



# Installation Instructions:

(Part # SB612840)  
2008-2010 Toyota Tundra M1  
Front Bumper Kit

**NOTE:** Carefully read entire instructions thoroughly before attempting to install this part.

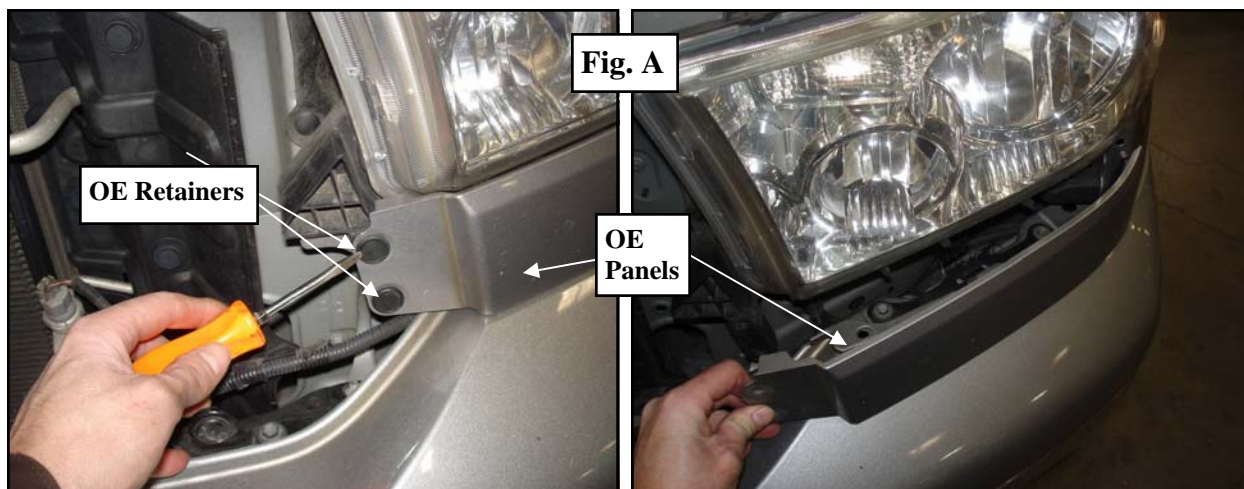
Parts Included	Qty
93-7669 M1 Front Bumper	1
93-7610 Winch Mounting Plate	1
93-7632 Bumper Mounting Bracket: Driver	1
93-7635 Bumper Mounting Bracket: Passenger	1
93-7606 Outer Support Brace: Driver	1
93-7607 Outer Support Brace: Passenger	1
93-7608 Frame Horn Support: Driver	1
93-7609 Frame Horn Support: Passenger	1
90-7640 Bolt Plate	2
90-7756 Dual Nut Plate	2
90-7665 Window Bezel: Driver	1
90-7666 Window Bezel: Passenger	1
90-7318 Fog Light Bracket: DLAA LA5070	2

Parts Included	Qty
93-7667 Window Backing: Driver	1
93-7668 Window Backing: Passenger	1
90-6859 Hardware Pack: Front Bumper	1
1/2" X 1 1/2" Hex Bolt Gr. 8	14
1/2" SAE Hardened Flat Washer	24
1/2" Stover Nut	10
1/4"-20 X 3/4" Hex Bolt Gr. 8	8
1/4"- 20 Nylock Nut	8
1/4" SAE Hardened Flat Washer	16
#10-24 X 3/4" Stainless Button Head Bolt	8
#10-24 Nylock Nut	8
#10-24 SAE Flat Washer	8
S/B612800-01 3 1/2" Clear Driving Light Kit	1
S/B612800-02 2 1/2" Amber Driving Light Kit	1

## INSTALLATION:

**Step 1:** Unclip the wiring harness for the fog lights in the OE front bumper if so equipped..

**Step 2:** Remove the plastic panels under the head lights by pushing the OE retainers toward the center of the truck. The panels will pull straight out. (Fig A)



