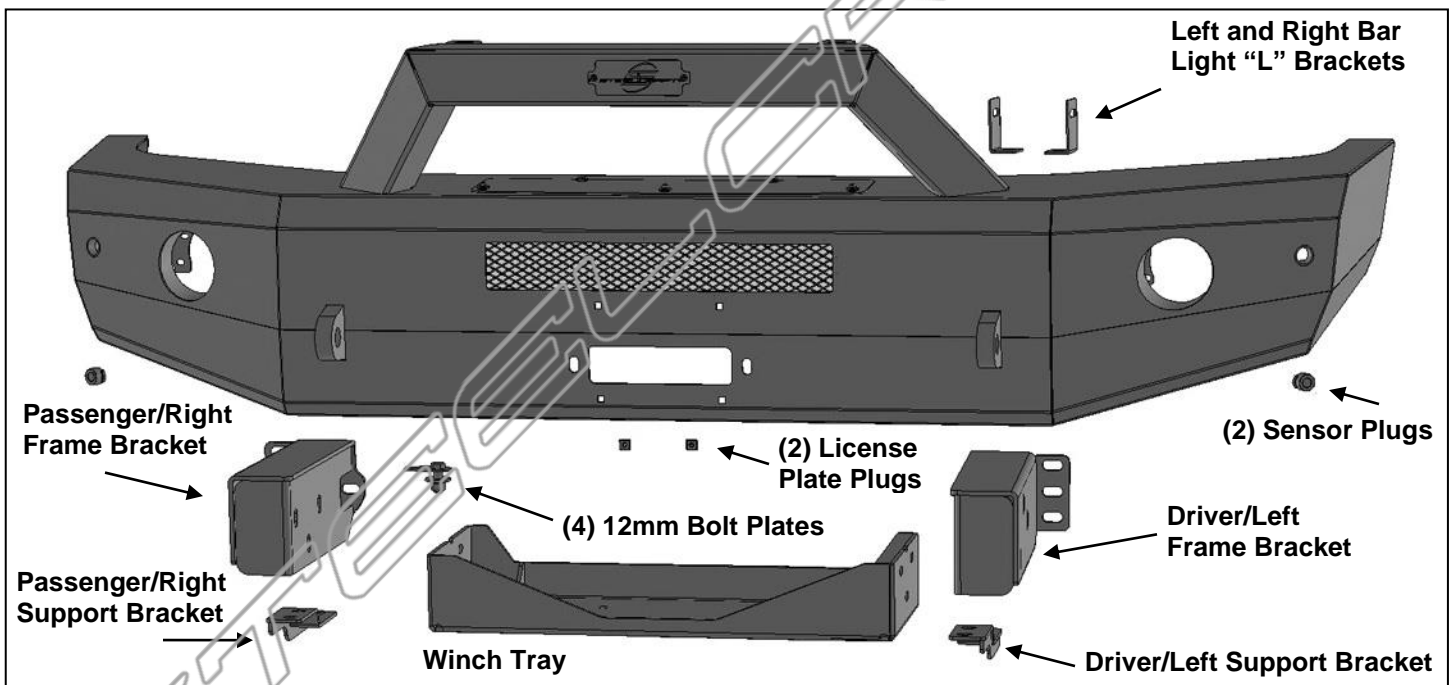


**ELEVATION BULL NOSE FRONT BUMPER
2014-17 TOYOTA TUNDRA**

PARTS LIST:

1	Front Bumper	16	12mm Hex Nuts
1	Winch Tray	8	10mm x 34mm x 3mm Large Flat Washers
1	Driver/left Frame Mounting Bracket	2	8-1.25mm x 16mm Hex Bolts
1	Passenger/right Frame Mounting Bracket	2	8-1.25mm x 25mm Hex Bolts
1	Driver/left Lower Support Bracket	6	8mm x 24mm x 2mm Flat Washers
1	Passenger/right Lower Support Bracket	4	8mm Lock Washer
2	Plastic Plugs for License Plate	2	8mm Hex Nut
2	Rubber Sensor Hole Block Offs	5	6mm Combo Bolts (access cover)
1	"L" Light bracket driver side	1	4mm Wrench
1	"L" Light bracket passenger side	8	6mm x 20mm Hex Bolts
1	Winch Access Cover	16	6mm x 18mm x 1.6mm Flat Washers
4	12mm x 35mm Bolt Plates	8	6mm Nylon Lock Nuts
12	12-1.75mm x 50mm Hex Bolts	4	4mm x 10mm Button Head Screws
28	12mm x 37mm OD x 3mm Flat Washers	1	2.5mm Wrench
16	12mm Lock Washers		



PROCEDURE:

REMOVE CONTENTS FROM BOX. VERIFY ALL PARTS ARE PRESENT. READ INSTRUCTIONS CAREFULLY BEFORE STARTING INSTALLATION. BUMPER IS HEAVY, ASSISTANCE IS HIGHLY RECOMMENDED TO AVOID POSSIBLE INJURY OR DAMAGE TO THE VEHICLE.

