INSTALLATION INSTRUCTIONS
ELITE REAR BUMPER KIT

Part Number: 111170

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

©2024 Warn Industries, Inc. WARN® and the WARN logo are trademarks of Warn Industries Inc.

⚠ 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

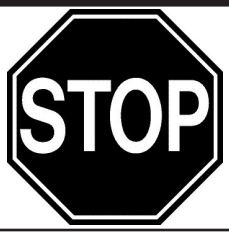
- **Never** tow vehicle by attaching a tow bar to the eyelets on the bumper.
- Do not attach tow bars directly to the bumper. Damage to bumper may occur. WARN bumpers are not designed to be used for flat towing. Consult with the manufacturer of your tow bar system for the proper vehicle tow bar brackets.

Read installation and operating instructions thoroughly.

TABLE OF CONTENTS

Tools Required.....page 2
Parts List.....page 3
Torque Specifications.....page 3
Installation .....page 4-10
Maintenance/Care.....page 10

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.

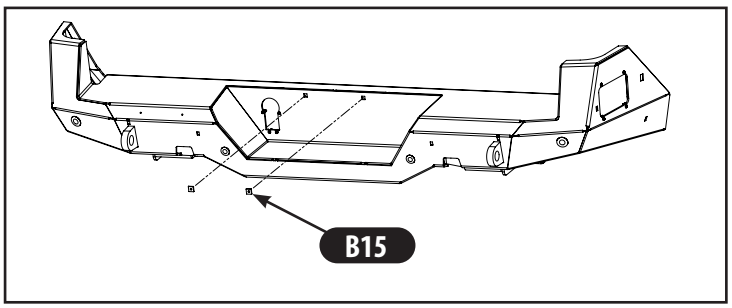
TOOLS REQUIRED

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

©2024 Warn Industries, Inc. WARN® and the WARN logo are trademarks of Warn Industries Inc.

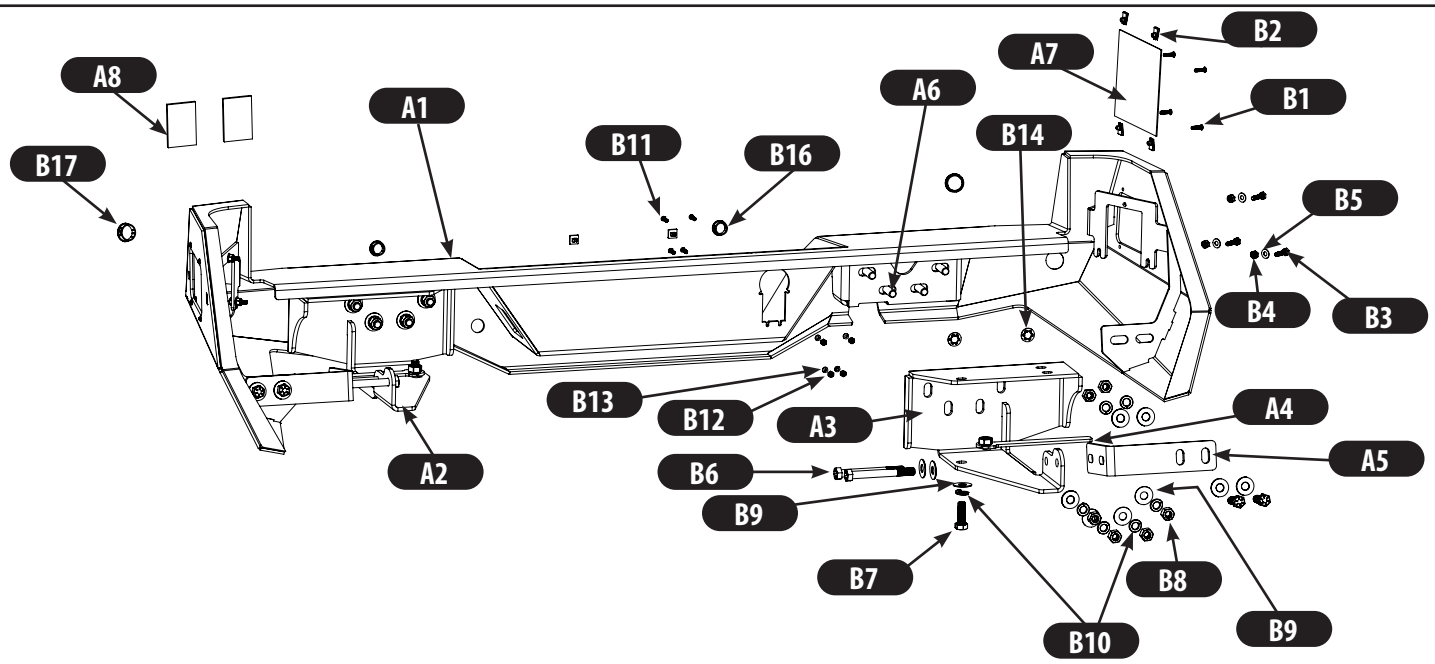
PARTS LIST

ITEM	QTY	NAME	PN
A1	1	ELITE REAR BUMPER	23341-W
A2	1	PS FRAME MOUNT	23342-W
A3	1	DS FRAME MOUNT	23343-W
A4	2	WELD NUT ASSEMBLY	23324-W
A5	2	L-BRACKET	23348-01
A6	4	BOLT STRIPS	20296-W
A7	2	PROTECTIVE FILLER SHEET	61784
A8	4	EPOXY	61632



