


Part Number: PT228-04030

Section I  Installation Preparation

Kit Contents

Item #	Quantity Req'd.	Description
1	1	Center Hitch Assembly
2	2	Frame Mounting Bracket
3	2	Frame Reinforcement Bracket
4	1	Hitch Cover
5	1	DIO Installation Instructions

Hardware Bag Contents

Item #	Quantity Req'd.	Description
1	14	M12x1.25x35 Bolt
2	12	M12x1.25 Spirallock nut



Additional Items Required For Installation

Item #	Quantity Req'd.	Description
1		


Conflicts

Note:

Recommended Tools

Safety Tools	
Safety glasses	
Vehicle Protection	None
Special Tools	
None	
Installation Tools	
Ratchet w/extension	4  min.
Sockets	19 mm - deep well
Torque wrench	0-100 lbf  ft reading
Special Chemicals	
None	

General Applicability






PT228-04030  MY 1997 - current Toyota Tacoma Trucks

Recommended Sequence of Application

Item #	Accessory	
1	Receiver Hitch	
2	Wiring Harness	
3		



*Mandatory

Legend



	STOP: Damage to the vehicle may occur. Do not proceed until process has been complied with.
	OPERATOR SAFETY: Use caution to avoid risk of injury
	CRITICAL PROCESS: Proceed with caution to ensure a quality installation.
	GENERAL PROCESS: This highlights specific processes to ensure a quality installation.
	TOOLS & EQUIPMENT: This calls out the specific tools and equipment required for this process

Section II  Installation Procedure


A. Preliminary Preparation

-  1. Wear safety glasses throughout this installation process.
- 2. Disconnect License Lamp Wiring.
 - i. Ensure Light Control Switch is off (tail lights off).
 -  ii. Unplug bumper license plate lamp wiring from vehicle side connection. (Fig. A1)


B. Remove Bumper from Bumper Mounting Brackets

-  1. Remove the two (2) M12 bolts (save for later re-use) from each side of the bumper that connect the bumper tie-plate to the bumper mounting brackets. (Fig. B1)
-  2. Carefully remove bumper and place to the side for later re-installation. (Fig. B2)

C. Remove Bumper Brackets

-  1. Remove and discard the two (2) M12 bolts and one (1) M12 nut from each side of the vehicle frame that connect the bumper-mounting bracket to the frame. (Fig. C1)
- 2. Note the location of the small welded tabs on each of the brackets as these are noted in a later installation step. (Fig. C1)

D. Position Frame Reinforcement Brackets

-  1. Position LH and RH frame reinforcement brackets on the inside of the frame so that all three holes align with the holes in the vehicle frame. (Fig. D1)