INSTALLATION IS NOT COMPATIBLE WITH LASER CONTROLLED CRUISE CONTROL SYSTEMS.

1. Open the hood and remove the plastic cover on top of the radiator and the grille, **(Figure 1)**. Temporarily remove the plastic grille.
2. Move to the driver/left wheel opening. Remove the hardware attaching the plastic cover to the back and bottom of the outer end of the front bumper, **(Figures 2 & 3)**. Next, remove the plastic clip attaching the cover to the side of the frame and remove the cover, **(Figure 4)**.
3. Remove the hardware attaching the plastic body fill panel between the bumper and the headlight and temporarily remove the body panel, **(Figures 2, 5 & 6)**.
4. Repeat **Steps 2 and 3** to remove the plastic covers from the passenger/right side of the vehicle.

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5. On models with factory fog lights, unplug both lights, **(Figure 7)**. On models with bumper mounted sensors, unplug all sensors. Release the wiring harnesses from the clips attached to the back of the bumper and move all wiring harnesses away from the bumper.
6. Remove the license plate and bracket.
7. Remove the hardware attaching the plastic cover on the bottom of the bumper to the bottom of the frame cross member, **(Figure 8)**. Next, remove both tow hooks. **NOTE:** Tow hooks will not be reinstalled.
8. Place blocks or jack stands under the front bumper to support it during mounting bolt removal. Once the bumper has been supported, remove the hex nuts attaching the inner bumper bracket to the end of the frame, **(Figures 9)**. **WARNING!** Assistance is required to hold the bumper in place during hardware removal to prevent the bumper from falling. Remove the bumper assembly, **(Figure 10)**.
9. Next, select driver/left Support Bracket, **(Figure 11)**. Reuse the tow hook hardware to attach the Support Bracket to the bottom of the frame, **(Figures 11 & 12)**. Leave hardware loose at this time. Repeat this Step to attach the passenger/right Support Bracket.
10. Select the driver/left Frame Bracket, **(Figure 13)**. Carefully place the Bracket on top of the Support Bracket and over the (4) studs on the end of the frame. Use the included (4) 10mm Large Flat Washers and reuse (4) factory bumper bracket hex nuts to attach the Bracket to the end of the frame, **(Figures 13—15)**. Snug but do not fully tighten hardware at this time.
11. Insert (2) 12mm Bolt Plates into the end of the Bracket and down through the Support Bracket. Attach the Frame Bracket to the Support Bracket with (2) 12mm Flat Washers, (2) 12mm Lock Washers and (2) 12mm Hex Nuts **(Figures 13—15)**. Snug but do not fully tighten all hardware at this time.
12. Repeat **Steps 9—11** to install the passenger/right Support Bracket and Frame Bracket.
13. **Optional Winch Tray and Winch installation (winch sold separately):**
 - a. Select the Winch Tray. With assistance, slide the Winch Tray between the Frame Brackets. Attach the Winch Tray to the Frame Brackets with (6) 12mm x 50mm Hex Bolts, (12) 12mm Flat Washers and (6) 12mm Nylon Lock Nuts, **(Figures 16 & 17)**. Snug but do not fully tighten all hardware. **IMPORTANT: LED bar style light cannot be installed with Winch Tray. If installation of LED bar style light is desired, do not install the Winch Tray and skip to Step 14.**
 - b. If installing winch, follow manufacturer's instructions to attach the winch to the Winch Tray. Winch must be installed before Bumper is placed in position against Brackets. Attach winch cable guide, (not included), to Bumper assembly. Follow manufacturer's instructions to properly wire the winch to the electrical system.
14. **Optional Center LED light installation (sold separately).** **NOTE:** Light must be installed before Bumper Assembly is attached to the Frame Brackets. **IMPORTANT: Winch Tray cannot be installed with LED bar style light assembly.**
 - a. Select the L/R "L" Brackets, **(Figure 18)**. **NOTE:** "L" Brackets are offset for universal fitment for most LED bar style lights. Attach the LED light assembly to the "L" Brackets with the included (2) 8mm x 16mm Hex Bolts, (2) 8mm Lock Washers and (2) 8mm Flat Washers. Do not fully tighten hardware at this time. **NOTE:** "L" Brackets may require modification for hardware larger than 8mm or use brackets supplied with light if possible.
 - b. Attach the light and Brackets to the top of the (2) tabs on the back of the Bumper with the included 8mm x 25mm Hex Bolts, (4) 8mm Flat Washers, (2) 8mm Lock Washers and (2) 8mm Hex Nuts, **(Figure 18)**. Adjust light position and tighten hardware.
 - c. Follow light manufacturer's instructions to wire the light once Bumper has been fully installed.
15. With assistance, position the Bumper Assembly up to the Frame Brackets. Temporarily support the weight of the Bumper. **WARNING:** To avoid possible injury or damage to the vehicle, do not proceed until the Bumper is fully and safely supported.
16. Line up the driver/left side mounting plate on the inside of the Bumper with the (3) slots in the Frame Bracket. Attach the Bumper to the Bracket with the included (3) 12mm x 50mm Hex Bolts, (6) 12mm Flat Washers, (3) 13mm Lock Washers and (3) 12mm Hex Nuts, **(Figures 19 & 20)**. Do not fully tighten hardware at this time. Repeat this Step to attach the passenger/right side of Bumper.
17. Level and adjust the bumper and fully tighten all 12mm hardware to 65-70ft-lbs. Remove access cover on the top of the Bumper to reach hardware if necessary. **NOTE:** It may be necessary to temporarily remove the outer bumper assembly to shift the inner Winch Tray/Bracket assembly left or right for more

