



# 2023+ TOYOTA SEQUOIA FRONT BUMPER



## INSTALL GUIDE

LAST UPDATE 6/20/24 v1

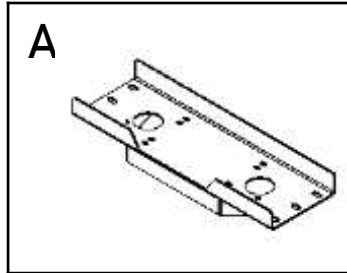
### PLEASE READ ENTIRE GUIDE BEFORE INSTALLATION

Recommended that you read this entire install guide before installation. Check that all hardware is present before starting or scheduling an install. This guide is supplemental to mechanical knowledge and ability. Anyone not familiar with automotive installation should seek professional installation.

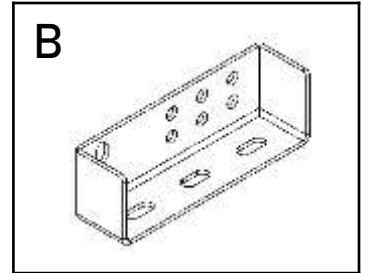
### INSTALL GUIDE

#### WINCH & FRAME MOUNTS

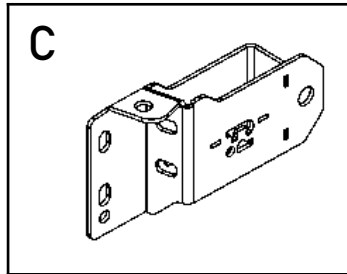
A Winch Mount 1



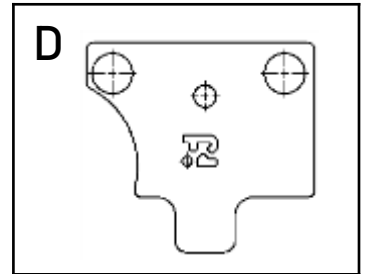
B Winch Mount Brackets 2



C Front Reinforcement Brackets 2

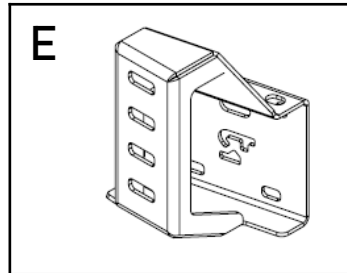


D Frame Spacer 2

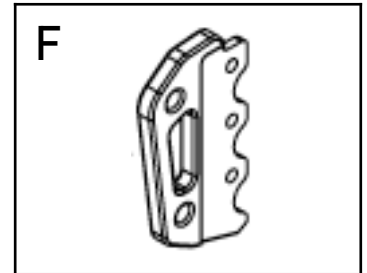


#### BUMPER MOUNTS

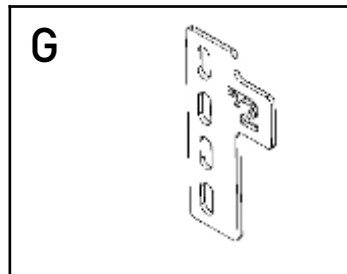
E Bumper Mount Bracket 2



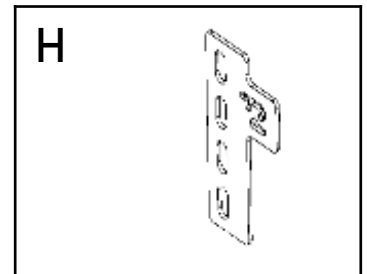
F Clevis Mounts A + B 2



G Mount Shim Thick 2



H Mount Shim Thin 2



#### BUMPER SPECIFIC HARDWARE

Sequoia Shutter Mount Top 1 + 2 2

Sequoia Shuter Mount Bottom 1

Sequoia Grill Mount Brace 2

Sequoia Grille Mount 1

NOTE - Extra hardware may be left over due to model or option specific items that may not be required for the install.

### WINCH & FRAME MOUNT HARDWARE

3/8"-16 X 1 1/4" Hex Cap Bolt	8
3/8"-16 Nyloc Nut	8
3/8" USS Washer	16
1/2"-13 X 1 1/2" Hex Cap Bolt	22
1/2"-13 Nyloc Nut	22
1/2" SAE Washer	44
3/4" - 10 X 4 1/4" Hex Cap Bolt	2
3/4" - 10 Nyloc Nut	2
3/4" USS Washer	4

### MISC HARDWARE

Sensor Bezels	4
Sensor Bezel Ties	4

### BUMPER HARDWARE

1/4" - 20 x 3/4" Button Head	4
1/4" - 20 x 1 1/4" Hex Cap Bolt	10
1/4" - 20 Nyloc Nut	14
1/4" SAE Washer	24
5/16"-18 X 1" Carriage Bolt	7
5/16"-18 Nyloc Nut	7
5/16" USS Washer	8
1/2"-1 X 1 1/2" Hex Cap Bolt	8
1/2"-13 Nyloc Nut	8
1/2" USS Washer	8
9/16" X 2" Hex Cap Bolt	6
9/16" Nyloc Nut	6
9/16" USS Washer	12

## 1 - REMOVE OEM BUMPER HARDWARE

Remove the front bumper OEM hardware from the front wheel wells on each side of the vehicle. Extra locations may need to be unbolted to flex the fender trim (or completely remove the trim) for bumper removal, access and installation.

NOTE - Extra hardware may need to be removed due to model or option specific items that were not be present for the models and year specific vehicles used in our install. Check for extra connections before removing hardware.

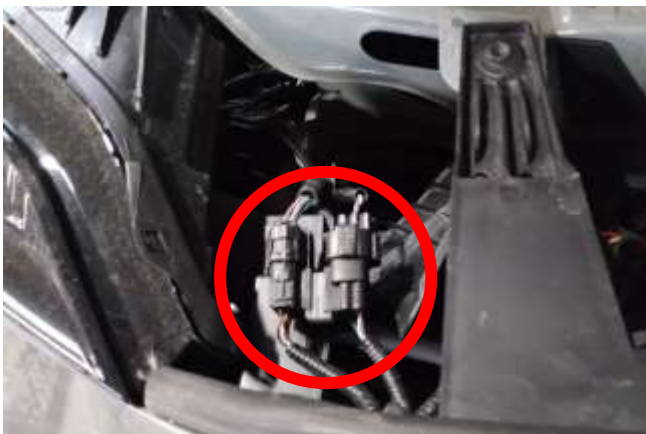


Unbolt the OEM hardware from the top of the grille as circled below. Save hardware as it will be reused.



