

TIME FOR INSTALLATION

1-2 HOURS



MODERATE

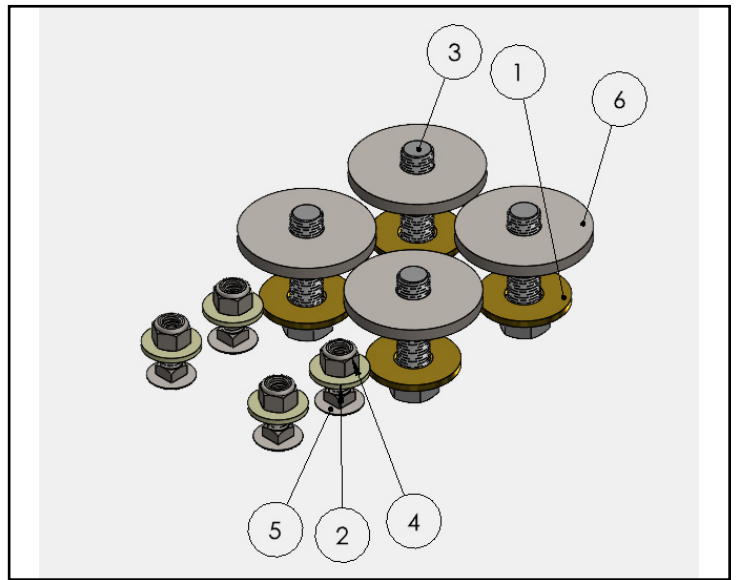
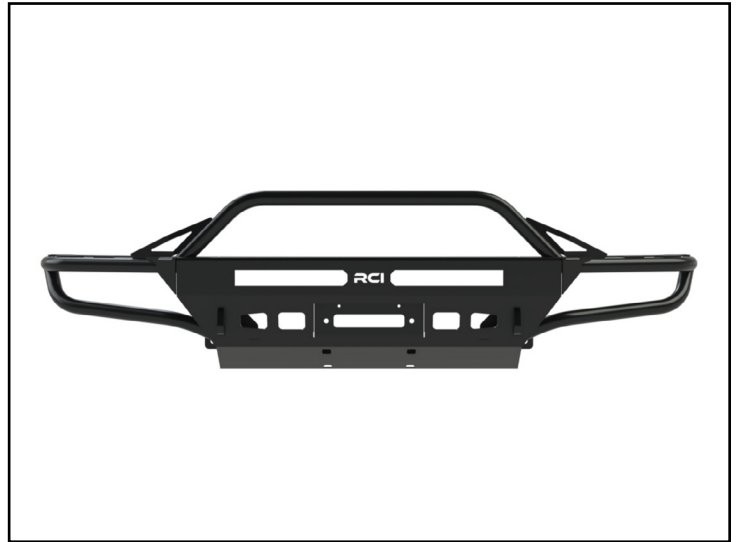


SOME EXPERIENCE RECOMMENDED

14-21 Toyota Tundra Gunnison Front Bumper Installation Guide

Contact RCI: SALES@RCIOFFROAD.COM
(970) 797-3089

Item No.	Part number	Description	Qty:
*	SM-00443	14-21 Tundra Front Bumper	1
*	SM-00045	14-21 Tundra Steering Relocation Bracket	2
*	SM-01169	14-21 Tundra Gunnison Parking Sensor Mount	2
*	HK-00076	KIT: 14 Tundra Arapahoe Bumper Hardware	1
1	HW-00022	1/2 USS Flat Washer Thru Hard	4
2	HW-00037	5/16 USS Flat Washer Zinc	4
3	HW-00057	M12-1.25 x 40mm Hex Flange	4
4	HW-00062	5/16-18 Nylon insert Lock Nut	4
5	HW-00067	5/16-18 x 3/4 Carriage Bolt	4
6	HW-00028	Full Moon Spacer	4



Caution: Use hand tools, impact wrenches may cause damage if over torqued.

Read the entire notes and instructions before installation.

DISCLAIMER:

The products sold by RCI Metalworks are intended for off-road use only, should not be modified, and are for use only on the vehicle(s) specifically stated. RCI Metalworks makes no warranties express or implied, including of fitness for a particular purpose or merchantability. RCI Metalworks will not be liable for any damages arising out of the use or misuse of its products. It is the customers' responsibility to ensure the products are safely and properly attached to the vehicle, and all products should be installed by trained professionals. We strive to maintain extremely high-quality standards; however, all RCI Metalworks products are individually handcrafted, may vary slightly, and may contain minor imperfections. Due to the nature of raw aluminum, the material may have minor scratches and other blemishes caused by the manufacturing process, especially on the back side of the product. RCI Metalworks is constantly seeking to improve its products and reserves the right to make changes to any product.

Installation of an RCI bumper requires removal of factory-installed components such as crash bars and foam impact absorbers. These components are designed for vehicle safety and impact absorption, and their removal may negatively impact occupant protection in a crash. RCI is not responsible for the removal of these components, and the owner/installer assumes all risks associated with their removal and any resulting consequences. It is the owner/installer's sole responsibility to understand the implications of removing these components before proceeding with installation. The installation of this RCI bumper, improper installation of this RCI bumper, and use or misuse of this RCI bumper with other components or failure to use it in conjunction with other components, could result in or cause serious personal injury, property damage or death.