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adjustment. Once properly adjusted, fully tighten the Winch Tray to Frame Bracket hardware first, then Frame Bracket to frame, Support Bracket to Frame Bracket then reinstall the outer Bumper assembly and fully tighten the Bumper mounting hardware.

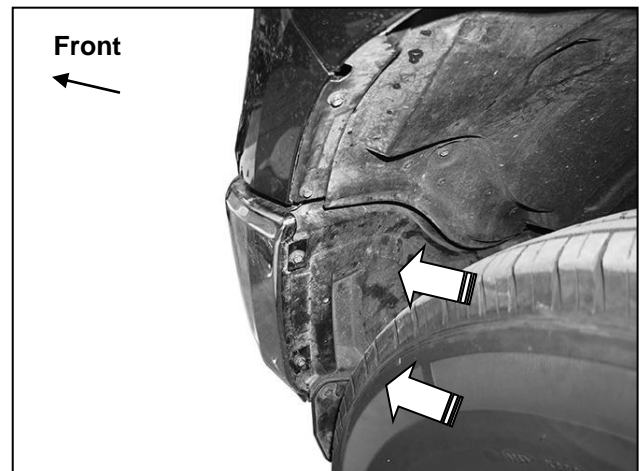
18. Reinstall the plastic fill panels between the bumper and the headlights, **(Figure 5)**. Reinstall the plastic grille and top cover, **(Figure 1)**.
19. **Models without bumper sensors:**
 - a. Select the included (2) Rubber Plugs.
 - b. From behind bumper, push plugs into sensor mounting holes, **(Figure 21)**.**Models with bumper mounted sensors:**
 - a. Push the sensor into the mounting socket in the back of the bumper until flush with outside of bumper if possible.
 - b. Secure each sensor to the socket with (2) 4mm x 10mm Button Head Screws, **(Figure 21)**.
IMPORTANT: Sensors fit snug in sockets. The 4mm Screws are used to apply slight pressure to lock the sensors in place. Tighten both screws evenly until they touch the sensor body only. Do not overtighten screws or damage to sensors will result.
20. **Models with factory fog lights:**
 - a. Remove the driver/left light assembly from the back of the bumper.
 - b. Attach the light assembly to the tabs on the back of the Bumper with (4) 6mm x 16mm Hex Bolts, (8) 6mm Flat Washers and (4) 6mm Nylon Lock Nuts. **IMPORTANT:** to avoid damage to the plastic tabs on the fog light, do not overtighten the hex bolts, **(Figure 22)**. **NOTE:** Mounting tabs may shift during shipping, adjust location of mounting tabs to line up properly with light assembly.
 - c. Repeat to install the passenger/right fog light.
 - d. Reattach the wiring harness. Adjust lights as necessary and tighten all fog light bracket hardware.
21. Use the included (2) push-in plastic nuts to attach the front license plate, (if required), to the (2) holes in the front bumper, **(Figure 23)**.
22. Do periodic inspections to the installation to make sure that all hardware is secure and tight.

To protect your investment, wax this product after installing. Regular waxing is recommended to add a protective layer over the finish. Do not use any type of polish or wax that may contain abrasives that could damage the finish. Mild soap may be used to clean the HD Front Bumper assembly.