## 2 - WIRING CONNECTIONS

Disconnect all wiring at the top of the grille,, grille shutter and main harness connect point. The OEM lights and sensors should remain attached to the bumper as part of the harness.



### 3 – BUMPER REMOVAL

Check for any remaining hardware connecting the bumper. Remove the bumper by pulling it away from the corner near the wheel wells.

### 4 – FRONT SPOILER REMOVAL

With the bumper removed, disconnect the wiring for the front spoiler motor. Unbolt all hardware and remove the motor and associated spoiler. The motor will be separated and remounted later to avoid setting a check engine code. The spoiler can't be remounted.



### 5 – CROSS MEMBER REMOVAL

Unbolt and remove the cross member as shown below. Save OEM hardware to be reused in mounting.



## 5 – CONTINUED

Remove the lower grace brace and remaining fixtures from the area of the cross member.



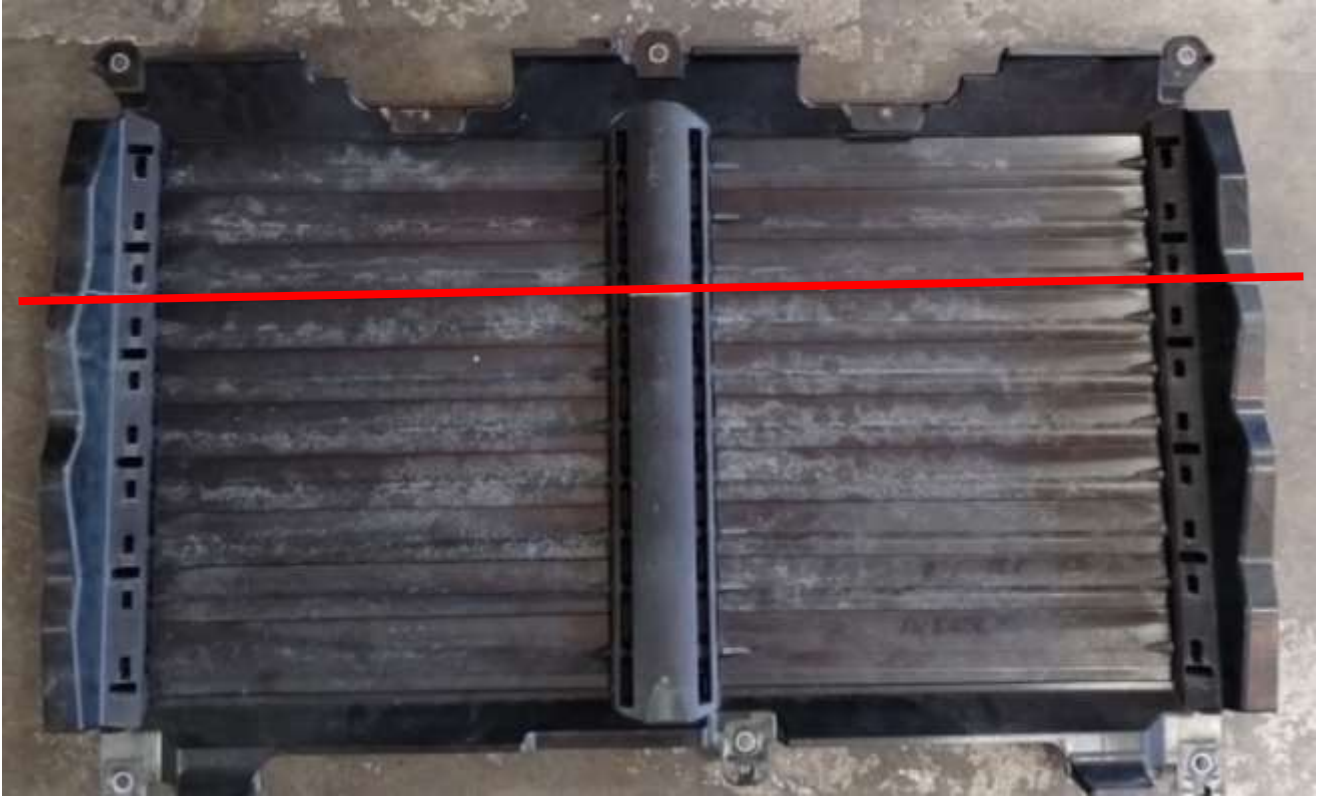
## 6 – GRILLE SHUTTER REMOVAL (TRD PRO OR NO WINCH INSTALLS CAN SKIP)

Unbolt grill shutter assembly from the grille and disconnect from the wiring harness.

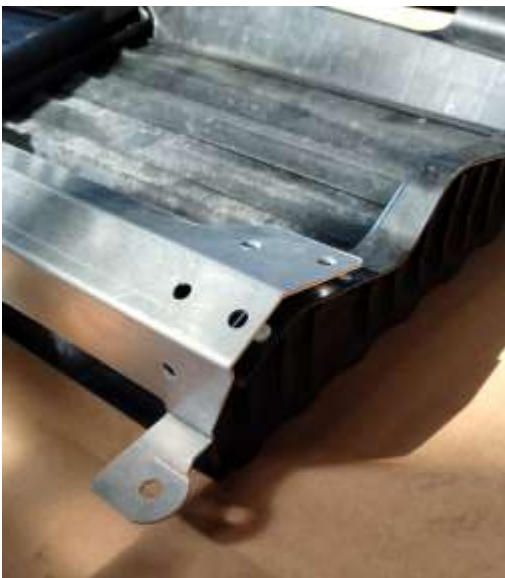


## 6 – CONTINUED

Cut apart the grill shutter assembly as shown below. Remove the wiring and motor inside as these will be reinstalled.



