

IRON CROSS AUTOMOTIVE INC.

2007-2014 Toyota Tundra
Rear Bumper Installation
21-715-07

Installation Instructions

Tools Required

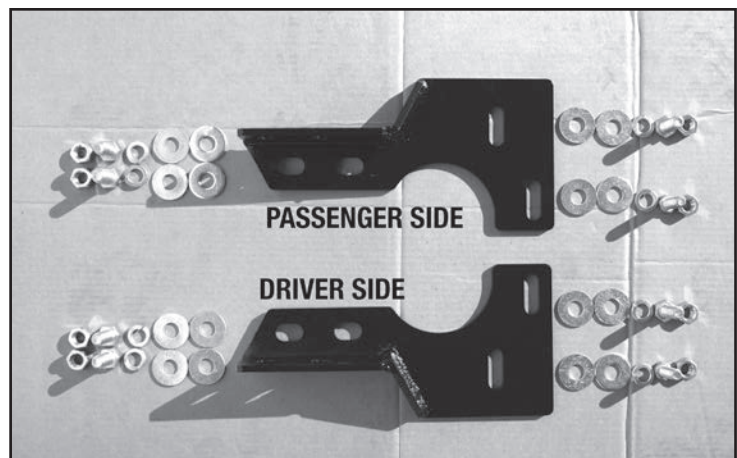
- Socket Wrench with extension
- 3/4", 12MM, & 19MM Sockets
- 3/4", 12MM Box End Wrench
- Flat and Phillips Head Screw Drivers
- Floor Jack and Wook Block

Note- 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.

Hardware

16	1/2" Flat Washers
8	1/2" Lock Washers
8	1/2" Hex Bolts
8	1/2" Hex Nuts
1	Driver Side Bracket
1	Passenger Side Bracet
1	Tag Lights



Stock Bumper Removal

A) Using a Philips head screw driver, remove the license plate lights from each side of the OEM bumper. Disconnect the harness on the back side of the light to remove fully. Secure the harness out of harms way to the frame.

B) Remove your license plate from teh OEM bumper.

C) Remove the plastic corner pieces from teh top of the OEM bumper by pulling up form the outside edge. If the plastic is being stubborn during removal, the plastic clips can be popped loose from the bottom side of the bumper. **Fig. 1**

D) Remove the Phillips head screw passing through the plastic that was hidden by the license plate previously. **Fig 1a**

E) Pop the plastic clips loose on the bottom side of the main piece of plastic on the top side of the bumper allowing access to the OEM fasteners.

F) Remove (3) clips and (2) bolts on the under side of the bumper end cap. **Fig. 2**

G) Remove (4) bolts holding on center step support. **Fig. 3**

H) Unbolt (3) bolts holding on outer bumper end cap support, underneath the bumper. **Fig. 4**

I) Unbolt (3) bolts holding on outer bumper end cap on the top side of the bumper. **Fig. 5**