Driver/left Side Installation Pictured



(Fig 1) Remove plastic cover and grille



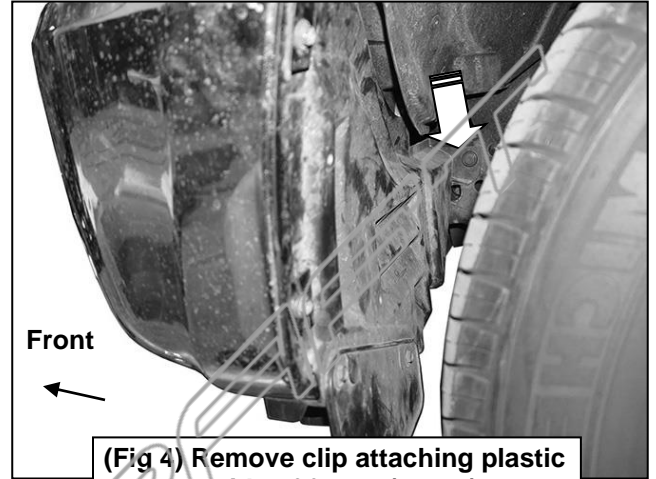
(Fig 2) Remove hardware attaching plastic cover to back of bumper (arrows).

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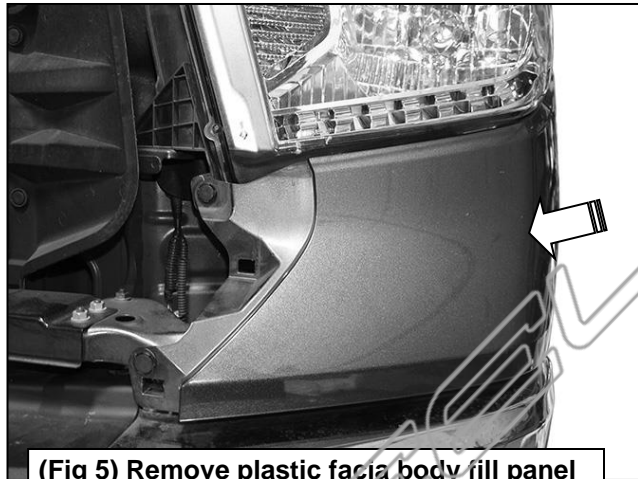
Driver/left Side Installation Pictured



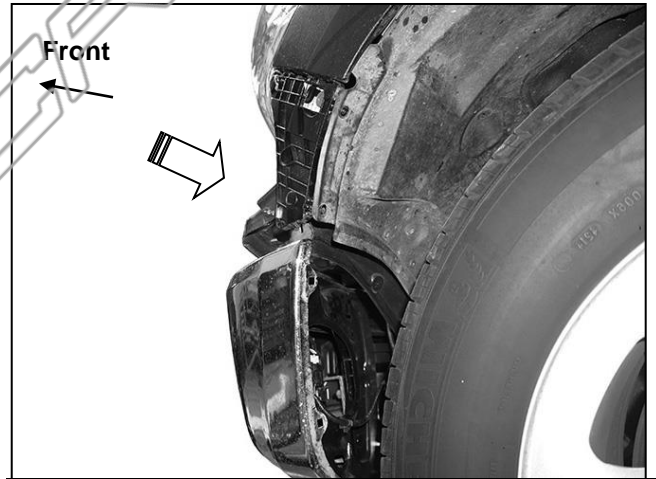
(Fig 3) Remove hardware attaching plastic cover to bottom of bumper (arrows)



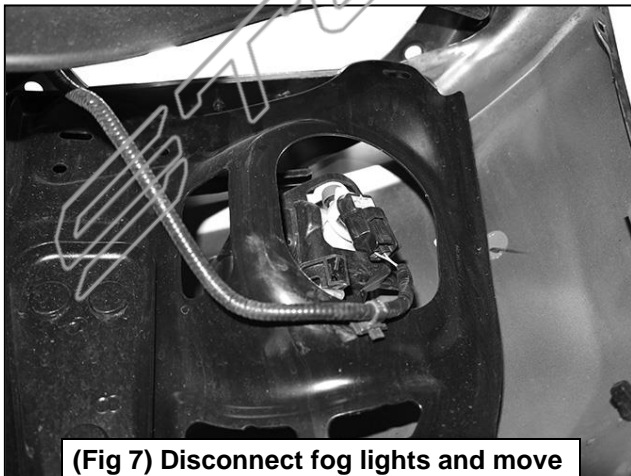
(Fig 4) Remove clip attaching plastic cover to side of frame (arrow)