RCI bumpers are not crash-tested and are intended for off-road use only. Vehicle owners are responsible for testing and recalibrating any affected sensors after bumper installation. While RCI may conduct preliminary sensor functionality checks during product development, this does not constitute testing to Original Equipment Manufacturer (OEM) specifications. RCI is not responsible and does not accept liability, for breakage or failure of parts as a result of rugged off-road use or reckless and/or improper installation. Modifications to your vehicle are done at your own risk and RCI does not accept liability or responsibility arising from damage caused by installing parts or doing modifications.

RCI performs off-road testing on its bumpers, including winch pulls, static and dynamic recovery pulls, and general off-road use. However, RCI is not liable for any damages arising from the use or misuse of its products. Customers are responsible for ensuring products are safely and properly attached to their vehicle, and professional installation is strongly recommended. After installing any off-road product, customers should test and recalibrate all safety sensors to ensure proper functionality. Do not rely on any safety sensor functionality until this verification is complete.

RCI Offroad bumpers with receiver hitches are not load rated. Using a receiver hitch for towing or other heavy-duty tasks is not recommended unless explicitly stated by the manufacturer. The bumper and receiver hitch are intended for off-road recovery use and not designed for sustained towing or load-bearing applications. Any misuse, such as towing or overloading, may result in bumper failure, vehicle damage, or personal injury. RCI is not responsible for any damages or injuries resulting from the use of the bumper with a receiver hitch beyond its intended purpose.

If an RCI product is purchased by a third party, such as a dealer, wholesaler, or installer, it is the third party's responsibility to inform the end customer of this disclaimer.

Installation Notes

Installation Notes:

RH refers to the passenger side of the vehicle.

LH refers to the driver side of the vehicle.

Always use the proper torque specifications.

If applicable to this installation, torque specifications will be listed throughout the document.

Please read all of these instructions and familiarize yourself with the complete process **BEFORE** you begin.

General Safety:

Park your car in a safe, well lit, level area.

Shut the engine off and remove the key from the ignition switch.

Make sure any remote start devices are properly disabled.

ALWAYS wear safety glasses.

Make sure the parking brake is applied until the vehicle is safely lifted and supported.

Whether lifting a vehicle using an automotive lift or a hydraulic jack, utilize the factory specified lift points.

Lifting a vehicle in an incorrect location can cause damage to the suspension/running gear.

ALWAYS support the vehicle with properly rated jack stands.

ALWAYS read and follow all safety information and warnings for the equipment you are using.

Required Tools:

1/4", 3/8" & 1/2" Socket Sets & Ratchets

Floor Jack

Jack Stands

Combination Wrench Set

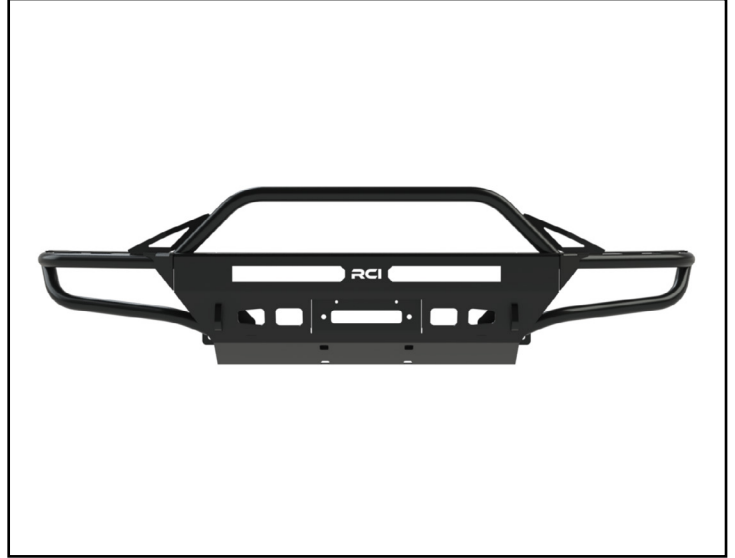
Plier Set

Torque Wrenches

Section 1: Removing the Stock Front Bumper

Step #1

Unpack and remove all components and hardware from their packaging and verify that all the components are present.



Step #2 10mm Socket, Ratchet & Panel Clip Tool

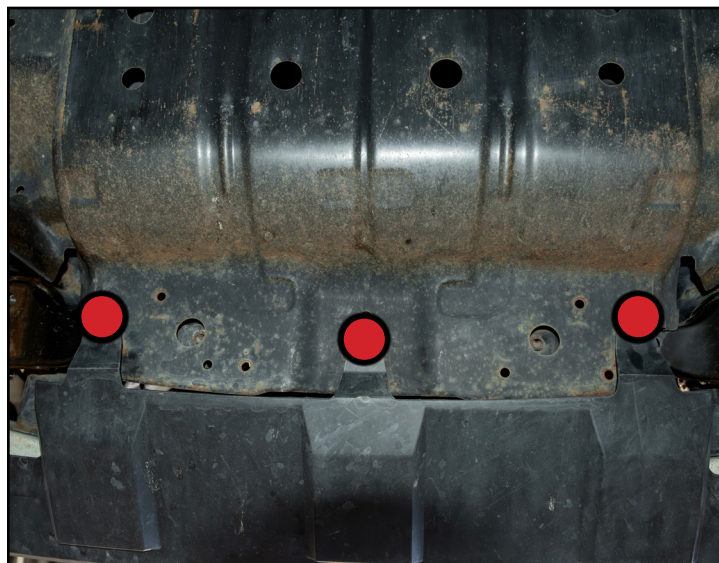
Remove the plastic clips (**RED** circles), then remove the screws (circled in **RED**) and remove the front grille from the vehicle.