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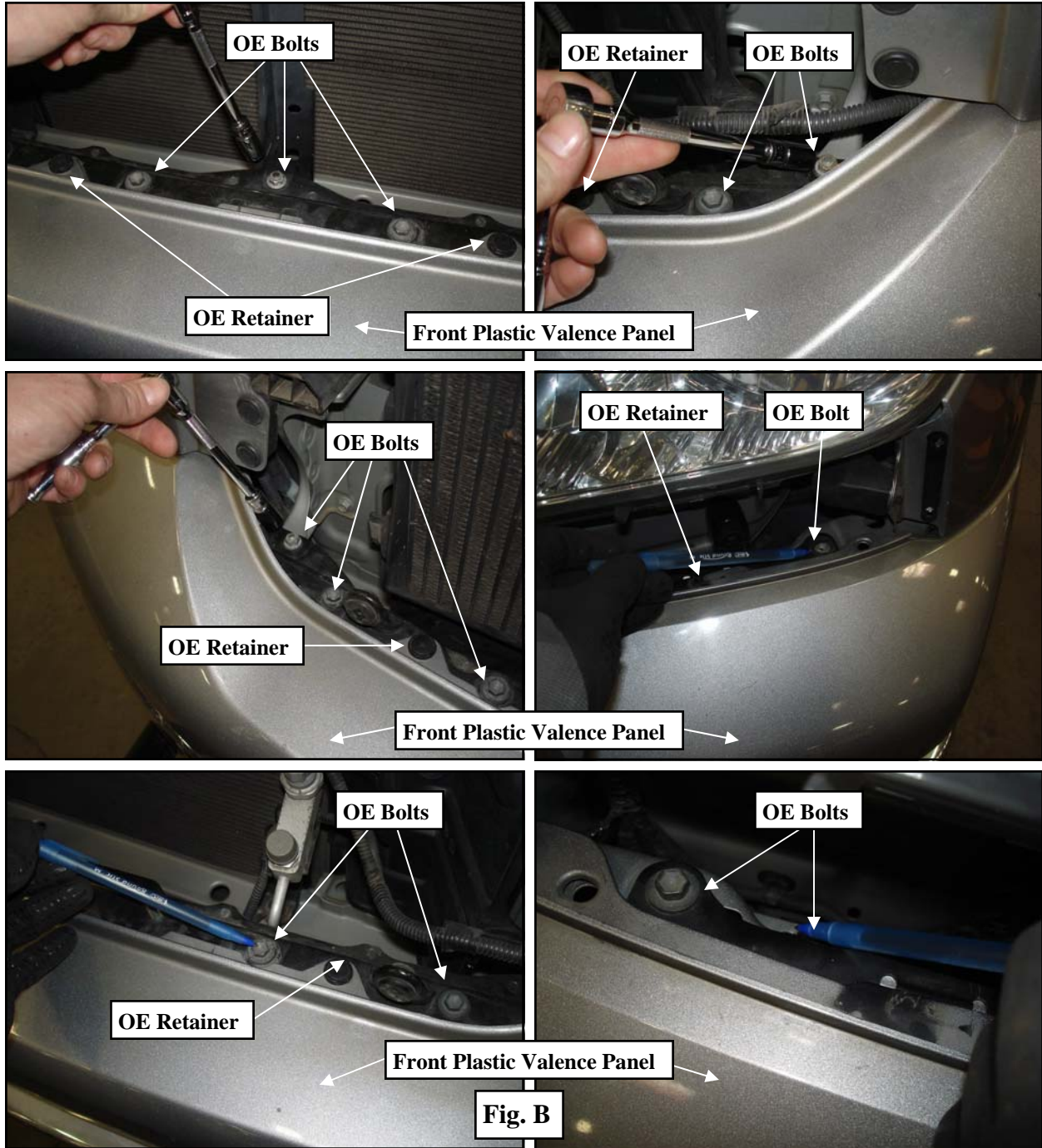


Revised 1.2.12

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**Step 3:** Remove all of the upper OE hardware for the front plastic valence panel. (Fig B)



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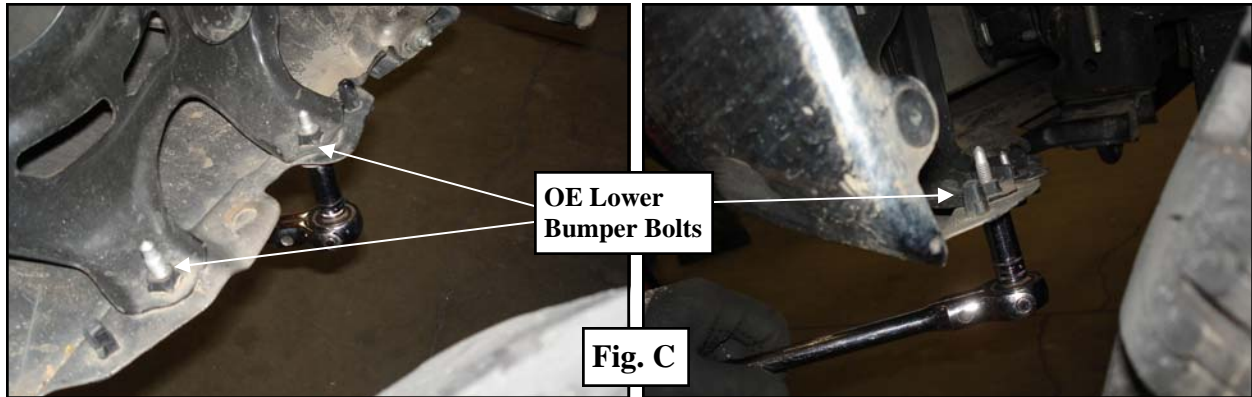