50496-HW KIT

ITEM	QTY	NAME
B1	8	10-24 x 3/4" BUTTON HEAD SCREW
B2	8	10-24 CLIP ON BARREL NUT
B3	6	1/4"-20 X 1" BOLT
B4	6	1/4"-20 LOCK NUT
B5	12	1/4" FLAT WASHER
B6	4	1/2"-13 X 4-1/2" BOLT
B7	6	1/2"-13 X 1-1/2" BOLT
B8	16	1/2"-13 HEX NUT
B9	26	1/2" FLAT WASHER
B10	18	1/2" LOCK WASHER
B11	4	8-32 X 3/4" BUTTON HEAD SCREW
B12	4	8-32 LOCK NUT
B13	4	8 FLAT WASHER
B14	4	1/2" BOLT RETAINER
B15	2	1/4" LICENSE PLATE NUT
B16	2	7/8" ID PLASTIC PLUG
B17	2	1-1/8" 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

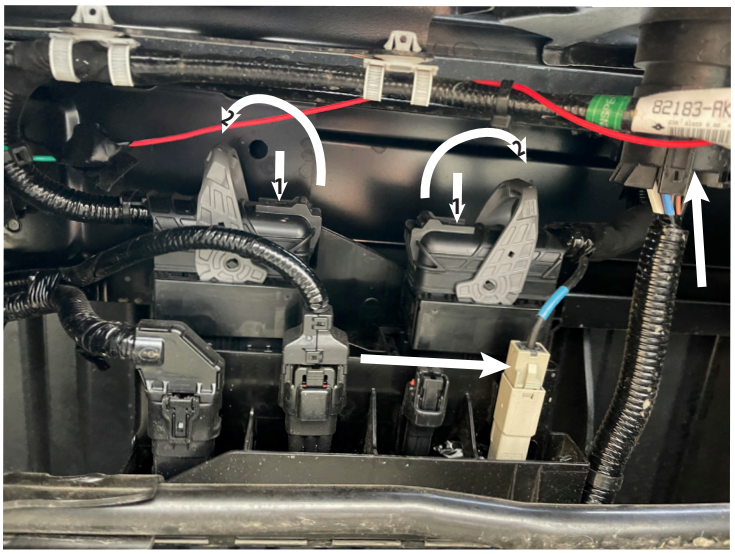
FASTENER SIZE	FASTENER TORQUE		FASTENER SIZE	FASTENER TORQUE	
	lb-ft	(N.m)		lb-ft	(N.m)
1/2"	74	(100)	M10	(37)	50
9/16"	106	(144)			
5/8"	148	(200)			
3/4"	269	(364)			

©2024 Warn Industries, Inc. WARN® and the WARN logo are trademarks of Warn Industries Inc.

