



INSTALLATION GUIDE

2024-UP TOYOTA LAND CRUISER STEALTH FRONT BUMPER F770343070103



TOOLS REQUIRED

- 10mm, 17mm, 7/16, 9/16, 3/4 Sockets
- 10mm, 17mm, 7/16, 9/16, 3/4 Wrenches
- Flathead Screwdriver
- Phillips Screwdriver
- 5/32, 7/32 Allen
- Zip Ties
- Cutting Tools
- Heat Gun
- Razor Blade



SKILL LEVEL

- Expert



TIME REQUIRED

- Approximately 4 Hours

⚠ WARNINGS/CAUTIONS BEFORE STARTING INSTALLATION ⚠

-BEFORE YOU INSTALL THIS KIT-

Read and understand all instructions, warnings, cautions, & notes contained in this installation instruction guide. Consult your vehicle owner's manual for proper disconnection of electrical and lifting of vehicle if required for installation of this product.

This install may require some technical skills and knowledge of basic mechanical work. If you do not feel that you are capable of performing this install please take this product to a trained professional.

After reading this guide please contact us with any questions or concerns before installing product.

Customer Service: (480) 671-0820

Addictive Desert Designs is not responsible for any bodily injury or harm to you or your vehicle as a result of an improper install.

Proper installation of this kit required knowledge of the factory recommended procedures for removal and installation of original equipment components.

We recommend that the factory shop manual and any special tools needed to service your vehicle be on hand during the installation. Installation of this kit without proper knowledge of the factory recommended procedures may affect the

performance of these components and the safety of the vehicle.

Inspect all contents of this package to make sure product is not damaged and all installation hardware has been included. If parts are missing from kit, please be prepared to provide the following information:

1. Name of purchase location
2. Bar Code on side of box
3. Date above bar code
4. Date inside box cover

***ALWAYS WEAR EYE PROTECTION
WHEN OPERATING POWER TOOLS***



INSTALLATION GUIDE

HARDWARE/PARTS

A1.



1/4-20 X 3/4" BUTTON HEAD BOLT

QTY: 8

A2.



M6 FLAT WASHER

QTY: 2

A3.



1/4" FLAT WASHER

QTY: 8

A4.



1/4-20" NYLON LOCK NUT

QTY: 8

B1.



3/8-16 X 1" BUTTON HEAD BOLT

QTY: 11

B2.



3/8-16 X 1" CARRIAGE BOLT

QTY: 4

B3.



3/8-16 X 1-1/4" HEX HEAD BOLT

QTY: 4

B4.



3/8" FLAT WASHER

QTY: 8

B5.



3/8" FLAT WASHER

QTY: 10

B6.



3/8-16 NYLON LOCK NUT

QTY: 4

B7.



3/8-16 NYLON LOCK NUT

QTY: 10

B8.



3/8-16 U-NUT CLIP

QTY: 7

C1.



1/2-13 X 1-1/2" HEX HEAD BOLT

QTY: 4

C2.



1/2-13 X 1-1/2" CARRIAGE BOLT

QTY: 4

C3.



1/2" FLAT WASHER

QTY: 14

C4.



1/2-13 NYLON LOCK NUT

QTY: 10



INSTALLATION GUIDE

HARDWARE/PARTS

D1.



3M DOUBLE SIDED TAPE

QTY: 4

E1.



WINCH MOUNT

QTY: 1

E2.



LIGHT MOUNT TAB

QTY: 1

E3.



LIGHT MOUNT TAB

QTY: 1

E4.



CAMERA COVER PANEL

QTY: 1

E5.



VALANCE SUPPORT BRACKET

QTY: 2

E6.



NUT PLATE | OUTER

QTY: 2

E7.



NUT PLATE | CENTER

QTY: 1

E8.