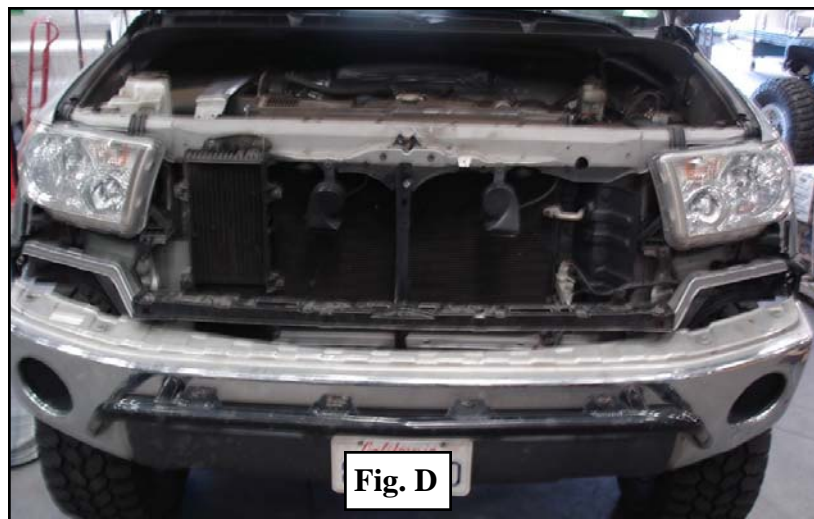
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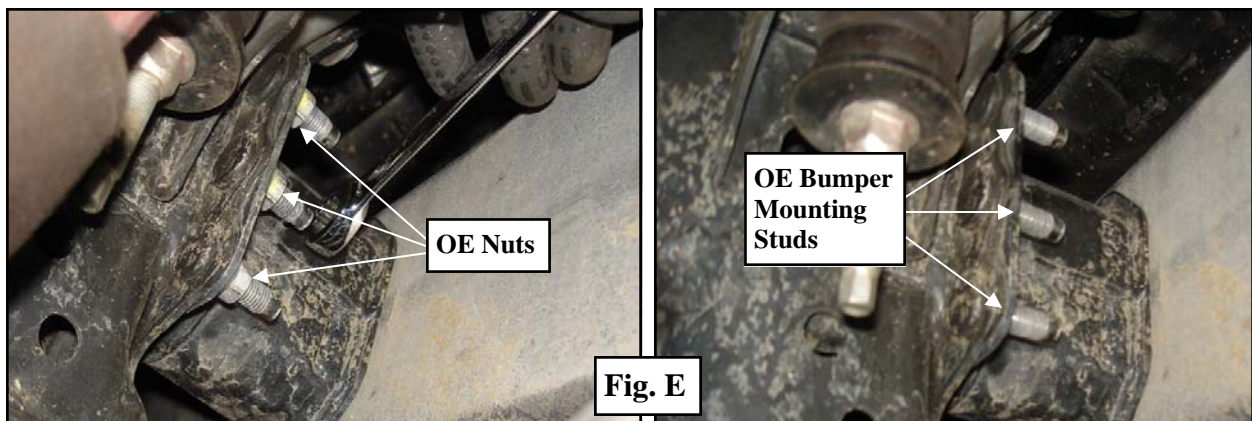
**Step 4:** Remove the (2 per side) OE lower bumper bolts from in front of the tires. (Fig C)



**Step 5:** Remove the front valance from the vehicle by pulling it straight forward. (Fig D)



**Step 6:** Unbolt the (4 per side) OE bumper retaining nuts from the bumper mounting studs (3 per side) toward the outside of the bumper and (1 per side) toward the inside. (Fig E)

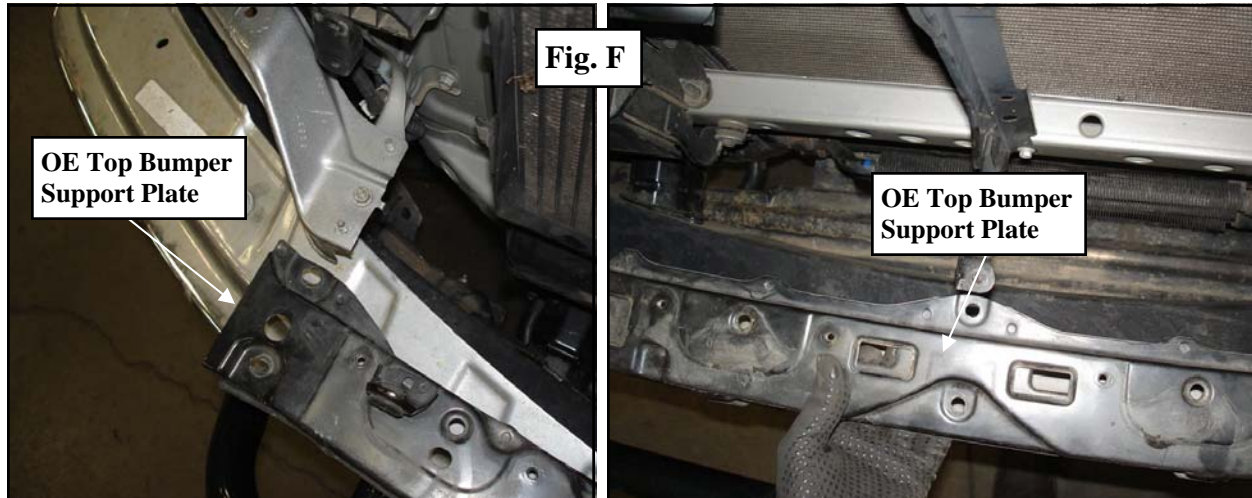




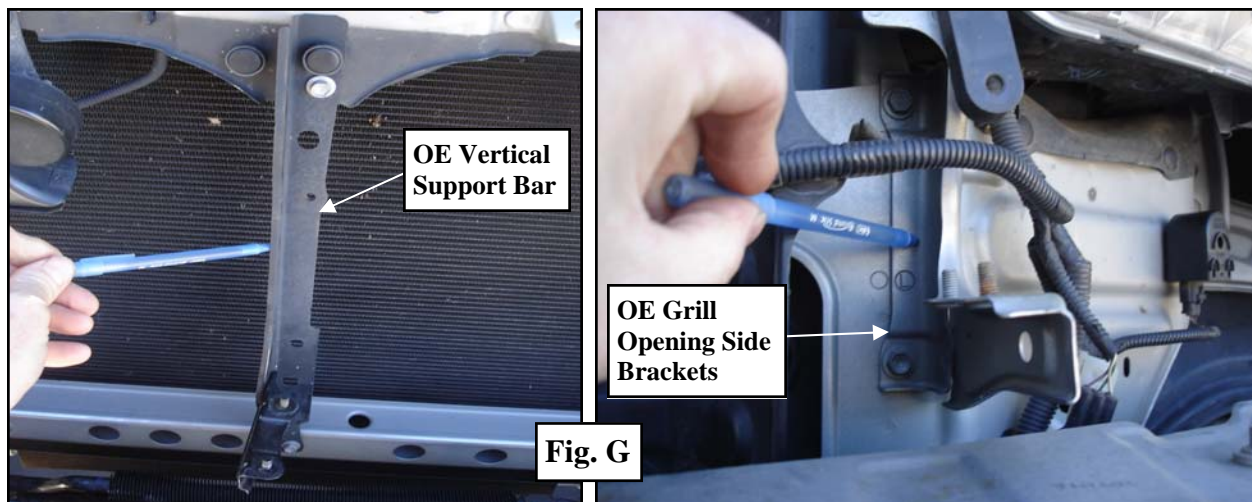
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**Step 7:** Unbolt the (6) bolts from the OE top bumper support plate. Remove the support plate from the vehicle. (Fig F) This support plate will not be reinstalled.



