



Installation Instructions

2016 TOYOTA TACOMA TUBE WINCH MOUNT

Product Number: TB16-01-123

Application: 2016+ TOYOTA TACOMA



Installation Manual
Tacoma Beast Front Bumper
Product Number: TB16-01
Application: 2016+ Toyota Tacoma



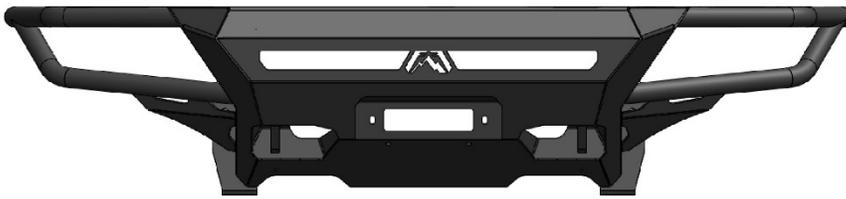
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PROVIDED MATERIALS

50289-HW QTY-1
TB16-01-X-IM QTY-1



22486
QTY 1



21871-10
QTY 2



22491
QTY 1



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Tools used:

5/16" Socket wrench, 3/8" Socket wrench, 3/4" Socket wrench
5/16" Open-end wrench
10mm Socket wrench, 14mm Socket wrench, 17mm Socket wrench
Needle nose pliers
Flat head screwdriver
Plastic panel pry tool
Silver sharpie
Body saw (small reciprocating saw)
Angle grinder with flat disk pad
Painters tape

Hardware Kit:

FAB FOURS IDENTIFICATION	COMPONENT DESCRIPTION	QTY
50289-HW	1/4"-20, Yellow Zinc Hex Cap Bolt, Grade 8	2
50289-HW	1/4"-20, Yellow Zinc Hex Nut, Grade 8	2
50289-HW	1/4", Yellow Zinc Flat Washer, Grade 8	4
50289-HW	1/4", Yellow Zinc Lock Washer, Grade 8	2
50289-HW	5/16"-18, Yellow Zinc Hex Cap Bolt, Grade 8	2
50289-HW	5/16", Stainless Steel Flat Washer	4
50289-HW	5/16", Yellow Zinc Lock Washer, Grade 8	2
50289-HW	5/16"-18, Yellow Zinc Hex Nut, Grade 8	2
50289-HW	1/2"-13, Yellow Zinc Hex Cap Bolt, Grade 8	2
50289-HW	1/2", Yellow Zinc Lock Washer, Grade 8	2
50289-HW	1/2", Yellow Zinc Flat Washer, Grade 8	4
50289-HW	1/2"-13, Yellow Zinc Hex Nut, Grade 8	2
50289-HW	1.75" Round Plastic Plug	2



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DISASSEMBLY

Note: Save all OEM parts until installation is complete!

1. Using a 10mm socket wrench, remove the two (2) screws holding the grille to the core support. **(Figure 1)**



Figure 1

2. Using a plastic body panel pry tool, remove the push lock clip from the outer edge of the grille on either side near the headlights. To release these clips, lift up on the center portion and then pull the whole clip upwards. With the clips removed, pull firmly outward on the grille shell and it should pop loose. **(Figure 2)**



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Figure 2

3. Using a 10mm socket wrench, remove the nine (9) screws attaching the black plastic valance to the lower portion of the bumper cover on the outside. (Figure 3)



Figure 3

4. Using a 10mm socket wrench, remove the three (3) screws attaching the black plastic valance and inner fender to the lower portion of the bumper cover on the inside of each side of the vehicle. (Figure 4)