The cut section needs to match the mounting bracket piece as shown on the ends. With this part in place, align the triangle-shaped mount up with its shared location on the larger bracket. Mark the location where it will mount to the grille shutter and drill. Attach using the provided  $\frac{1}{4}$  hardware. Repeat the same operation for the larger bracket on the side locations. Reinstall the wiring and motor





With the mounts installed. The grille shutter can now be installed into the original OEM grille location.



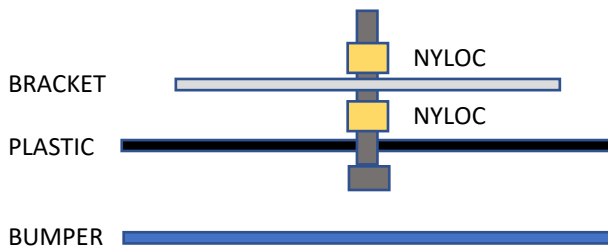
Attach the bottom mount to the OEM grille using the provided hardware. Install the grille brace later in the instructions after trimming the bumper and removing the sensor.







Attach the trapezoid piece as shown to mark the locations for drilling 2 holes to mount the 5/16" hardware. Recommended you separate the piece and DO NOT drill all the way into the front outside painted plastic of the bumper. Once drilled mount the bolts through thought and tighten down with Nyloc nuts. Reattach the trapezoid piece and again mount with another nyloc nut.





## 7 - WIRE LOOM REMOVAL

Unclip the wiring loom from the grille. Disconnect the parking sensors from the bezels. Be care to not break any clips or parts of the bezel as they will be reused in the new bumper. Unplug the fog lights and ACC at this time. Note the position of sensors and plug locations for correct reinstallation position.

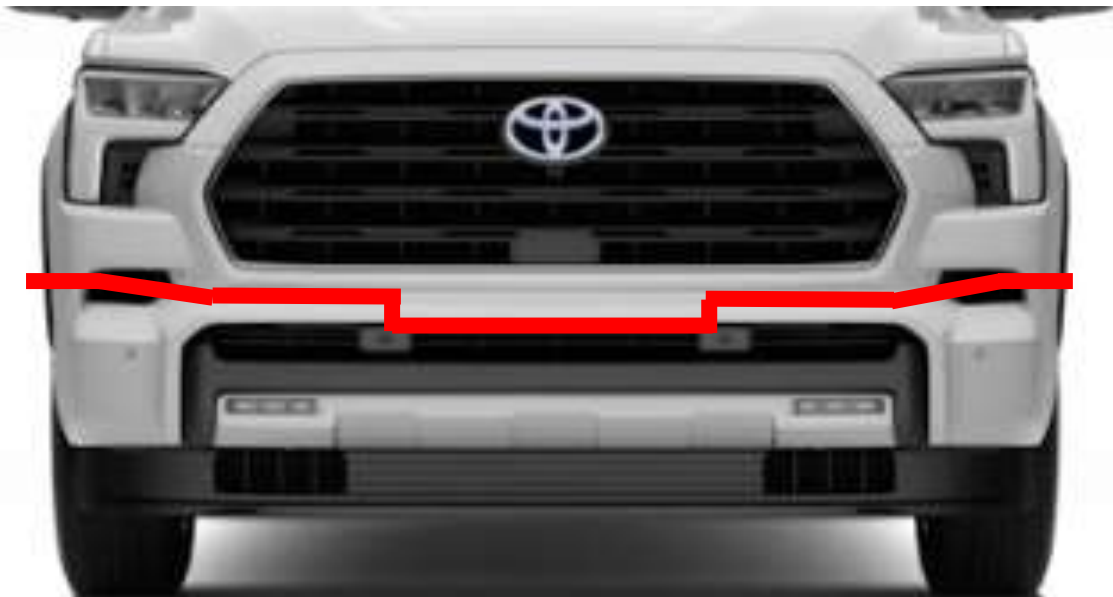


## 8 – GRILLE TRIM REMOVAL

Undo the clips and pull off the lower front fascia panel. Remove the OEM lights and the remaining lower grill side trim. Save hardware as some parts will be reinstalled after trimming.



General Cutting line.



## 9 – BUMPER TRIMMING

Cut 4 1/2" down from the body line



Cut back the fender piece 1 1/4" down from the body line (TRDs will lose the side light)

Cut across the vent down to below the grille to about 1" from the bottom of the grille curve. (about 5 1/2" to 6" from the bottom headlight edge)





Cut across past where the frame rail  
 Mounting brackets will be located in  
 steps 10-13s (this doesn't have to be  
 Exact and will be covered by the  
 bumper. May also require more  
 trimming if certain light bars are  
 added or for winch access.)  
 The region can be trimmed down  
 about 3/4" from the body line.  
 DO NOT cut away the lower outside  
 tabs as these are needed to reconnect  
 The grille in step 20.



## 10 – FRAME MODIFICATION (IF APPLICABLE) NOTE

The OEM frame tops may be bent or have undersized  
 holes.

This may require one of the options below

- 1 – Bend them back to level
- 2 – Drill holes to fit 1/2" hardware (recoat surface)
- 3 – Use 3/8" hardware in place of 1/2" if needed