**Step 8:** Unbolt and remove the center vertical support bar. Also unbolt and remove the grill opening side brackets from both sides of the vehicle. These parts will not be reinstalled. (Fig G)



**Step 9:** Carefully remove the front bumper from the vehicle.

**Step 10:** Unbolt and remove the OE outside support bracket under the head light assemblies and the OE side bumper support brackets from the vehicle. (Fig H) These support brackets will not be reinstalled.



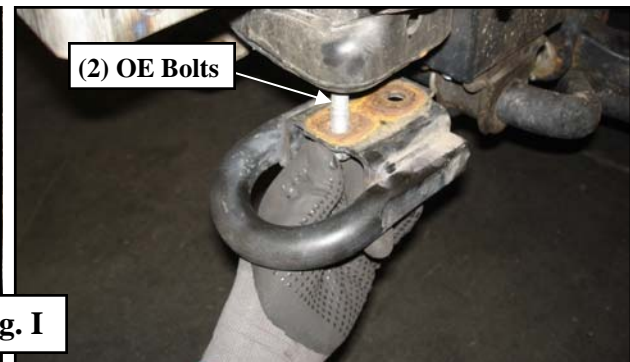
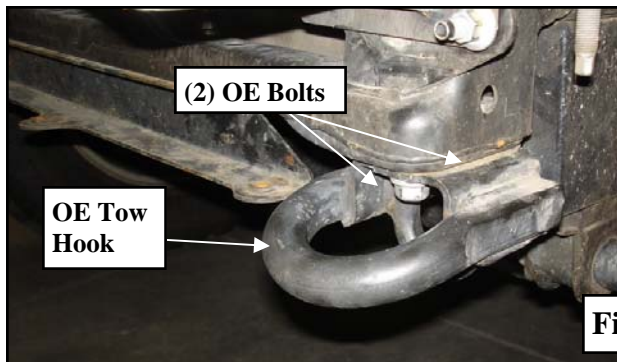


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**Step 11:** Unbolt and remove the OE tow hooks from the vehicle and discard. Save the (2 per side) OE hardware for reinstallation. (Fig I)