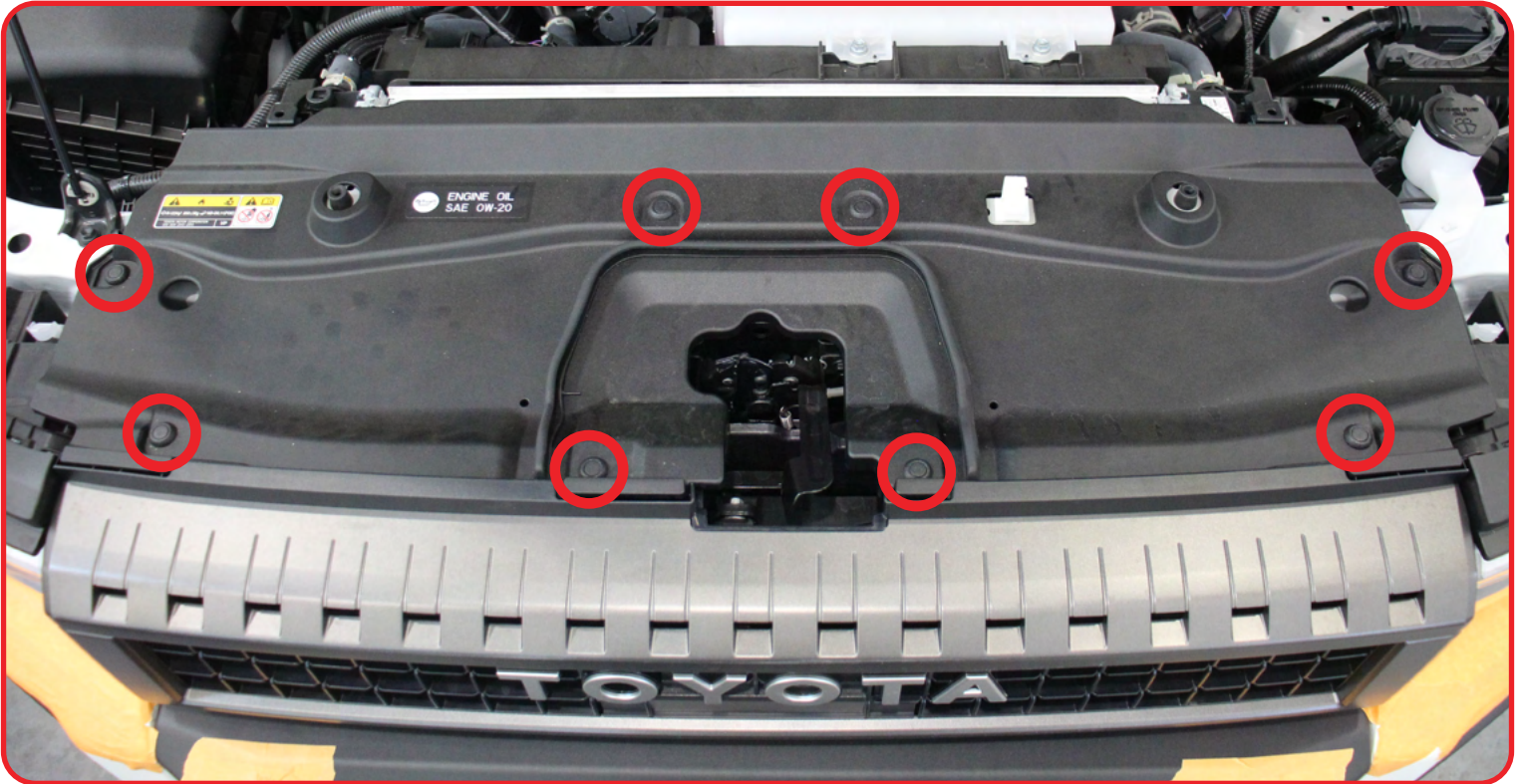


ROCK GUARD

QTY: 1