## 11 – FRAME SPACER

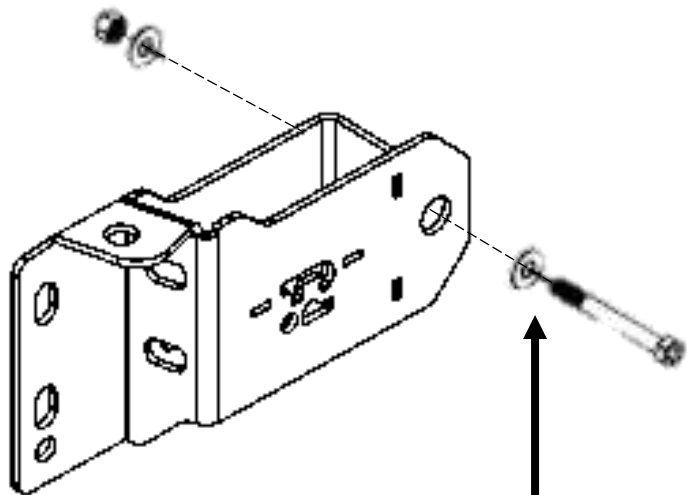
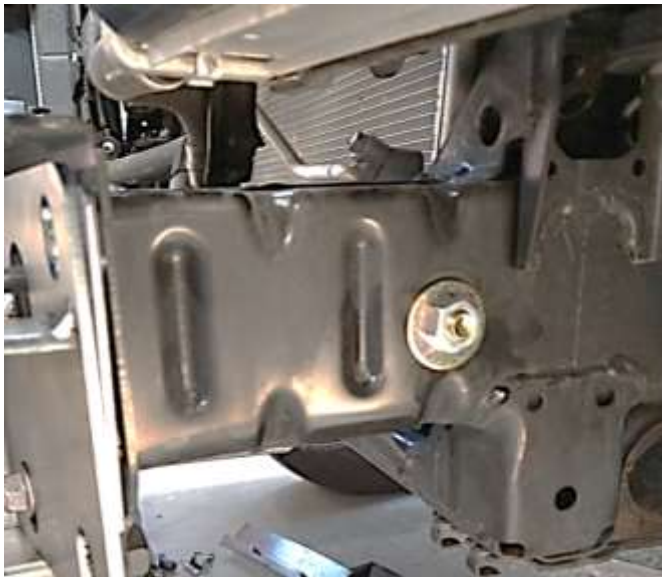
Attach the provided frame spacer as shown.



## 12 – REINFORCEMENT BRACKET INSTALLATION

Attach the reinforcement bracket next to the frame as shown. Mount using the provided 3/4" hardware.

Leave all hardware loose for adjustment.



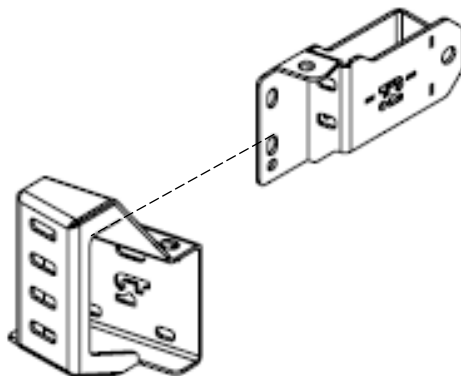
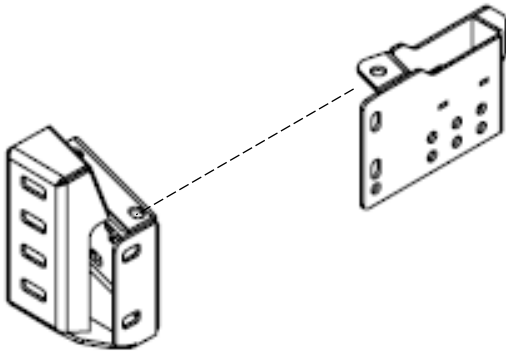
3/4" - 10 X 4 1/4" Hex Cap Bolt	2
3/4" - 10 Nyloc Nut	2
3/4" USS Washer	4

## 13- REINFORCEMENT BRACKET INSTALLATION

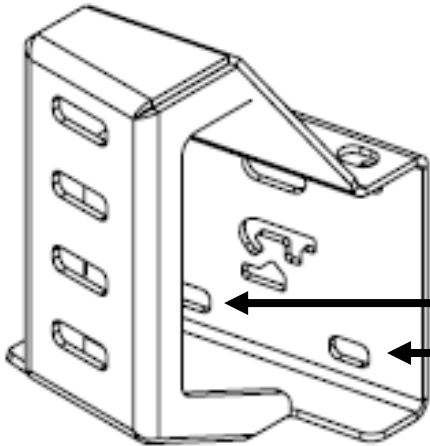
Attach the bumper mount bracket next to the frame and reinforcement bracket as shown. Mount using the provided 3/8" & 1/2" hardware and OEM bolts. Leave all hardware loose for adjustment.



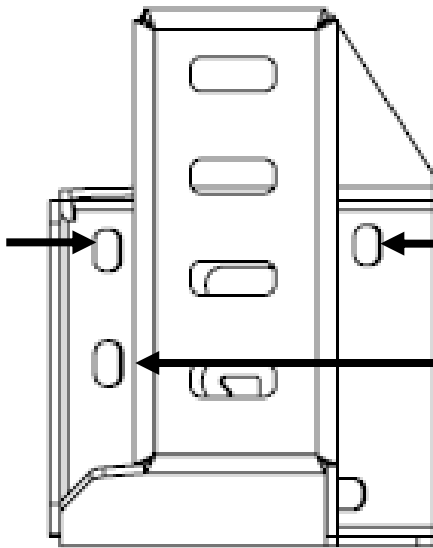
The intercooler plastic will need to be trimmed to fit the bracket area



# 13 - HARDWARE DIAGRAM

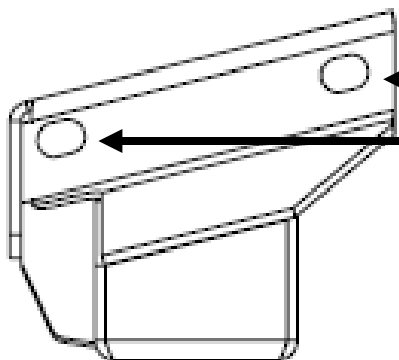


OEM HARDWARE	4
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3/8" - 16 X 1 1/4" Hex Cap Bolt	4
3/8" - 16 Nyloc Nut	4
3/8" USS Washer	8

