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Rough Country 10723 Installation Instructions

High-Clearance Bumper, 12000-lb Winch and LED Bar, Tacoma (2016-2023)

Part number: 10723

trailfortress.com/rough-country-front-bumper-10723

Scan for fitment, price and install help

ROUGH COUNTRY
SUSPENSION SYSTEMS®

2016 - 2023 Tacoma Hybrid Bumper

Thank you for choosing Rough Country for all of your suspension needs.

Rough Country recommends that a certified technician install this system. In addition to these instructions, professional knowledge of disassemble/reassembly procedures as well as post installation checks must be known. Attempts to install this system without this knowledge and expertise may jeopardize the integrity and/or operating safety of the vehicle. Please read all the instructions before beginning the installation. Check the kit hardware against the ''Kit Contents'' list below. If question exist, please call us @1-800-222-7023. We will be happy to answer any questions concerning this product. Check all fasteners for proper torque. Check to ensure for adequate clearance between all components. Check and retighten wheels at 50 miles and again at 500 miles. Periodically check all hardware for tightness. Be sure you have all the needed parts and understand where they go. Also, please review the "Tools Needed" list to be certain you have the necessary tools to complete the installation.

PRODUCT USE INFORMATION

⚠WARNING As a general rule, the taller a vehicle is the easier it will roll. We strongly recommend that seat belts and shoulder harnesses be worn at all times. Braking performance and capabilities are decreased when significantly larger/ heavier tires and wheels are used. Do not add, alter, or fabricate any factory or after-market parts which increase vehicle height over the intended height of the Rough Country product purchased. Rough Country makes no claims regarding lifting devices and excludes any and all implied claims. We will not be responsible for any product that is altered.

NOTICE TO DEALER AND VEHICLE OWNER

⚠NOTICE Any vehicle equipped with any Rough country product must have the "Warning to Driver" decal installed on the sun visor or dash. The decal is to act as a constant reminder for whoever is operating the vehicle of its unique handling characteristics. INSTALLING DEALER—It is your responsibility to install the warning decal and to forward these installation instructions on too the vehicle owner for review and to be kept in the vehicle for its service life.





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Tacoma Hybrid Bumper

TOOLS NEEDED:
Welder
Grinder
Sander
Cutting Tools
Measuring Tape
5/32” Allen Wrench

Metric Wrench/Socket
10mm
13mm
14mm
16mm
17mm
18mm
19mm

KIT CONTENTS:
Outer Skin Contents:
Center Skin (1)
Driver Side Wing (1)
Pass Side Wing (1)
Driver Top Wing (1)
Pass Top Wing (1)
Driver Bottom Wing (1)
Pass Bottom Wing (1)
Winch Chin (1)
Fairlead Spacer (1)
Fairlead Mount (1)
Stinger Bar (1)

Inner Skin Contents:
Inner Driver Frame Mount (1)
Inner Pass Frame Mount (1)
Outer Driver Frame Mount (1)
Outer Pass Frame Mount (1)
Frame Plate (2)
Winch Tray Mount (1)
D-Ring Mount (2)
Winch Tray (1)
Winch Tray Brace (1)
Winch Tray Outer Rib (2)
Winch Tray Inner Rib (4)

KIT CONTENTS:
Bolt On Wing Contents:
Driver Low Cut Wing (1)
Pass Low Cut Wing (1)
Driver High Cut Wing (1)
Pass High Cut Wing (1)
Wing Bolt Plate (4)

KIT CONTENTS:
Add On’s:
Winch Block Off Grill (1)
Light Bar Block Off Grill (1)
Skid Plate (1)
Driver Skid Plate Mount (1)
Pass Skid Plate Mount (1)

HARDWARE INCLUDED:
1/4” Thick Spacer (2)
12mm Allen Bolt (6)
12mm Bolt (6)
12mm Washer Thick (6)
12mm Flange Nut (10)
8mm Bolt (10)
8mm Flange Nut (10)
8mm Flat Washer (4)
8mm Fender Washer (10)
1/4” Allen Bolts (7)
1/4” Flat Washer (7)
1/4” Raw Nut (5)



Center w/ Low Cut Wing option shown.

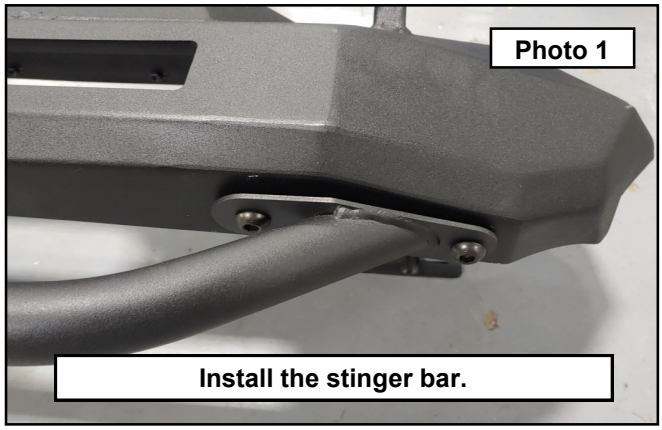


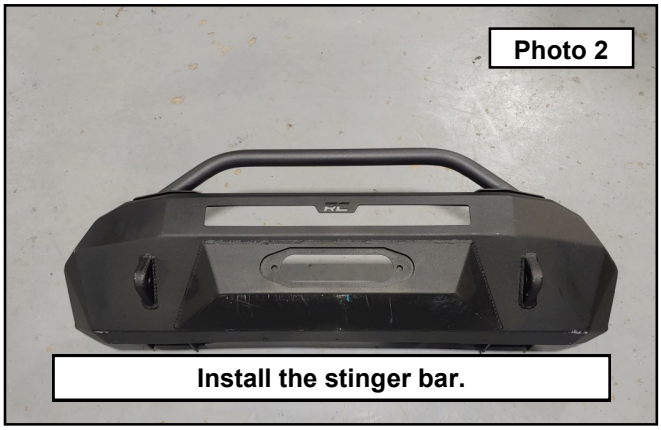
High Clearance Wing option shown.

