



INSTALLATION INSTRUCTIONS

ELITE FRONT BUMPER KIT

Part Number: 111169

Application: 2024 Toyota Tacoma

GENERAL SAFETY PRECAUTIONS

Your safety, and the safety of others, is very important. To help you make informed decisions about safety, we have provided installation and operating instructions and other information on labels and in this guide. This information alerts you to potential hazards that could hurt you or others. It is not possible to warn you about all potential hazards associated with this product, you must use your own good judgment.

CARELESS INSTALLATION AND OPERATION CAN RESULT IN SERIOUS INJURY OR EQUIPMENT DAMAGE. READ AND UNDERSTAND ALL SAFETY PRECAUTIONS AND OPERATING INSTRUCTIONS BEFORE INSTALLING AND OPERATING THIS PRODUCT.

This guide identifies potential hazards and has important safety messages that help you and others avoid personal injury or death. WARNING and CAUTION are signal words that identify the level of hazard. These signal words mean:

▲ **WARNING** signals a hazard that could cause serious injury or death, if you do not follow recommendations. ▲ **CAUTION** signals a hazard that may cause minor to moderate injury, if you do not follow recommendations.

This guide uses **NOTICE** to call attention to important mechanical information, and Note: to emphasize general information worthy of special attention.

▲ WARNING

IMPACT AND MOVING PARTS ENTANGLEMENT HAZARD

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

- **Always** Know Your Winch. Take time to fully read the Instructions and/or Operations Guide, and/or Basic Guide to Winching Techniques, in order to understand your winch and its operations.
- **Never** work under vehicle before properly securing vehicle.
- **Always** use appropriate and adequate care in lifting components into place.
- **Never** use a jack to support the vehicle.
- **Always** use jack stands in pairs to support the vehicle.
- **Always** use jacks or jack stands only on a hard, stable, and level surface.
- **Never** exceed the rated capacity of a jack or jack stands.
- **Always** verify that the parking brake is set, the transmission is in park (automatic) or reverse (manual) and the rear wheels are blocked before working on vehicle.
- **Never** work under vehicle before properly securing vehicle.
- **Always** use appropriate and adequate care in lifting components into place.
- **Always** insure components will remain secure during installation and operation.
- **Always** tighten all nuts and bolts securely, per the installation and operation.
- **Always** perform regular inspections and maintenance on the winch, winch mount and related hardware.
- **Always** replace all worn or damaged parts before operating.
- **Never** operate this WARN product with damaged or missing parts.
- **Always** use extreme caution when drilling on any vehicle. Make sure that all fuel lines, brake lines, electrical wires, and other objects are not punctured or damaged when / if drilling on the vehicle. Thoroughly inspect the area to be drilled (on both sides of material) prior to drilling, and relocate any objects that may be damaged. Failure to inspect the area to be drilled may result in vehicle damage, electrical shock, fire or personal injury.
- **Always** use extreme caution when cutting and trimming during fitting.
- **Always** wear safety glasses when installing this kit. A drilling operation will cause flying metal chips. Flying chips can cause eye injury.
- **Always** remove jewelry and wear eye protection.
- **Never** lean over battery while making connections.
- **Never** route electrical cables across any sharp edge, through or near moving parts, near parts that become hot.

Read installation and operating instructions thoroughly.

WARN INDUSTRIES, INC. 12900 S.E. Capps Road,
Clackamas, OR USA 97015-8903, 1-503-722-1200, FAX: 1-503-722-3000
Customer Service: 1-800-543-9276
Dealer Locator Service: 1-800-910-1122
International Sales/Customer Service: 1-503-722-3008
International Fax: 1-503-722-3005

⚠ CAUTION

MOVING PARTS ENTANGLEMENT HAZARD

Failure to observe these instructions could lead to minor or moderate injury

- Part edges may be sharp!
- **Always** use proper posture / lifting technique or get lifting assistance while handling and installing product.

Read installation and operating instructions thoroughly.

NOTICE

EQUIPMENT DAMAGE

- **Never** tow vehicle by attaching a tow bar to the eyelets on the bumper.
- Do not attach tow bars directly to the bumper. Damage to bumper may occur. WARN bumpers are not designed to be used for flat towing. Consult with the manufacturer of your tow bar system for the proper vehicle tow bar brackets.

Read installation and operating instructions thoroughly.

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BEFORE YOU BEGIN



This product may interfere with driver assist systems such as adaptive cruise control and parking assist systems that have sensors or cameras installed in the bumpers or front grill area. If your vehicle is equipped with any of these systems or features, consult your vehicle owner's manual before installing this product. These systems may need to be disabled as a result of installing this product.

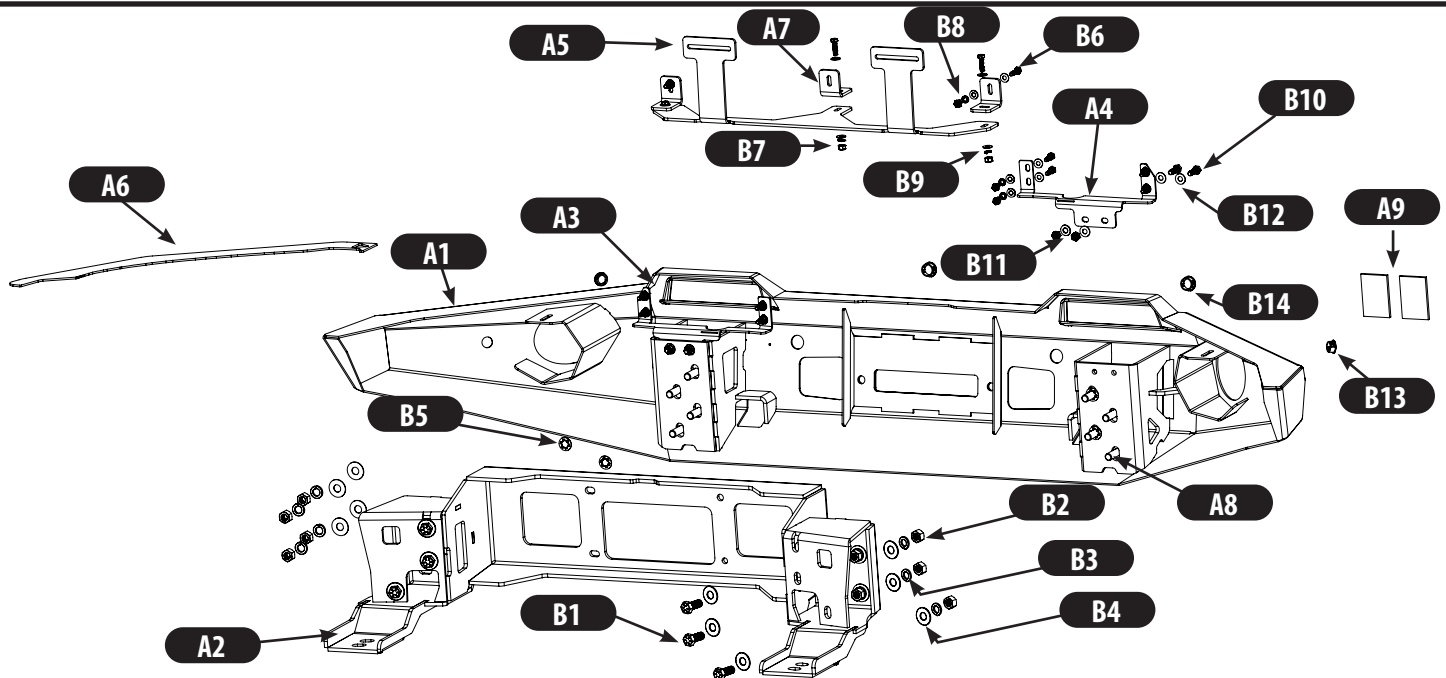
TOOLS REQUIRED

- Body Pry Tool
- Phillips head screwdriver
- Flathead screwdriver
- Metric socket and wrench set
- Standard socket and wrench set
- Socket extension
- Cutting tool