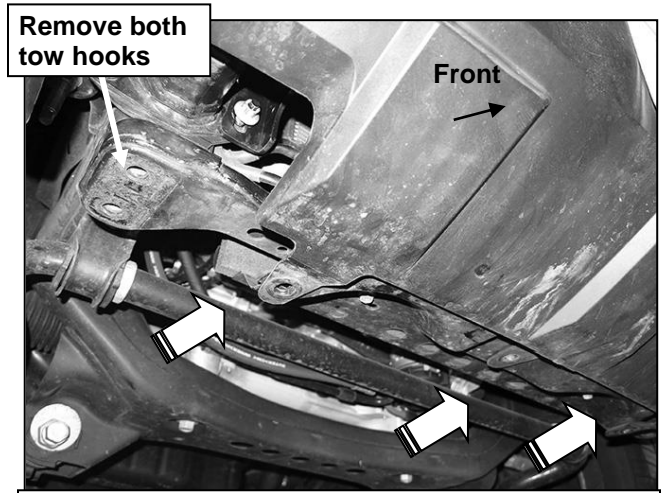
(Fig 5) Remove plastic fascia body fill panel between headlight and bumper (arrow)



(Fig 6) Plastic cover and fascia body panel removed

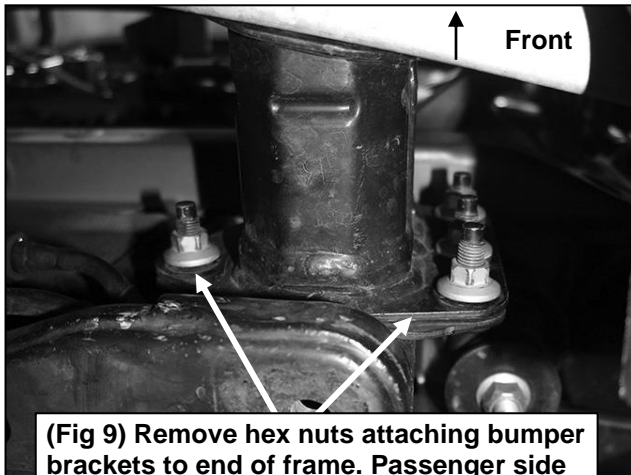


(Fig 7) Disconnect fog lights and move wiring harness away from bumper



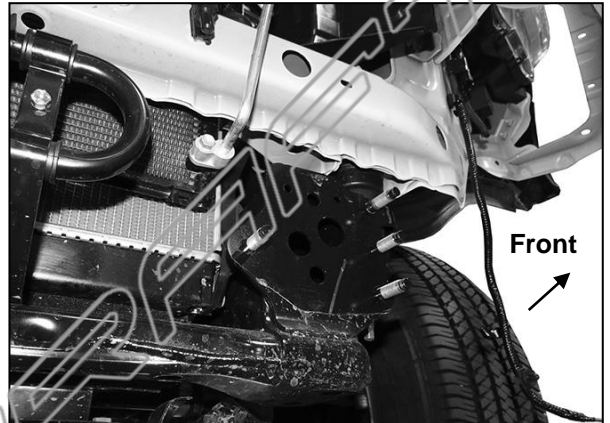
(Fig 8) Remove hardware attaching plastic cover on bottom of bumper to cross member (arrows)

Driver/left Side Installation Pictured

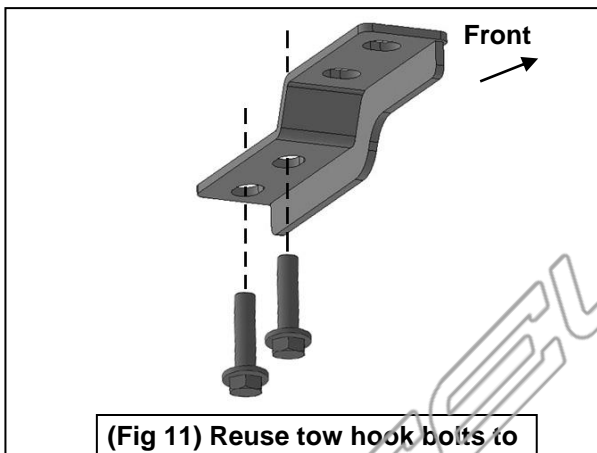


(Fig 9) Remove hex nuts attaching bumper brackets to end of frame. Passenger side bumper bracket pictured from below

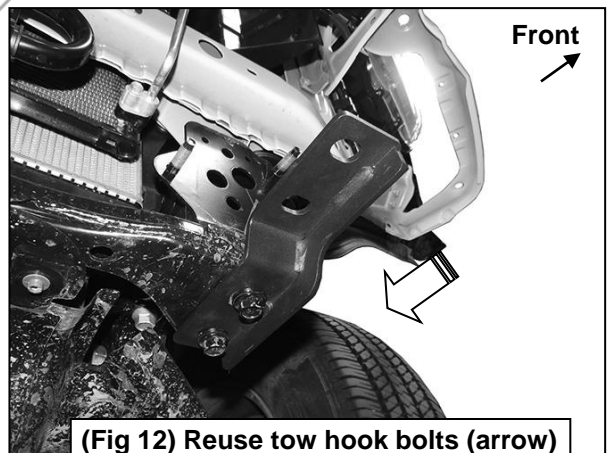
WARNING! Do not remove bumper bolts unless the bumper is properly supported on blocks or stands or the bumper may fall.