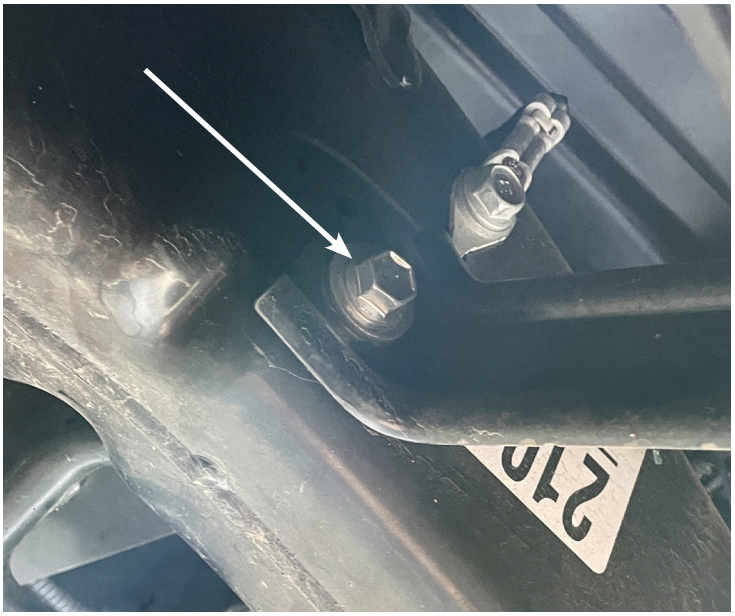
DISASSEMBLY

1. From behind the rear bumper on the driver side, unplug the bumper wire harnesses and trailer plug.

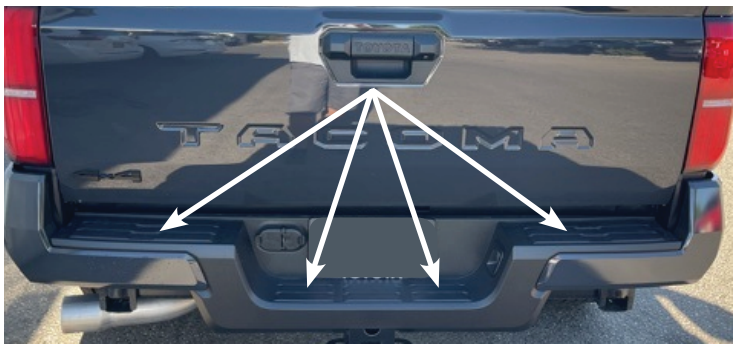
   NOTE: For the two large plugs, first press the small tab in and then rotate the lever to fully disconnect the harness.



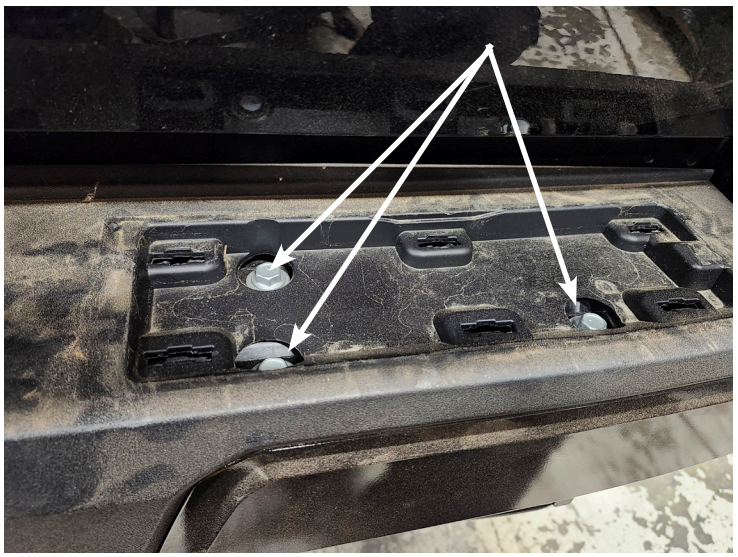
2. Using a rachet and socket, remove the bolt attaching the bumper bracket to the frame rail on each side of the vehicle. ***This hardware will not be reused and can be discarded***.



3. Using a plastic pry tool, remove the driver, passenger and the two center plastic bumper covers. ***Plastic covers will not be reused and can be discarded.***



4. Using a rachet and 13-mm socket, remove the three bolts from the driver and passenger sides of the bumper. ***Save hardware for later use.***



5. Remove the two nuts from the center of the bumper. ***The nuts will not be reused.***



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

6. With assistance, remove the rear bumper from the truck and place it safely aside.

©2024 Warn Industries, Inc. WARN® and the WARN logo are trademarks of Warn Industries Inc.

7. Carefully use a grinder with a cutoff wheel to remove the two tabs with studs from the trailer hitch at the weld.

   NOTE: Apply a black touch-up paint to prevent rust.