1/2" - 13 x 1 1/2" HEX CAP BOLT	2
1/2" - 13 NYLOC NUT	2
1/2" USS WASHER	2



1/2" - 13 x 1 1/2" HEX CAP BOLT	4
1/2" - 13 NYLOC NUT	4
1/2" USS WASHER	8

## 110-FRAME MODIFICATION (IF APPLICABLE)\*

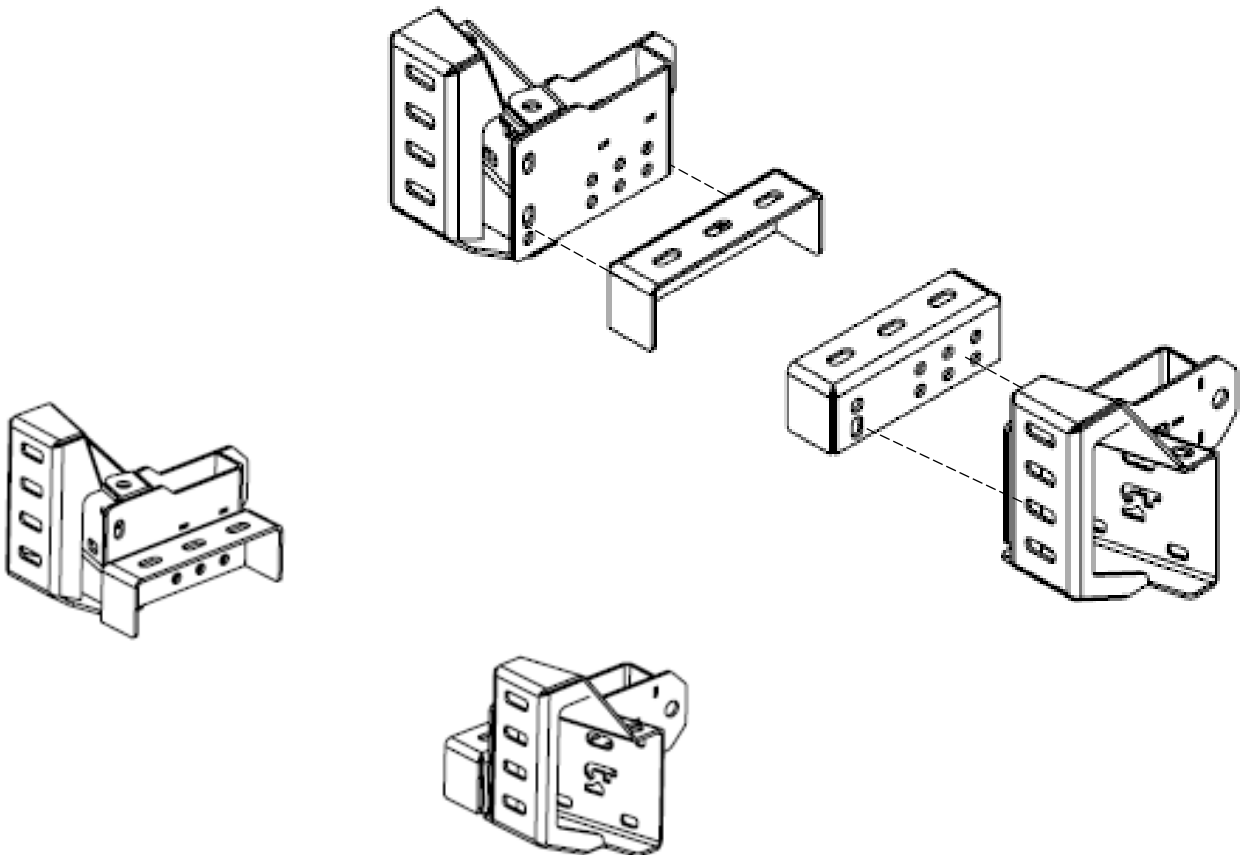
3/8" - 16X 1 1/4" Hex Cap Bolt	4
3/8" - 16 Nyloc Nut	4
3/8" USS Washer	8



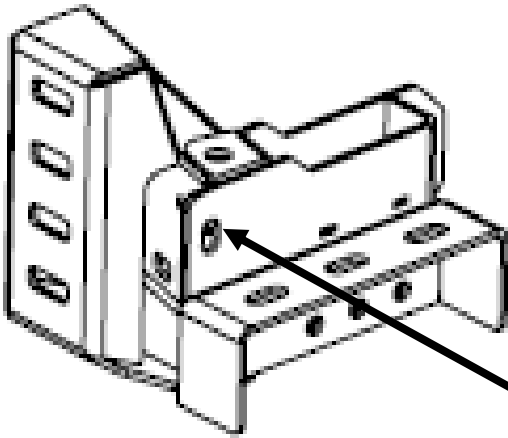
## 14 – WINCH MOUNT BRACKET INSTALLATION

Attach the winch mount bracket next to the bumper mount and reinforcement bracket as shown.

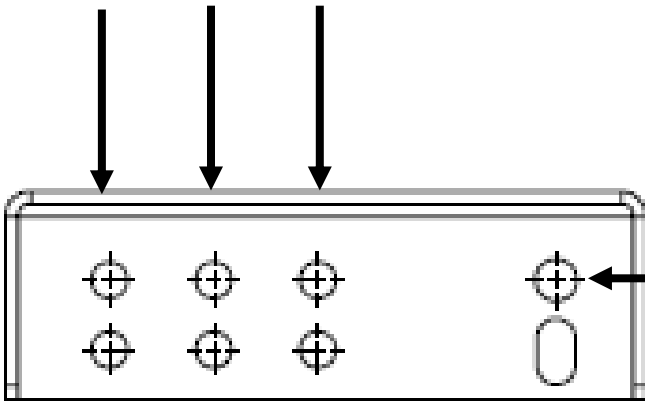
Use the provided 1/2" hardware. Leave all hardware loose for adjustment.