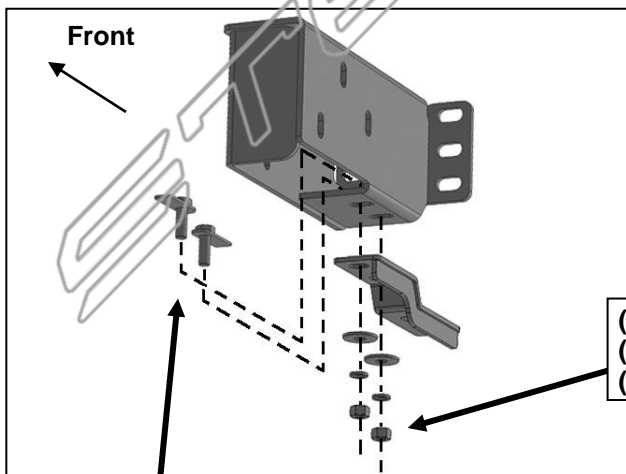
(Fig 10) Bumper removed, driver/left pictured



(Fig 11) Reuse tow hook bolts to attach passenger/right Support Bracket to bottom of frame



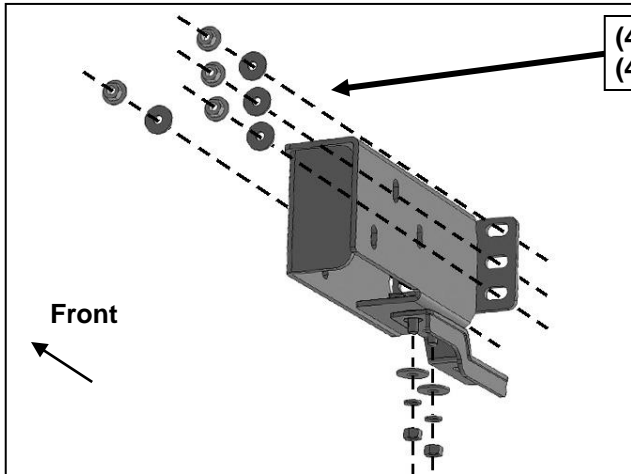
(Fig 12) Reuse tow hook bolts (arrow) to attach passenger/right Support Bracket to bottom of frame



- (2) 12mm Flat Washers
- (2) 12mm Lock Washers
- (2) 12mm Hex Nuts

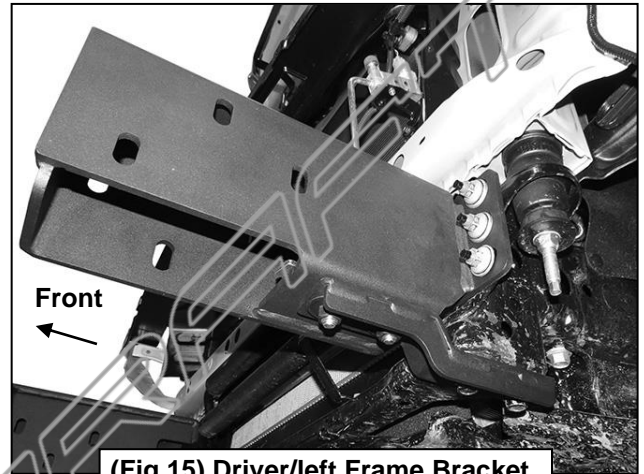
(Fig 13) Insert (2) Bolt Plates into Frame Bracket and down through Support Bracket

