

INSTALLATION INSTRUCTIONS

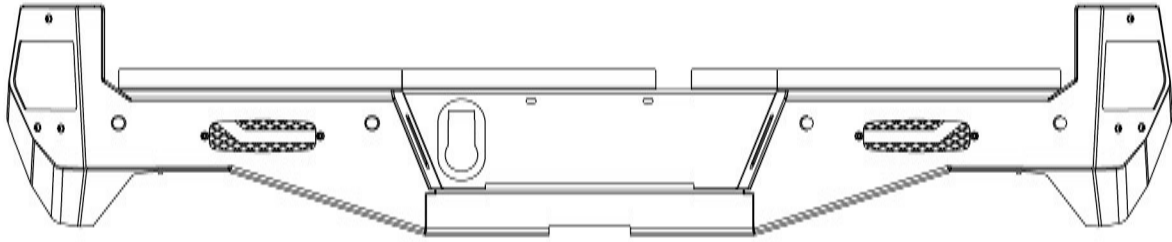
PRO-SERIES REAR BUMPER



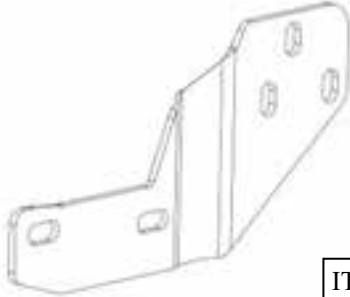
APPLICATION:
2024 TACOMA
PART NUMBER:
58-422785

CONTENT			
ITEM	QUANTITY	DESCRIPTION	TOOLS NEEDED
1	1	BUMPER ASSEMBLY	19MM SOCKET
2	1	DRIVER BRACKET	10MM SOCKET
3	1	PASSENGER BRACKET	RATCHET
4	4	HOLE PLUG	PRY TOOL
5	4	SENSOR L-TAB	
6	1	DRIVER SENSOR BRACKET	
7	1	PASSENGER SENSOR BRACKET	
8	2	SENSOR COVER	
9	2	SENSOR PLATE	
10	6	M12 SERRATED FLANGE HEX HEAD BOLT (YELLOW ZINC)	
11	6	M12 SERRATED FLANGE HEX NUT (YELLOW ZINC)	
12	6	M6 HEX HEAD BOLT (YELLOW ZINC)	
13	12	M6 FLAT WASHER (YELLOW ZINC)	
14	6	M6 SPLIT LOCK WASHER (YELLOW ZINC)	
15	6	M6 HEX NUT (YELLOW ZINC)	
16	4	M12 HEX HEAD BOLT (BLACK ZINC)	
17	4	M12 FLAT WASHER (BLACK ZINC)	
18	4	M12 SPLIT LOCK WASHER (BLACK ZINC)	
19	4	M12 SERRATED FLANGE HEX NUT (BLACK ZINC)	
20	4	M6 ROUND HEAD SQUARE NECK BOLT (BLACK ZINC)	
21	12	M6 FLAT WASHER (BLACK ZINC)	
22	4	M6 SPLIT LOCK WASHER (BLACK ZINC)	
23	4	M6 HEX NUT (BLACK ZINC)	
24	6	SHORT M6 BUTTON HEAD BOLT (BLACK ZINC)	
25	2	LONG M6 BUTTON HEAD BOLT (BLACK ZINC)	
26	8	M6 SERRATED FLANGE HEX NUT (BLACK ZINC)	
27	4	DOUBLE SIDED FOAM TAPE	