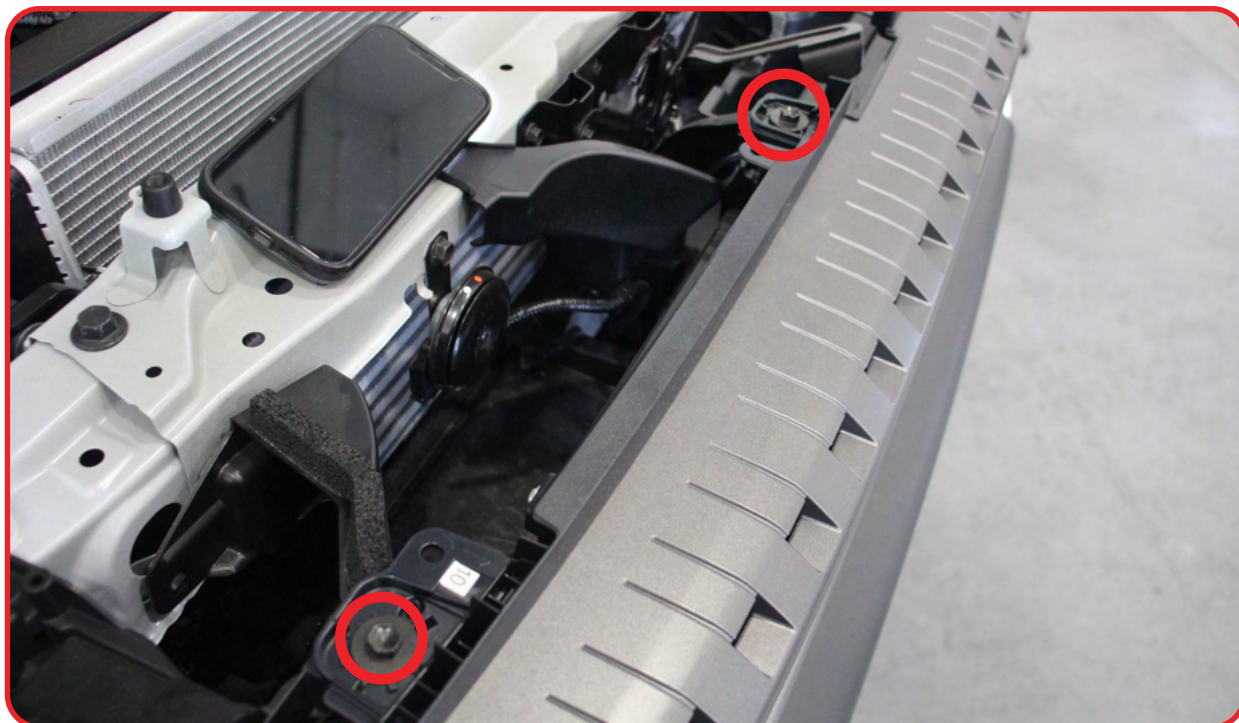
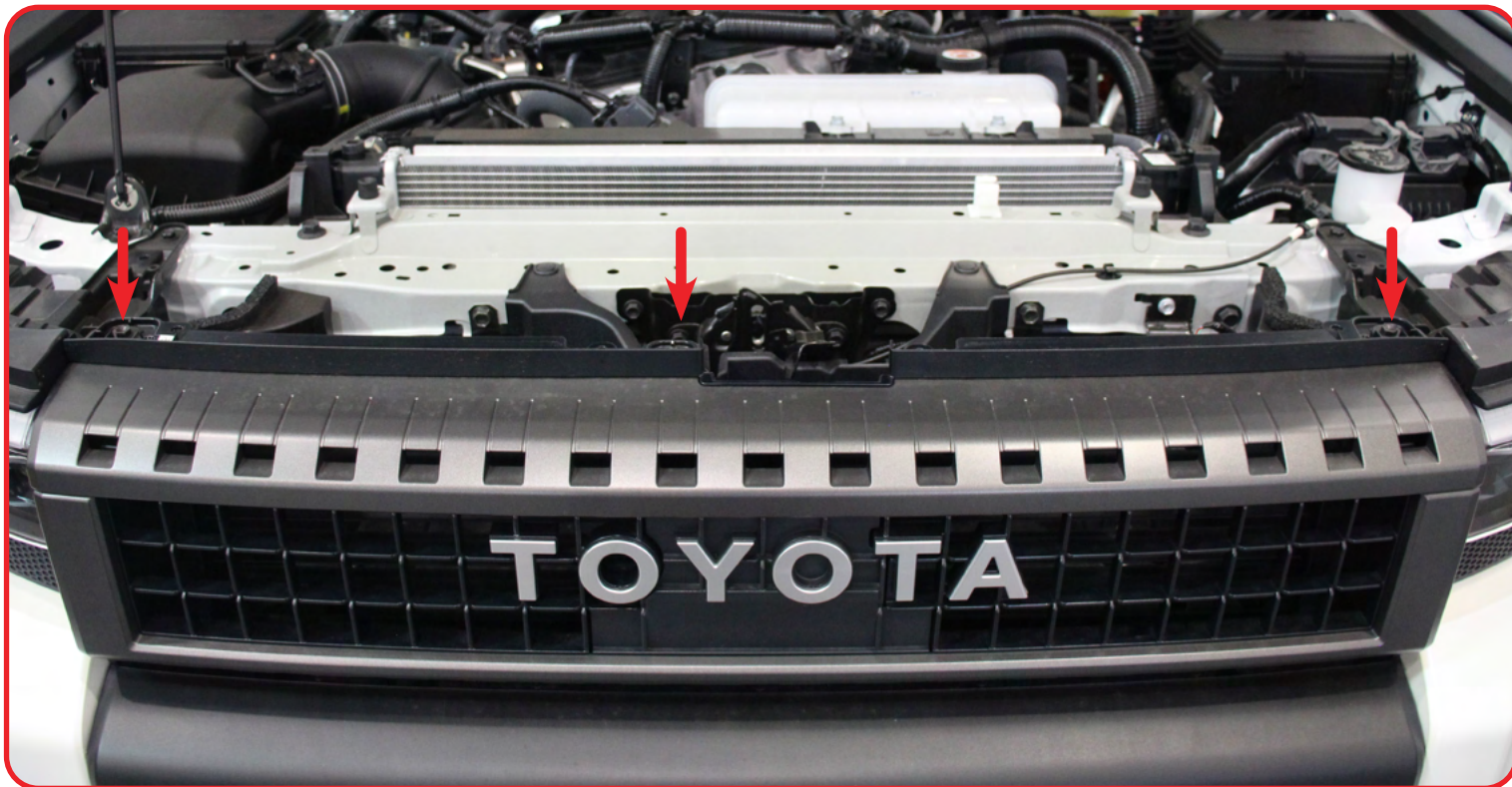
□ STEP 1