Driver/left Side Installation Pictured

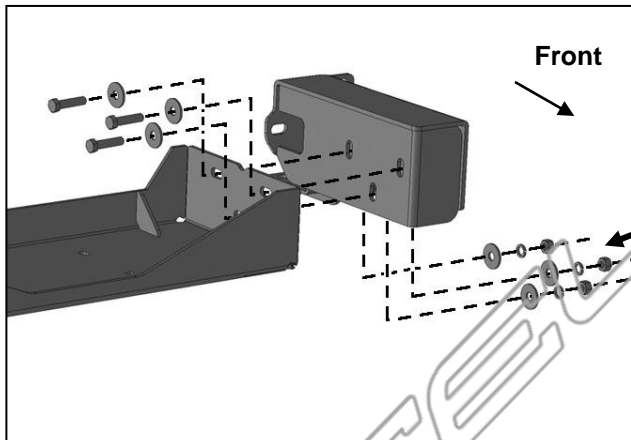


- (4) 10mm Large Flat Washers
- (4) Factory Hex Nuts

(Fig 14) Reuse factory hex nuts to attach Frame Bracket to end of frame

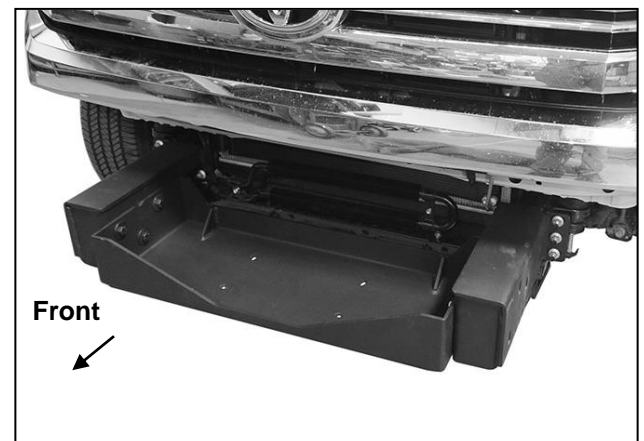


(Fig 15) Driver/left Frame Bracket and Support Bracket installed

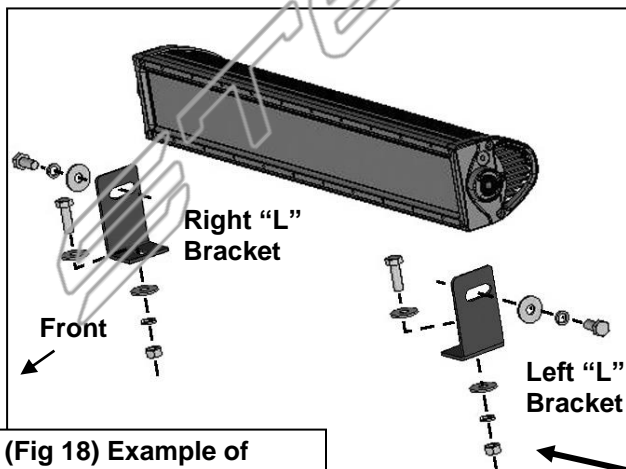


- (3) 12mm x 50mm Hex Bolts
- (6) 12mm Flat Washers
- (3) 12mm Lock Washers
- (3) 12mm Hex Nuts

(Fig 16) Attach Winch Tray to Frame Brackets



(Fig 17) Attach Winch Tray to Frame Brackets



- (2) 8mm x 16mm Hex Bolts
- (2) 8mm Lock Washers
- (2) 8mm Flat Washers

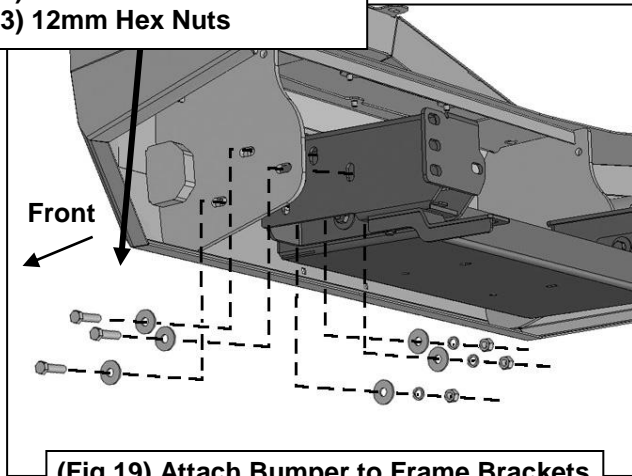
(Fig 18) Example of center light installation

- (2) 8mm x 25mm Hex Bolts
- (4) 8mm Flat Washers
- (2) 8mm Lock Washers
- (2) 8mm Hex Nuts