ANTI-SEIZE LUBRICANT MUST BE USED ON ALL STAINLESS STEEL FASTENERS TO PREVENT THREAD DAMAGE AND GALLING



ITEM 1



ITEM 2



ITEM 4



ITEM 5



ITEM 6



ITEM 8

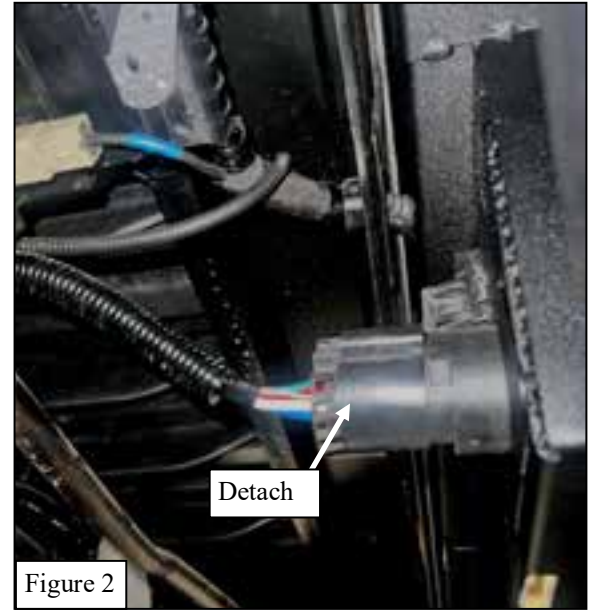
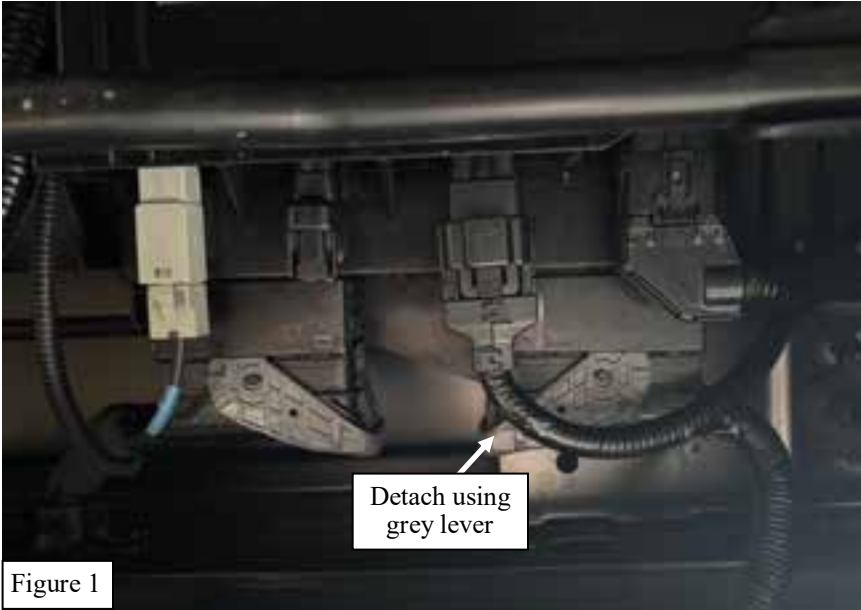


ITEM 9

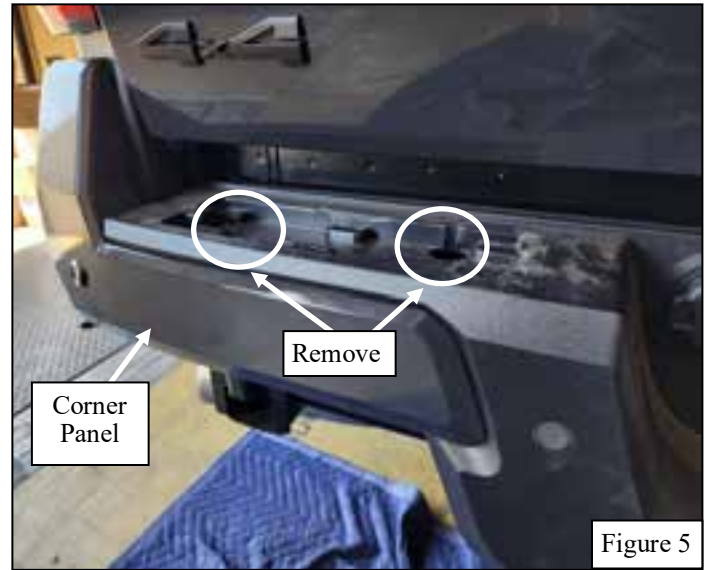
PROCEDURE

1. Remove contents from box, verify if all parts listed are present and free from damage.
Carefully read and understand all instructions before attempting installation.
Failure to identify damage before installation could lead to a rejection of any claim.