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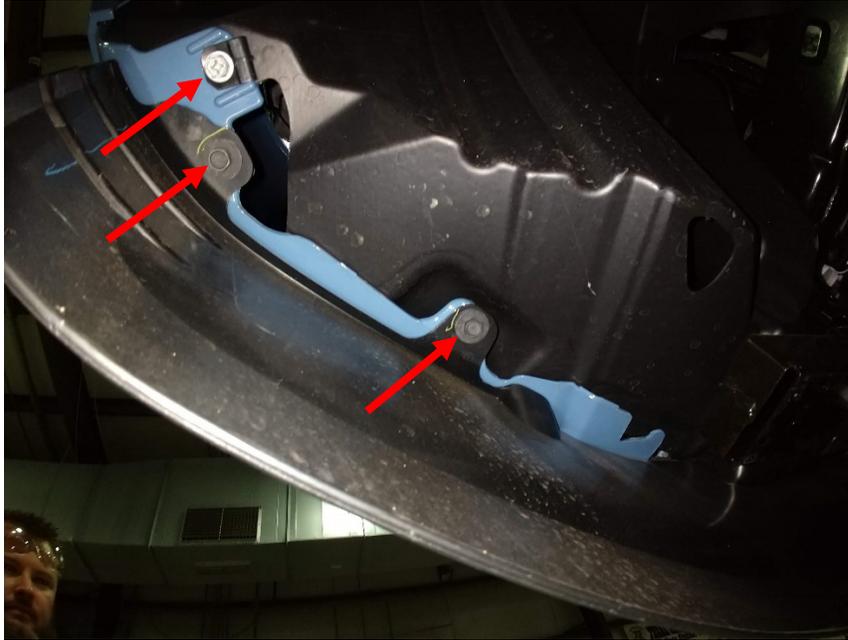


Figure 4

5. Using a 10mm socket wrench, remove the two (2) screws at the bottom center of the bumper cover. (Figure 5)



Figure 5



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6. Using a 10mm socket wrench and a flat head screwdriver, remove the screw and the twist lock clip attaching the inner fender to the bumper cover. **(Figure 6)**



Figure 6

7. Using a plastic body panel pry tool, remove the six (6) push lock clips from the top of the bumper cover. **(Figure 7)**



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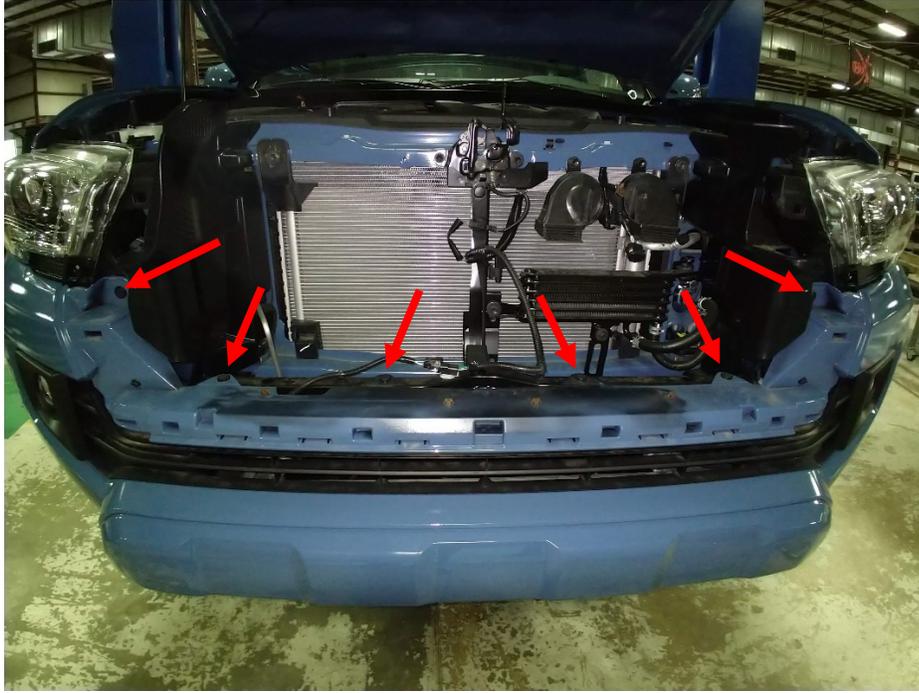


Figure 7

8. Using a plastic body panel pry tool, reach inside the bumper cover and pinch the two (2) clips holding the flare to the bumper cover and pull out on the flare. **(Figure 8)** With the flares pulled out of the cover remove the bumper cover from the vehicle.