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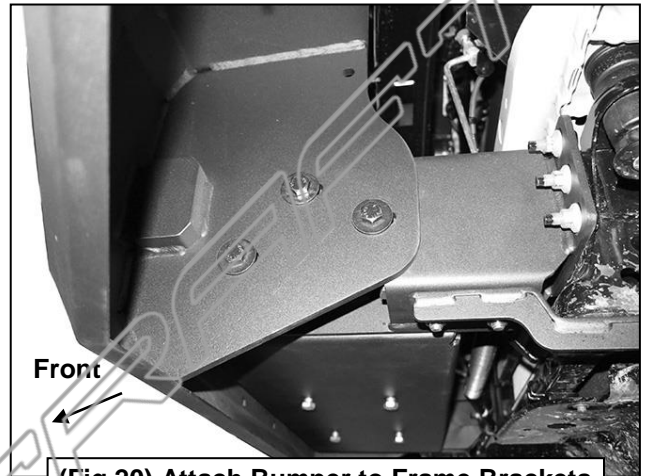
Driver/left Side Installation Pictured

- (3) 12mm x 50mm Hex Bolts
- (6) 12mm Flat Washers
- (3) 12mm Lock Washers
- (3) 12mm Hex Nuts

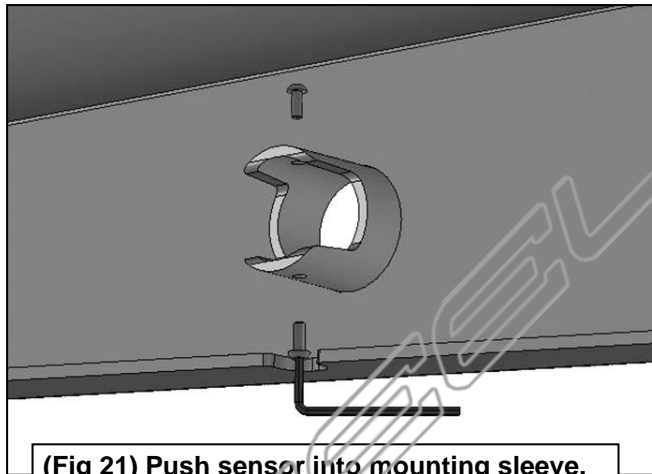


(Fig 19) Attach Bumper to Frame Brackets

WARNING! Do not crawl under bumper unless the bumper is properly supported on blocks or stands or the bumper may fall.



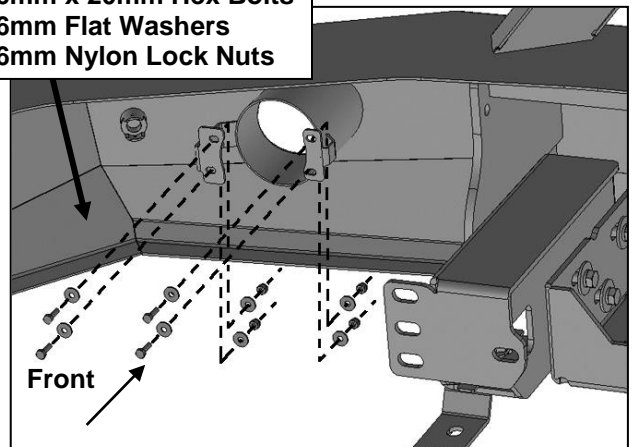
(Fig 20) Attach Bumper to Frame Brackets



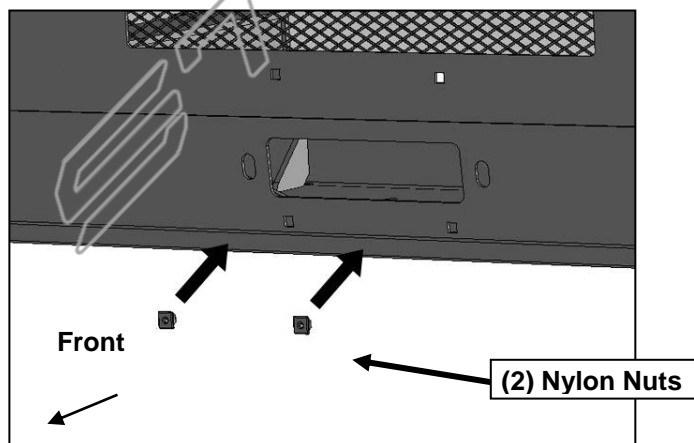
(Fig 21) Push sensor into mounting sleeve. Use 4mm Screws to lock sensor in place.

IMPORTANT: Sensors fit snug in sockets. The 4mm Screws are only used to apply slight pressure to lock the sensors in place. Tighten both screws evenly until they touch the sensor body only. Do not overtighten screws or damage to sensors will result.

- (4) 6mm x 20mm Hex Bolts
- (8) 6mm Flat Washers
- (4) 6mm Nylon Lock Nuts



(Fig 22) Attach factory fog light (if equipped) to mounting tabs on back of Bumper



- (2) Nylon Nuts

(Fig 23) Attach License Plate Bracket to Bumper