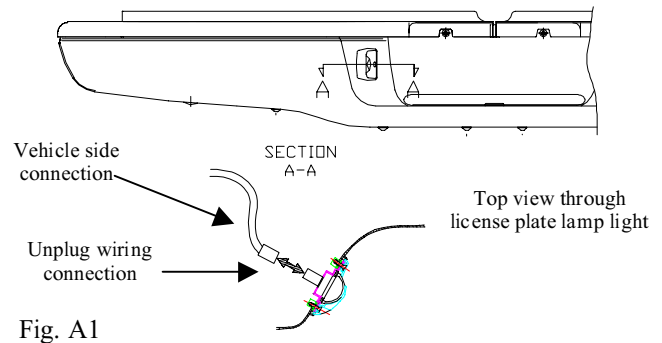


Fig. A1

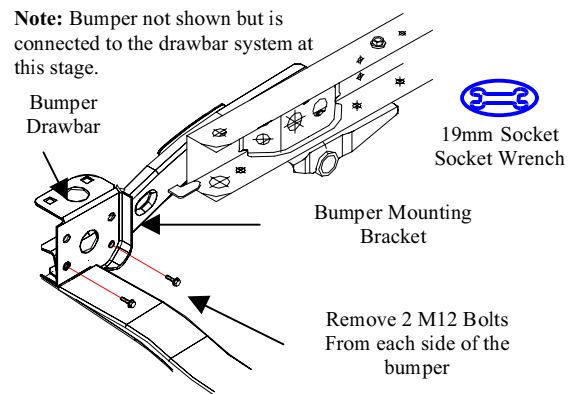


Fig. B1

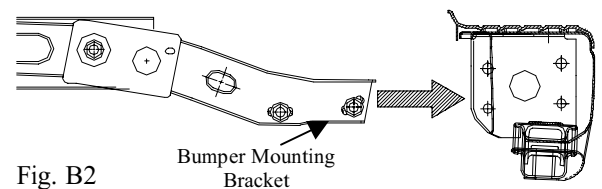


Fig. B2

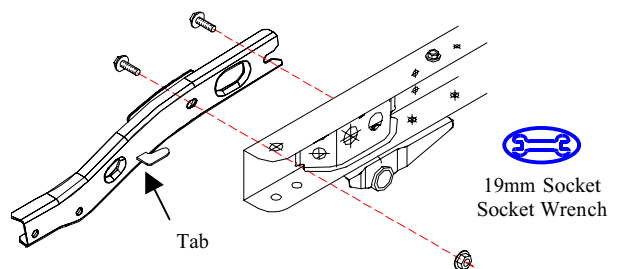


Fig. C1

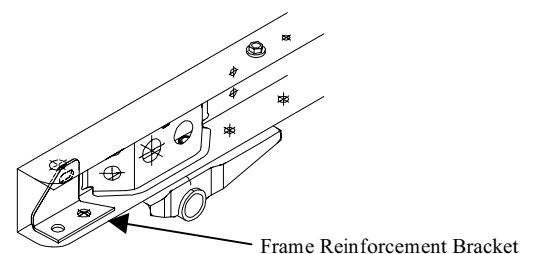









Fig. D1

E. Attach Receiver Hitch Mounting Brackets and Bumper Mounting Brackets to Vehicle Frame

-  1. Position driver's side receiver mounting bracket against the side of the vehicle frame. Align holes of bracket with holes in frame and frame reinforcement bracket. (Fig. E1)
-  2. Locate driver's side bumper mounting bracket on the outside of the receiver hitch-mounting bracket. (Fig. E1)
 - i. Align the receiver bracket to allow for bumper mounting tab to pass through the receiver-mounting bracket. (Fig. E2)
-  3. Hand start bolt A1 and nut A2 into rear bumper bracket attachment hole on side of vehicle frame.
- 4. Hand start forward bumper bracket bolt (B1) into existing weld nut (B2) inside vehicle frame. (Fig.E1)
 - i. Make sure both brackets are secure and flush with vehicle frame. (Fig. E2)
-  5. Hand start two (2) M12 bolts (C1, D1) and M12 nuts (C2, D2), provided in hardware kit, into the two mounting locations on the lower side of the frame until frame reinforcement bracket is flush with frame. (Fig. E2)
- 6. Repeat above steps (E.1.  E.5.) for the passenger side bracket.

F. Reinstall Bumper

-  1. Reinstall bumper to bumper mounting brackets using the four (4) M12 bolts removed in Step B-2. Bolts will thread into the existing weld nuts on bumper mounting bracket. (Fig. F1)
-  2. Reconnect license plate lamp wiring.