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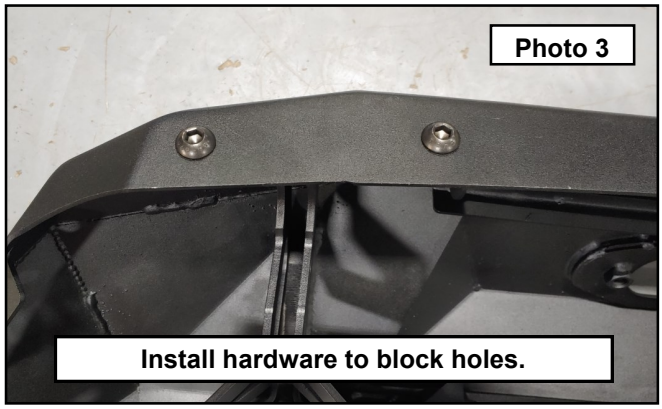
Stinger Bar Installation

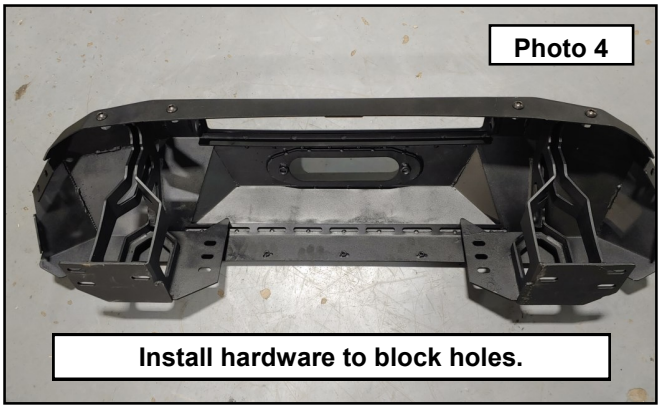
1. The stinger bar is a bolt on unit for vehicles with sensor clearance issues. If your vehicle has the sonar sensor located in the grill for adaptive cruise control, you can leave the stinger bar off. Follow the instructions for the style of bumper you have purchased on the following pages. Photo 1
2. If you are going to use the stinger bar, install using the provided 12mm button head bolts and the 12mm flange nuts. Photo 2





3. If you are not going to install the stinger bar, install the 12mm button head bolts and 12mm flange nuts into the hole locations on the bumper to block off the holes. Or you can use these holes for auxiliary lighting. Photo 3



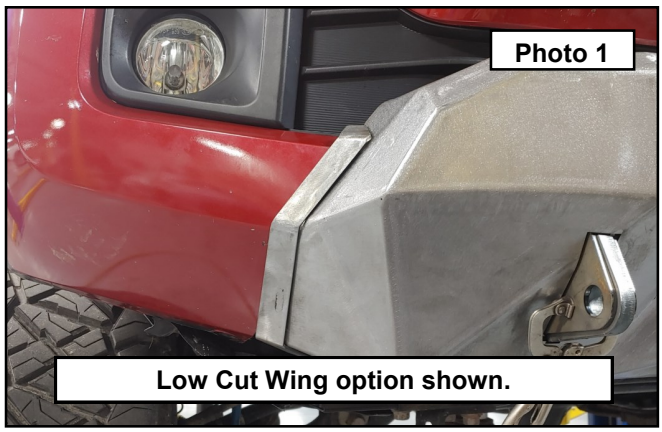




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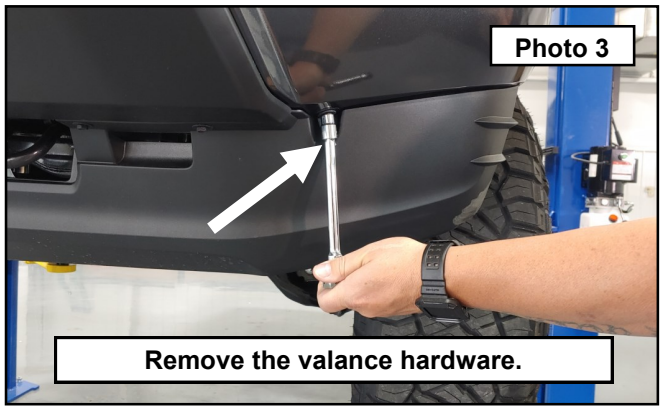
Bumper Installation