PARTS LIST

50495-HW KIT

ITEM	QTY	NAME	PN	ITEM	QTY	NAME
A1	1	ELITE FRONT BUMPER	23335-W	B1	6	1/2"-13 X 1.25" BOLT
A2	1	WINCH TRAY	23336-W	B2	14	1/2"-13 HEX NUT
A3	1	DS FOG LIGHT BRACKET	23337-01	B3	14	1/2" LOCK WASHER
A4	1	PS FOG LIGHT BRACKET	23338-01	B4	20	1/2" FLAT WASHER
A5	1	GRILL SUPPORT BRACKET	23300-01	B5	4	1/2" BOLT RETAINER
A6	1	CUT TEMPLATE BRACKET	23304-01	B6	13	1/4"-20 X 1.00" BOLT
A7	3	GRILL SUPPORT TAB	23305-01	B7	13	1/4"-20 LOCK NUT
A8	4	BOLT STRIP	20296-W	B8	13	1/4" LOCK WASHER
A9	2	EPOXY	61632	B9	26	1/4" FLAT WASHER
				B10	4	5/16"-18 X 1.00" BOLT
				B11	4	5/16"-18 HEX NUT
				B12	8	5/16" FLAT WASHER
				B13	2	3/4" ID PLASTIC PLUG
				B14	2	7/8" ID PLASTIC PLUG



TORQUE SPECIFICATIONS

Please use the recommended torque specifications when assembling this product unless otherwise specified in the instructions.

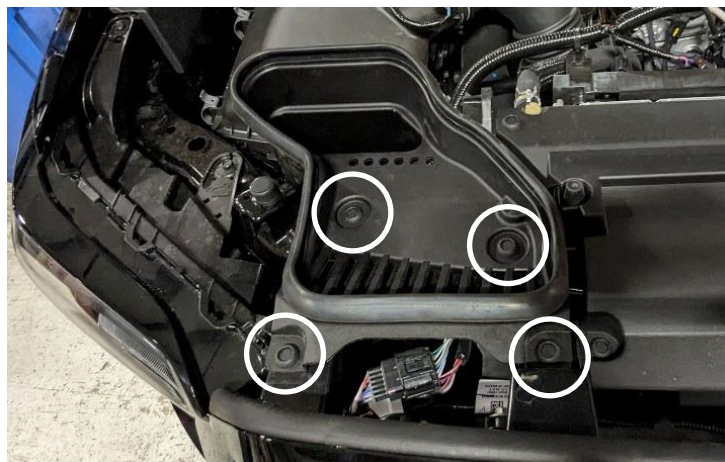
FASTENER SIZE	FASTENER TORQUE		FASTENER SIZE	FASTENER TORQUE	
	lb-ft	(N.m)		lb-ft	(N.m)
1/4"	8	(11)	M4	(2)	3
5/16"	17	(23)	M5	(4.5)	6
3/8"	30	(40)	M6	(7.5)	10
7/16"	48	(66)	M8	(18)	25
1/2"	74	(100)	M10	(37)	50
9/16"	106	(144)			
5/8"	148	(200)			
3/4"	269	(364)			

INSTALLATION INSTRUCTIONS

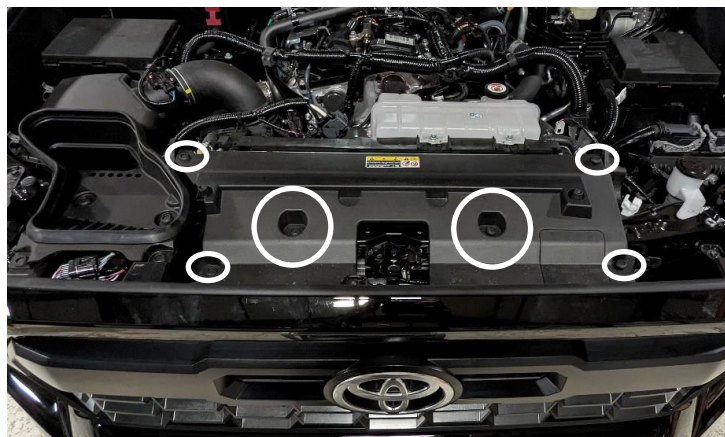
DISASSEMBLY

NOTICE *This application requires extensive cutting on the vehicle. PROFESSIONAL INSTALLATION IS HIGHLY RECOMMENDED.*

1. Remove the four push pins in the air intake scoop by pressing the center of each pin to pop up and use a pry tool to remove completely. Set air intake scoop and pins aside for later.



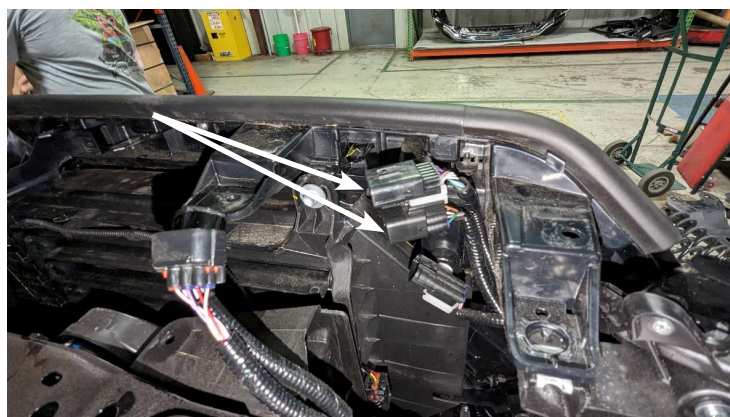
2. In the same manner as above, remove the six push pins from the plastic shroud. Set shroud and pins aside for later.



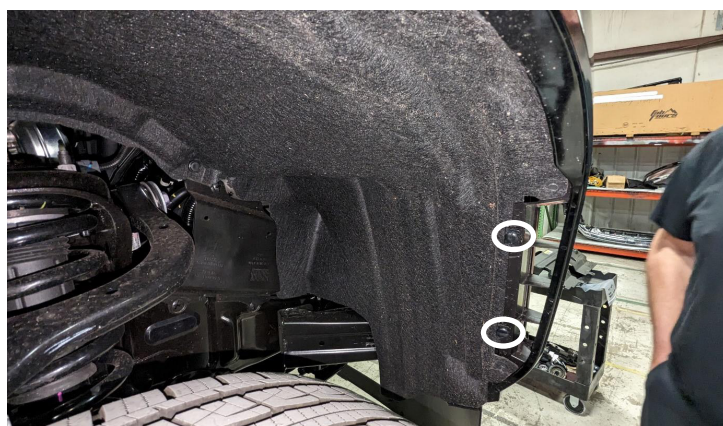
3. Using a ratchet and 10-mm socket, remove the three screws along the top of the grill. Place screws safely aside.



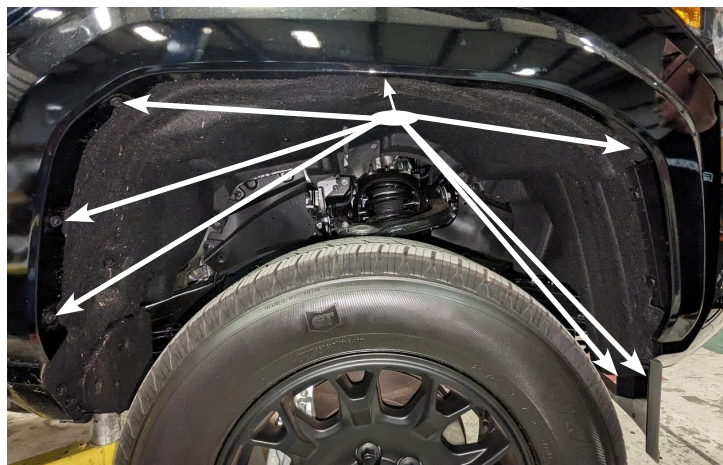
4. Disconnect the two electrical connectors located along the top of the grill on the front driver side.