# 14 - HARDWARE DIAGRAM

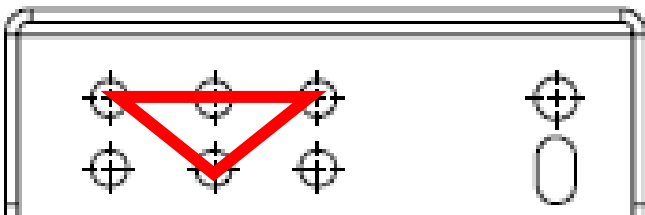
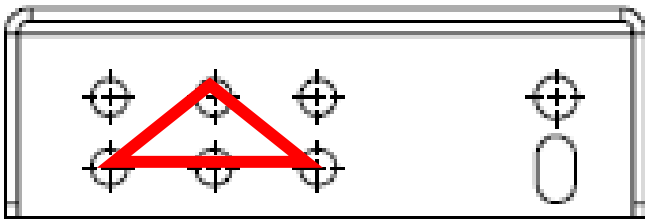


1/2" - 13 x 1 1/2" HEX CAP BOLT	2
1/2" - 13 NYLOC NUT	2
1/2" USS WASHER	4



1/2" - 13 x 1 1/2" HEX CAP BOLT	8
1/2" - 13 NYLOC NUT	8
1/2" USS WASHER	16

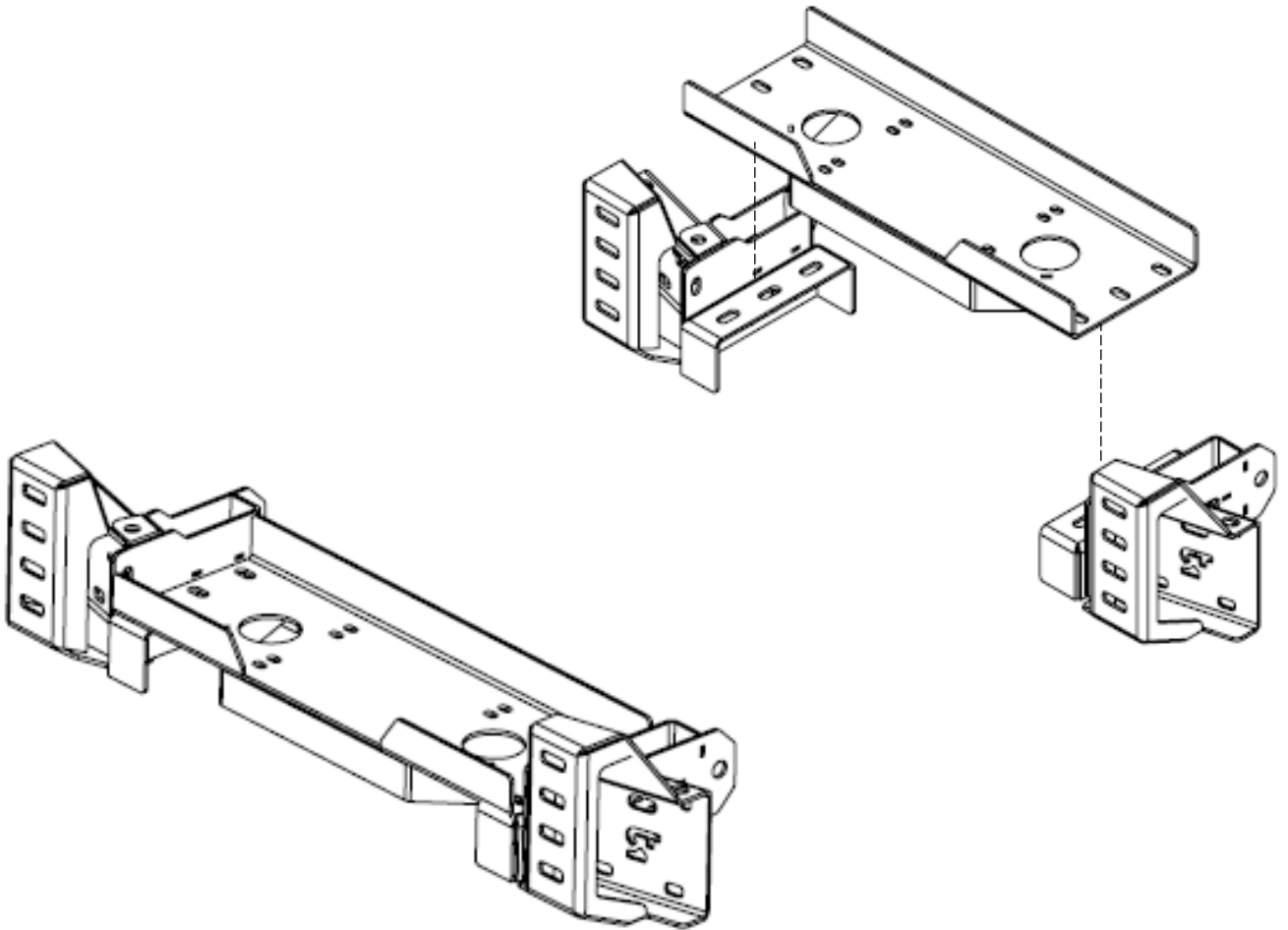
## MOUNT IN A TRIANGLE PATTERN



## 15 – WINCH MOUNT INSTALLATION

Place the winch mount onto the winch mount bracket as shown. Mount with the provided 1/2" hardware

Leave all hardware loose for adjustment.



1/2" – 13 x 1 1/2" HEX CAP BOLT

6

1/2" – 13 NYLOC NUT

6

1/2" USS WASHER

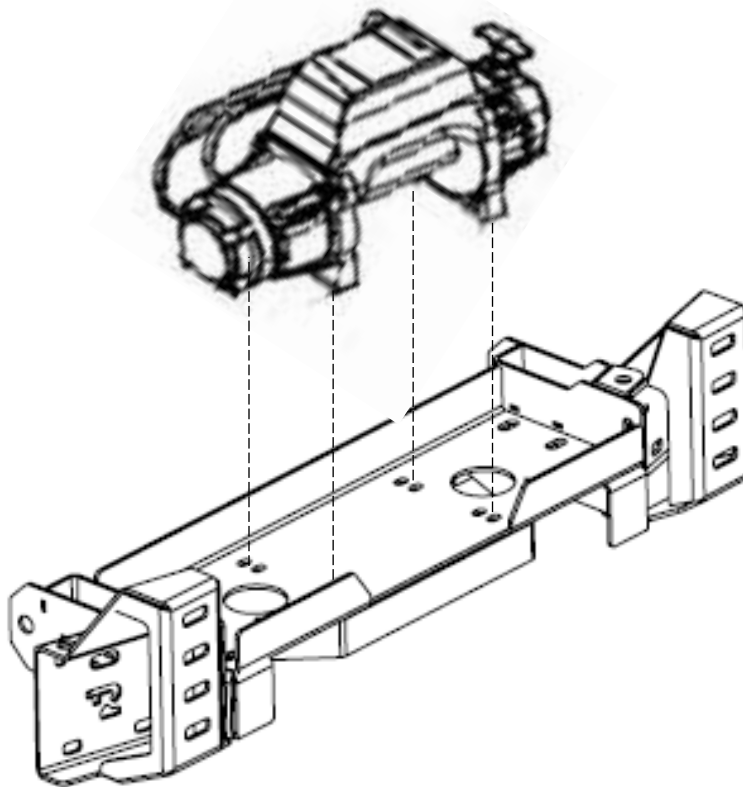
12

## 16 – TIGHTEN HARDWARE

Adjust the winch mount to its desired location and **TIGHTEN HARDWARE**. Check that all hardware is tightened including all brackets and mounting locations