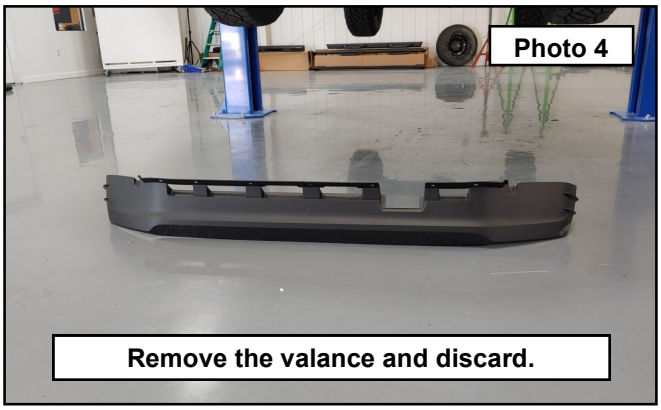
1. Park your vehicle on a clean flat surface, engage the parking brake and block the rear tires.
2. **Save all hardware removed from the vehicle unless otherwise noted.**
3. Open the hood and disconnect the negative terminal on the battery.
4. This bumper install requires you to cut your factory plastic bumper. Suggested cutting tools are an air body saw and sander. There are two styles of cuts that you can do for this bumper, both include a bolt on wing to cover the cut. One for the low cut option which leaves the factory bumper under the fog lights, or the high cut option which removes the plastic under the fog lights. **Photo 1 / 2**



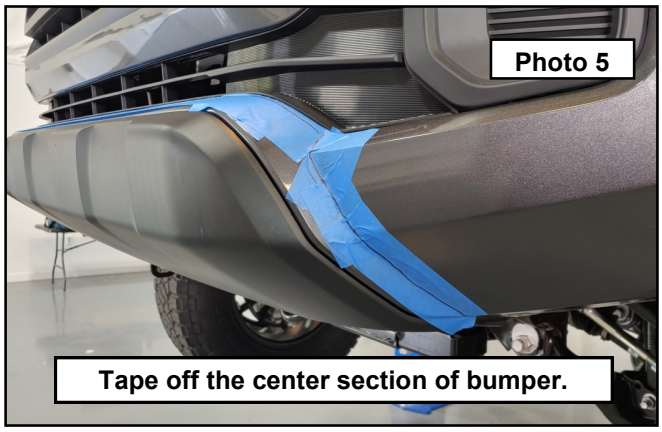


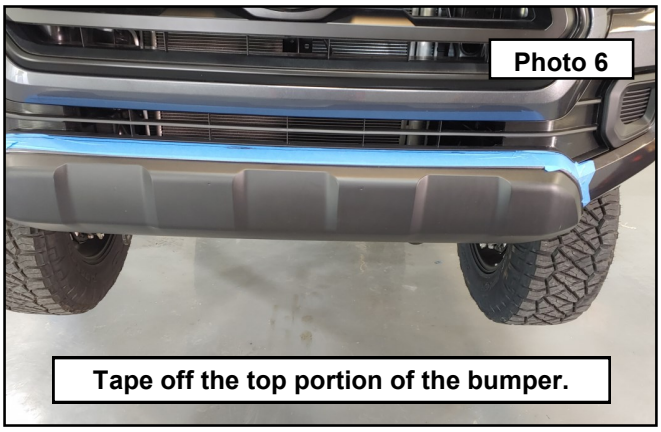
5. Under the vehicle, remove the hardware holding the valance to the bumper using a 10mm socket. There is hardware in the wheel wells that hold the valance on also. Discard valance. **Photo 3 / 4**



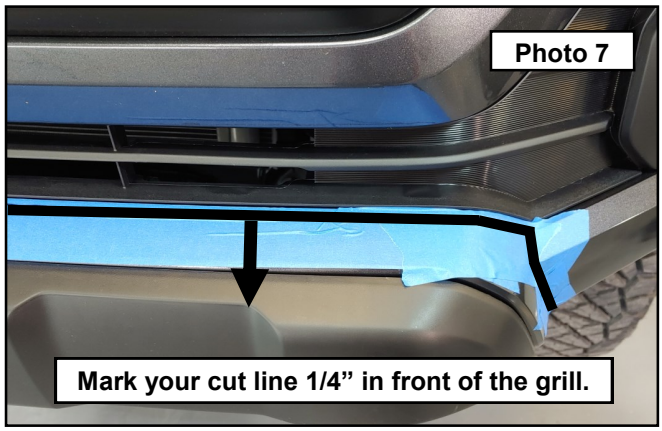


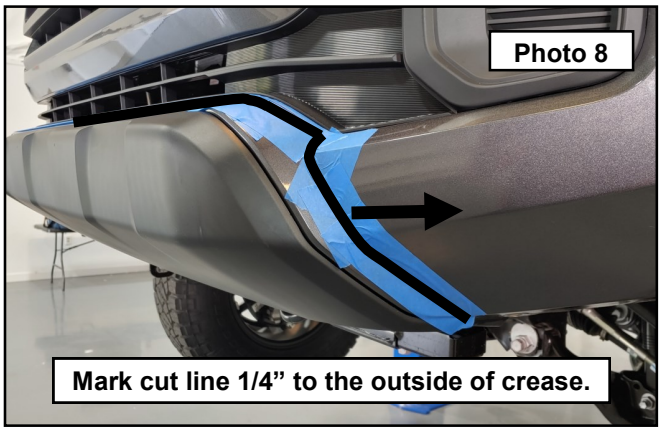
6. Either style of bumper (Low or High Cut) that you choose will still remove the center section of the plastic bumper. Start by taping off the bumper along the grill and down the crease where the sides meet the middle. The tape is used as paint protection and something to mark onto. **Photo 4 / 5**