5. Using a flathead screwdriver, remove the two plastic pins holding the fender liner to the fender guard trim. *TIP: Rotate the pin until you feel them click. This will "unlock" it and allow you to pull the pin out. Carefully set pins aside.*

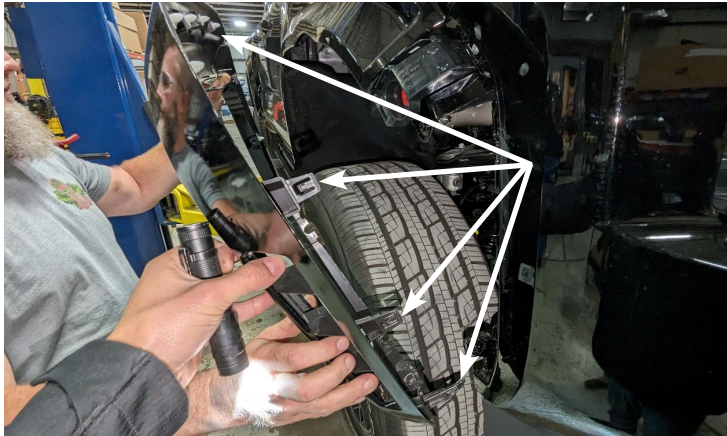


6. Remove the seven screws holding the fender flares to the fender liner using a ratchet and 10mm socket. Carefully place hardware aside as they will be reinstalled later.



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7. Pull back on the liner and then carefully release the three clips at the front of the fender flares.
8. Pull outward and away from the vehicle to release the rest of the clips and carefully set aside.



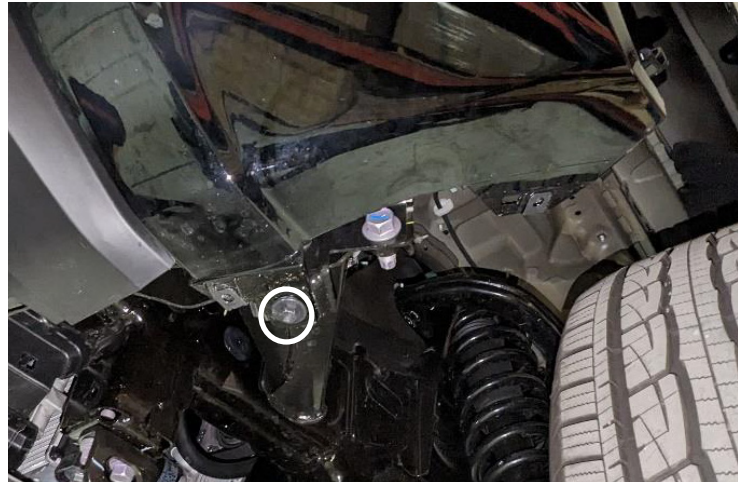
9. Remove the small screw on the side of the front bumper using a Phillips head screwdriver. Carefully set aside.
10. Repeat the steps to remove the fender flare and small bumper screw on the other side of the vehicle.



11. Using a ratchet and 10-mm socket, remove the five screws from the air dam. Dam and screws will not be reused.



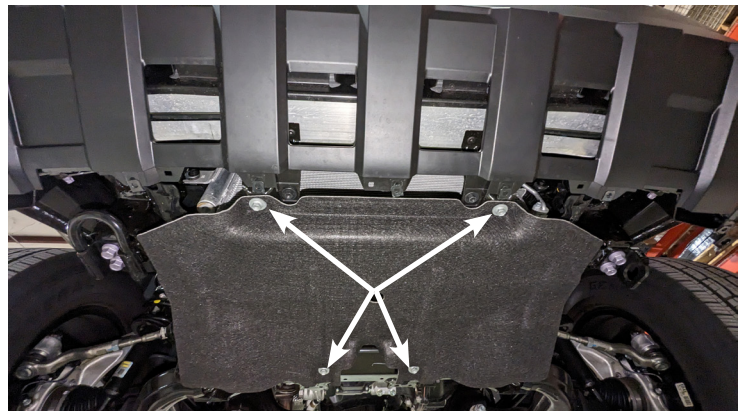
12. Remove the screw (each side) from the bottom corner tab of the bumper. These will not be reused.



13. Using a ratchet and 17mm socket, remove the two tow hooks from the bottom of the frame rails. Place hardware aside, it will be reused, the tow hooks will not.

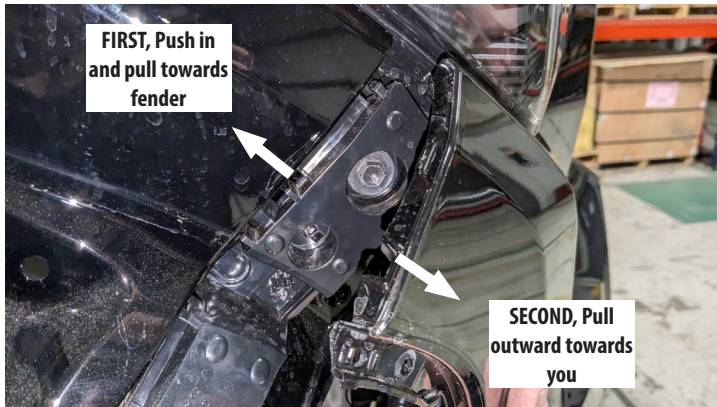


14. Remove the skid plate by removing the four screws. Place hardware and skid plate safely aside as they will be reinstalled later.

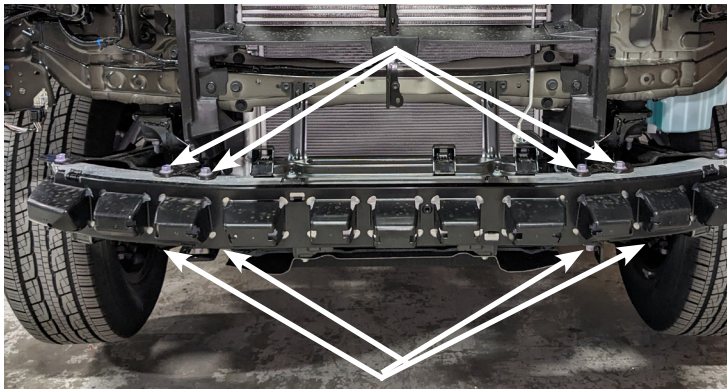


INSTALLATION INSTRUCTIONS

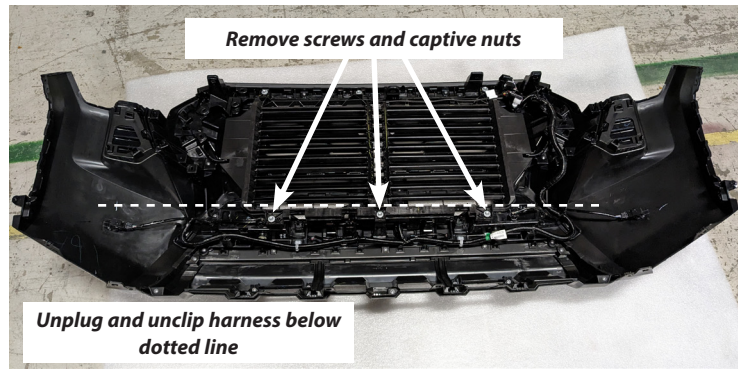
15. Carefully push in and then pull the top corner of the bumper up towards the fender and then outward to release the clips. *TIP: You need to go down and around the hook like clip holding this corner in place.* Repeat for other side.