Section 1: Removing the Stock Front Bumper

Step #3 | 10mm Socket & Ratchet

Remove the screws (RED circles) that secure the bottom of the front bumper cover to the engine skid plate.



Step #4 | 10mm, 12mm Sockets & Ratchet

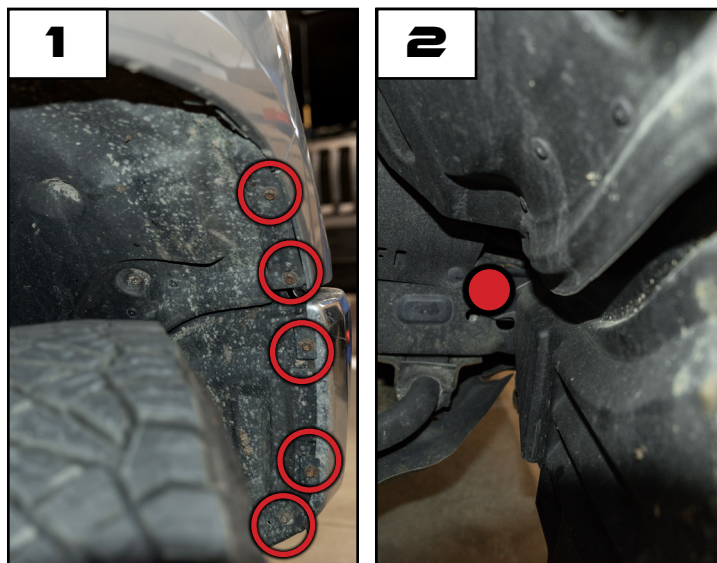
Remove the M8 screws (circled in RED) that secure the lower fender liner to the front bumper cover, then remove the M10 bolts (arrows) that secure the lower bumper cover to the front bumper. Repeat for the opposite side.



Section 1: Removing the Stock Front Bumper

Step #5 | 10mm Socket, Ratchet & Panel Clip Tool

Remove the screws (circled in **RED** in photo #1), then remove the plastic clip (**RED** circle in photo #2) and remove the lower section of the fender liner. Repeat for the opposite side.



Step #6

Disconnect the fog light wiring harness (highlighted in **RED**) from the fog light. Repeat for the opposite side.



Section 1: Removing the Stock Front Bumper

Step #7 Flat Blade Screwdriver

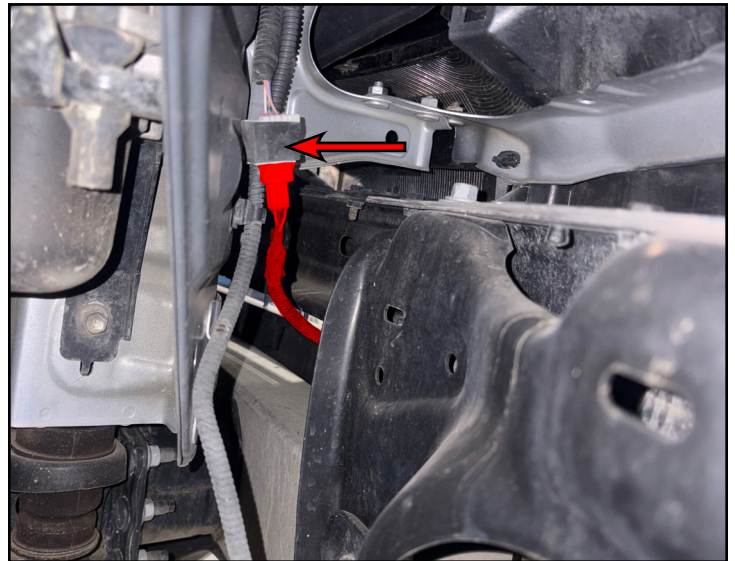
Release the clip (arrow) that secures the fog light wiring harness to the front bumper. Repeat for the opposite side.

Installations without parking sensors only: Skip ahead to ***section 1, step 9.***



Step #8

For parking sensor equipped vehicles only: Disconnect the connector (arrow) for the parking sensor wiring harness (highlighted in **RED**). Repeat for the opposite side.



Section 1: Removing the Stock Front Bumper

Step #9 | Panel Clip Tool

Remove the plastic clips (arrows), then free the headlight trim panel from its mounting location by pulling the panel outward. Repeat for the opposite side.



Step #10 | 12mm Wrench

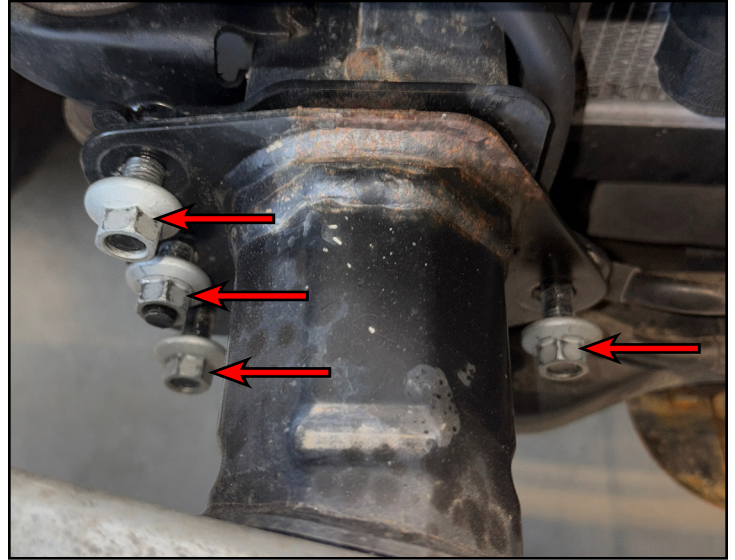
Remove the bolts (circled in **RED**) that secure the front bumper cover to the front bumper, then repeat for the opposite side and remove the front bumper cover from the vehicle.