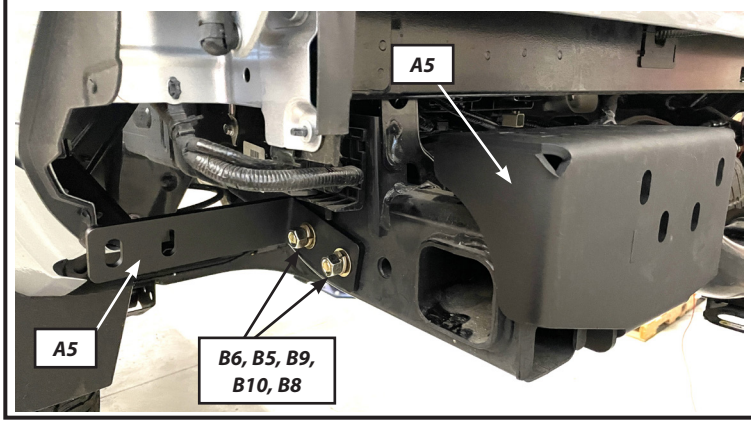


8. Using a pry tool, pop the plastic plugs from the outer and inner side of the frame rail (each side).



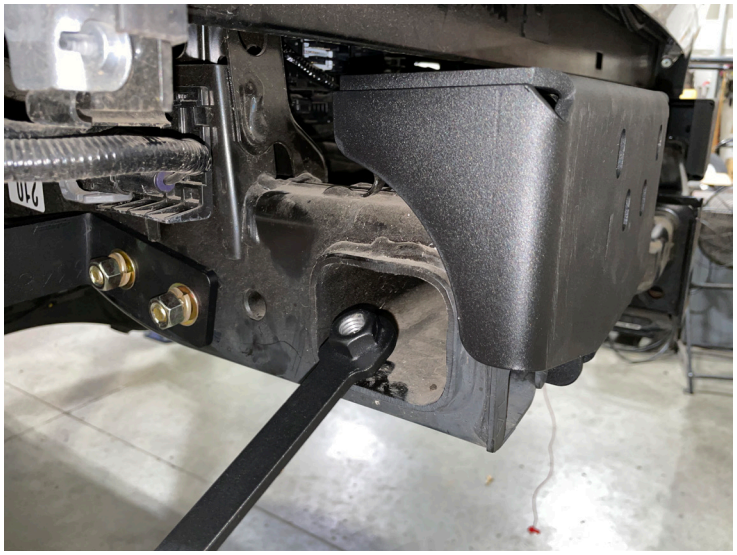
9. Slide the passenger and driver's side frame mounts (A2 and A3) on each correlating side of the frame.

10. Hold one L-bracket (A5) on the outside of the frame rail so the longer end sticks out towards fender, and loosely fasten them to the frame rail using the 1/2" hardware (two 1/2" x 4.5" bolts (B6), 1/2" lock washers (B10) and 1/2" nuts (B8) and four flat washers (B5). Repeat for other side. ***Do not completely tighten at this time.***



NOTE: There may be a metal slug inside the hitch tube. Use a hammer and chisel to remove it prior to installing the weld nut assembly plate.

11. Insert the weld nut assembly plate (A4) into the side opening of the trailer hitch tubing.

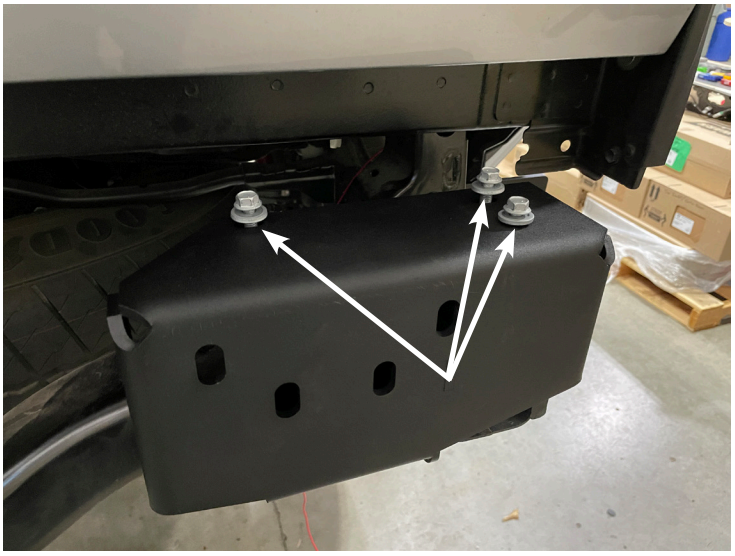


12. Loosely fasten the weld nut assembly plate to the frame mount and frame using one 1/2"x1.5" bolt (B7), 1/2" lock washer B10 and 1/2" flat washer (B9). Repeat for other side.



©2024 Warn Industries, Inc. WARN® and the WARN logo are trademarks of Warn Industries Inc.

13. Locate the six bolts removed in Step 4. Reinstall three bolts to each frame mount.



14. Fully tighten the top three bolts, and the bottom 1/2" bolt (**each side**). Leave the bolts holding the L-bracket loosely fastened.

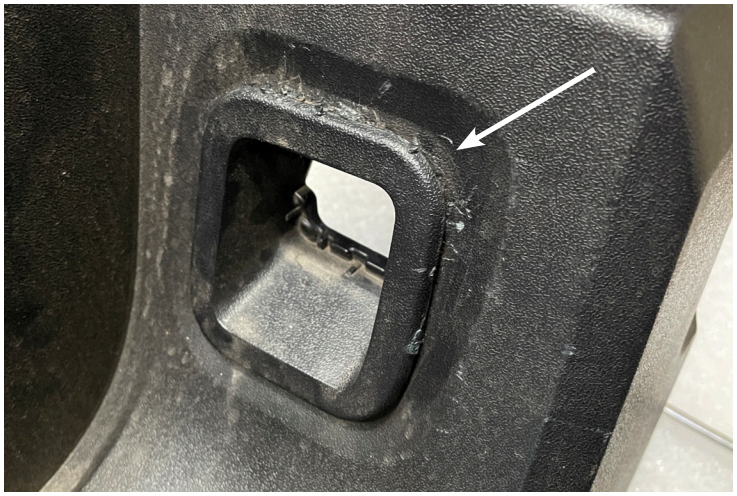
15. Remove the trailer plug from the OE rear bumper by pressing in the two clips and then pulling it free.



16. Remove the license plate tag light by first pressing on two housing clips to pop the light free, and then press down on the clip to unplug the harness from the light.

