

Toyota Tacoma Front Bumpers for 98-00 Trucks

Important notices:

These instructions are intended only as a general guide for installing All-Pro products. For some items, specialized mechanical skills, metal fabrication and/or welding skills may be needed for proper installation. If you have any doubts or questions about installing these or other parts please call us at the shop 406-961-0126 or contact a competent mechanic, fabricator, welder or other appropriate professional.

Aftermarket accessories are intended to modify and/or prepare a vehicle for uses that exceed conditions anticipated by the vehicle manufacturer. These uses may include high performance demands and negotiation of rough terrain. These conditions have extreme variance and cannot be controlled by the vehicle manufacturer or aftermarket accessory manufacturer. Therefore, the safe control of your vehicle is entirely your responsibility. Do not purchase parts from All-Pro Off Road unless you are willing to accept this responsibility. Do not install any All-Pro part that you do not feel competent at installing without causing present or future injury to yourself or others; consult a professional installer.

All parts sold by All-Pro Off Road are for off road racing use only and are not intended for use on the street. Modification of your vehicle to enhance performance with the parts sold by All-Pro Off Road can result in dangerous situations that may result in bodily harm. The buyer hereby assumes all risks associated with any such modifications. All-Pro Off Road will not accept responsibility for personal injury or property damage arising from the failure of any parts manufactured or sold by All-Pro Off Road.

In an effort to provide both durability and safety, All Pro Off Road recommends you carefully read the entire installation procedure before beginning, then rigidly follow these instructions during installation. Also, it is extremely important that you abide by proper safety procedures including the use of jack stands, setting the parking brake, wearing eye protection, etc.

*****Please Note:** Once you modify your truck to fit All-Pro's Front Tacoma Winch Mount Bumper, your factory bumper will not longer fit.

Tools Required

- 10mm – 17mm sockets
- Ratchet for sockets
- #2 Phillips screw driver
- Fine marker
- Ruler
- Straight edge
- Square
- Small mallet/hammer

- Reciprocating saw (“sawzall”) with 6” or longer metal cutting blade
- Hand-held grinder
- Welding equipment

Install Procedure:

1. Remove factory transport tie down brackets on driver and passenger side frame rails with a 17mm socket.



2. Remove lower bumper fascia screws/clips from driver and passenger side frame rails using a #2 Phillips screw driver.



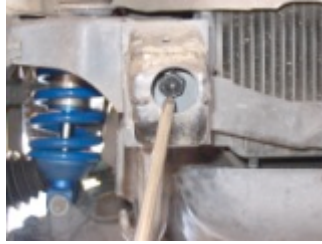
3. Remove driver and passenger side outer bumper mounts using a 14mm socket.



4. Remove driver and passenger side bumper rear mounts using a 12mm socket, working the socket through the inner fender well splash guard access hole. Have someone assist you while removing these nuts as the bumper will be "loose" from the vehicle after removal.



5. Remove driver and passenger side frame rail end caps using a 17mm socket.



6. Remove factory skid plate from truck using 10mm - 14mm sockets. There are a total of 7 fasteners.



7. Remove factory skid plate by compressing skid plate clips from frame until skid is free.



8. On the driver and passenger side frame rails, measure 3 inches in from the end of the frame rail and make a mark using a ruler and fine marker.



9. Transfer this mark into a vertical line running down both sides of each frame rail using a square and fine marker. Make sure this line is at 3 inches exactly and is perpendicular to the frame rail's top and bottom surfaces (confirm with a square).



10. OPTIONAL: Mark the side bumper mount "arrow tips" with a vertical line just in front of the welded-on nut (DO NOT MARK BEHIND THE NUT AS YOU DO NOT WANT TO CUT THIS NUT OFF. IT IS USED TO MOUNT THE BUMPER!)



11. Using a thin piece of wood, heavy cardboard, or a scrap piece of sheet metal, protect the radiator.



12. Cut the cross-member that joins that supported the factory skid plate off the truck. Protect the radiator and be careful to not cut into the radiator support, any electrical wires, hoses, or tubes. On each side, cut as close to the frame rails as possible. You will later grind off any remnants of the cross-member from the frame rail.