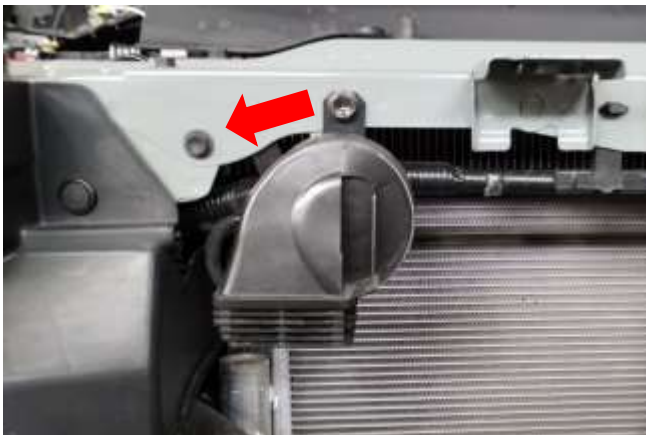
## 17 – WINCH INSTALLATION

Mount the winch at this time using the winch manufacture provided hardware. This will mount directly to the winch mount. Adjust as needed, and see winch section for details



## 18 – SPOILER MOTOR RELOCATION (IF APPLICABLE)

Unbolt and relocate the horn as shown. Before for reinstalling the spoiler motor, bend the tab back from the old horn location. Next the motors housing will need to be trim of tabs or gussets for clearance and weight. Once trimmed reinstall the motor into the horns original location. Don't over tighten and use the provided washer to prevent cracking of the housing



## 19 - CONTINUED



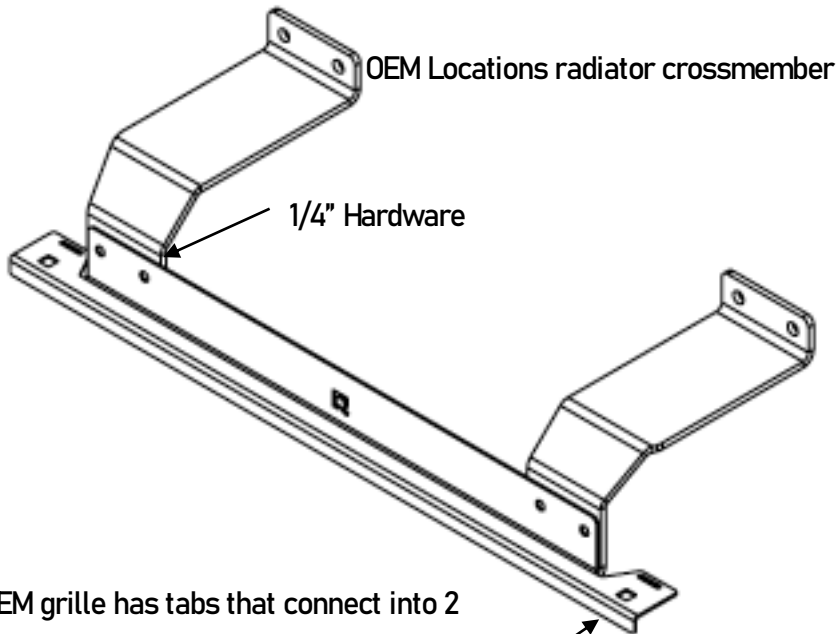
## 20 - GRILLE BRACE

Attach the grille brace brackets to the crossmember above the winch location using the OEM bolts. Leave loose for adjustment once on the vehicle and the bumper is mounted.



## 20 – CONTINUED

Attach the grace brace to radiator crossmember and using the OEM bolts. This will attach to the OEM



OEM grille has tabs that connect into 2 black boxes. Remove these boxes and relocate to the tabs on the end. Grille will reconnect to these