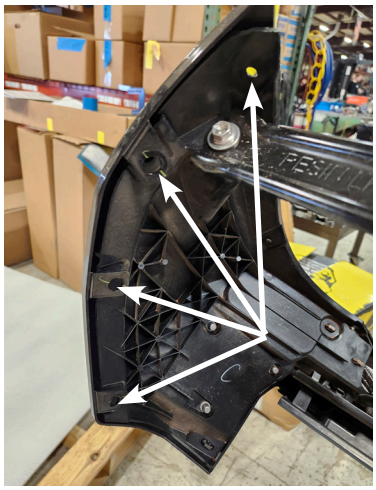


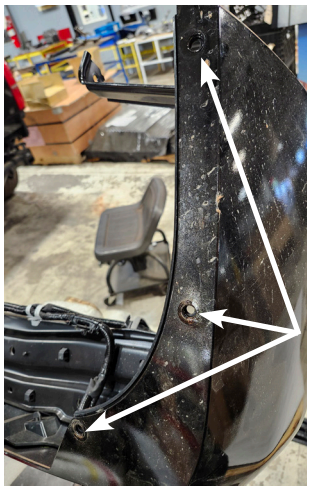
17. Use a heat gun and plastic pry tools to remove the license plate tag light housing from the OE rear bumper.



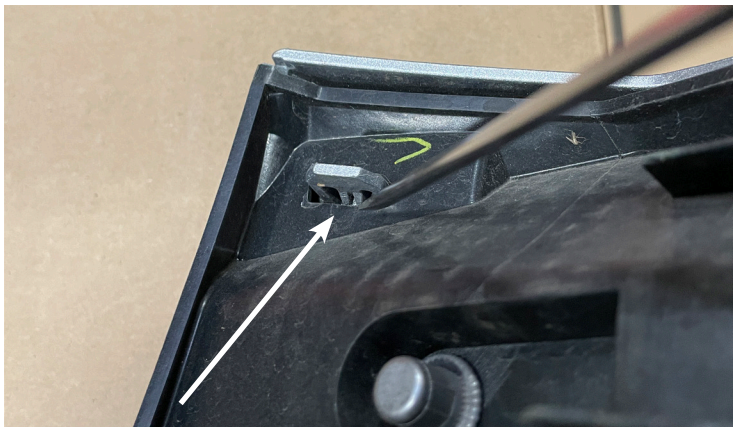
18. Safely place all three items aside as they will be reused later.

19. Remove the seven push pins from the outer and inner corners of the OE bumper.



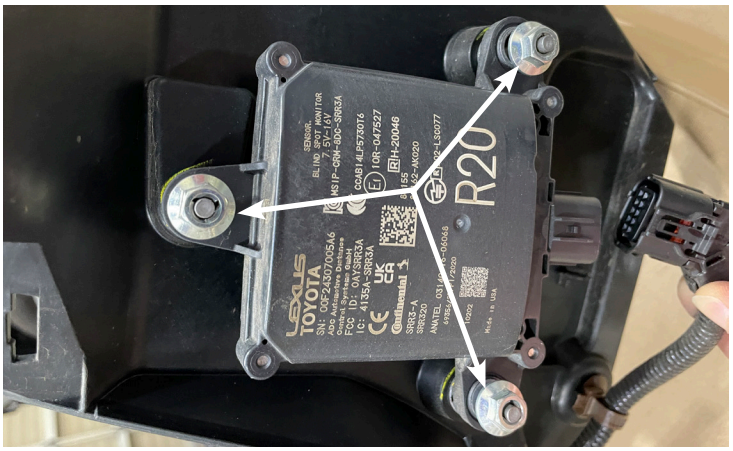


20. Using a screwdriver or pry tool, press on the five clips to release the blind spot sensor covers (each side).



©2024 Warn Industries, Inc. WARN® and the WARN logo are trademarks of Warn Industries Inc.

21. With the blind spot sensors exposed, unplug the harness and removed the three (3) nuts holding them in place using a rachet and 10-mm socket. This hardware will not be reused and can be discarded.



22. Label the both sensors and safely place aside.



23. ***If equipped***, remove the parking sensor from the housing.