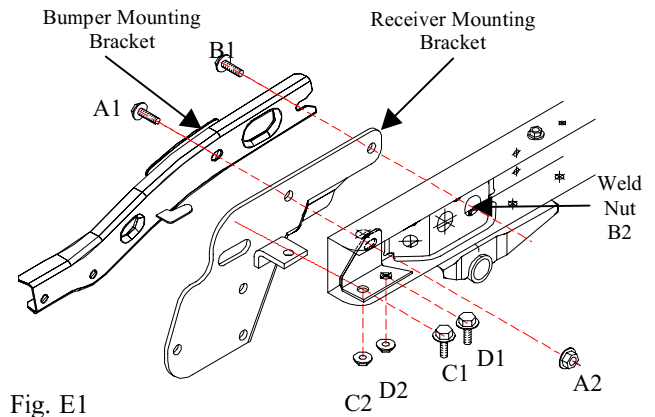


Fig. E1

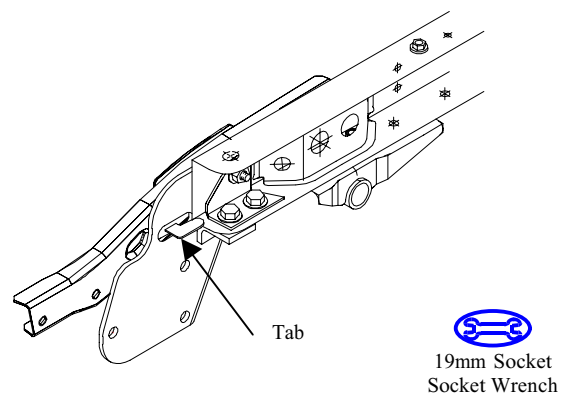


Fig. E2

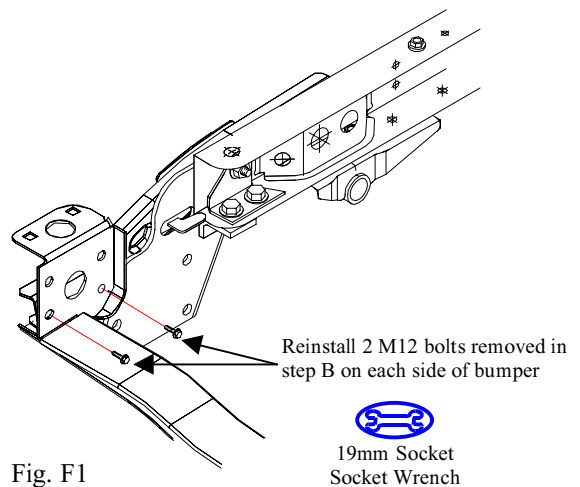


Fig. F1

G. Install Center Hitch Sub-Assembly

- ➡ 1. Position hitch center sub-assembly between previously installed receiver hitch mounting brackets. (Fig. G1)
- ➡ 2. Align 3-hole pattern on hitch sub-assembly and receiver hitch mounting bracket and hand start three (3) M12 bolts and three (3) M12 nuts per side (provided in hardware kit). (Fig. G2)
- ⚠ 3. Hitch should not contact bumper shell. (Fig. G2)

H. Tighten All M12 Bolts

- ⚠ 1. Tighten all 18 M12 bolts to 85 lbf☑t (115 N☑m.). (Fig. H1)
- ⚠ 2. Place hitch plug (provided in hardware kit) in glove box.
- ⚠ 3. Verify function of license plate lamps

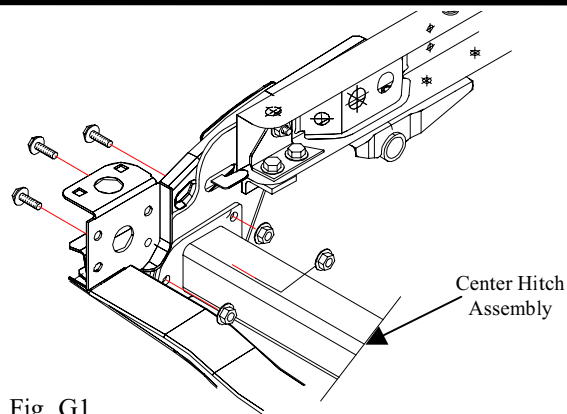


Fig. G1

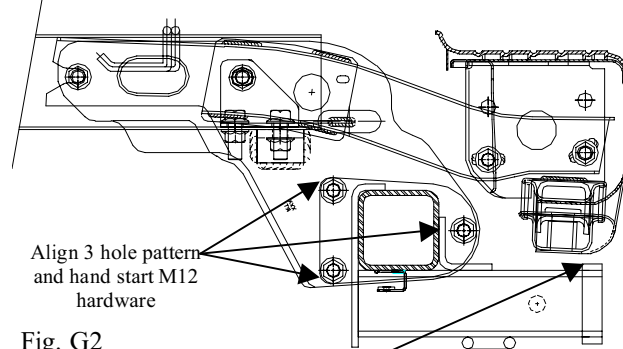


Fig. G2

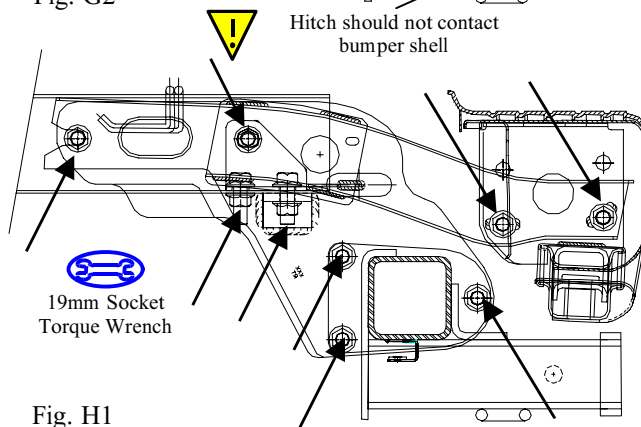



Fig. H1



Section III ☑ Functional Verifications

Check: _____

-  Inspection torque (M12 bolts)
- Bumper shell
- Hitch plug
- Verify function of license plate lamps

Look For: _____

- 85 ± 10 lbf☑t (115 ± 15 N☑m)
- No contact with hitch
- Placed in glove box
- Lamps illuminate