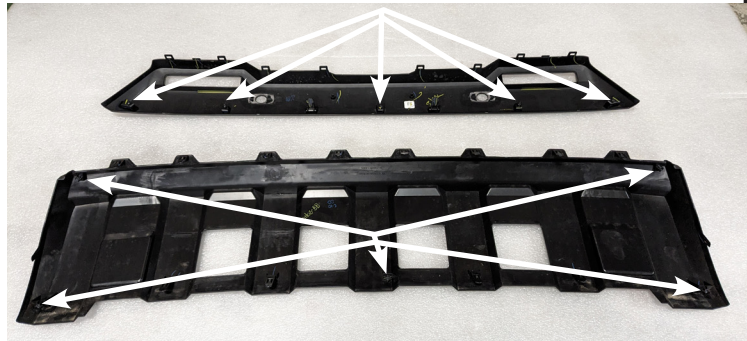
16. Slowly work your way across the front bumper and grill, pulling outward to release the rest of the clips to completely free the front bumper and grill assembly. Once removed, place fascia aside on a clean flat surface.
17. With the front fascia fully removed, use a ratchet and 17mm socket to remove the eight bolts attaching the crash bar to the frame (each side). The crash bar and hardware will not be reused and can be discarded.



18. Flip the front fascia over and remove the three lower screws and captive nuts attaching the louvers to the front fascia. **Save hardware to be reused later.**
19. If equipped, unplug the parking sensors and fog lights.
20. Unclip the harness from the lower portion of the front fascia. **NOTE: The Toyota Safety System (TSS) or the temperature sensor do not need to be unplugged. The harness above the TSS does not need to be unclipped.**



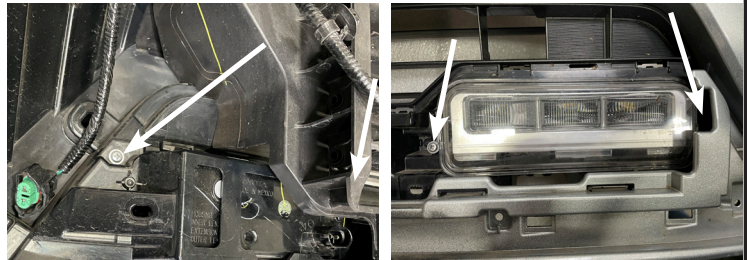
21. Remove the ten screws holding the upper and lower bumper valance to the front fascia.
22. Carefully use a screwdriver to press the various clips to release both pieces. These will not be reused and can be discarded.



23. If equipped, remove the parking sensor housings from the upper valance and front fascia corners by carefully applying heat to soften the adhesive and then using a razor blade, carefully lift and peel the housing away. **NOTE: Mark the orientation and location of EACH parking sensor housing as they will must be reinstalled in the exact same way.**



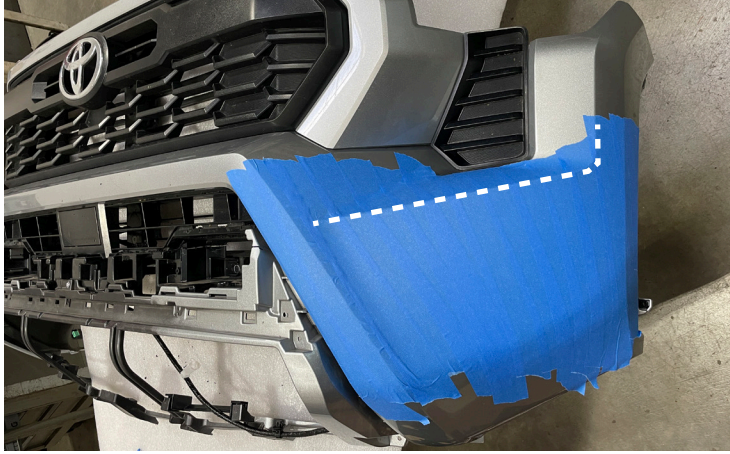
24. If equipped, remove the fog lights from both sides of the front fascia by removing the three screws. Place the fog lights and hardware safely aside as they will be reused later.



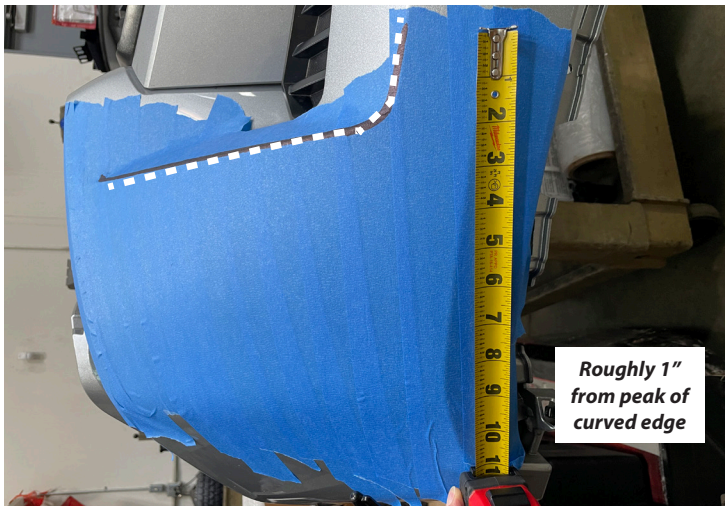
INSTALLATION INSTRUCTIONS

CUTTING FRONT FASCIA

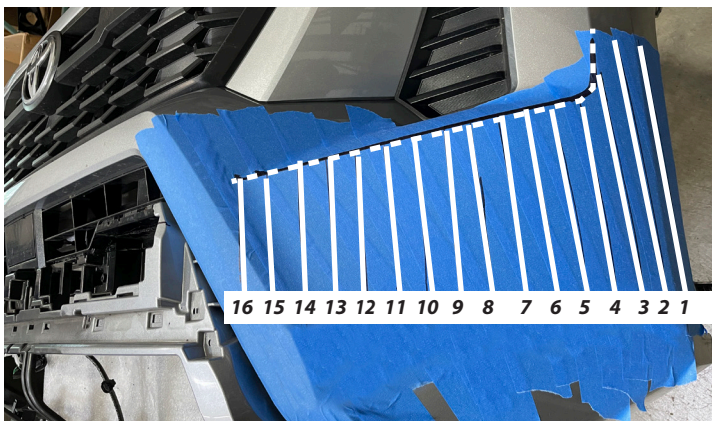
1. Apply masking tape to the front lower corner portions of the front bumper, each side.
2. Using a marker, trace the curve of the bumper that is under the side black accent piece. See *dotted line*.



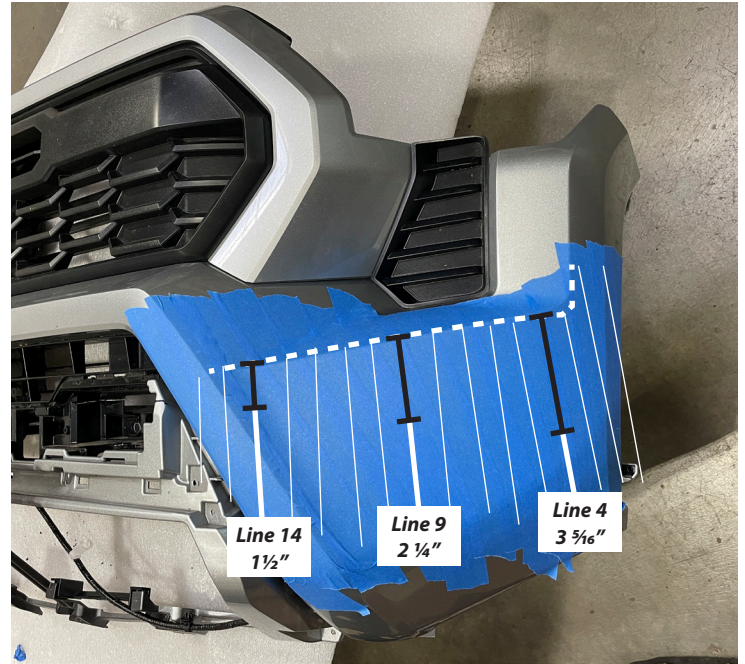
3. Using a 1" ruler or straight edge and marker, draw a line straight down the body just in front of where the fender flare sits.