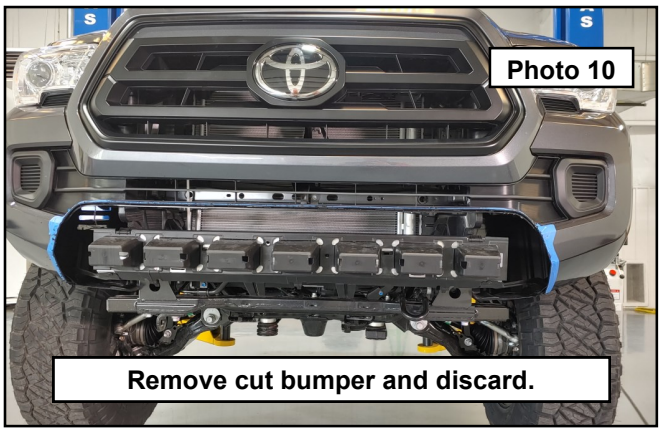
7. Once you have taped off the bumper, mark a line 1/4” in front of the grill. This will be the upper cut line. **Photo 7**
8. **Low Cut Option**: Follow the body line around where the center section meets the sides of the bumper. In the crease where the chin and the bumper meet mark a line 1/4” to the outside of the crease. Under the vehicle, mark straight back towards the engine bay. This cut does not have to be exact as the new bumper wings will cover a decent amount of the area cut and you may be trimming more later for final fitment. **Photo 8**





9. Use a suitable cutting tool to follow your line around the bumper. An air body saw is recommended but you can use anything designed to cut plastic. **Photo 9**
10. Remove cut portion and discard. **Photo 10**





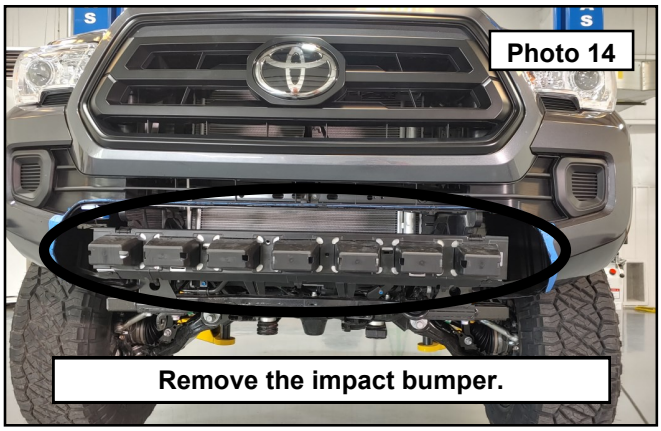
11. **High Cut Option:** This step can be done now or later on and will be shown with the bumper in place for reference. Tape along the body line under the fog light. You will follow this line around the sides of the bumper keeping the tape as straight as possible. The line will angle up the side of the bumper. If you have the factory style flares, follow over the top of them with the tape as shown. **Photo 11 / 12**



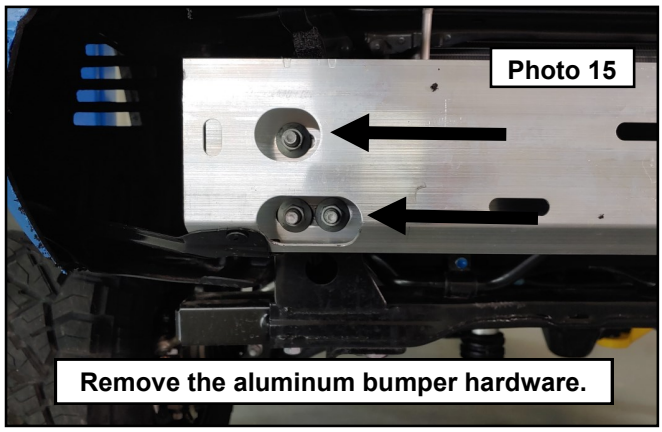


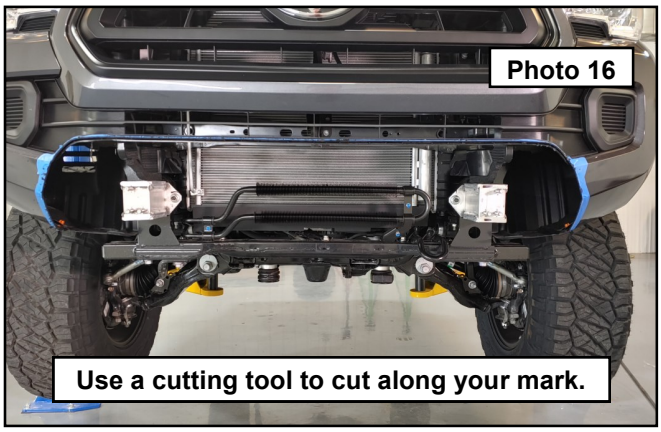
12. Use the cutting tool of choice and cut along the tape line. If you have fender flares, they will need to be trimmed higher at a later step for the wing to fit. **Photo 13**
13. Behind the plastic bumper cover is a 5mph impact bumper either made of plastic or foam. If you have the foam, just pull away from the aluminum bumper and discard. If you have the plastic impact bumper, remove by pushing on the clips that are holding it to the aluminum bumper. As you press a clip, pull the plastic away from the aluminum. Do this until the entire plastic bumper is removed and discard. **Photo 14**