Section 1: Removing the Stock Front Bumper

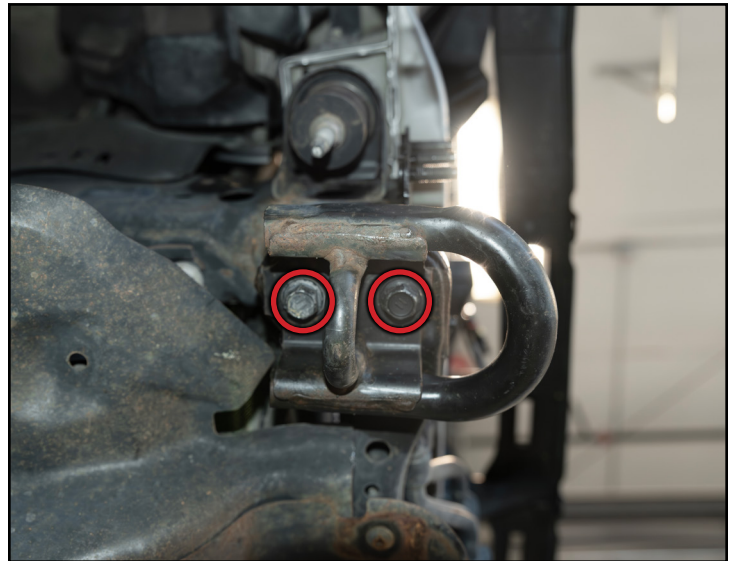
Step #11 | 14mm Socket & Ratchet

Remove the nuts (arrows) that secure the front bumper to the front frame rails of the vehicle and set them aside, then remove the front bumper from the vehicle.



Step #12 | 17mm Socket & Ratchet

Remove the M12 bolts (circled in **RED**) that secure the OEM recovery points to the frame, then remove the recovery points from the vehicle.

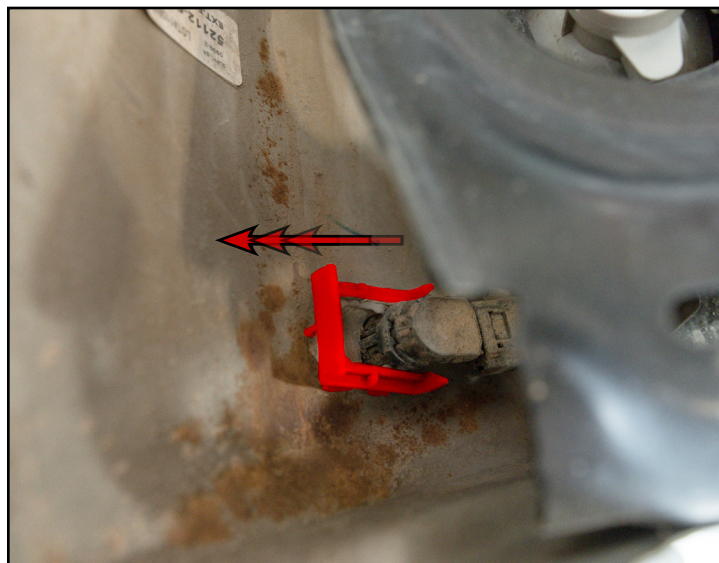


Installations without parking sensors only: Skip ahead to ***section 1, step 16.***

Section 1: Removing the Stock Front Bumper

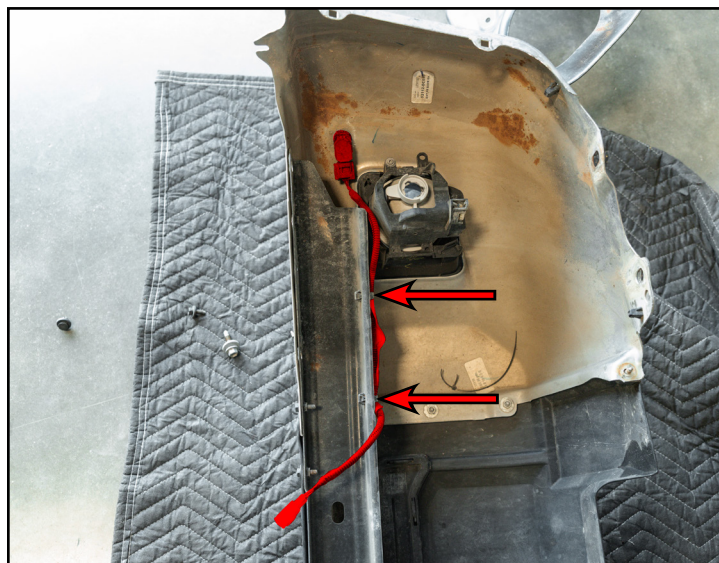
Step #13

For parking sensor equipped vehicles only: Slide the retention clip (highlighted in **RED**) to free the parking sensor.



Step #14 Flat Blade Screwdriver

For parking sensor equipped vehicles only: free the clips (arrows) that secure the parking sensor wiring harness (highlighted in **RED**) to the front bumper cover. Then remove the sensor from the front bumper cover.