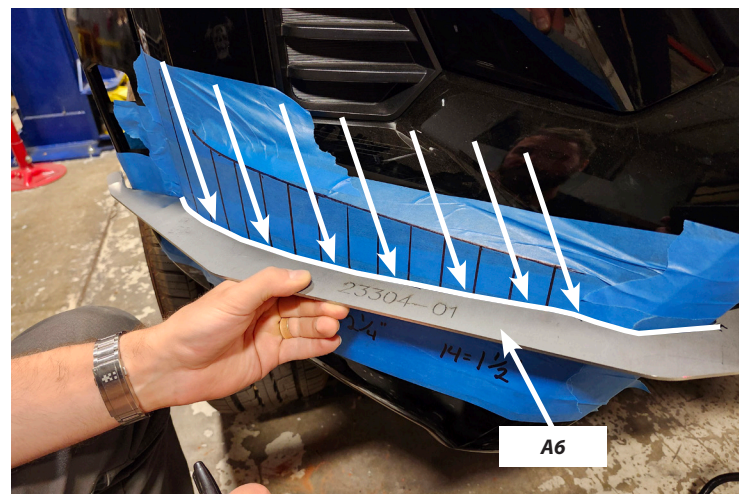
4. Continue creating straight parallel lines that are 1" apart down the bumper, and then number the lines 1 through 16 with 1 starting closest to the fender flare.



5. Highlight lines 4, 9, and 14.
6. Measure from the traced curve of the bumper downward and make a mark on the corresponding line.
 - Line 4: 3-5/16"
 - Line 9: 2-1/4"
 - Line 14: 1-1/2"



7. Locate the cut template bracket (A6) included in your kit and place it over the bumper.
8. Line up bracket with the three marks measured in the previous step.
9. Use a marker to trace a straight cut line across the bumper.
10. Repeat these steps on the opposite side of the bumper.

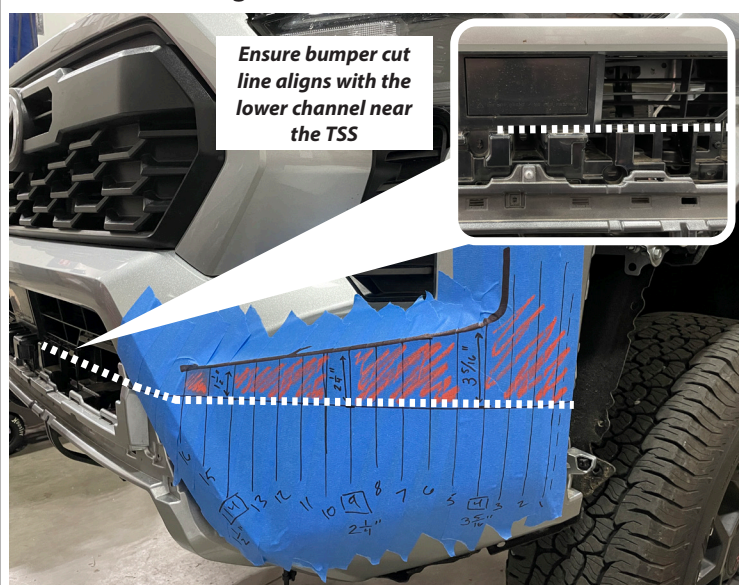


INSTALLATION INSTRUCTIONS

NOTICE The next steps require extensive cutting on the vehicle. **PROFESSIONAL INSTALLATION IS HIGHLY RECOMMENDED.** Proceed at your own risk.

NOTICE The next steps will require appropriate cutting tools and will be destructive to your front bumper. You will not be able to go back to stock without purchasing a new OE front bumper.

11. Ensure your cut line aligns with the plastic channel and is below the TSS using a straight edge.
12. Double check that your three measurements of lines 4, 9 and 14 are correct.
13. Do not damage or scratch the TSS front cover.



⚠ WARNING Always use extreme caution when cutting and trimming during fitting. Make sure that all fuel lines, brake lines, electrical wires, and other objects are not punctured or damaged when / if cutting on the vehicle. Thoroughly inspect the area to be cut (on both sides of material) prior to cutting. Failure to inspect the area to be cut may result in vehicle damage, electrical shock, fire or personal injury.

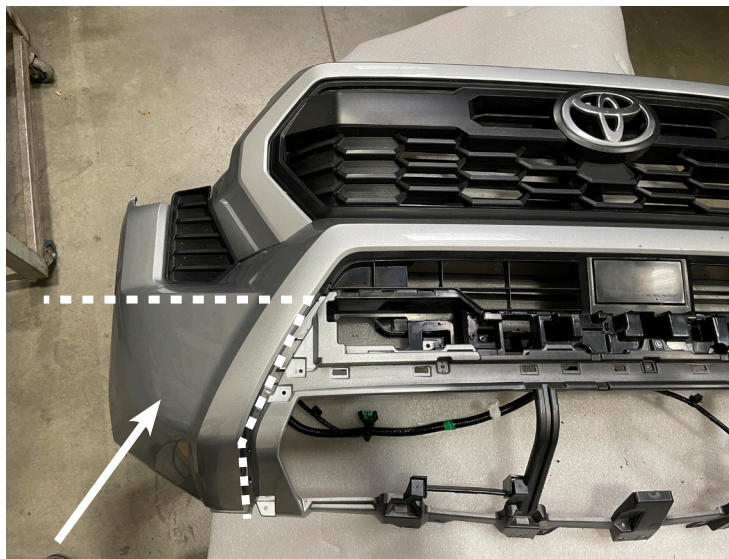
14. Temporarily reinstall the front fascia back onto by pushing the clips in place. This will help keep the plastic rigid while you cut.

BEFORE YOU CUT: It is recommended to draw another line approximately 1/4" below the main cut line. Use a sanding tool to clean and create a nice straight edge. An edge trim seal strip (not included in kit) can also be used on the cut to hide any imperfections.

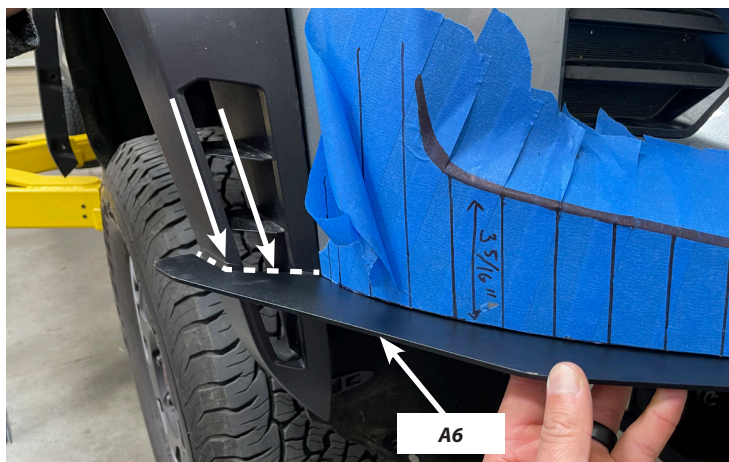
15. Using a cutting tool, carefully and slowly follow your cut line towards the center of the vehicle. Ensure all wires and cables are out of the way

and you are only cutting through the bumper. **Only cut the outer portion of the bumper at this time.**

Do not cut into the center section until reading the next steps. We recommend to cut in sections. Repeat for other side.