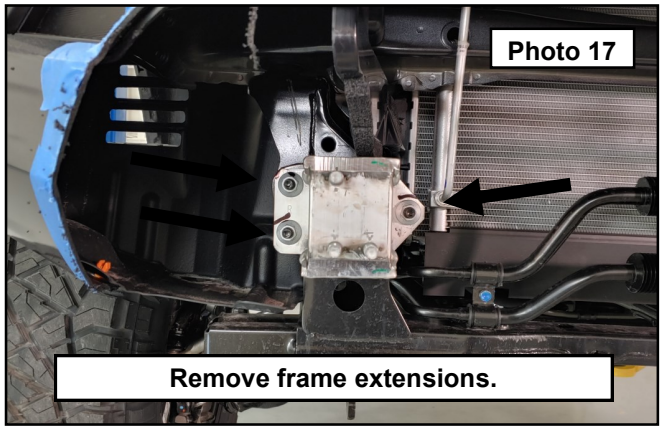


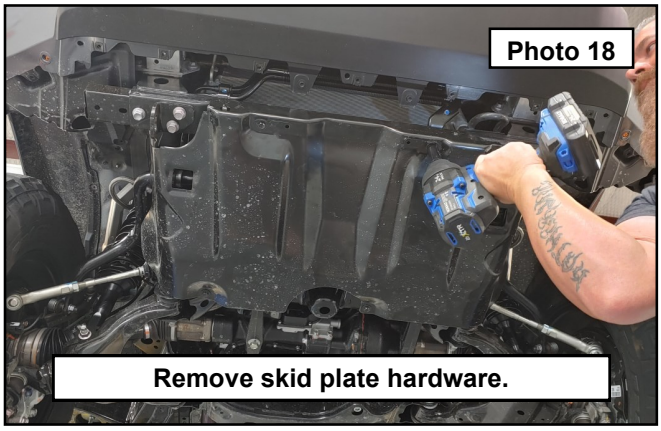
14. Behind the impact bumper is the aluminum bumper structure. Remove this using a 14mm socket on both sides of the vehicle. **Photo 15**
15. Remove the aluminum bumper. If you are doing the low cut version, you will have to shimmy the bumper out by sliding to one side and pulling out of the other side. **Photo 16**



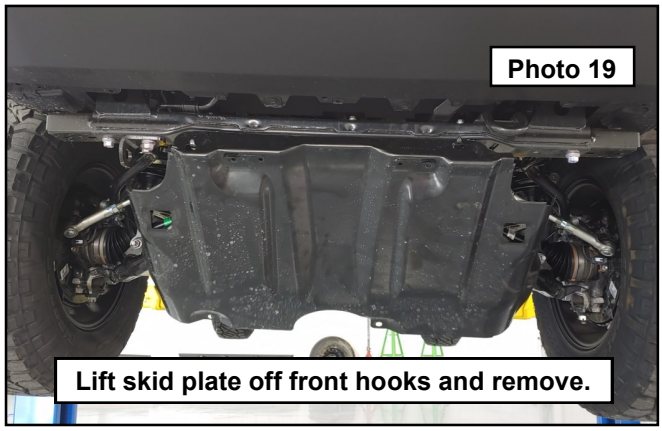


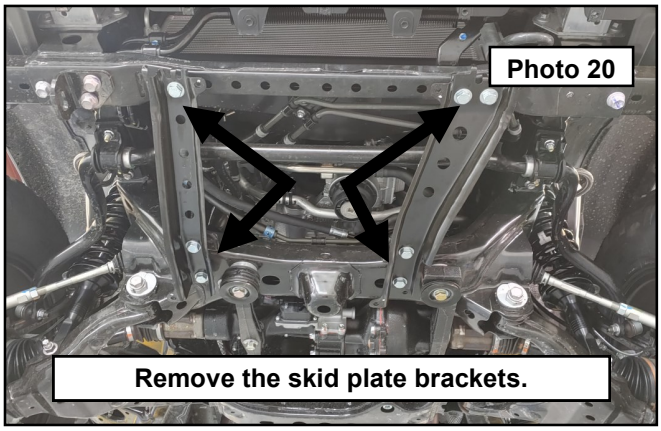
16. With the aluminum bumper out of the way, remove the frame extensions using a 14mm socket and discard. Save the hardware as it will be reused later. **Photo 17**
17. Under the vehicle, remove the factory skid plate using a 12mm socket. **Photo 18**