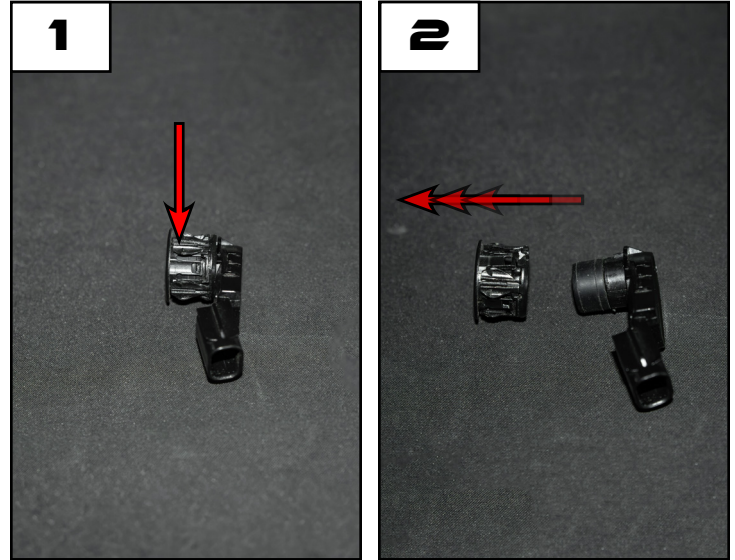


Section 1: Removing the Stock Front Bumper

Step #15

For parking sensor equipped vehicles only: Squeeze the clip (arrow in photo #1) to release it from the sensor (as shown in photo #2).

Installations without winches only: Skip ahead to section 2, step 3.



Step #16 10mm Socket & Ratchet

For winch installations only: The power steering cooler brackets will need to be relocated to create enough clearance for the winch.

Remove the bolt (arrow) that secures the RH power steering cooler bracket to the lower radiator core support and set it aside.



Section 1: Removing the Stock Front Bumper

Step #	10mm Socket & Ratchet
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For winch installations only: The power steering cooler brackets will need to be relocated to create enough clearance for the winch.

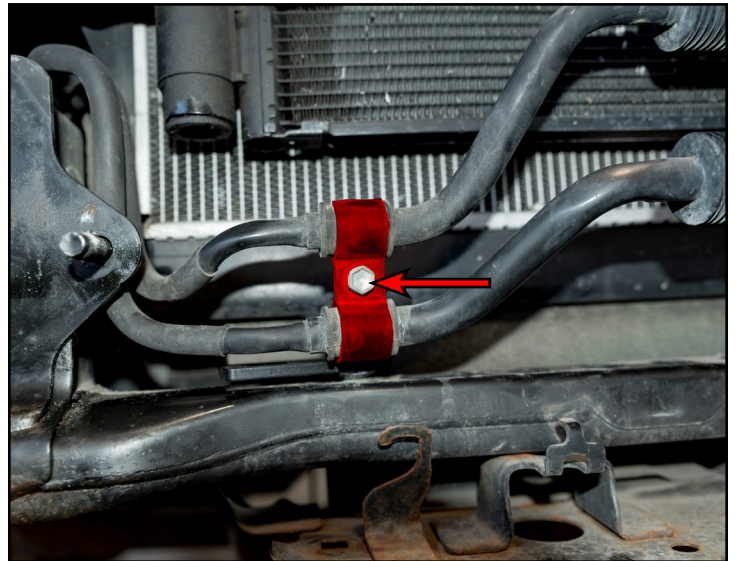
Remove the bolt (arrow) that secures the LH power steering cooler bracket to the lower radiator core support and set it aside.



Step #	10mm Socket & Ratchet
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For winch installations only: The power steering cooler brackets will need to be relocated to create enough clearance for the winch.

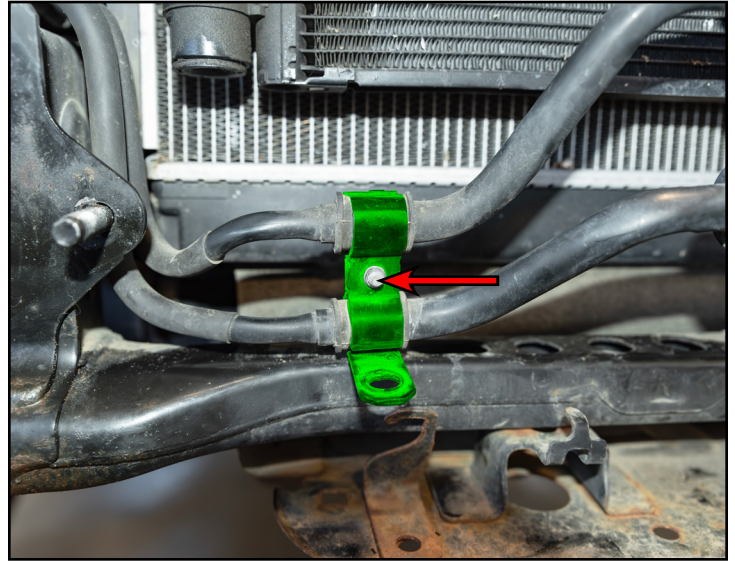
Remove the bolt (arrow) that secures the bracket RH bracket (highlighted in **RED**) to the power steering lines and set it aside.