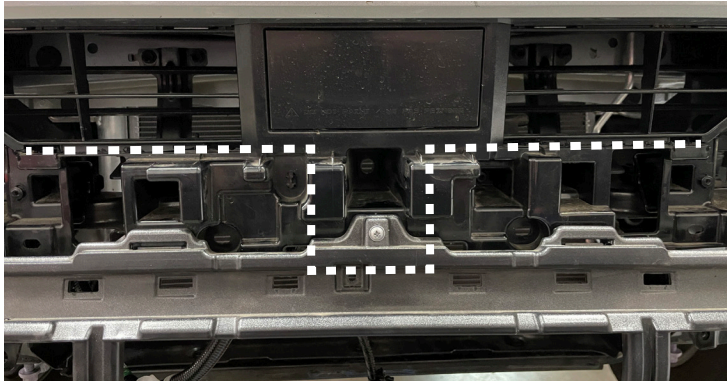


16. Temporarily fasten the fender flare in place. Do not fully reinstall.
17. Locate your cut template bracket (A6), and line up the bracket against the bottom of your cut you made.
18. Mark a line across the fender flare.
19. Remove the fender flare and place on a flat surface. Using your cutting tool, cut through the fender flare at mark.
20. Repeat on opposite side of vehicle.

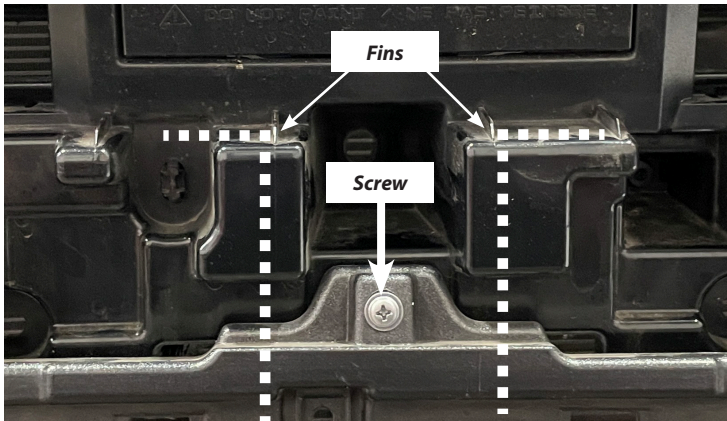


INSTALLATION INSTRUCTIONS

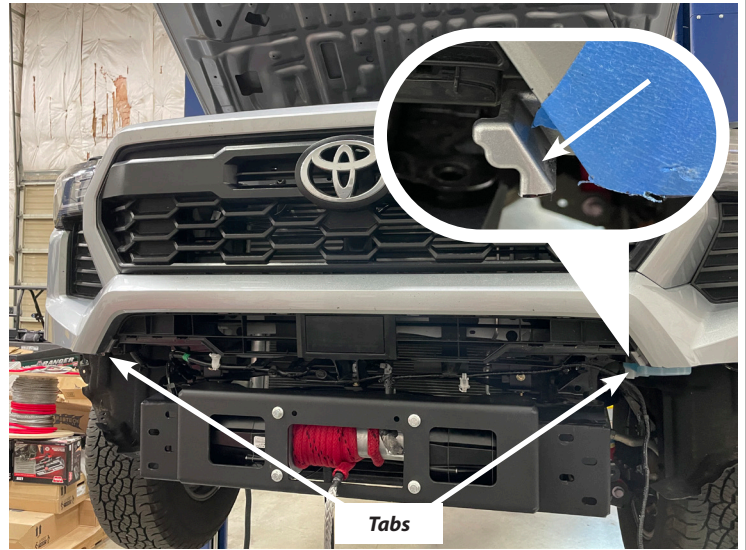
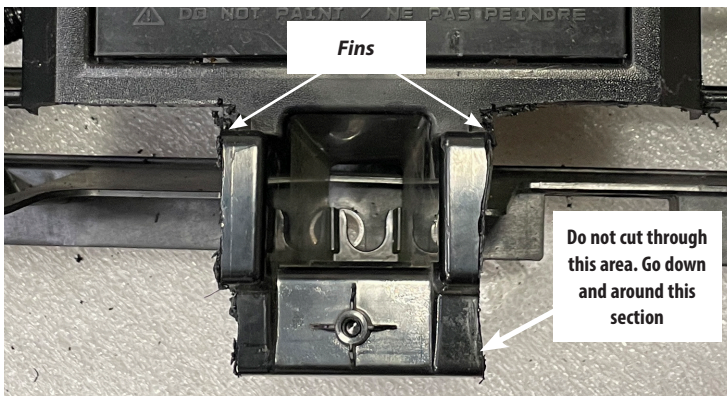
21. Remove the front fascia again. Lay on a flat surface.
22. Carefully cut inside the bottom of the small lower channel to the left and right of the TSS. **DO NOT cut the center most part of the grill. You will need the center portion to mount the center of the grill to a bracket.**
23. Create a straight line cut that meets with the cut created on the corner portions of the bumper. **NOTE: Ensure the harness behind the front fascia is out of the way.**



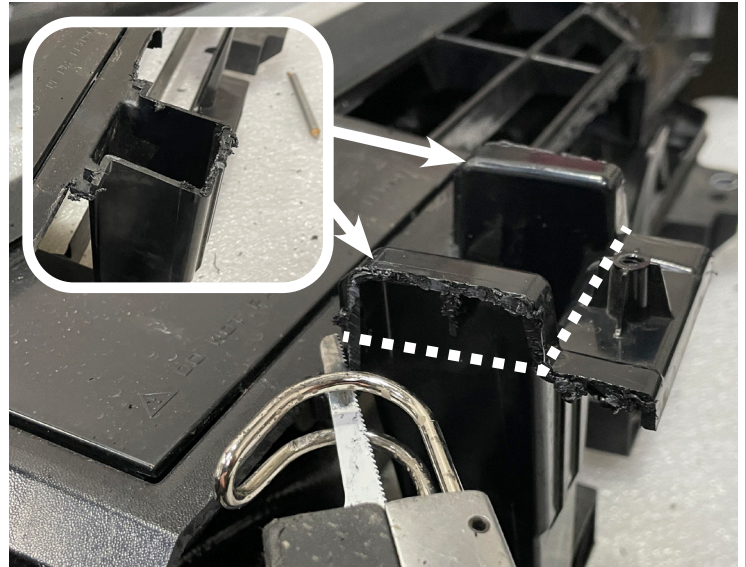
24. There are two plastic fins just before the center opening that can be used as the stopping point for the straight line cut across the bumper.
25. From the outside of the fins, cut downward.
26. Remove the set screw.