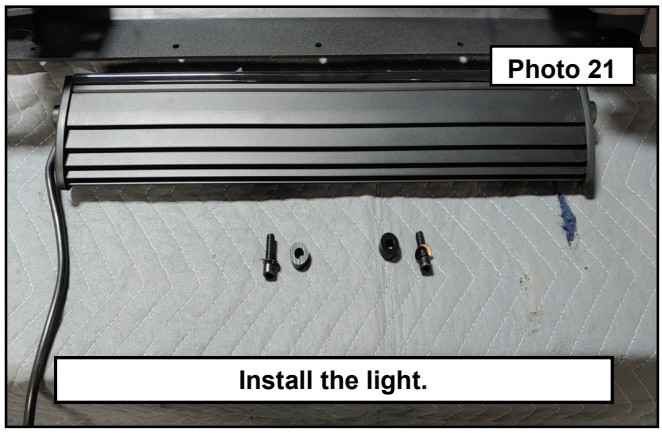


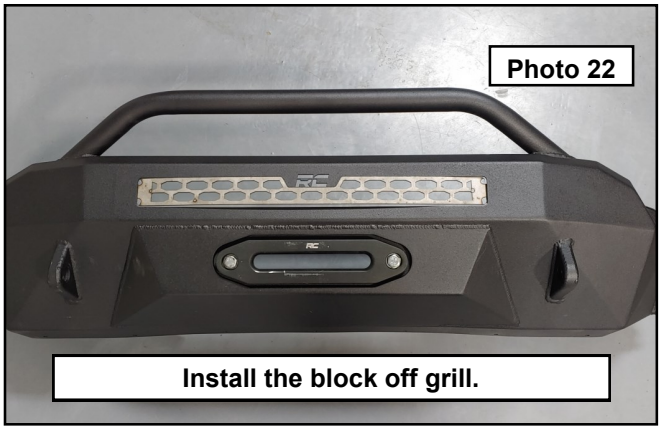
18. Let skid plate hang down. There are two hooks holding the skid plate onto the core support, lift off the hooks and add to your discard pile. **Photo 19**
19. Remove the skid plate mounting brackets using a 15mm socket. Save two bolts for later install of the new skid plate. **Photo 20**



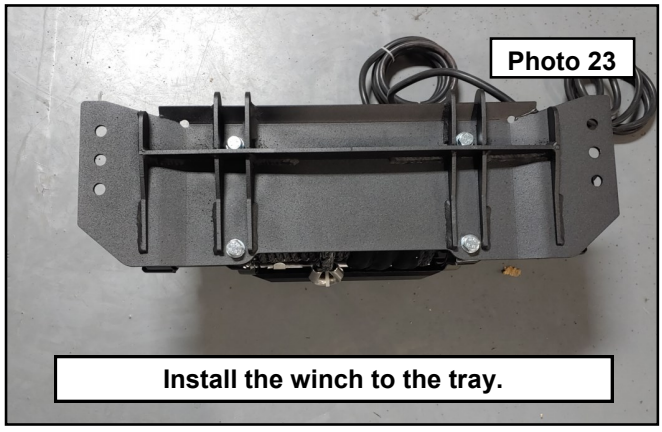


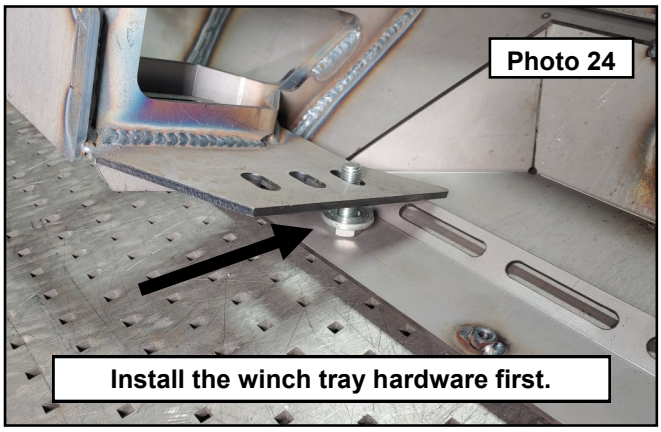
20. **<u>Light Option Kits</u>:** Install using the hardware that comes with the light. Some light kits require a spacer and longer bolts, so make sure to open all hardware bags. **Photo 21**
21. **<u>Non Light Option Kits</u>:** Install the block off grill to the light bar mount using the provided 8mm bolts, small washers and flange nuts. **Photo 22**





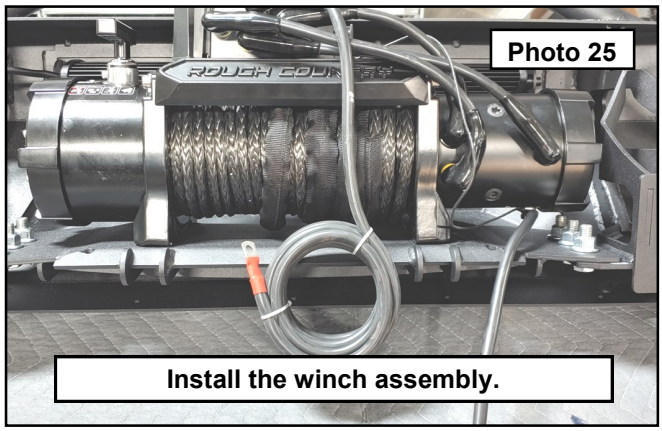
22. Install the winch to the tray using the hardware from the winch kit. **Photo 23**
23. Install the winch tray to the bumper using the previously removed 12 mm hardware. Start by installing the washers to the bolts, installing the two front bolts into the bumper first. If you are not installing a winch, still install the tray to the bumper for the added support. **Photo 24**