Section 2: Installing the New Front Bumper

Step #1 | 10mm Socket & Ratchet

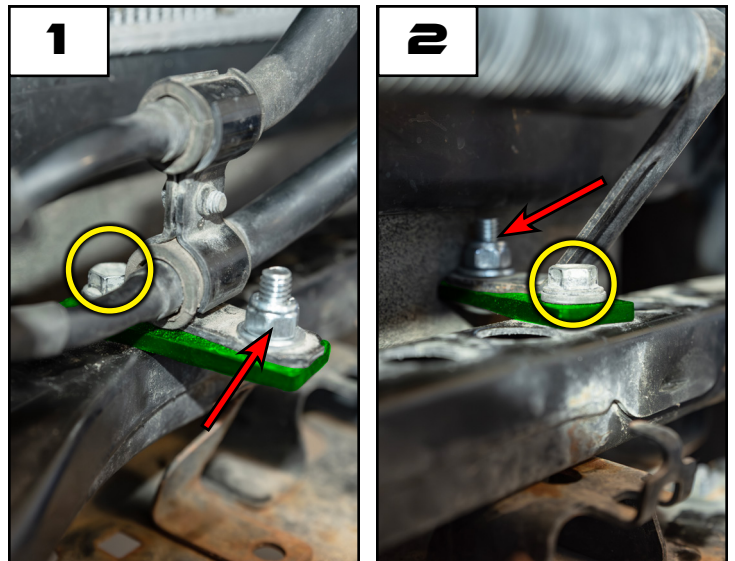
For winch installations only: Flip the RH power steering line bracket (highlighted in **GREEN**) and reinstall the bolt (arrow) to secure it in place.



Step #2 | 10mm Socket, Ratchet & 1/2 Wrench

For winch installations only: Install the power steering line relocation brackets (highlighted in **GREEN** in photos 1 & 2) and secure them to the OEM brackets with the provided 5/16" hardware (arrows in photos 1 & 2).

Secure the relocation brackets to the lower radiator core support by reinstalling the OEM bolts (circled in **YELLOW** in photos 1 & 2).



*RH shown in photo #1

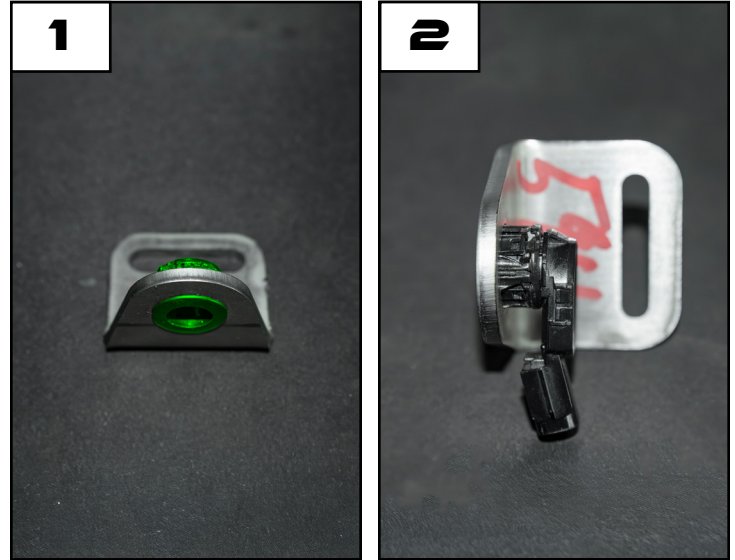
*LH shown in photo #2

Section 2: Installing the New Front Bumper

Step #3

For parking sensor equipped vehicles only: Install the parking sensor clip (highlighted in **GREEN** in photo #1), then install the parking sensor (arrow in photo #2).

Installations without parking sensors only: Skip ahead to **section 2, step 6**.



Step #4

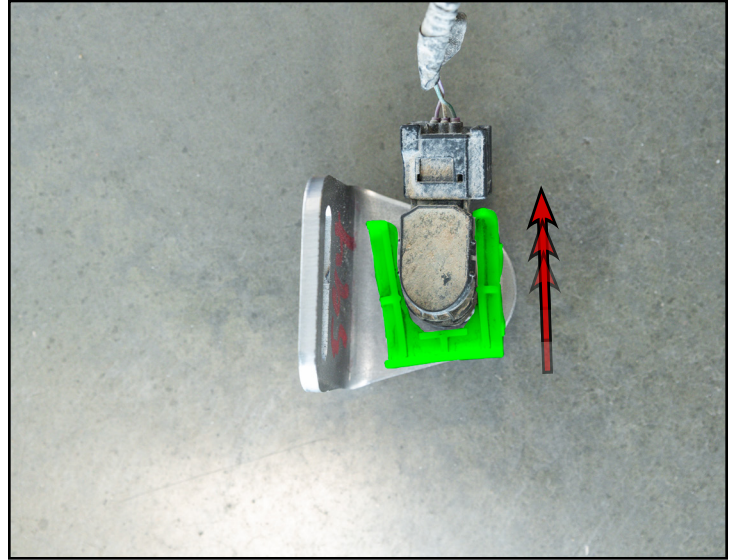
For parking sensor equipped vehicles only: Reconnect the parking sensor wiring harness (highlighted in **GREEN**) to the parking sensor.