**Step 12:** This is what your vehicle should look like at this point in the installation. (Fig J)

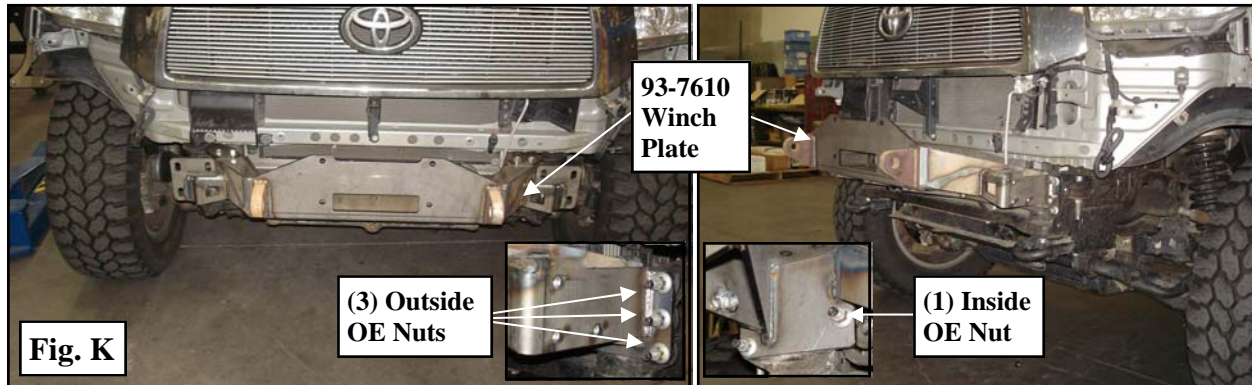




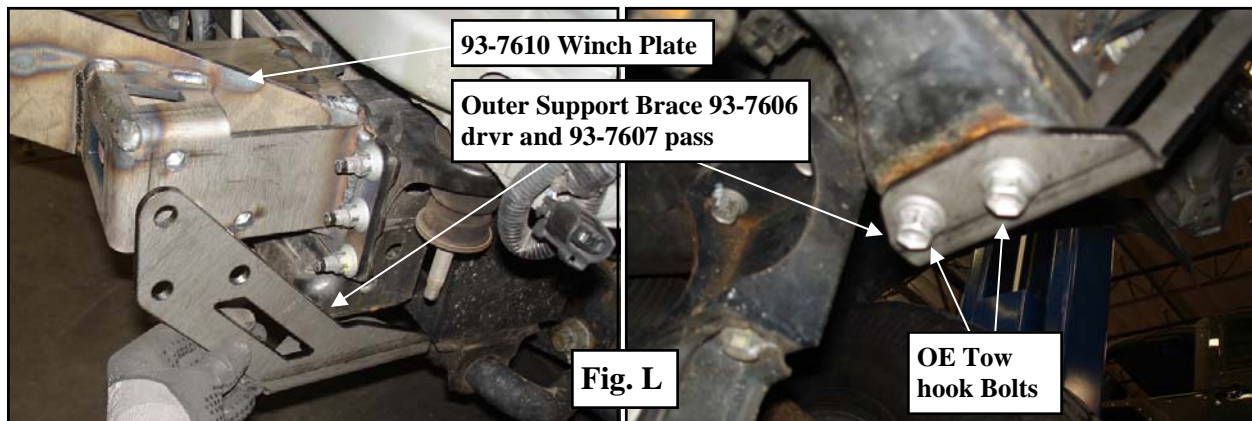
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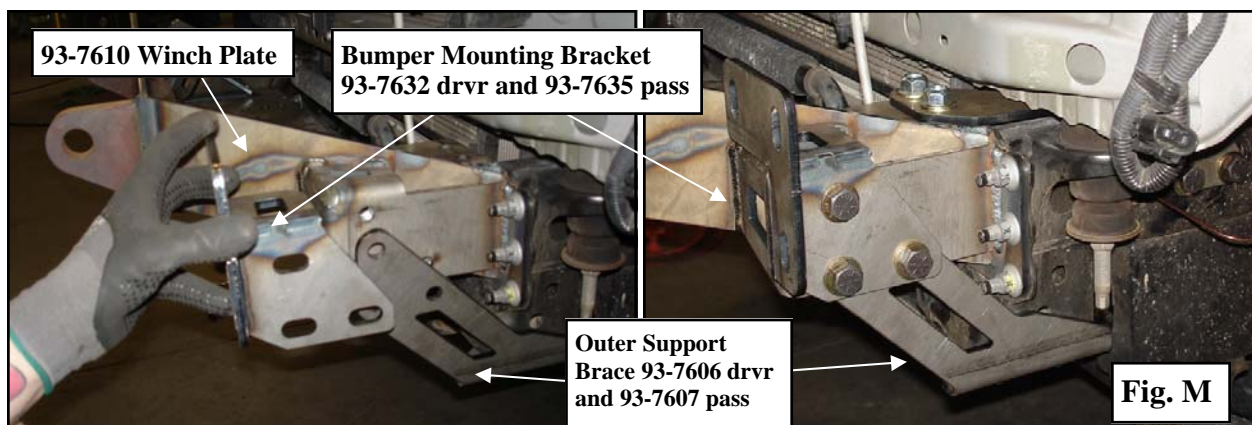
**Step 13:** Install the winch plate (93-7610) into the OE bumper mounting studs using the previously removed (3 per side) outside and (1 per side) inside OE nuts. Be sure to apply thread locker to the studs. (Fig K)



**Step 14:** Install the outer support braces (93-7606 Drvr and 93-7607 Pass) to the frame using the (2 per side) previously removed OE tow hook bolts. Leave the bolts loose at this time. (Fig L)



**Step 15:** Install the bumper mounting brackets (93-7632 Drvr and 93-7635 Pass) to the winch plate and outer bumper support braces using the (3 per side) supplied 1/2" X 1 1/2" bolts. Leave all bolts loose for final adjustment. (Fig M)



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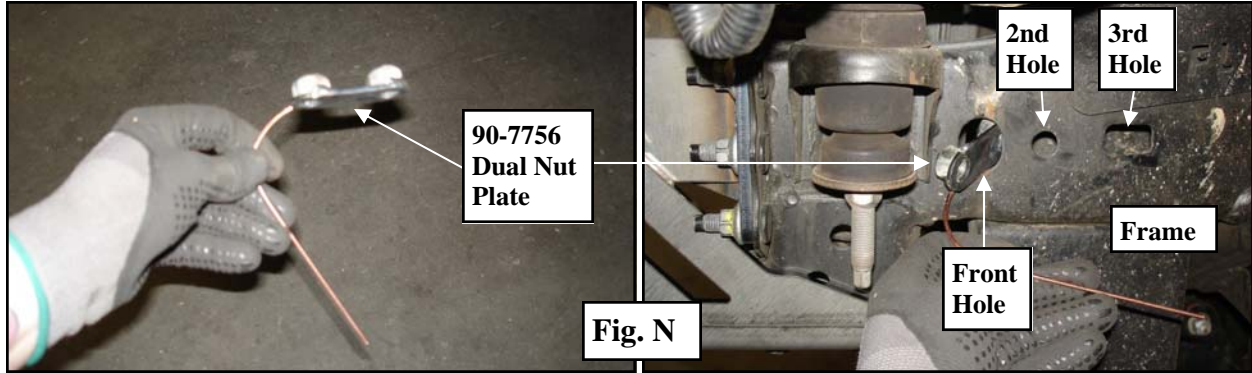