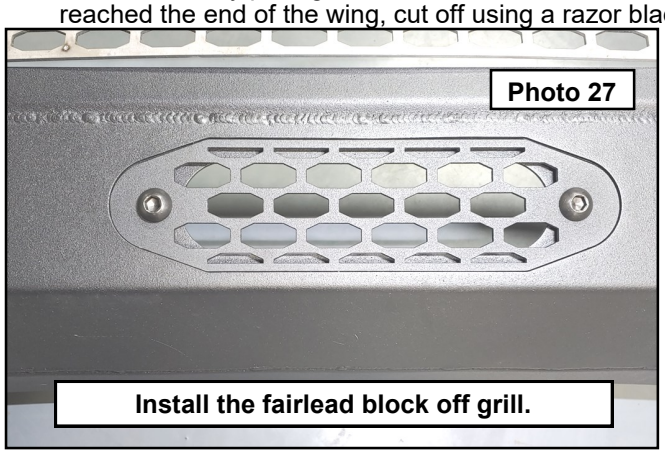
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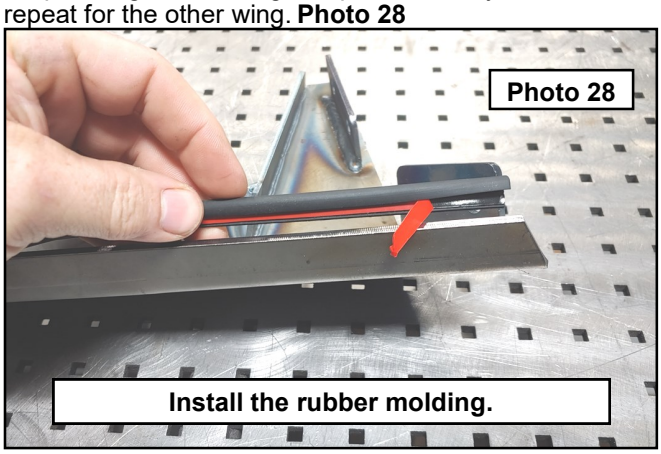
24. Lower the winch tray assembly to the bumper mounts while passing the winch rope through the fairlead opening. Install the remaining 12mm hardware. **Photo 25**
25. **Winch Option Kits:** This bumper is designed around the Rough Country synthetic rope fairlead which comes in the winch box or can be purchased separately. Install with the provided button head bolts from the bumper kit. **Photo 26**



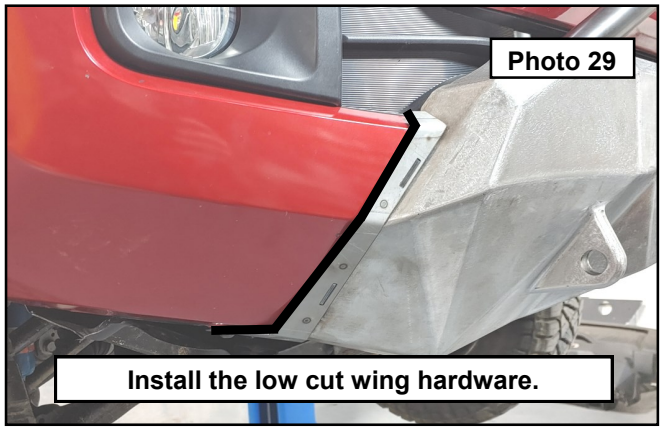


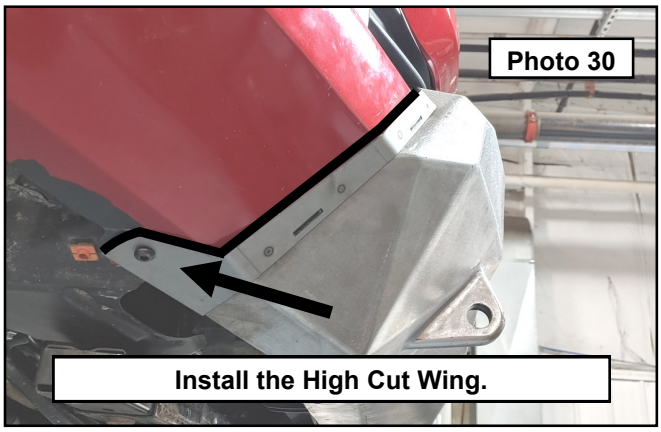
26. **Non Winch Option Kits:** Install the fairlead block off grill using the provided 12mm button head bolts and 1/4" thick spacers behind the grill. Center the grill and tighten the bolts. **Photo 27**
27. Install the bumper to the vehicle using the factory hardware. Center the bumper and torque the nuts to 35 ft/lbs.
28. **Low Cut and High Cut Kits:** Install the provided rubber molding to the wing edge as shown by peeling back about an inch of the red tape cover and sliding the rubber over the edge of the wing where it will contact the plastic bumper. Tape side goes to the inside of the bumper wings, small end of the rubber to the outside. Press down the tape and continue by pulling the red cover off an inch at a time while pressing the molding into place. Once you have reached the end of the wing, cut off using a razor blade and repeat for the other wing. **Photo 28**





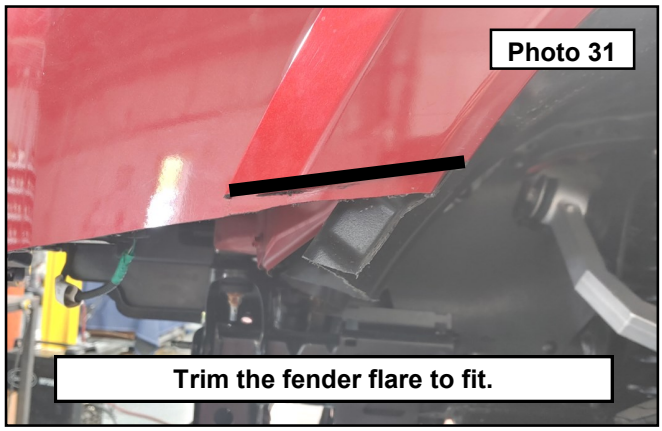
29. **Low Cut Option Kits**: Install the Low Cut Wing to the bumper using the provided 8mm bolts, fender washer, and flange nut. The bolts need to pass from the metal bumper out to the plastic bumper. This helps "sandwich" the plastic bumper ends between the wing and the bolt. **Photo 29**
30. Under the vehicle bolt the Low Cut Wing to the bumper and wheel liner using the provided 8mm button head bolt, washer, fender washer on the backside, and flange nut. **Photo 30**