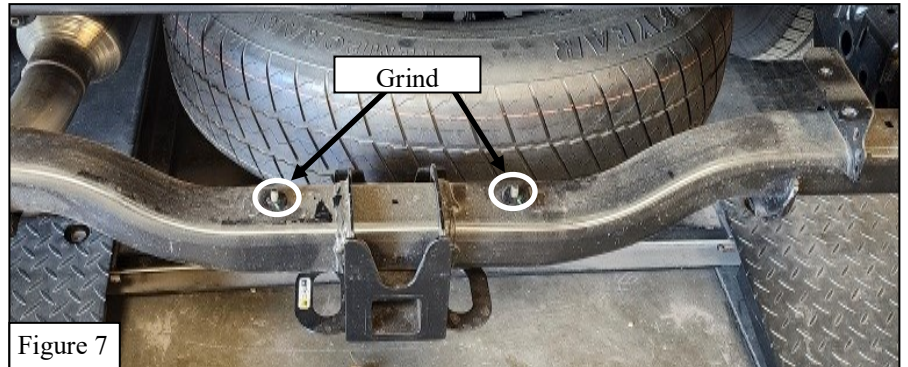
2. Begin the installation by removing the bumper.
3. Start by detaching the main wiring harness located on the driver side. See **Figure 1**
4. Disconnect the trailer plug. **Figure 2**
5. Start by removing bumper bolts located at the side of the frame see **Figure 3**.



6. Remove the (4) panels on the top of the bumper and remove hardware located inside. See **Figures 4 and 5**.



7. Remove the rear bumper from the vehicle.
8. Remove the corner panels from the rear bumper. Remove all push pin clips retaining the corner panels. See **Figure 5**.
9. Gently pry and pull the (4) parking sensors from the bezels.
Note: Be very careful when removing parking sensors. Be sure to keep the rubber gaskets on the parking sensors.
10. Gently remove all the wiring clips from the OEM bumper.
11. Remove the keyless entry antenna located at the center of the bumper by removing the nut holding it in place.
12. Remove the trailer plug located on the inside of the bumper.
13. Remove the blind spot sensors from each side of the bumper. Remove the nuts holding them in place. See **Figure 6**.
14. Grind the studs located near the hitch off of the frame. See **Figure 7**.



15. Remove the clips on the side of the frame on the driver and passenger side.
16. Loosely install the mounting brackets (items 2 and 3) using the M12 Mounting hardware (items 16-19). See **Figures 8 and 9.**



17. Attach the blind spot sensors onto the sensor brackets (items 6 and 7) using the M6 Hex head hardware (items 12-15). See **Figures 10-12.**