Figure 8



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- Using a 14mm socket wrench, remove the three (3) nuts per side holding the impact bar to the core support. **(Figure 9)**

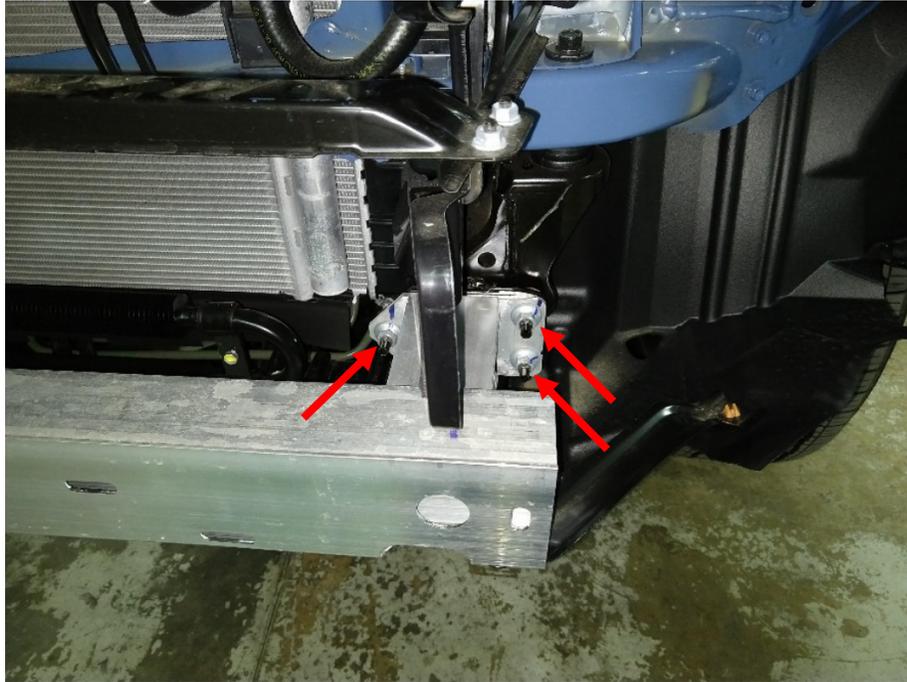


Figure 9

- Using a pair of needle nose pliers, remove the plastic captured nut from the inner fender and support bar. **(Figure 10)** Remove the impact bar from the vehicle.





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Figure 10

11. Using a 17mm socket wrench, remove the screw on either end of the bottom of the core support. Leave the crash bars in place. **(Figure 11)**