Fig 1

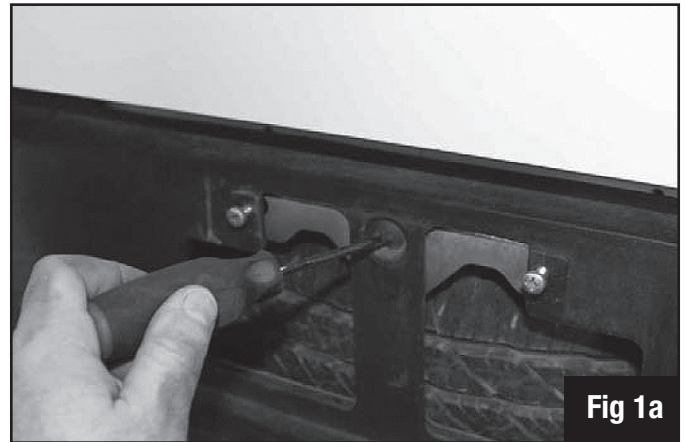


Fig 1a

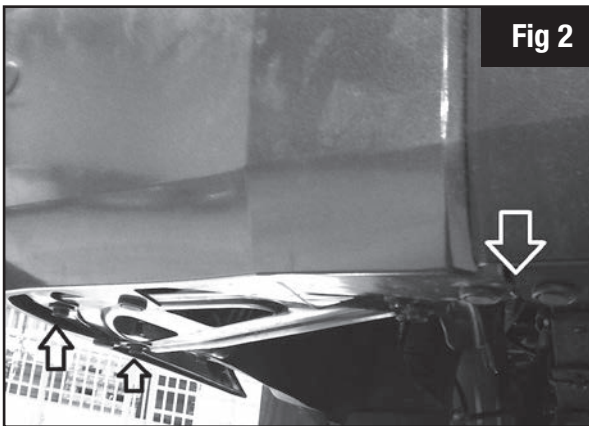


Fig 2



Fig 3

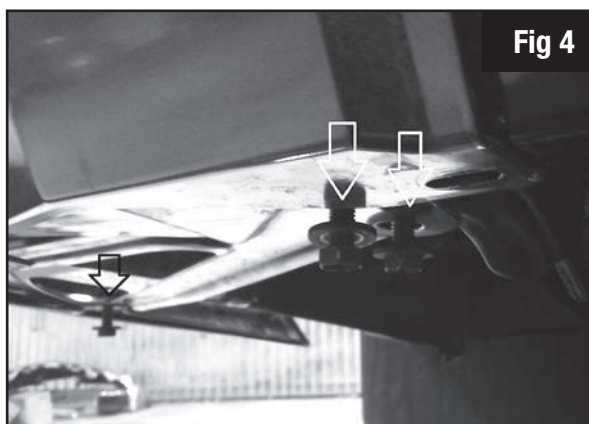


Fig 4

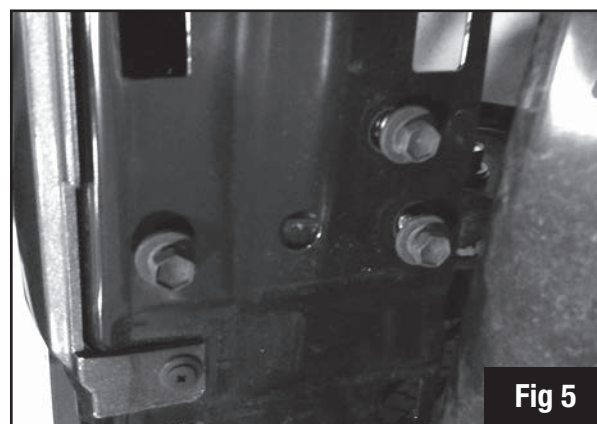


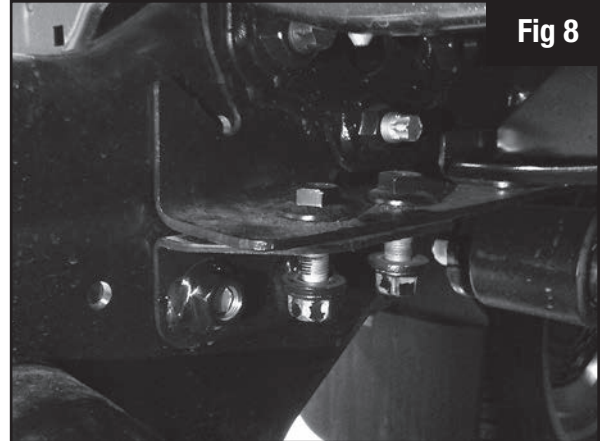
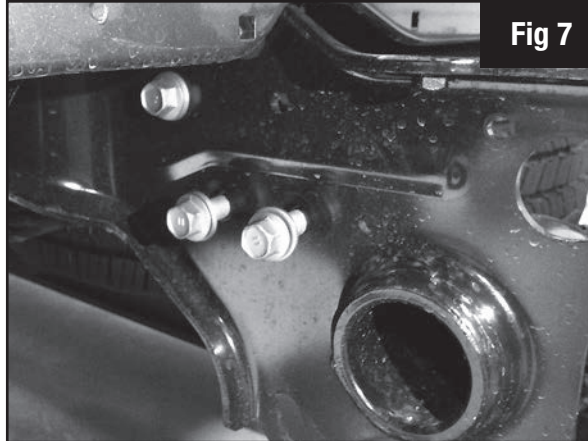
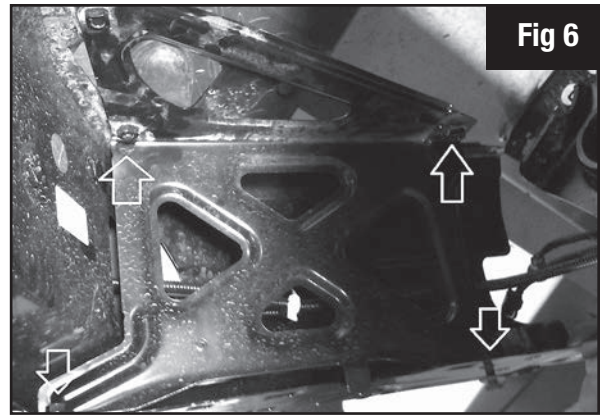
Fig 5

Stock Bumper Removal Continued...

J) Remove internal end cap support. There are numerous bolts that hold this on. The only reason to remove this piece is to unhook sensors in the bumper. If you have no sensors then skip this step. **Fig. 6**

K) Remove (3) bolts attaching support bracket to frame. Also there are (2) bolts on the inside going up. **Fig.7 and Fig.8**

G) Remove the OEM bumper and set aside.