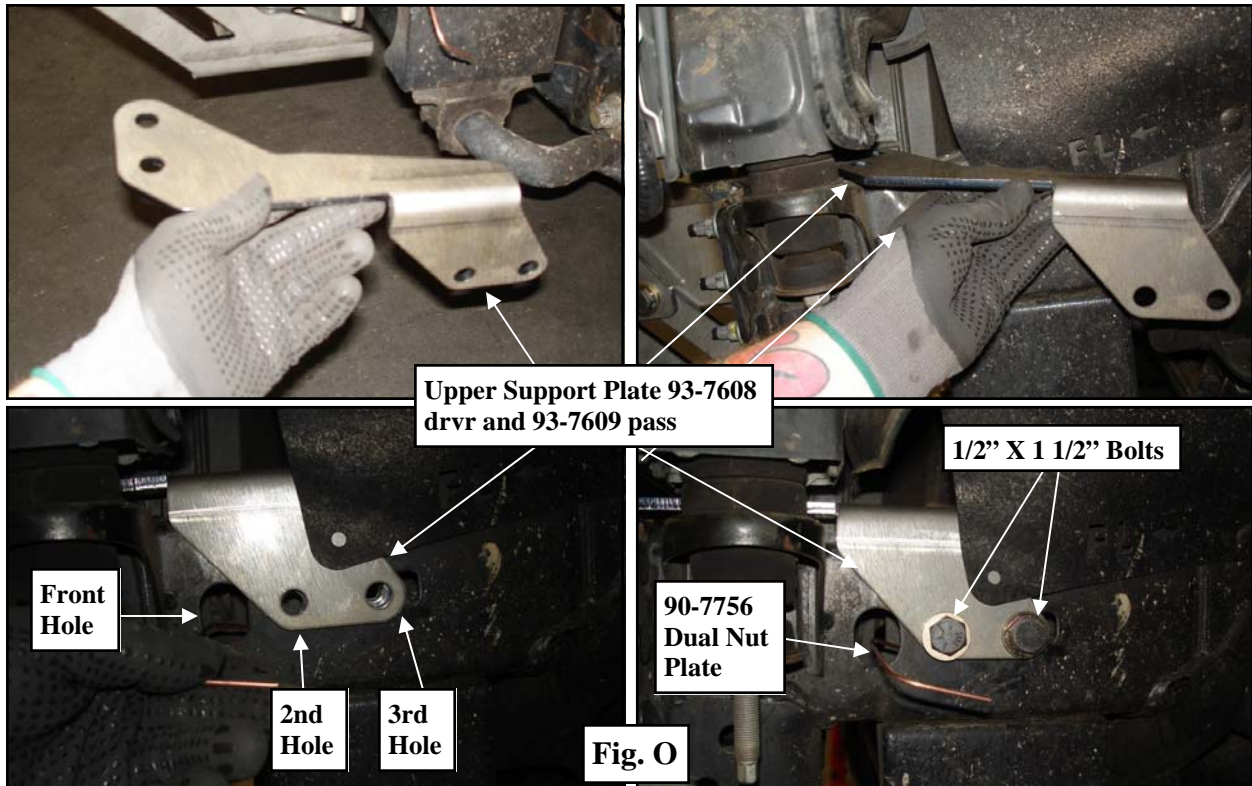
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**Step 16:** Insert the (1 per side) dual nut plate (90-7756) into the front frame hole. (Fig N)



**Step 17:** Install the upper support plate (93-7608 Drvr and 93-7609 Pass) from the outside behind the core support, and secure the rear of the plate to the dual nut plate (90-7756) through 2nd & 3rd holes in the frame rails using the (2 per side) supplied 1/2" X 1 1/2" bolts and washers. Leave bolts loose at this time. (Fig O)



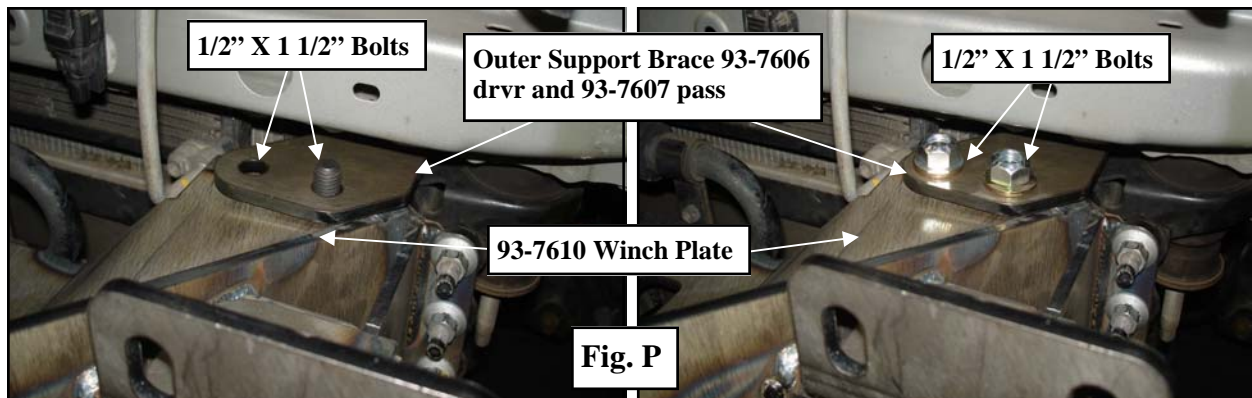
**Step 18:** Secure the front of the upper support plate (93-7608 Drvr and 93-7609 Pass) to the holes in the top of the winch plate (93-7610) using the (2 per side) supplied 1/2" X 1 1/2" bolts and hardware. (Fig P)

**IMPORTANT!** The 1/2" bolts must be inserted from the bottom due to clearance issues.



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**Step 19:** Torque all of the 1/2" winch plate and bracket assembly mounting hardware to **85** ft./lbs or OE hardware to manufacturers specifications.