Section 2: Installing the New Front Bumper

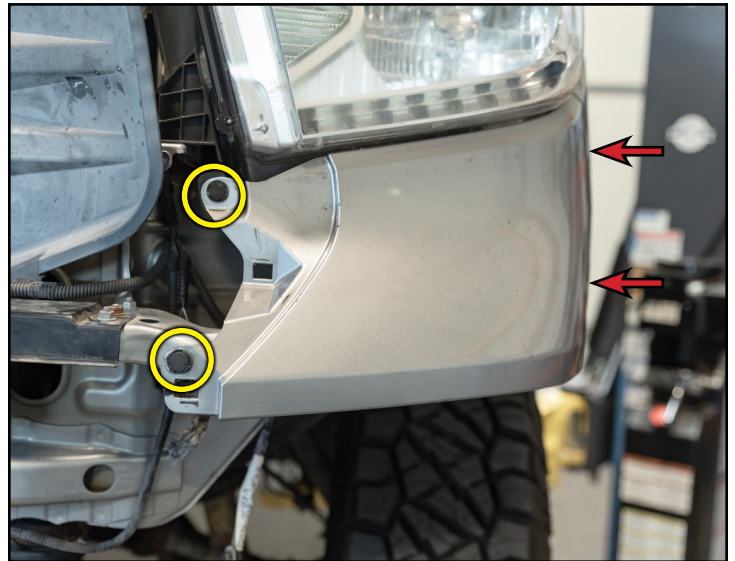
Step #5

For parking sensor equipped vehicles only: Secure the parking sensor to the provided parking sensor bracket by reusing the OEM clip (highlighted in **GREEN**).



Step #6 10mm Socket & Ratchet

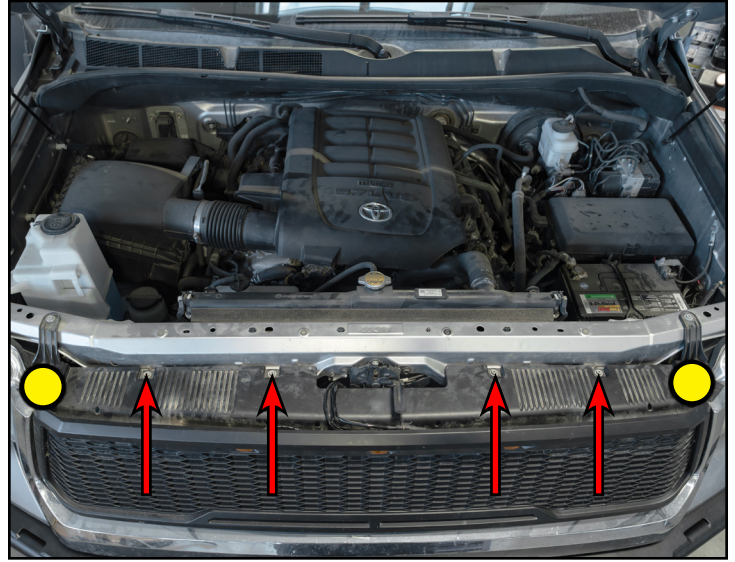
Reinstall the front panels and secure them in place with the plastic clips (circled in **YELLOW**), then reinstall the screws (arrows) to secure the fender liner.



Section 2: Installing the New Front Bumper

Step #7 | 10mm Socket & Ratchet

Reinstall the front grille, then reinstall the screws (arrows) and plastic clips (**YELLOW** circles) to secure it in place.



Step #8

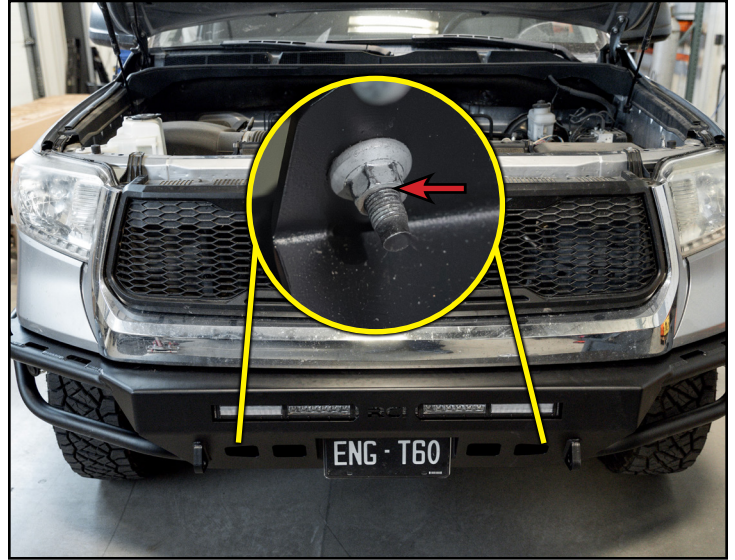
Install any front accessories like auxiliary lighting or winches into the new front bumper prior to installing it onto the vehicle.



Section 2: Installing the New Front Bumper

Step #9 | 14mm Socket & Ratchet

Lift the new front bumper, then install it onto the OEM front bumper studs and secure it in place by loosely re-installing the nuts (arrow in inset photo) onto the inner OEM stud locations.