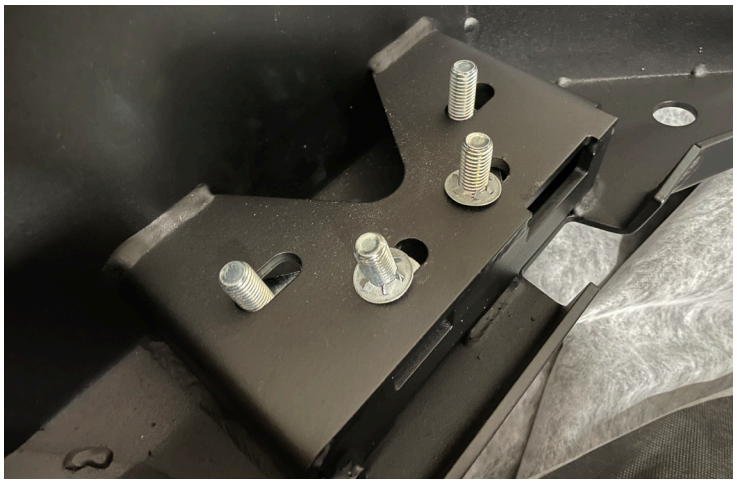
24. Remove the housing from the bumper by carefully applying heat to soften the adhesive, and then using a razor blade, carefully lift and peel away. ***NOTE: Mark the orientation and location of each parking sensor housing as they will need to be reinstalled in the exact same way.***



25. Work your way around the bumper, releasing the various clips holding the harness in place, and free the harness completely.



26. Locate two bolt strips (A6) and 1/2" bolt retainers (B14) and install into the Warn Elite bumper. ***NOTE: Using a 3/4" deep socket can assist in pushing the retainers flush against the mount.***
27. Repeat for other side.

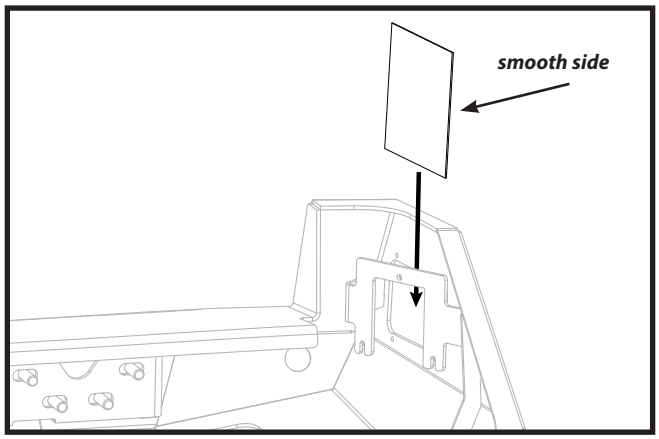


28. Insert the OE license plate light into the OE housing.
30. Open and mix the two-part epoxy (A8).
31. Carefully apply the epoxy to the back of the OE housing and install the housing assembly into the Warn Elite bumper. ***NOTE: It is helpful to use tape to hold the housing firmly in place against the bumper. However, you must ensure the epoxy does not spill/leak out the sides of the housing and that the area is clean before applying the tape.***

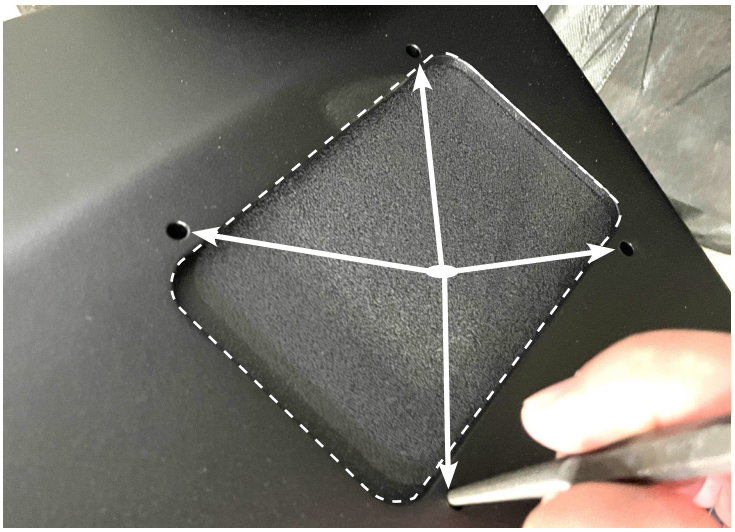


©2024 Warn Industries, Inc. WARN® and the WARN logo are trademarks of Warn Industries Inc.

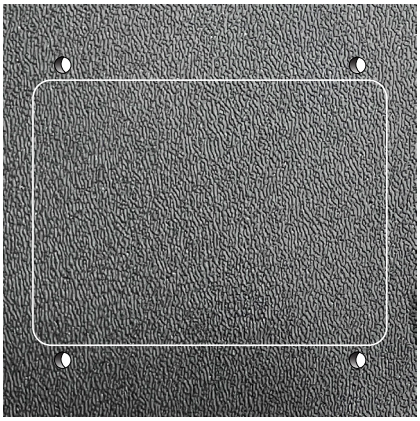
32. Place one protective filler panel (A7) (smooth side against bumper) on the inside face of the corner blind spot sensor cutout of the new bumper. ***NOTE: Ensure that the smooth side of the protective filler panel is against the inside bumper wall.***