Figure 10



Figure 11

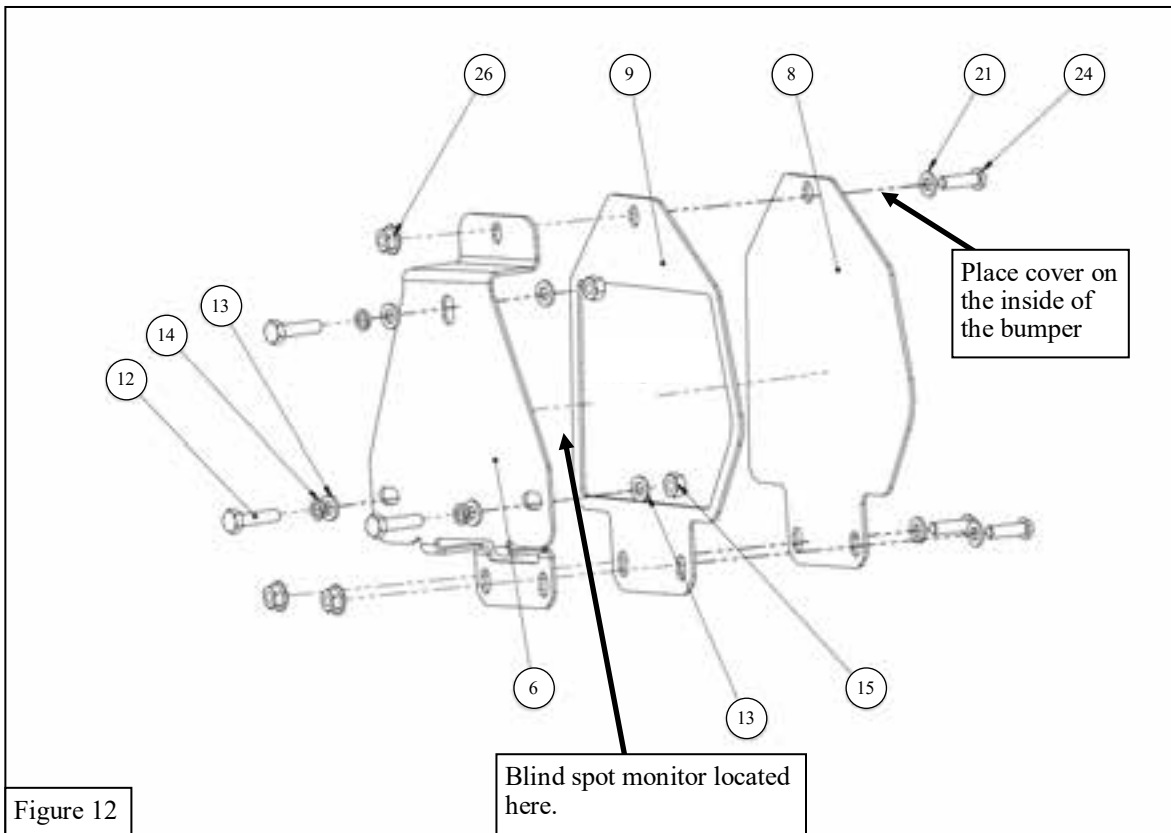
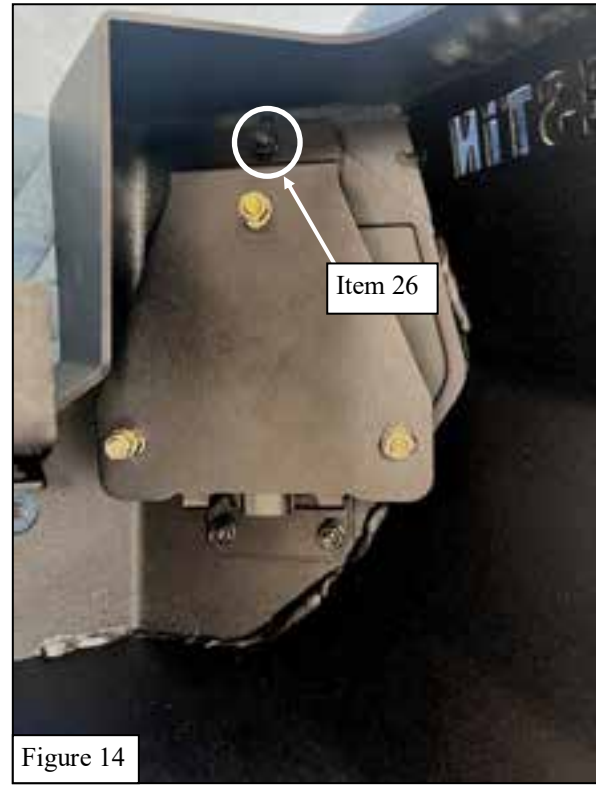
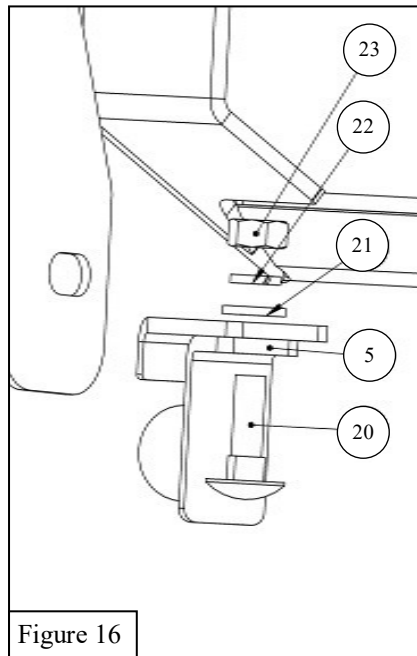
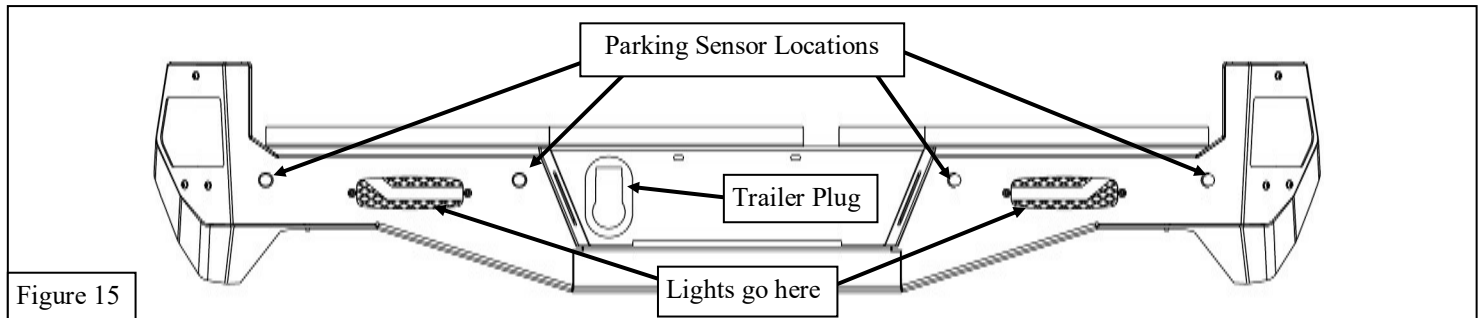