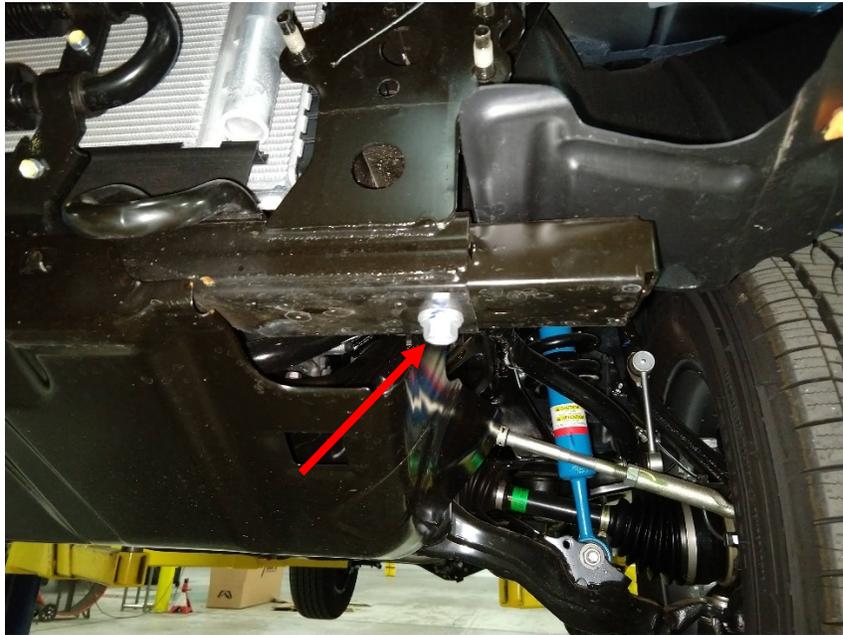


Figure 11

12. Using a plastic body panel pry tool, remove the push lock clip holding the air dams on either side of the radiator then pull. **(Figure 12)**



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Figure 12

13. Using a silver sharpie and a body saw, mark and cut a line on the bumper cover bracket at the edge of the fender. (Figure 13)

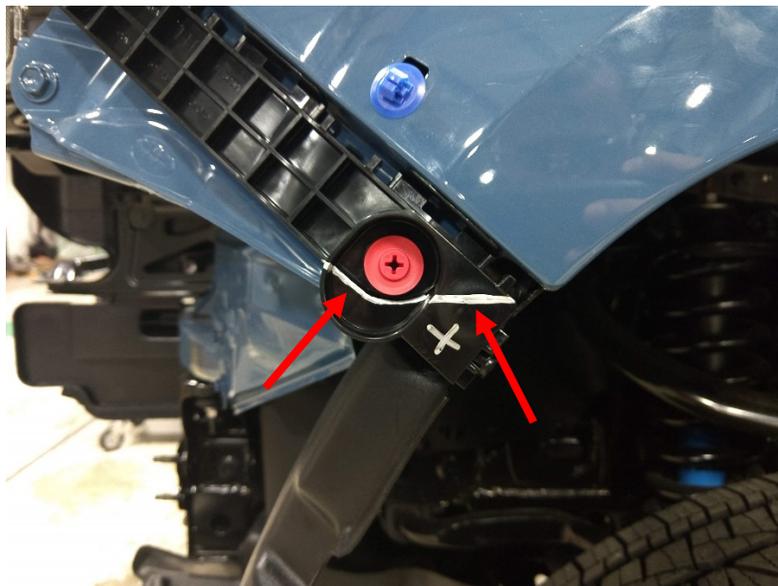


Figure 13



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- Using painters' tape and a body saw, mark and cut the inner fender following the profile of the body in front of the wheel. Remove any rough edges using an angle grinder with flap disk pad. (Figure 14)

