



# Installation Instructions

## Black Steel/Elite Front Bumper

Product Number: K1860,K1861,K1862,R1860,R1861,R1862

Application: '07- Current Toyota Tundra

## SAFETY

### Your safety and the safety of others is very important.

- In order to help you make informed decisions about safety, we have provided installation instructions and other information.
- These instructions alert you to potential hazards that could hurt you or others.
- Please do a job safety analysis (JSA) before each task to identify potential hazards for your situation and remove/protect against them.
- You must use your own good judgment, and take your time.

**Read and understand all safety precautions and instructions before installing this product.**

THIS PRODUCT IS FOR OFFROAD USE ONLY. ALL LIABILITY FOR INSTALLATION AND USE RESTS WITH THE OWNER.

**CARELESS INSTALLATION AND OPERATION CAN RESULT IN SERIOUS INJURY OR EQUIPMENT DAMAGE.**

## Injury hazard

### Failure to observe these instructions could lead to severe injury or death.

- Always** remove jewelry and wear eye protection.
- Always** use extreme caution when jacking up a vehicle for work. Set emergency brake and use tire blocks. Locate and use the vehicle manufacturers designated lifting points. Use jack stands.
- Always** use appropriate and adequate care in lifting components into place.
- Always** insure components will remain secure during installation and operation.
- Always** wear safety glasses when installing this kit. A drilling operation will cause flying metal chips. Flying chips can cause serious eye injury.
- Always** use extreme caution when drilling on a vehicle. Thoroughly inspect the area to be drilled (on both sides of material) prior to drilling, and relocate any objects that may be damaged.
- Always** use extreme caution when cutting and trimming during fitting.
- Always** tighten all nuts and bolts securely per installation instructions.
- Always** route electrical cables carefully. Avoid moving parts, components that become hot and rough or sharp edges.
- Always** insulate and protect all exposed wiring and electrical terminals.
- Always** perform regular inspections and maintenance on mounts and related hardware.



### NOTE: Black Steel Accessory Compatibility

- This product **is** compatible with the Black Steel D-Ring mounting kit - M1850
- This product **is** compatible with the Black Steel Winch Mount kit 20483
- This product **is not** compatible with the Black Steel Winch Mount and 2" receiver hitch kits – M1650 & M1750

### I. Tool List

- Metric and Standard socket set
- Various socket extensions
- ¾" box end wrench
- Philips head screwdriver
- Flat head screwdriver
- "Christmas tree" clip remover

### II. OEM Bumper Removal

1. Remove Dart Clip from front inner fender lining from frame. Complete both sides, see image below.



Figure 1 – FENDER LINER DART CLIP REMOVAL

- Using a Phillips Head screwdriver, remove the three screws from the bottom plastic on the bumper. See image below.



**Figure 2 – LOWER BUMPER PLASTIC REMOVAL**

- Remove the 2 Phillips Head screws located in the inner fender well lining, per side.
- Disconnect the factory fog light harness from the fog lights and secure harness out of harm's way and to the frame.
- Remove the factory tow hooks (2 bolts per tow hook) using a 17mm socket and wrench.
- Using a deep 14mm socket and breaker bar, loosen the four 14mm nuts located at the connection between the factory frame end and the bumper. See image below.



**Figure 3 – BUMPER TO FRAME FASTENER REMOVAL**

7. Remove the bumper by pulling forward away from the vehicle and rolling forward.
8. Remove the two (per side) plastic clips from the painted plastic trim pieces located below the headlights. The Hood must be open for this. See Image Below.



Figure 1 - Fascia Mount Screws

9. Remove these plastic painted trim pieces by pulling directly away from the front of the truck. Do not discard these!
10. Remove all pop rivets (8 Total) from the front painted plastic bumper upper fascia. See Image Below.



Figure 2 - Center Fascia Fasteners

11. Remove all bolts holding the painted plastic fascia piece using a 10mm socket and wrench (16 total). See Image Below in addition to Image Above.



**Figure 3 - Outer Fascia Fasteners**

12. Remove the Phillips pop rivet holding the fascia to the inner fender. 1 per side.
13. Remove the two(one per side) 10mm screws from the recessed hole in the inner fender well.
14. Pull the edges of the plastic fascia from the truck and directly away from the front to snap free. Set fascia aside.
15. Remove the two 10mm screws using a socket from the plastic spacer pieces located on the lower fender. With Screws removed pull bracket straight off the truck. Complete on opposite side. See Image Below.