Figure 12

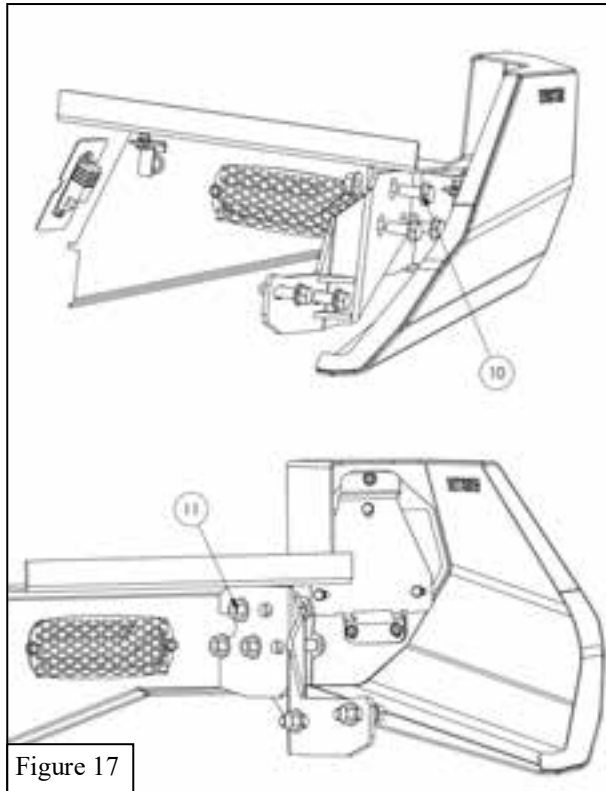
18. Install the sensor cover (item 8), sensor plate (item 9), and sensor brackets (items 6 & 7) onto the bumper using the M6 hardware (items 21, 24, and 26) see **Figures 12-14**.