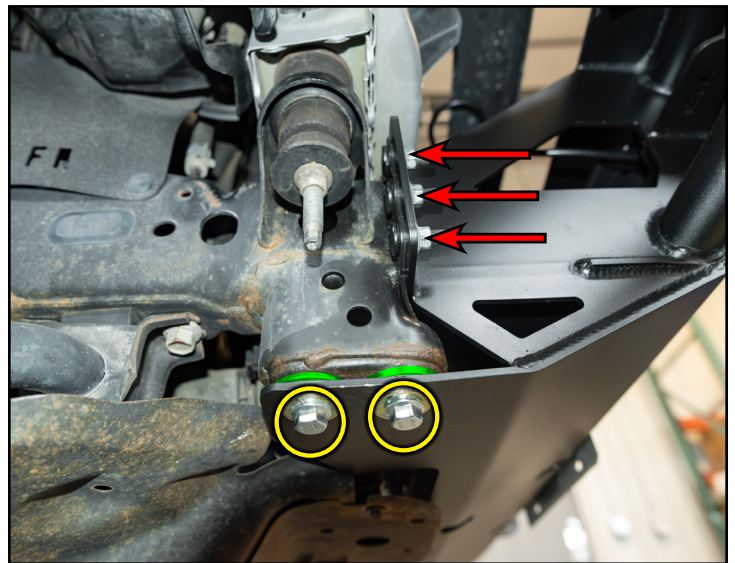


Step #10 | 14mm, 17mm Sockets & Ratchet

Adjust the front bumper until desired fitment has been achieved.

Secure the front bumper by installing the M12 hardware (circled in **YELLOW**) through the bottom of the bumper, then through the full-moon spacer (highlighted in **GREEN**) and into the OEM recovery point mounting location. Torque the M12 bolts to 55 ft-lbs (75 Nm).

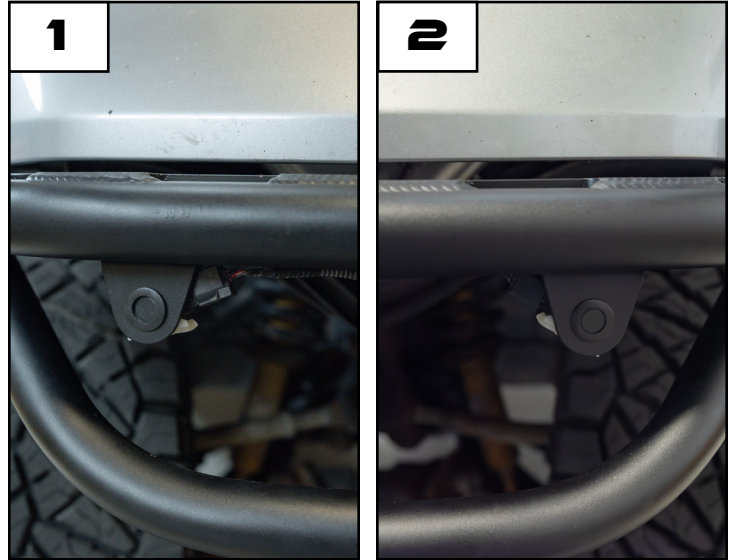
Install the remaining OEM M10 nuts (arrows) and torque all of the M10 nuts to 43 ft-lbs (58 Nm).



Section 2: Installing the New Front Bumper

Step #11 | 1/2 Wrench

For parking sensor equipped vehicles only: install the assembled parking sensor brackets onto the front bumper and secure them in place with the provided 5/16" hardware (arrow in inset photo).

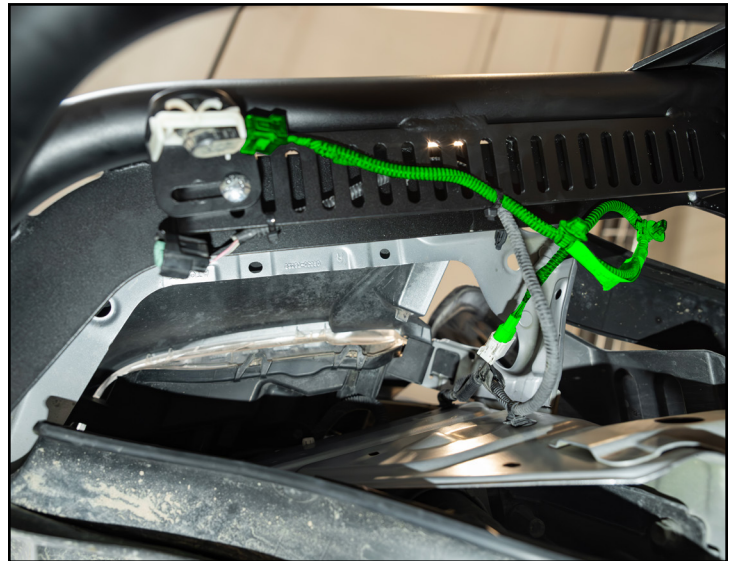


*RH shown in photo #1

*LH shown in photo #2

Step #12

For parking sensor equipped vehicles only: Reconnect the parking sensor harness (highlighted in **GREEN**) to the connector (arrow). Repeat for the opposite side.

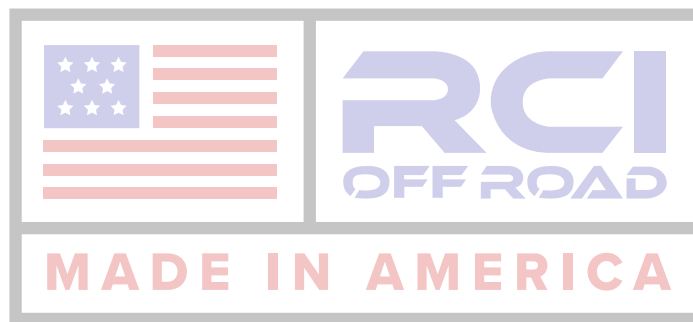


CONGRATULATIONS, YOUR INSTALLATION IS COMPLETE!

ENJOY YOUR NEW RCI PROTECTION!



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We love seeing our products in the wild!**



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