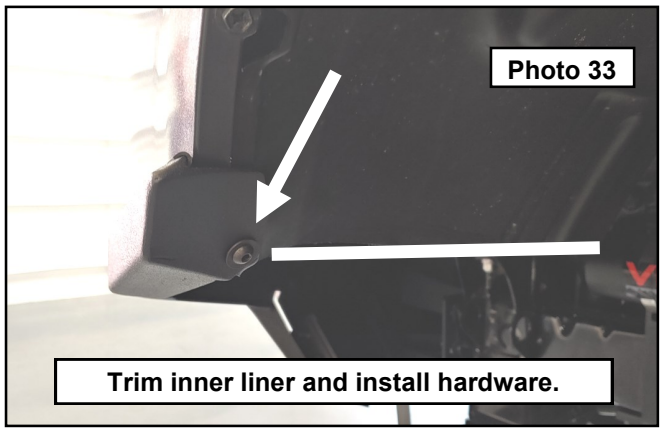
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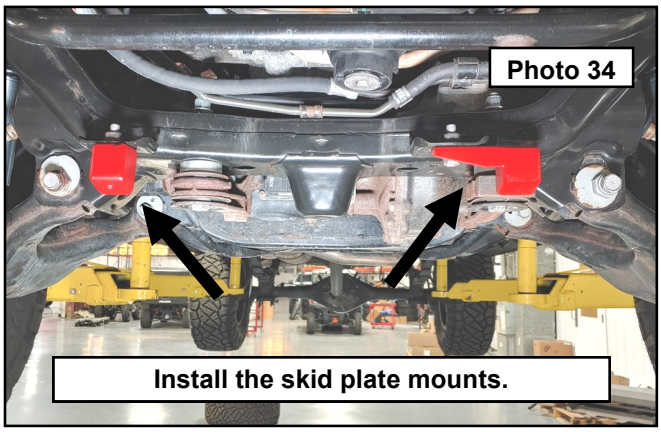
31. **<u>High Cut Wing Option Kits</u>:** Install the High Cut Wing to the bumper using the provided 8mm bolts, fender washer, and flange nut. If you have fender flares, mark where the wing will interfere and trim to fit. **Photo 31 / 32**



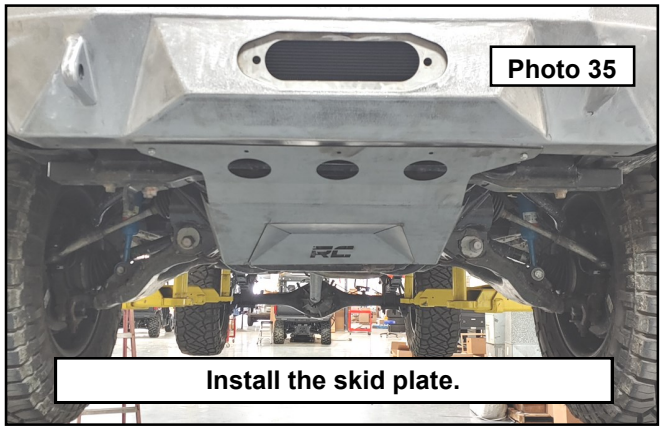


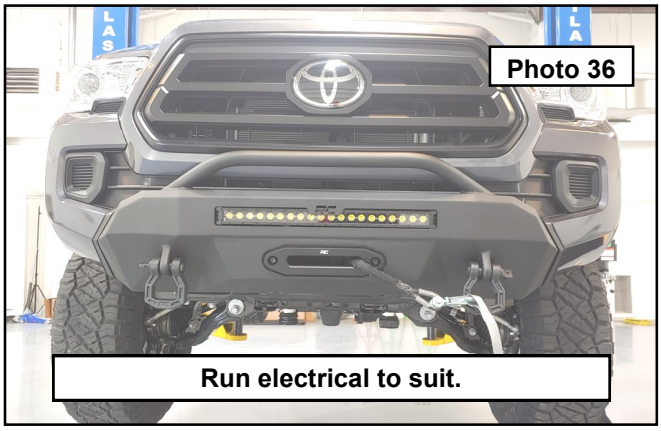
32. Trim the inner fender liner straight across from the edge of the wing to the frame using a suitable cutting tool. Razor knife works really well here. Bolt the inner fender liner to the High Cut Wing using the provided 8mm button head bolt, washer, fender washer on the backside, and flange nut. Due to manufacturing variances, you may have to adjust the wing to fit by pushing or pulling on the end of the wing to get it to fit properly. **Photo 33**
33. Install the skid plate mounts using the factory hardware. Snug up but leave loose for adjustment. **Photo 34**





34. Install the skid plate using the provided 1/4” button head bolts and washers. To aid in removal later, coat each bolt in anti-seize before installing. Tighten the skid plate mounts using a 17mm wrench. **Photo 35**
35. Reconnect the battery and wire all electrical to suit. Hang D-Ring of choice. **Photo 36**





By purchasing any item sold by Rough Country, LLC, the buyer expressly warrants that he/she is in compliance with all applicable , State, and Local laws and regulations regarding the purchase, ownership, and use of the item. It shall be the buyers responsibility to comply with all Federal, State and Local laws governing the sales of any items listed, illustrated or sold. The buyer expressly agrees to indemnify and hold harmless Rough Country, LLC for all claims resulting directly or indirectly from the purchase, ownership, or use of the items.

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