Open the hood and remove the 8x push pins by pushing the center down to release. Remove covers and set aside.



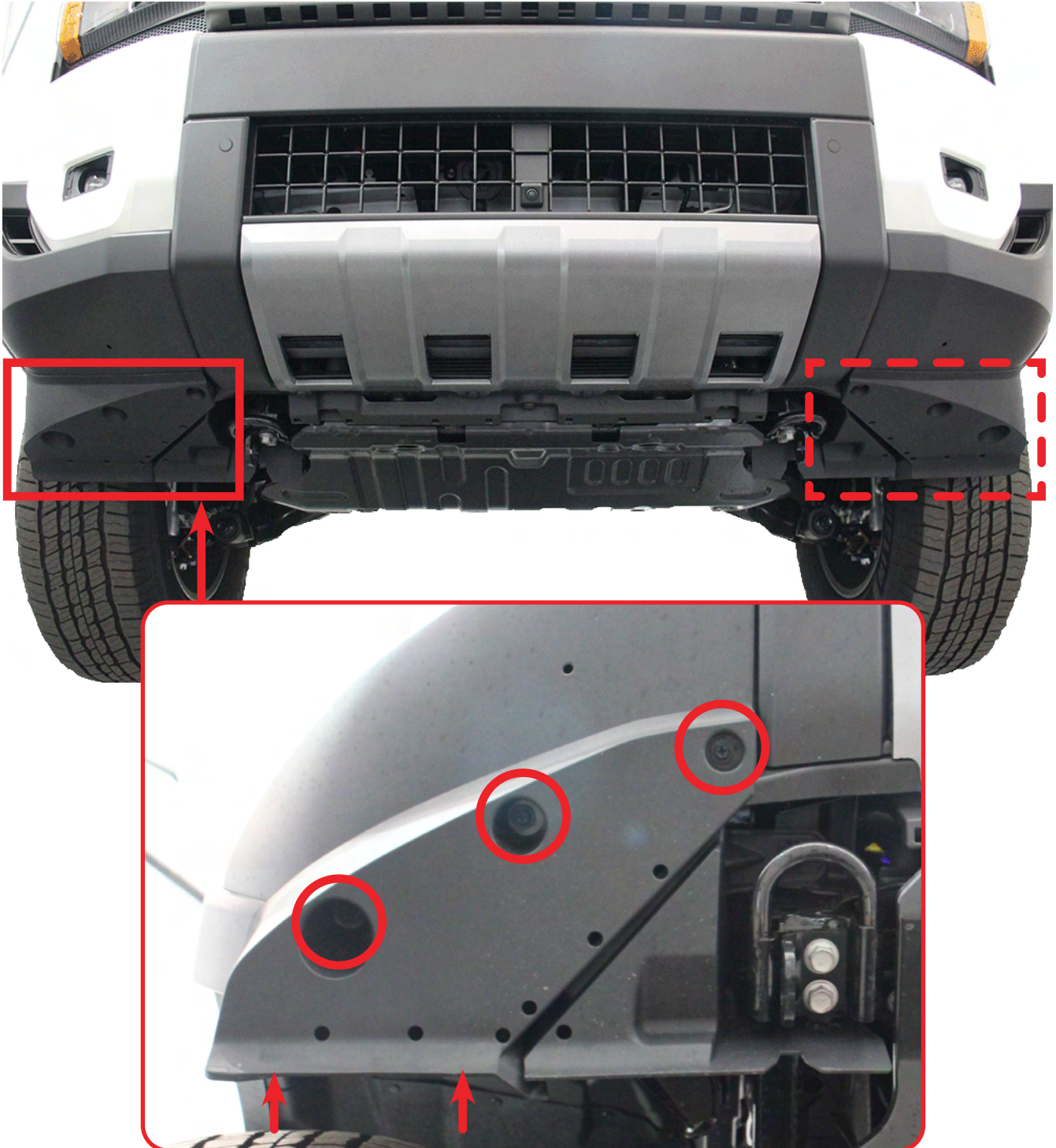
□ STEP 2

Next, using a (10mm socket) remove the hardware highlighted below.