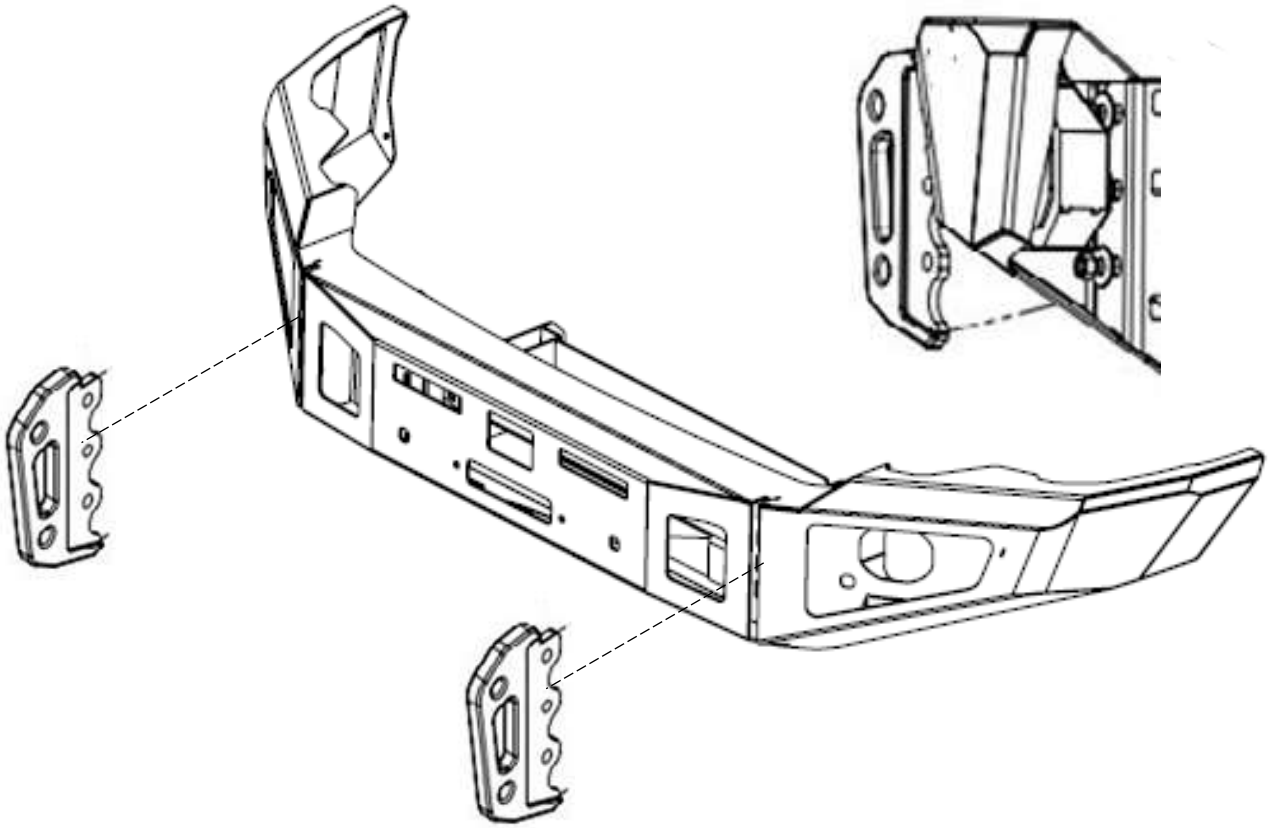
## 21 – OEM BUMPER REINSTALLATION

Loosely reinstall the wiring harness in the grille area matching the positions of sensors and plug locations from before, this will position the harness once the bumper is installed. Make sure wiring or other items including the winch rope are clear of pinch points for installation.. Reinstall the OEM bumper. Mask off the area around the grill and cut lines for installation of the bumper.



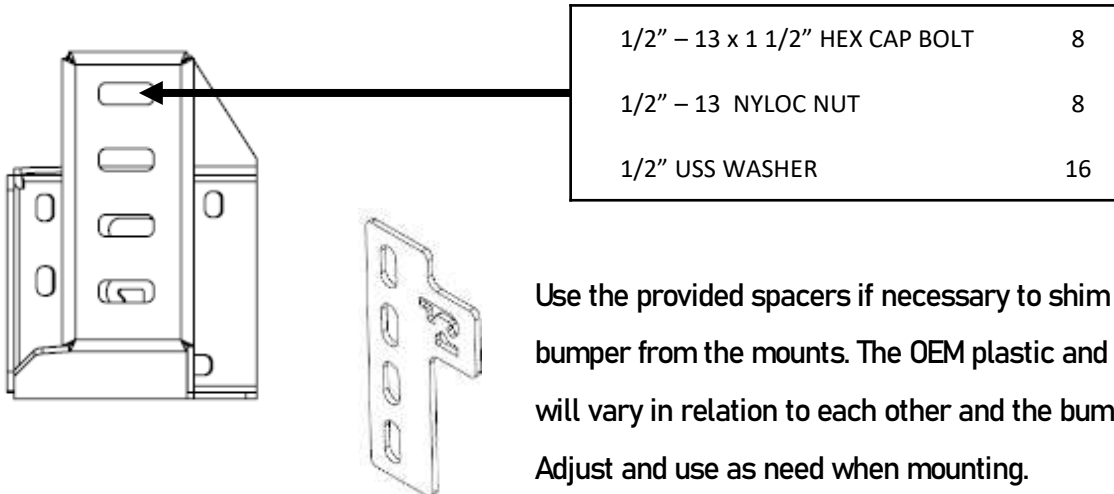
## 22 – CLEVIS INSTALLATION

Mount the clevis mounts to the bumper as shown. Use the provided 9/16" hardware



## 23 – BUMPER MOUNTING

Mount the bumper as shown using the provided 1/2" hardware. Center the bumper with the vehicle and align gaps between the body and bumper to your preference before mounting. Mount the front bumper using the OEM hardware as shown below. Leave all hardware loose for adjustment.



Use the provided spacers if necessary to shim the bumper from the mounts. The OEM plastic and frame will vary in relation to each other and the bumper. Adjust and use as need when mounting.

## 23 – BUMPER MOUNTING

Mount the bumper as shown using the provided 1/2" hardware. Center the bumper with the vehicle and align gaps between the body and bumper to your preference before mounting. Mount the front bumper using the OEM hardware as shown below. Leave all hardware loose for adjustment.

## 24– WIRING HARNESS

Reconnect the wiring harness into the new bumper. Place all wiring out of the way of mounting points and hardware locations. Check that the wiring loom connectors match the original points of connection per each side of the vehicle. Install the new bezels and connect the sensors. When using the provided replacement rubber bezels use WD40 and align the fat edge directional to the pointed surface when fitting. Secure the wiring loom.

## 25– TIGHTEN HARDWARE

Adjust the bumper to its desired location and TIGHTEN HARDWARE. Check that all hardware is tightened including all brackets and mounting locations. Reconnect the parking sensor wiring harness and other connections to the vehicles electronics and secure all loose wiring. Check that everything is working and adjust if needed before driving on the road.

### ADDITIONAL LINKS

<https://www.exp-one.com/wp-content/uploads/2016/10/Proper-Care-and-Maintenance.pdf>

<https://www.exp-one.com/wp-content/uploads/2016/10/Paint-touch-up-instructions.pdf>

<https://www.exp-one.com/wp-content/uploads/2018/02/Exp-One-2016-TC-word-doc.pdf>

**TIGHTEN ALL HARDWARE AFTER EVERYTHING IS INSTALLED ON THE VEHICLE  
CHECK AND RETIGHTEN ALL HARDWARE AFTER THE FIRST 100 MILES AND  
AFTER OFF ROADING. CHECK REGULARLY**