**Step 20:** Modify the vehicle wiring harness and DLAA fog light connector.

**IMPORTANT!:** *DO NOT connect the winch or fog lights wiring harnesses until the bumper is fully installed.*

**Step 21:** Install the bracket (90-7318) to the 2 1/2" amber DLAA fog light (LA5070) as a replacement for the included mounting bracket from amber driving light kit (S/B612800-02). (Fig Q)

**Step 22:** Install the included mounting bracket to the 3 1/2" clear DLAA fog light (LA2040) from clear driving light kit (S/B612800-01). (Fig Q)



**Step 23:** Install the fog lights into the new M1 front bumper (93-7669) using the supplied (4 per side) 1/4"-20 X 3/4" bolt and hardware. (Fig Q)



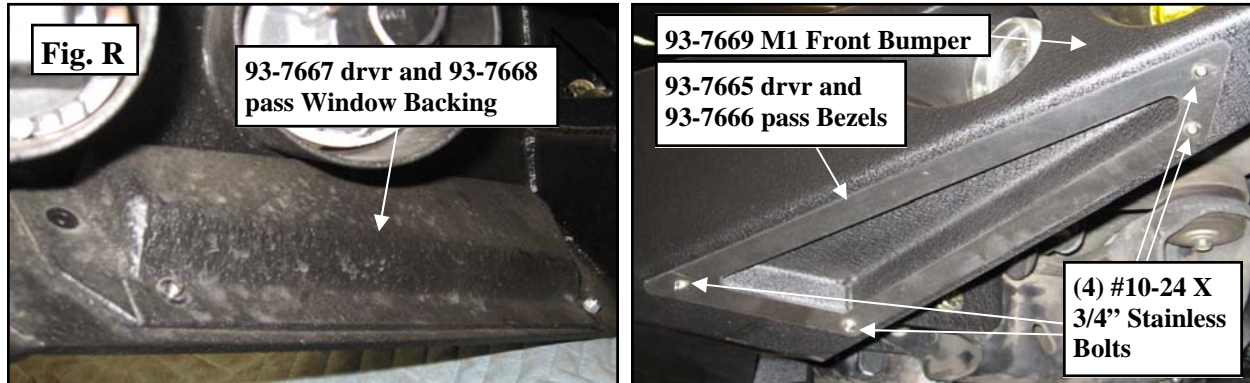


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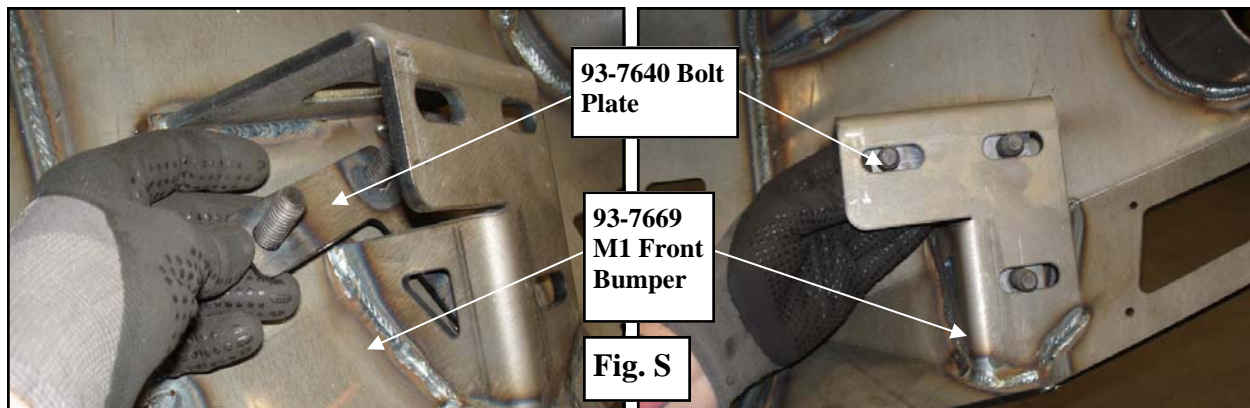
(Part # SB612840)

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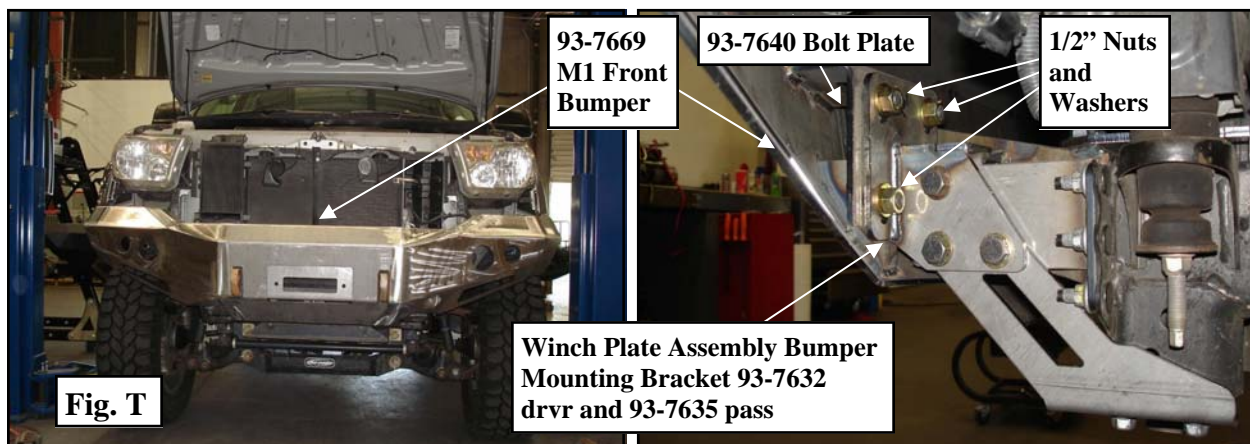
**Step 24:** Install the window backing (93-7667 Drvr and 93-7668 Pass) and bezels (90-7665 drvr and 90-7666 pass) to the new M1 front bumper (93-7669) using (4 per side) 10-24 X 3/4" stainless button head bolts and #10 hardware. (Fig R)



**Step 25:** Insert the (1 per side) bolt plates (90-7640) into position on the mounting plates on the M1 Tundra bumper (93-7669). (Fig S)



**Step 26:** Carefully raise and install the new M1 Tundra bumper (93-7669) assembly to the winch plate assembly bumper mounting brackets (93-7632 Drvr and 93-7635 Pass). Secure using the supplied (6 per side) 1/2" nuts and washers. Leave hardware loose at this time. (Fig T)



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**Step 27:** Properly align the M1 bumper (93-7669) on the vehicle. Once proper alignment is achieved, torque the 1/2" bumper mounting hardware to 85 ft./lbs. (Fig I)

**Step 28:** Reinstall the OE plastic panels under the head lights using the previously removed OE retainers.

**Step 29:** Connect the fog light wiring connectors to the connectors on the vehicle. Test, aim & adjust the fog lights at this time.