33. Mark the four mounting hole cutouts and trace the opening of the cutout. Repeat for other panel.

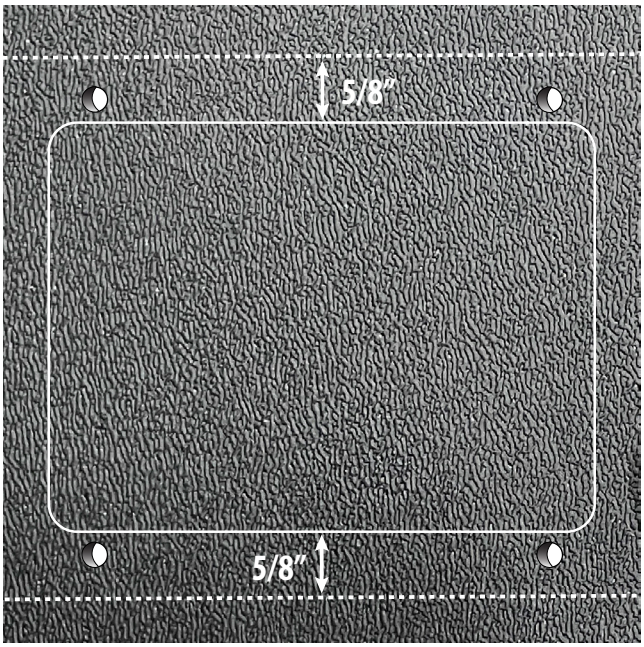


34. Use a drill and a 5/16" drill bit to drill the four marked holes on the sheet. Repeat for other panel.



35. Using a ruler, mark an offset line 5/8" from the top and bottom of the cutout outline.

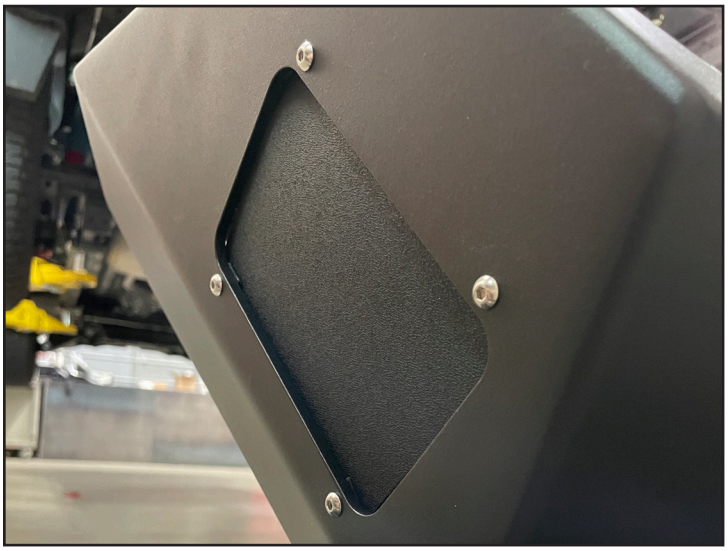
36. Use a cutting tool and cut along the offset line. Do this for both panels.



