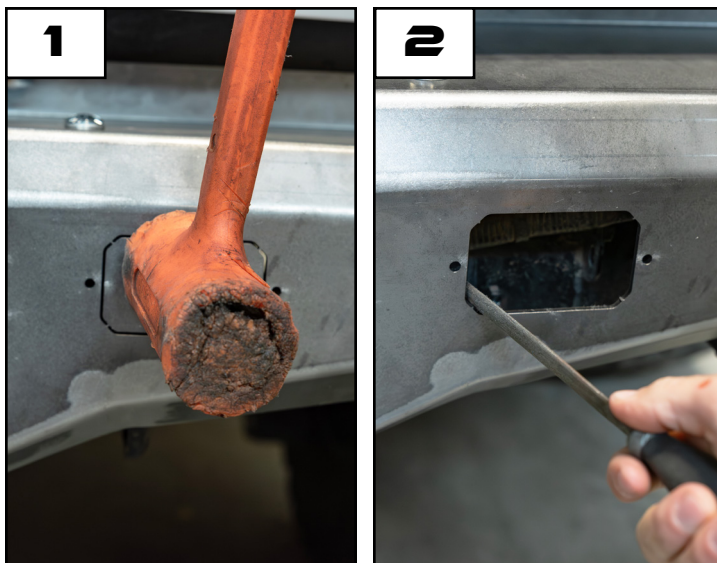


### Step #8 | Soft Faced Hammer & File

There are two locations in the RCI rear bumper that will allow lights to be mounted in these locations. Using a soft faced hammer, punch out the tabs (as shown in **photo #1**), then use a file (as shown in **photo #2**) to clean the edges from debris and burrs.

Once cleaned, apply paint or self etching primer to the exposed metal to prevent rust.

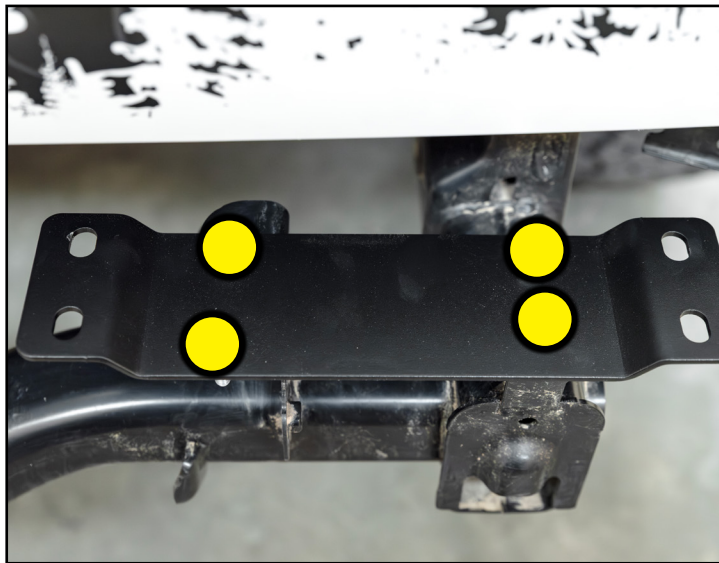
**OPTIONAL:** If purchased with a universal swing out kit, install the swing out mount to the bumper location (inset photo) prior to installing the bumper into place.



## Section 2: Installing the New Rear Bumper

### Step #9 | 13mm Socket & Torque Wrench

Install the provided rear bumper mounting plates utilizing the OEM mounting locations for the rear bumper, then secure the mounting plates in place with the provided M8 hardware (**YELLOW** circles) and torque them to 18 ft-lbs (25 Nm).



### Step #10 | 11/16" Socket & Ratchet

Install the new bumper onto the previously installed mounting plates, then align the holes on the bumper with the holes in the mounting plates.