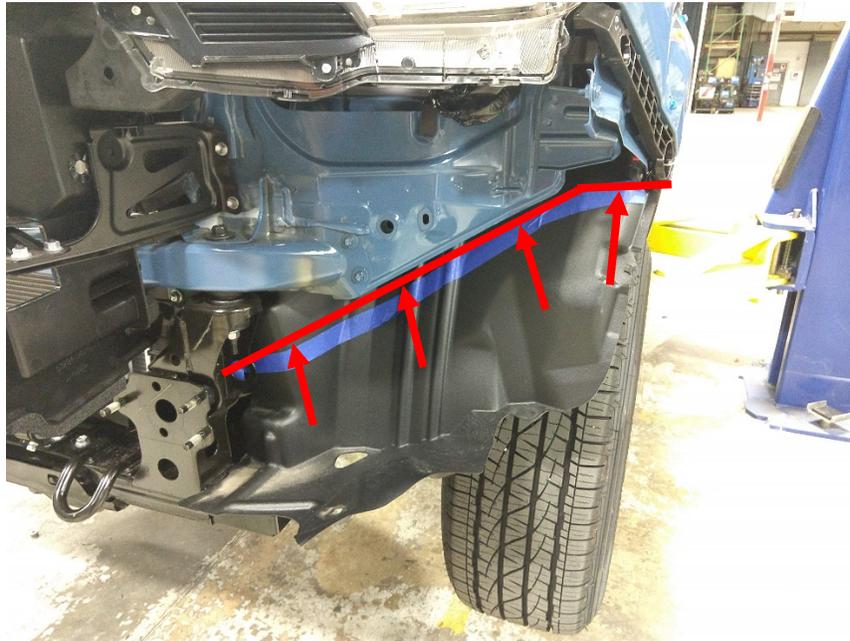


Figure 14

- Use a 1/2" socket wrench to remove the two bolts holding the lower cooler to the frame, and the bolt on the passenger side wheel well frame holding the lines (Figure 15-16).

16.



Figure 15.



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Figure 16.

17. Attach the cooler to the provided relocation brackets (22491) and 5/16" bolts, washers and nuts, and push the cooler as close as you can to the intercooler without touching it. Use the OEM bolts to attach the brackets and cooler back to the frame. Figure 17-18.



Figure 17.



Figure 18.



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18. Holding the bumper cover up the vehicle, use painters' tape to cover the upper portions of the bumper cover in preparation for being cut. **(Figure 19)**



Figure 19

19. Using a silver sharpie and a tape measure, scribe a straight line on the bumper cover connecting the bottom of the opening around the fog light and the bottom corner of the fender. **(Figure 20)**

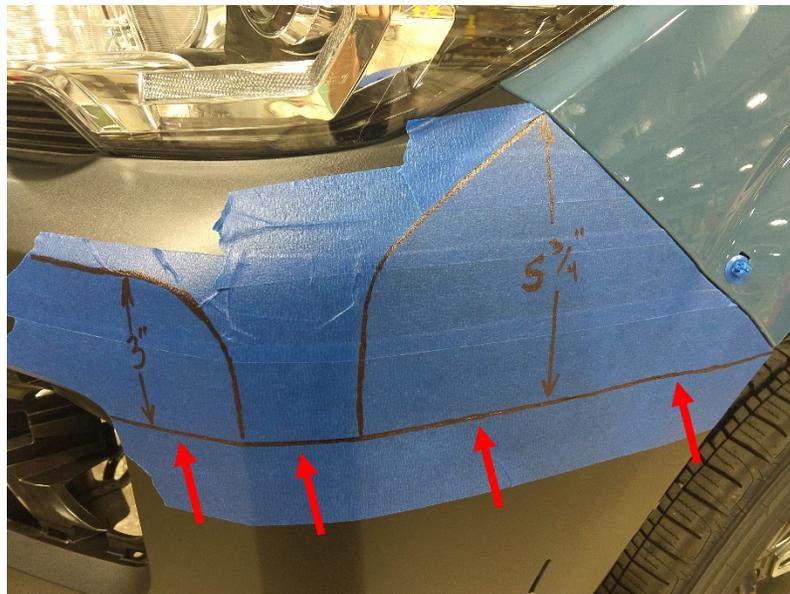


Figure 20



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20. Using painters' tape and a silver sharpie, cover and mark the fender flare inline with the mark made in step 19. **(Figure 21)**