13. Being careful to start your cut on the mark and keeping the saw blade vertical, cut each end of the frame rails off at the 3 inch marks/lines made earlier. It is safer to cut a little bit in from your marks/lines and grind up to your marks/lines to be sure and remove exactly 3 inches of frame rail and to keep your cuts square.



14. OPTIONAL: You can cut off the "arrow tips" from the bumper side mounts at this point. REMEMBER DO NOT CUT OFF THE WELD NUTS ON THE MOUNTS. By cutting these "arrow tips" off at this point they will not protrude through the face of the installed bumper.



15. Grind the remaining portion of the cross-member off the sides of each frame rail and lightly clean up the end of each frame rail ensuring the cut face is square to the sides, top, and bottom of the frame. Protect the radiator during grinding.



16. Insert the frame end caps with the treaded inserts as shown. the frame end caps are identical and will not fit both the driver and passenger side frame rails. In order for them to fit correctly, position the longer bent side towards the outside of the rails and the shorter bent side towards the inside of the rails. The brackets are designed to fit the irregular shape of the frame rails.



17. If necessary, gently tap the brackets into the frame rails until they are flush with the ends of the frame rails and the surface of the brackets are square to the sides, top, and bottom of the frame rails.



18. Double check the alignment of the brackets, and tack weld into place with a light tack between the bracket and frame rail ends. Check that the bracket is still aligned correctly after tacking it in place.



19. Finish welding the brackets into place along the vertical joints only. Weld a little at a time and let cool so as not to over heat the frame rail or catch anything on fire - "follow good welding practices and safety." If you are unsure of your welding skills, have a certified welder make these welds for you.



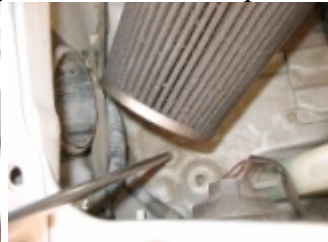
20. Grind the welds smooth and flush to the face of each bracket being careful not to overgrind them weakening the joint or bracket. Grind the ends of the side bumper mounts if you ground off the "arrow tips."



21. Prime and paint all raw metal surfaces to ensure surfaces do not rust over time.



22. While paint is drying on the frame rails, remove the original outer bumper supports. There are 3 nuts that retain a bracket on each side of the truck. Remove the nut on the outside of the truck and the 2 nuts inside the engine compartment. See photos for locations. The 2 nuts per side are under the air filter on one side and below/in-front of the battery on the other. Battery removal is not required.



23. Using a fine marker and ruler, mark the inner fender will splash guard as per the photos.



24. Carefully trim the inner fender well splash guard using heavy scissors or shears. A carefully used and sharp box cutter will cut through this material very easily, but the risk of injury is higher. Please go slow and be careful. Watch for any electrical lines, hoses, etc., that you may not realize are behind the splash guard.

25. In you plan to install a winch, do so now. If not, skip this step. Intall winch and Hawse style fairlead as per manufacturer's instructions. There are standard winch mount holes in place on the bumper's "winch beams" to mount all popular winches form Warn, Ramsey, etc, with remote solenoids.

26. Having an assistant hold the bumper up to the truck, slip the bumper over the frame rail ends and over the side outer bumper mounts. Mount the bumper by replacing the factory hardware from the side bumper mounts, removed in step 3.

27. After the bumper is loosely secured by the 4 side bumper mount bolts, insert and loosely tighten the ALL-PRO supplied bolts, lock washers, and washers through the front bumper holes and into the brackets you welded in.

28. Re-install the bolts removed from the factory transport tie down locations (step 1) through the lower holes in the bumper and into the factory weld nuts in the bottom of the factory frame rails.

29. With an assistant helping you, align the bumper so the main tube of the bumper is parallel to the truck/grill/body lines. When you are pleased with the alignment, tighten all bolts to factory specifications. Do not over tighten them, as you could strip the weld nuts welded into the frame/bracket. Removable thread lock "Locktight" (usually blue in color) is strongly recommended to keep the bolts tight without having to over tighten them.



30. Please check that all bolts are secure after driving the vehicle for about 50 miles. Check the all bolts are tight at conservative intervals after initial installation.