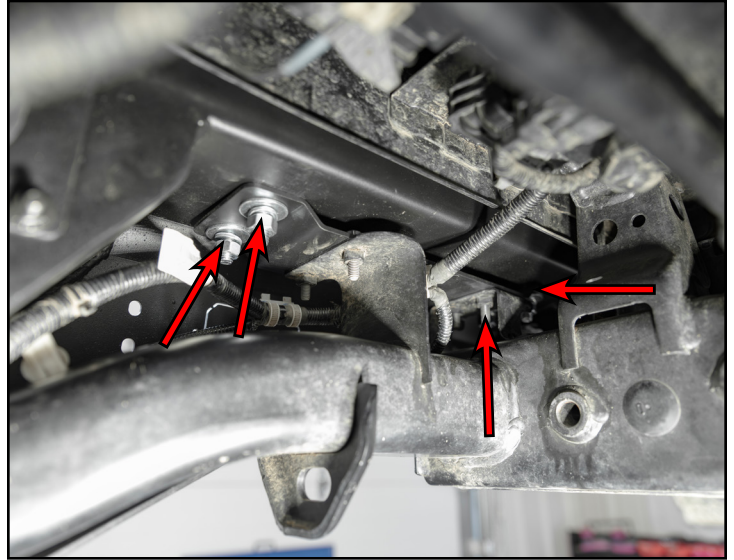
Once aligned, install the provided 7/16" carriage bolts (arrows) into place.



## Section 2: Installing the New Rear Bumper

### Step #11 | 11/16" Socket & Ratchet

From underneath secure the bumper to the mounting plates by installing the provided 7/16" flat washer, split-lock washer, and hex nut (arrows) onto the previously installed carriage bolt, then tighten until hand tight.



### Step #12

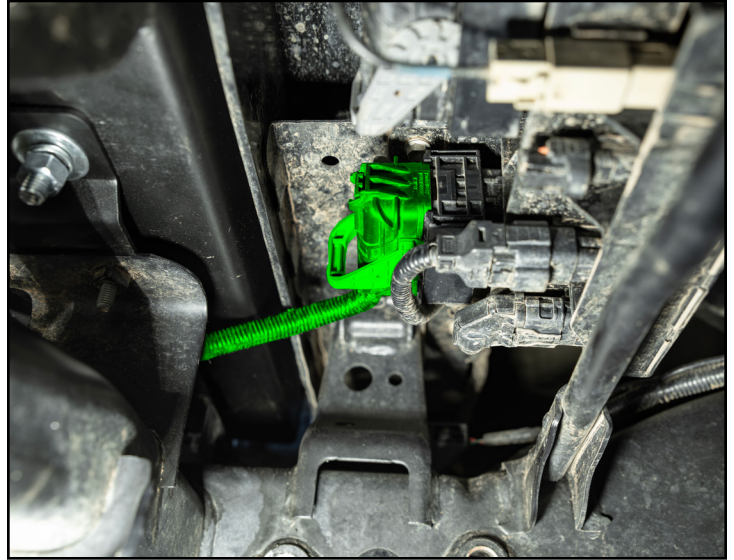
Connect the trailer plug wiring harness (highlighted in **GREEN**) connector to the trailer plug as shown.



## Section 2: Installing the New Rear Bumper

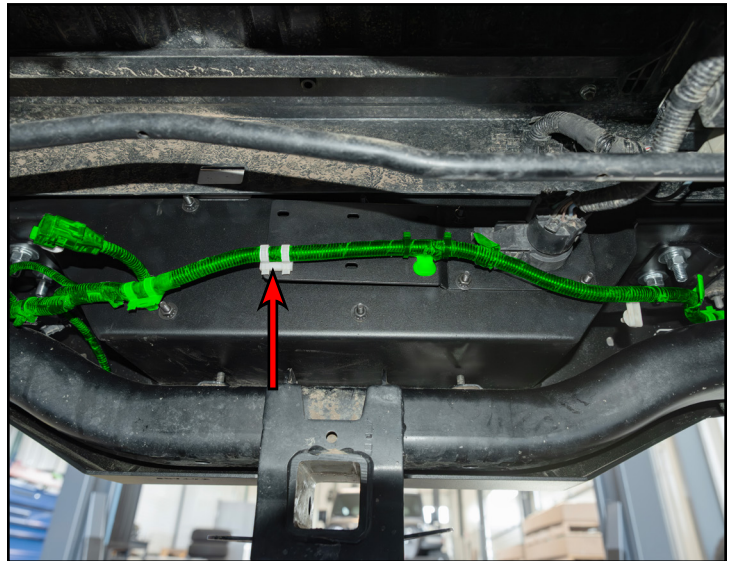
### Step #13

Reconnect the rear wiring harness (highlighted in **GREEN**) to the main connector for the rear harness as shown.