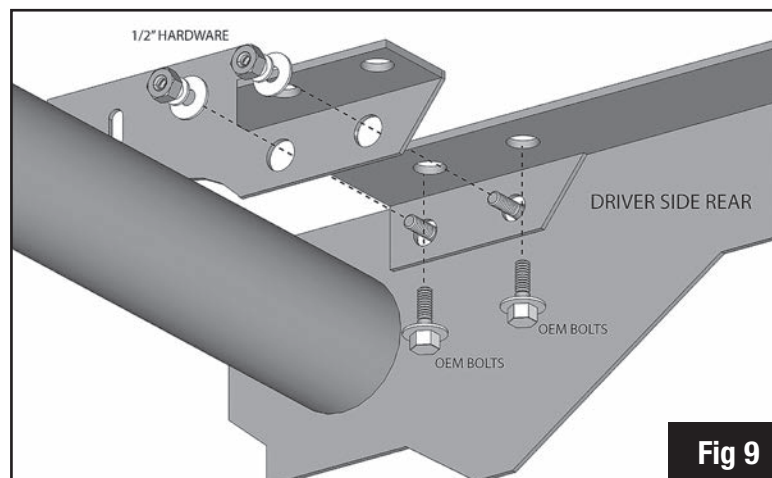
Rear Bumper Installation

Note: The following installation steps apply to the installation of the rear bumper. Please read the entire manual before attempting installation! Ignoring these steps will increase your probability of scratching the vehicle during product installation!

A) Remove the bumper from the shipping carton. Lay all items out on a blanket to prevent damage to the powder coating.

B) Using a 19MM socket and wrench, remove the (3) bolts from each side of the hitch frame plate.

C) Install supplied intermediate mounting brackets to the hitch frame plate using the fasteners removed in the previous step. Complete on both driver and passenger sides of the vehicle. Do not fully tighten; finger tighten only. Use supplied 1/2" hardware in the (2) two horizontal holes, use OEM hardware in threaded vertical holes. **Fig. 9**



Rear Bumper Installation Continued...

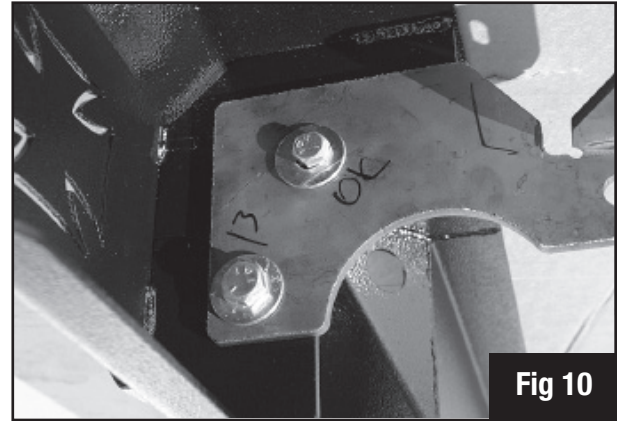
D) With the bumper held into place, insert the supplied 1/2" fasteners through the bumper and into the bumper brackets placing the nuts on the front side of the frame mount. Do not fully tighten. **Fig. 10**

E) Align the bumper side to side, and top to bottom to ensure a perfect fit to the truck. Allow for a 0.5" clearance to all painted surfaces if possible to allow for frame flex.

F) Check that the tailgate does not interfere with the bumper, by opening it very carefully and lowering it into place. If tailgate is too close to the bumper, adjust bumper lower.

G) Fully tighten all fasteners between bumper and brackets, and brackets and frame.

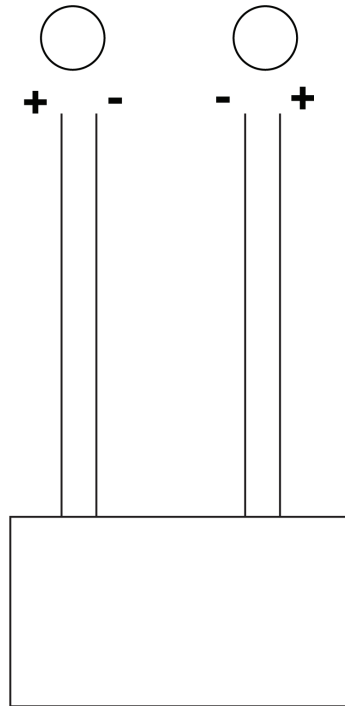
H) Install supplied aftermarket tag lights.



Tag Light Wiring

Factory tag lights must be cut and replaced with replacement tag lights.

FACTORY TAG LIGHTS



REPLACEMENT TAG LIGHTS