37. Place clip nuts (B2) on the trimmed filler panel, aligning the holes.

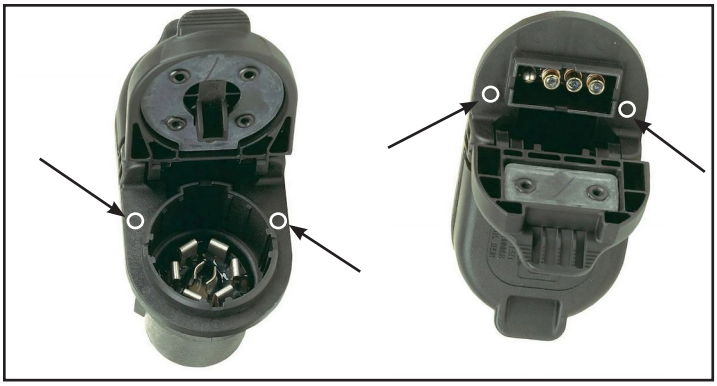


38. Using the #10 hardware (B1), install the protective filler panels to both sides of the bumper.

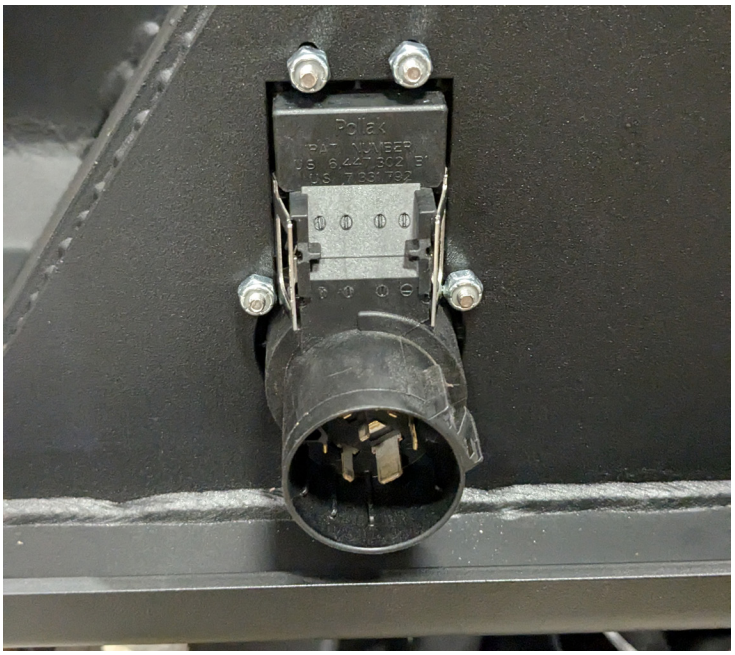


©2024 Warn Industries, Inc. WARN® and the WARN logo are trademarks of Warn Industries Inc.

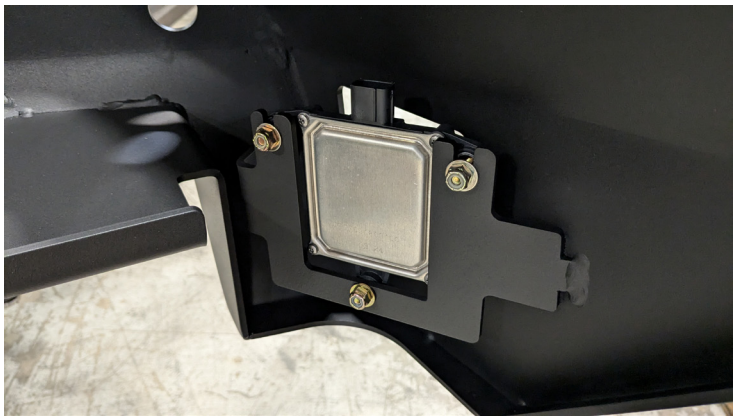
39. Gather the OE trailer plug receptacle, a center punch, a drill and a 7/32" or 1/4" drill bit, and the #8 hardware (B11, B12 & B13).
40. Use the four circular impressions on your trailer plug as guides for where to drill.



41. Use the center punch to create a pilot hole in the center of the circular impressions.
42. Carefully drill into the OE trailer plug receptacle.
43. Install the trailer plug into the cutout of the Warn bumper using the #8 hardware (B11, B12 & B13), and fully tighten.



44. Locate the blind spot sensors previously removed from the OE bumper, and the 1/4" hardware (B5, B6 & B7).
45. Install the each sensor into the correct side of the bumper and fully tighten the hardware.



46. If equipped, locate the parking sensor housings removed from the OE rear bumper, and the epoxy packets (A8).
47. Mix the two-part epoxy, and attach the OE parking sensor housings into the Warn bumper. Be sure to install in the same orientation and position from which they were removed from the OE bumper.
48. If no parking sensors are equipped, install the plastic plugs into the cutouts.



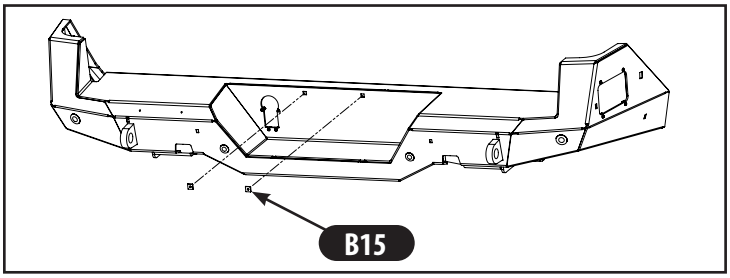
49. Locate the OE rear bumper wiring harness, and if equipped, install the parking sensors, and reconnect the plug for the license plate tag light and the blind spot sensors.
50. Tidy up the harness by using zip ties (not provided in the kit). ***NOTE: The bumper has small cutouts in the small bent flange that can be used.***



©2024 Warn Industries, Inc. WARN® and the WARN logo are trademarks of Warn Industries Inc.

INSTALLATION INSTRUCTIONS

51. Install the two plastic license plate nuts (B15) into the square cutouts of the Warn bumper and your rear license plate.



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

52. With assistance, lift and hold the bumper to the frame mounts. Use four 1/2" flat washers (B9), lock washers (B10), and nuts (B8) on the bolt strips to *loosely* hold the bumper in place.
53. Loosely, install two 1/2" bolts (B7), four flat washers (B9), two lock washers (B10), and two nuts (B8), loosely through the L-bracket on the bumper and into the frame of the vehicle. Repeat for other side.



54. Align the bumper into the correct position (center left and right), and then fully torque down the hardware. ***TIP: Tighten the bolts into the truck frame first (L-brackets) and then the nuts on the strip bolts.***
55. Reconnect any remaining wiring harnesses.
56. Confirm all hardware is has been tightened to recommended torque.

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.

©2024 Warn Industries, Inc. WARN® and the WARN logo are trademarks of Warn Industries Inc.