### Step #14

Route the wiring harness (highlighted in **GREEN**) away from any pinch points and secure the clip (arrow) into the provided mounting location in the trailer plug mounting plate.



## Section 2: Installing the New Rear Bumper

### Step #15 | 11/16" Wrench, 15mm Socket & Ratchet

Install the rear support bracket into place and secure one side to the frame with the provided M10 hardware (circled in **YELLOW**). Secure the opposite end of the bracket to the new bumper with the provided 7/16" carriage bolt, flat washer, split-lock washer and hex nut (arrow). Tighten the hardware until hand tight.



### Step #16 | 11/16" Socket & Ratchet

Install the rear frame bracket into place, then secure it in place to the new rear bumper by installing the 7/16" carriage bolts through the bracket and the mounting location. Install the flat washer, split-lock washer and hex nut (circled in **YELLOW**) in onto the carriage bolts and tighten them until hand tight.

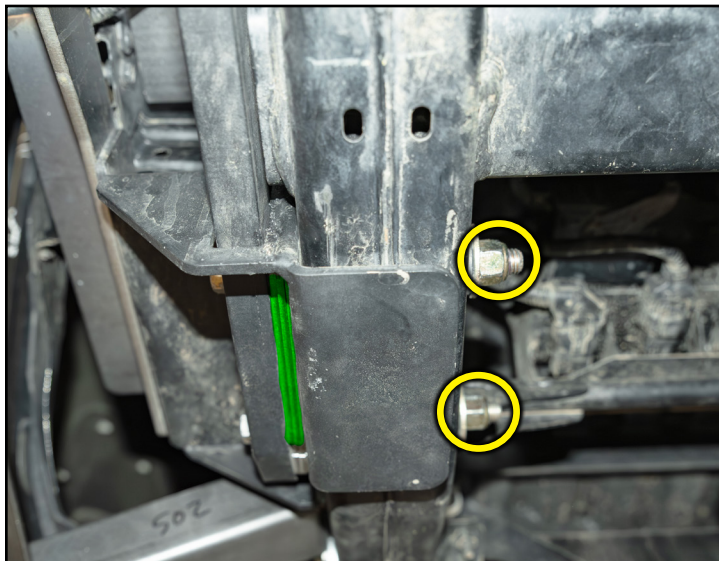


## Section 2: Installing the New Rear Bumper

### Step #17 | 3/4" Wrench, 3/4" Socket & Ratchet

Install the recovery point plate (arrow) through the previously installed rear frame bracket, then slide the provided spacers (highlighted in green) three per side in between the inside of the bracket and the recovery point plate.

Secure the recovery point plate and spacers using the provided 1/2" bolts, flat washers and nylock nuts (circled in **YELLOW**).



### Step #18 | 11/16, 15mm Sockets & Ratchet

With the hardware being hand tight, make fitment adjustments until the desired fitment has been achieved.

After desired fitment has been achieved fully tighten all of the installed hardware.

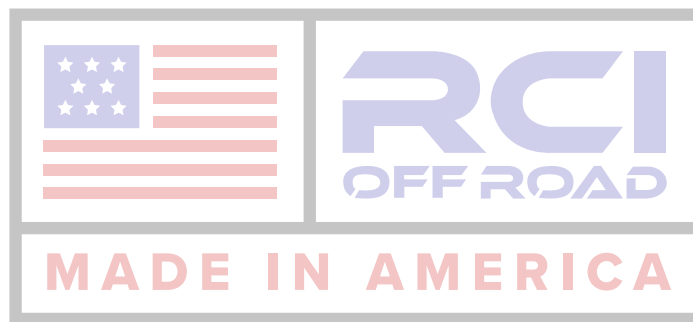


**CONGRATULATIONS, YOUR INSTALLATION IS COMPLETE!**

**ENJOY YOUR NEW RCI PROTECTION!**



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We love seeing our products in the wild!**



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**These instructions are provided as a courtesy by RCI Offroad**

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