**Step 30:** Installation is now complete. (Fig U)



**Fig. U**

### Product cleaning and maintenance instructions

**Stainless Steel Finish** – Aluminum polish may be used to polish small scratches and scuffs on the finish. Mild soap, window or glass cleaner may be used to clean the finish. **Dual state powder coat finish** – Mild soap, window or glass cleaner may be used to clean the finish. In order to protect the finish, you may wax your product on a regular basis with pure carnauba automotive wax. Do not use any types of soap, polish or wax that contains abrasive that could damage the finish. **Textured coated finishes** should be cleaned with a mild soap on a damp sponge. Do not apply polish or wax that requires to be removed by means of buffing. This type of wax is commonly used at car wash facilities. **Chrome Finish** – Mild soap, window or glass cleaner may be used to clean the finish. In order to protect the finish you should wax your product on a regular basis with pure carnauba automotive wax. Do not use any types of soap, polish or wax that contains abrasive that could damage the finish

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Use this only as a guide for hardware without a called out torque specification in the instruction manual.

<b>Bolt Torque and ID</b>						
<b>Decimal System</b>			<b>Metric System</b>			
All Torques in Ft. Lbs. Maximums						
Bolt Size	Grade 5	Grade 8	Bolt Size	Class 9.8	Class 10.9	Class 12.9
5/16	15	20	M6	5	9	12
3/8	30	45	M8	18	23	27
7/16	45	60	M10	32	45	50
1/2	65	90	M12	55	75	90
9/16	95	130	M14	85	120	145
5/8	135	175	M16	130	165	210
3/4	185	280	M18	170	240	290

1/2-13x1.75 HHCS  
 D T L X  
 Grade 5 Grade 8  
 (No. of Marks + 2)

M12-1.25x50 HHCS  
 D T L X  
 P

G = Grade (Bolt Strength)  
 D = Nominal Diameter (Inches)  
 T = Thread Count (Threads per Inch)  
 L = Length (Inches)  
 X = Description (Hex Head Cap Screw)

P = Property Class (Bolt Strength)  
 D = Nominal Diameter (Millimeters)  
 T = Thread Pitch (Thread Width, mm)  
 L = Length (Millimeters)  
 X = Description (Hex Head Cap Screw)



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## Limited Warranties

Smittybilt's products are covered under the following limited warranties only. Note that the duration of the limited warranty differs according to the material and finish of the product purchased. Subject to the duration and conditions of the limited warranty stated below, Smittybilt warrants to the original retail purchaser that its products are free from defects in material and workmanship. All other warranties and representations express or implied, are hereby disclaimed, including fitness for merchantability and buyer's intended use or purpose. All parts are sold "AS IS" except for the limited warranties granted herein. Buyer assumes all risks as to the selection, suitability and performance of all goods and products selected. This limited warranty does not cover damage or impairment in any part due to misuse, improper installation, accident or contact with on-road or off-road hazards, product modification, improper or inadequate cleaning and/or maintenance. Smittybilt is not responsible for items damaged during shipping. This warranty is not transferable from the original buyer. For the original Buyer to be eligible for the limited warranty coverage, the Buyer must provide proof of purchase. Smittybilt strongly recommends returning the warranty registration card.

Customer's remedy hereunder shall be limited only to repair or replacement (at Smittybilt's option) of any defective part(s) returned to Smittybilt at customer's expense. The determination of whether or not a returned part is defective or subject to coverage under the limited warranties stated herein shall be made at Smittybilt's sole discretion.

## Duration of Limited Warranty

### **Limited Lifetime Warranty on Stainless Steel Products -**

Smittybilt stainless steel products carry the foregoing limited repair or replacement warranty against workmanship and defects in the material so long as the original purchaser retains the original stainless steel parts.

### **Limited Five (5) Year / 50,000 Mile Pro-Rata Warranty (whichever occurs first) on Dual-Stage Powder Coating Products -**

Smittybilt dual-stage powder coated products carry the foregoing limited repair or replacement warranty for a period of (5) years or 50,000 miles (whichever occurs first) from date of purchase against workmanship and defects in the material, provided that any claim submitted after (2.5) years from date of purchase shall, if accepted, be satisfied by Smittybilt offering customer a credit on the purchase of a replacement product equal to fifty percent (50%) of customer's initial purchase price.

### **Limited Three (3) Year / 36,000 Mile Pro-Rata Warranty (whichever occurs first) on Chrome Products-**

Smittybilt chrome products finished carry the foregoing limited repair or replacement warranty for a period of three (3) years or 36,000 miles against workmanship and defects in the material (whichever occurs first) from the date of purchase.

To assure product quality, Smittybilt reserves the right to change product design, material, specification and finishes without prior notice to customers. This limited warranty gives you specific legal rights and you may also have other rights, which may vary from state to state. Some states do not allow limitations on how long an implied warranty lasts, so the above limitations may not apply as to you. Also, some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitations or exclusions may not apply to you. Smittybilt reserves the right to discontinue product lines and substitute products, or provide other remedies than those listed in this limited warranty for those discontinued products.

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