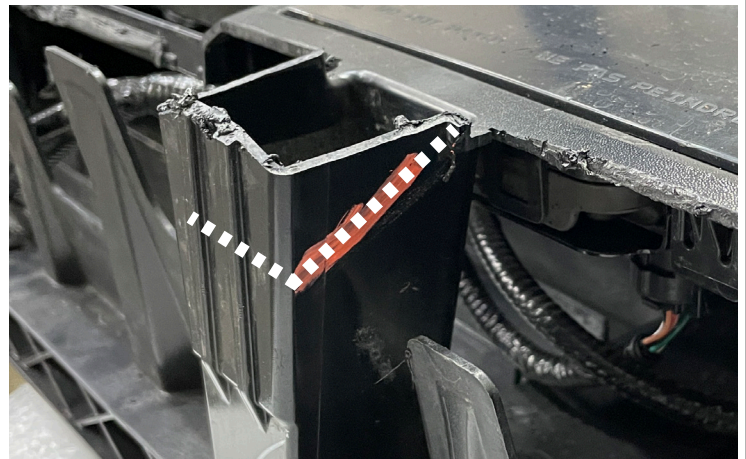
27. Use the cutting tool to cut off the plastic tabs that were in front of the fog lights. Cut them flush to the inner face. **Do not cut through lower mounting tab.**



28. Cut the front of the center plastic portion flat and remove the lower bottom plastic tab.



29. Use a marker to create a 45-degree line. Start near the TSS and then go back towards the louvers.



30. Carefully cut through the line, ensuring you do not cut off the center plastic portion of the grill.

INSTALLATION INSTRUCTIONS



WARN ELITE BUMPER INSTALL

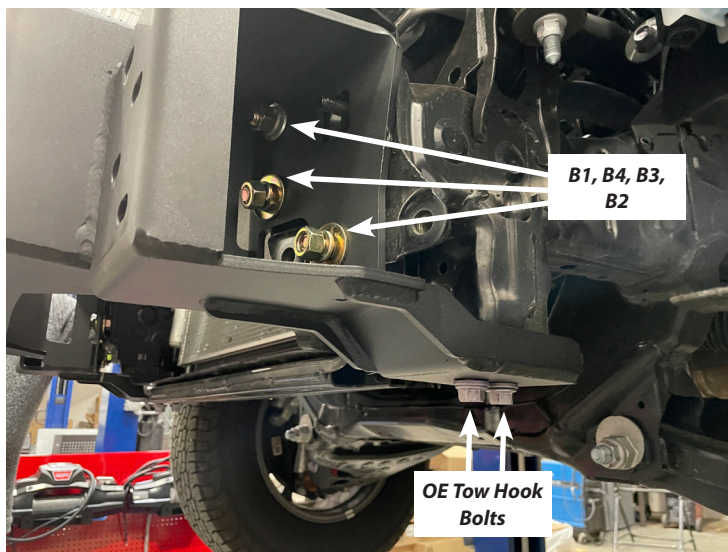
1. With the front fascia off and using a ratchet and 10-mm socket, remove the four screws securing the center mounting bracket.



2. Install the grill support bracket (A5) using the OE hardware removed in step above. Do not fully tighten bolts.



3. Gather the winch tray (A2), the 1/2" bolts (B1), washers (B4), lock washers (B3), nuts (B2) and the four OE tow hook bolts.
4. With assistance, place the winch tray up against the frame horns and loosely thread in the four OE tow hook bolts.
5. Loosely install the 1/2" hardware (B1, B4, B3, B2). Refer to exploded view on page 3.
6. Align and center the winch tray.
7. Torque the OE tow hook bolts and 1/2" hardware to specifications on page 3.



CAUTION Always use proper posture / lifting technique or get lifting assistance while handling and installing product.

8. With assistance, from underneath the winch tray, and between the radiator position winch on winch tray.
9. Install the Warn winch to the winch tray following your winch installation instructions.
10. Route the power and negative cables to the battery while the front of the vehicle is free of obstructions and complete your winch installation following your winch installation instructions.

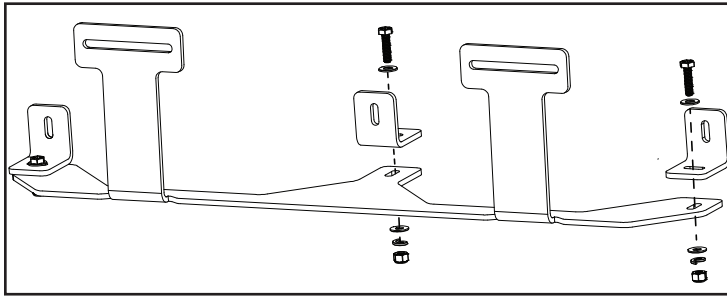


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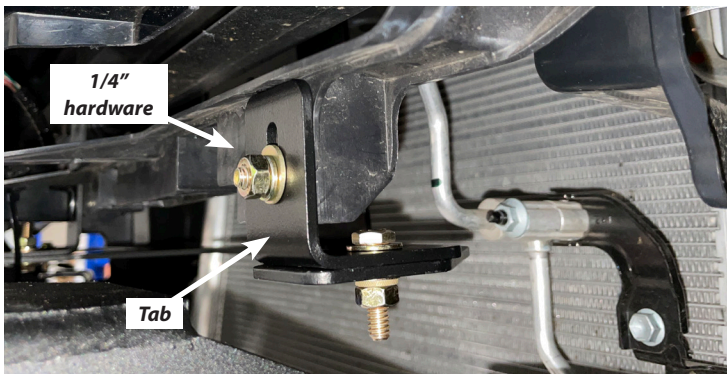
11. Fully reinstall the front fascia, plastic shroud, air scoop and the fender flares on both sides of the vehicle.
12. Reconnect any plugs that were disconnected in the engine compartment.
13. Zip tie and tidy the OE harness at this time. Leave enough slack in the fog lights and parking sensors harnesses so they can be easily reinstalled.



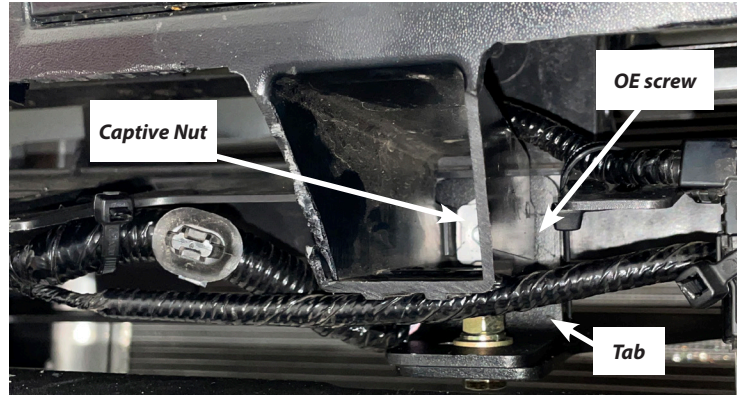
14. Locate the three grill support tabs (A7) and the rest of the 1/4" hardware (B6, B9, B8, B7).
15. Install three grill support tabs (A7) to the grill support bracket (A5) using 1/4" hardware. Refer to parts list on page 3. **Pay particular attention to the orientation of the tabs (the center one is installed in the opposite direction as the outer ones).**



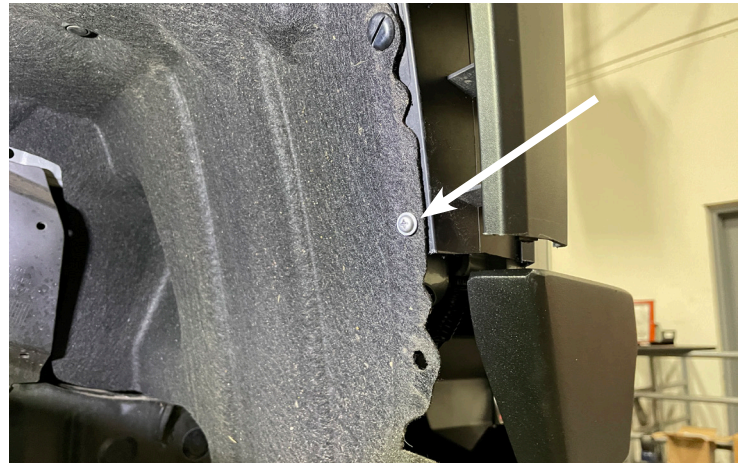
16. Reinstall the front fascia to the outer support tabs using one 1/4" screw (B6), two washers (B9), one lock washer (B8) and nut (B7).