**Figure 4 - Spacer Fastener Locations**

16. Your truck is now ready for installation of your new Fab Fours bumper!



### III. Installation

1. If equipped, remove the fog lights from the OEM bumper, making sure to keep all adjusting hardware. Pop the fog light out of the mounting bracket by lifting the tabs at the pivot point on each side.
2. If equipped, reinstall the OEM fog light into the brackets in the Black Steel front bumper. Use the OEM adjuster screw and spring to set the position of the beam.

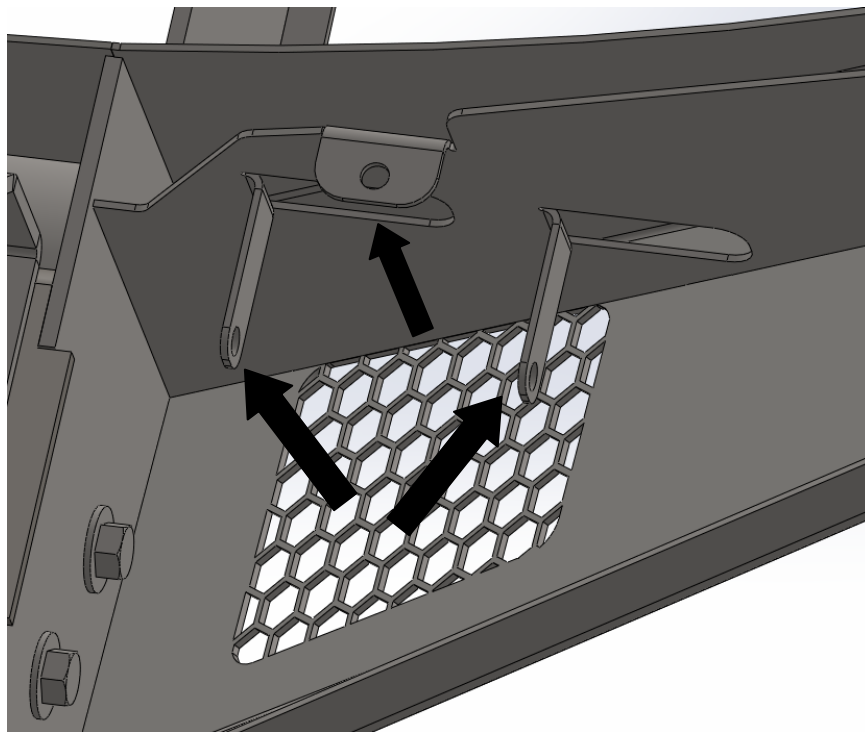


Figure 4 - FOG LIGHT INSTALLATION

3. Install the Black Steel mounting brackets onto the frame rail reusing OEM hardware.
4. If you have the M1850 D-ring kit, it must be installed at the same time as the bumper:
  - a. Install the lower guard into the bumper by inserting it between the uprights from the bottom of the bumper. Loosely secure it with one bolt per side.
  - b. Insert the D-ring mounts into the pockets on either side of the lower guard, aligning the D-ring mounting holes to the bumper mounting holes.



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5. With the assistance of a hoist or multiple assistants, lift the bumper and align the mounting slots on the bumper with those on the frame brackets. Fasten with the provided 1/2" - 13 x 2.0" bolts, washers, and nuts. Do not fully tighten at this time.
  - a. If installing the bumper with the M1850 D-Ring kit, remove the one fastener per side holding the lower guard, allowing it to rest on the top of the D-Rings. This will greatly improve access to the top outside fastener location.
6. Adjust the side to side alignment, and the level of the bumper in relation to the front clip of the truck.
7. Fully tighten all bumper and frame fasteners.
8. Reinstall the lower guard with the supplied hardware. Fully tighten the fasteners.
9. If equipped, reconnect the fog light wiring harness and check fog light aim.





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### IV. Maintenance/Care

- Periodically check and tighten all nuts.
- Stripped, fractured, or bent bolts or nuts need to be replaced.



More than expected... Better than expected