19. Loosely install the Sensor L-Tabs (item 5) using the M6 hardware (items 12,20-23). See **Figures 15 and 16**.
20. If parking sensors are equipped, remove the plugs from the parking sensor holes. Install the parking sensors into the bumper where the Sensor L-Tabs were mounted and secure them by tightening the M6 hardware 10.5 lb-ft. Place (1) piece of double sided foam tape (item 27) between each parking sensor and Sensor L-Tab.
21. If lights (**PN 09-1918FM6**) are being installed, remove the mesh covers and install them in the slots. Secure them with the hardware provided with the lights.
Note: Lights are sold separately.
22. Install the wiring harness to the blind spot monitor and parking sensors.
23. Install the trail plug onto the bumper.



24. Mount the bumper onto the mounting brackets using M12 hardware (items 10 and 11) See **Figure 17**.
25. Connect the main wiring harness and trailer plug.
26. Adjust the bumper and tighten the M12 Hardware to **70 lb-ft**.
27. Install the rear license plate using the M6 hardware (items 21, 22, 26, and 25).



INSTALLATION COMPLETE



CARE INSTRUCTIONS

- REGULAR WAXING IS RECOMMENDED. DO NOT USE ANY TYPE OF POLISH OR WAX THAT MAY CONTAIN ABRASIVES.
- STAINLESS STEEL PRODUCTS CAN BE CLEANED WITH MILD SOAP AND WATER. STAINLESS STEEL POLISH SHOULD BE USED TO POLISH SMALL SCRATCHES.
- GLOSS BLACK FINISHES SHOULD BE CLEANED WITH MILD SOAP AND WATER.

WESTIN Westin Automotive Products, Inc.
320 W. Covina Blvd
San Dimas, Ca. 91773

Thank you for choosing Westin products
for additional installation assistance please call
Customer Service (800) 793-7846
www.westinautomotive.com



WARNING



Failure to follow these instructions could lead to death, personal injury, and / or property damage.

Failure to follow these instructions could lead to death, personal injury, and / or property damage.

FASTENERS:

All Westin supplied fasteners must be utilized and installed in accordance with the installation instructions and apply torque to the specifications as defined. **DOUBLE CHECK ALL FASTENERS BEFORE INITIAL USE, AND PERIODICALLY IN THE FUTURE TO ENSURE PROPER FUNCTION AND SAFETY.**

DRILLING:

Most Westin products do not require drilling for installation. If drilling is defined as required, use caution when drilling a vehicle. **FAILURE TO REVIEW AN AREA TO BE DRILLED MAY RESULT IN PERSONAL INJURY AND/OR INJURY TO OTHERS AS WELL AS VEHICLE DAMAGE.**

EYE PROTECTION:

ALWAYS WEAR SAFETY GLASSES OR GOGGLES DURING THE INSTALLATION PROCESS TO AVOID PERSONAL INJURY.

MAXIMUM TOWING/CARRYING CAPACITY: (if applicable)

The Westin Receiver Hitches will have a visible tow rating label affixed directly on the product. User should never exceed the vehicle manufacturers maximum tow and weight rating regardless of the capacity of the hitch. **FAILURE TO FOLLOW THESE GUIDELINES WILL VOID THE WESTIN WARRANTY AND MAY RESULT IN PERSONAL INJURY AND/OR INJURY TO OTHERS AS WELL AS VEHICLE DAMAGE.**

FOR CALIFORNIA RESIDENTS ONLY-PROP 65 WARNING:

Some products may contain chemicals such as DEHP, which can cause cancer, birth defects or other reproductive harm. For more info go to www.p65warnings.ca.gov



Westin Automotive Products, Inc.
320 W. Covina Blvd
San Dimas, Ca. 91773