Figure 21

21. Using a silver sharpie, mark the bumper cover above the fog light pocket. **(Figure 22)**

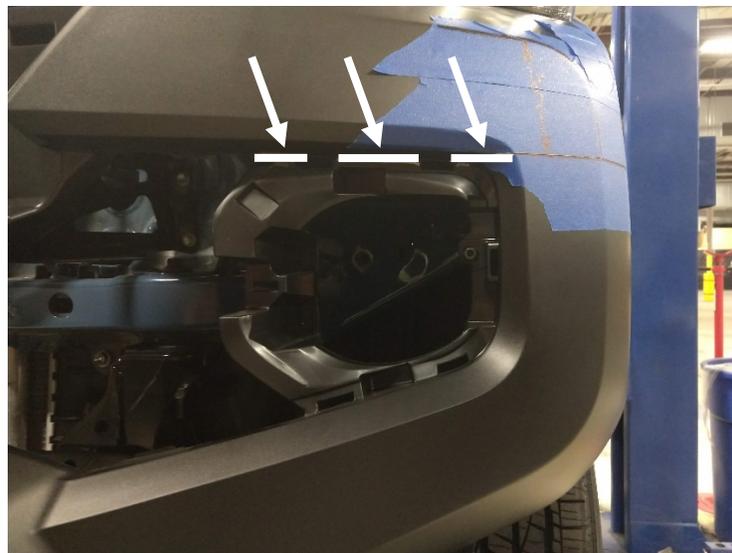


Figure 22



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22. Using a body saw, cut roughly 1/8" below the lines made in steps 19-21. (Figure 23)



Figure 23

23. Using an angle grinder with a flap disk pad, remove the rest of the material up to the marks made in steps 19-21 and to remove any roughness created by the body saw.
24. Reinstall the cut bumper cover and grille at this point by reversing the steps used earlier to remove them.



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25. If installing a winch: Do so at this time using the winch manufacturers installation instructions and hardware. Take two of the winch mounting bolts and install them into the front of your winch and leave a $\frac{1}{4}$ " gap, slide the winch into the front two winch mounting slots in the bumper. you can then install the rear two bolts and tighten the winch in place.
26. If installing a 30" light bar: Do so at this time using the provided L-brackets (21871) and $\frac{1}{4}$ " bolts, washers and nuts. Figure 24.

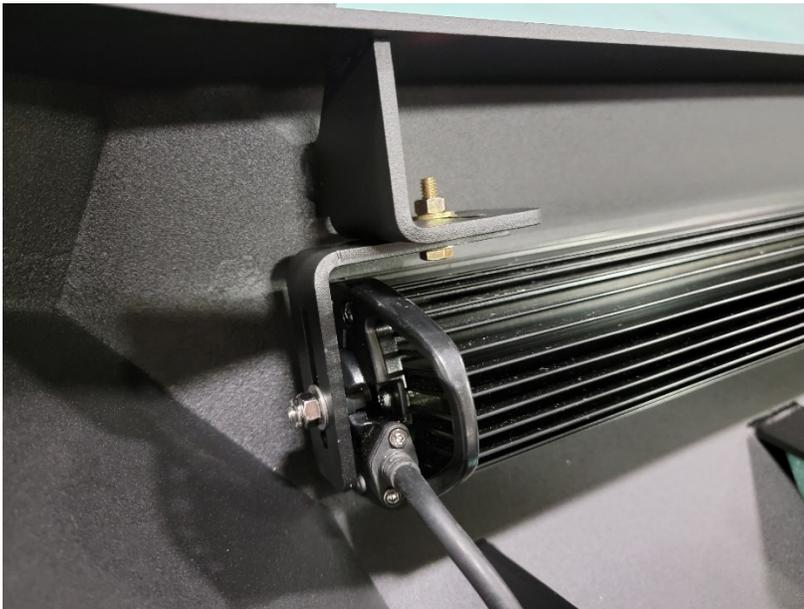


Figure 24



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27. With assistance, hold the bumper up to the frame and use the OEM nuts removed during step 9 to loosely attach it. Use the provided $\frac{1}{2}$ " bolts, washers and nuts to fasten the lower flange to the frame. Figure 25.

NOTE: Toyota frames may be out of square in some cases and your bumper will need to be shimmed in order to get a correct fitment.



Figure 25.

28. Position the bumper as desired and tighten all mounting hardware.



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