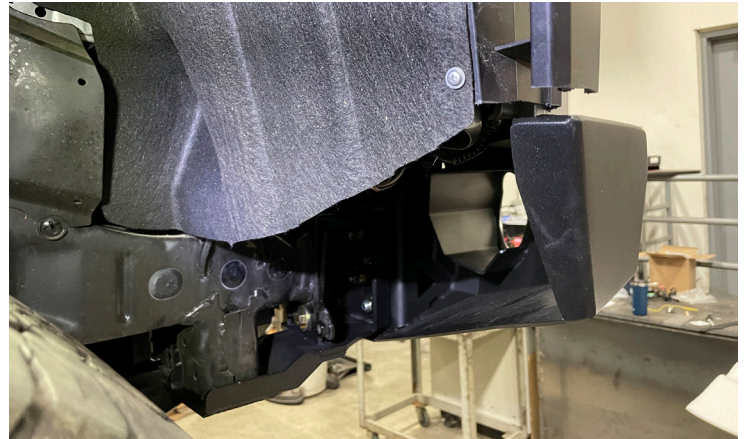
17. Secure fascia to the center support tab with one OE screw and captive nut (removed in **DISASSEMBLY** step 18) and tighten all.



18. Locate one of the OE screws removed during the fog light disassembly step.
19. Drill a small hole into the back of the fender flare and use a Phillips screwdriver to secure the bottom of the fender liner with one of the screws.

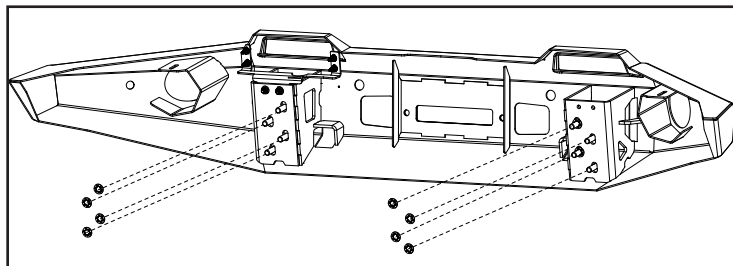


20. Use your cutting tool to cut the bottom portion of the fender liner so it is not visible from the front. *Adjustments to the cut can be made after Warn Elite bumper is installed to get the correct look.*
21. Repeat for other side.



INSTALLATION INSTRUCTIONS

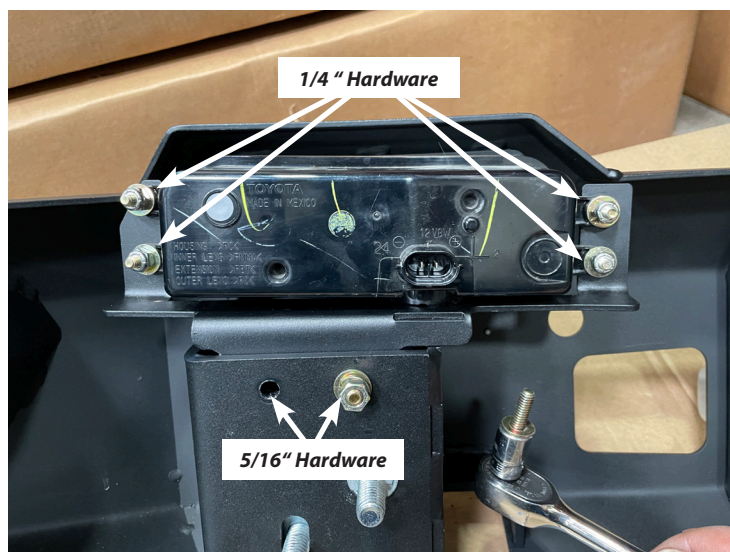
22. Gather the Warn Elite front bumper (A1) and lay on a flat surface.
23. Install the four bolt strips (A8) and 1/2" bolt retainers (B5) to bumper. **TIP: Using a 3/4" deep socket can assist in pushing the retainers flush against the mount.**



24. Locate the epoxy packets provided in your kit. Mix the two-part epoxy, and attach the OE parking sensor housings back into the Warn bumper in the same orientation and position from which they were removed from the OE bumper.



25. If equipped, locate the following:
 - Two OE fog lights
 - Fog light brackets (A3 & A4)
 - Eight 1/4" bolts (B6) and lock nuts (B7), and sixteen 1/4" flat washers (B9).
 - Four 5/16" bolts (B10) and nuts (B11), and eight 5/16" flat washers (B12).
26. Loosely mount the OE Fog Lights to the appropriate bracket using the 1/4" hardware.
27. Mount the fog light brackets to the bumper on the appropriate side using the 5/16" hardware. Fully tighten hardware.
28. Align the fog lights with the opening on the bumper and fully tighten the 1/4" hardware.



29. Install the Warn Fairlead (included in your winch kit) on the front bumper.
30. Bring the front bumper close to the front of the vehicle and install parking sensors into their respective housings and reconnect the fog lights.

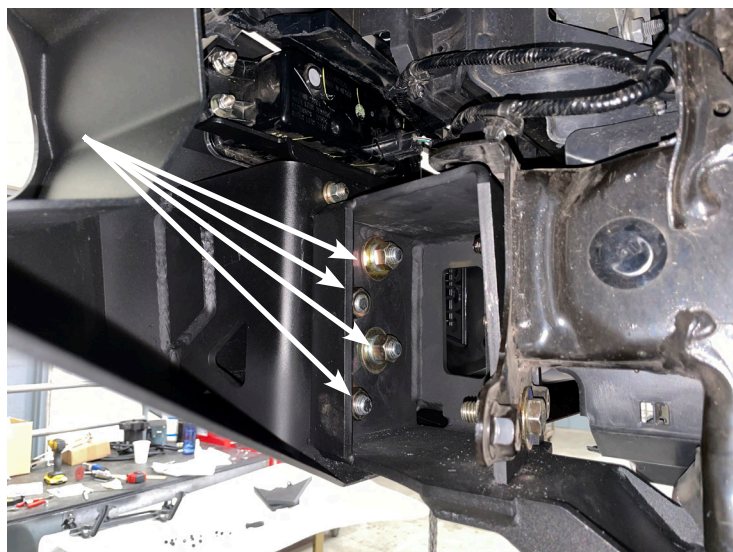
CAUTION Always use proper posture / lifting technique or get lifting assistance while handling and installing product.

31. With assistance, install bumper to winch tray, being sure bolts from bumper align with mounting holes in tray.



INSTALLATION INSTRUCTIONS

32. Loosely install, *to leave room for adjustment*, the 1/2" flat washer (B4), lock washer (B3), and nuts (B2) onto each bumper bolt.



33. Align and center the bumper with your vehicle and fully tighten the 1/2" hardware to recommended specifications on page 3.

34. Reinstall the OE skid plate using the OE hardware.
35. Confirm all hardware is tighten to recommended torque on page 3.

Congratulations installation is now complete!



MAINTENANCE / CARE

1. Inspect all parts on the winch, winch mount, and related hardware prior to each use. Replace all hardware that appears rusted or deformed.
2. Inspect all nuts and bolts on the winch, winch mount, and related hardware prior to each use. Tighten all nuts that appear to be loose. Stripped, fractured, or bent bolts or nuts need to be replaced.
3. Check all cables prior to use. Replace cables that look worn or frayed.
4. Check all moving or rotating parts. Remove debris that may inhibit the part from moving freely.

CARELESS INSTALLATION AND OPERATION CAN RESULT IN SERIOUS INJURY OR EQUIPMENT DAMAGE. READ AND UNDERSTAND ALL SAFETY PRECAUTIONS AND OPERATING INSTRUCTIONS BEFORE INSTALLING AND OPERATING THIS PRODUCT.