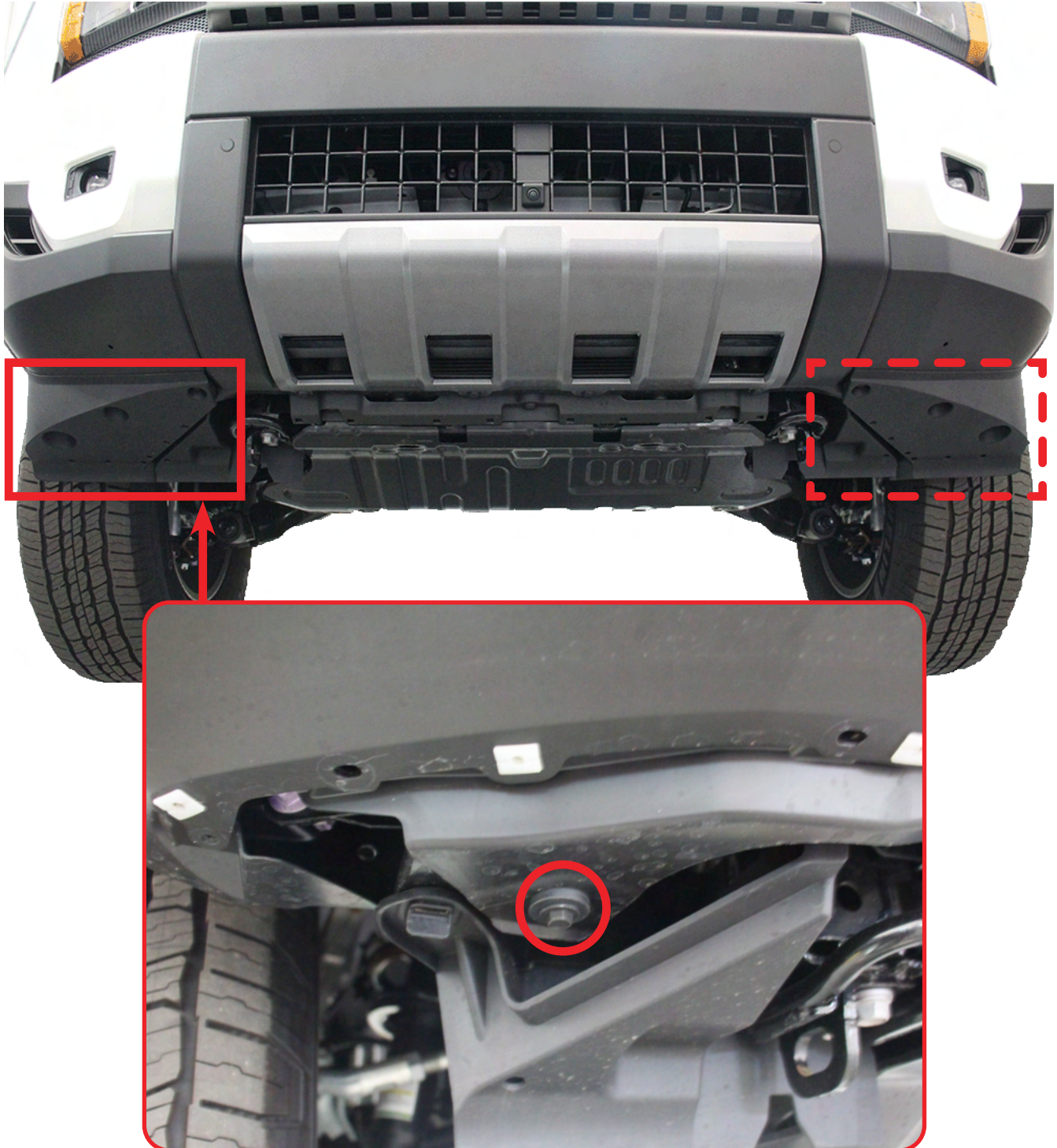
□ STEP 3

Using a (10mm socket) remove the bottom covers on both driver and passenger side.



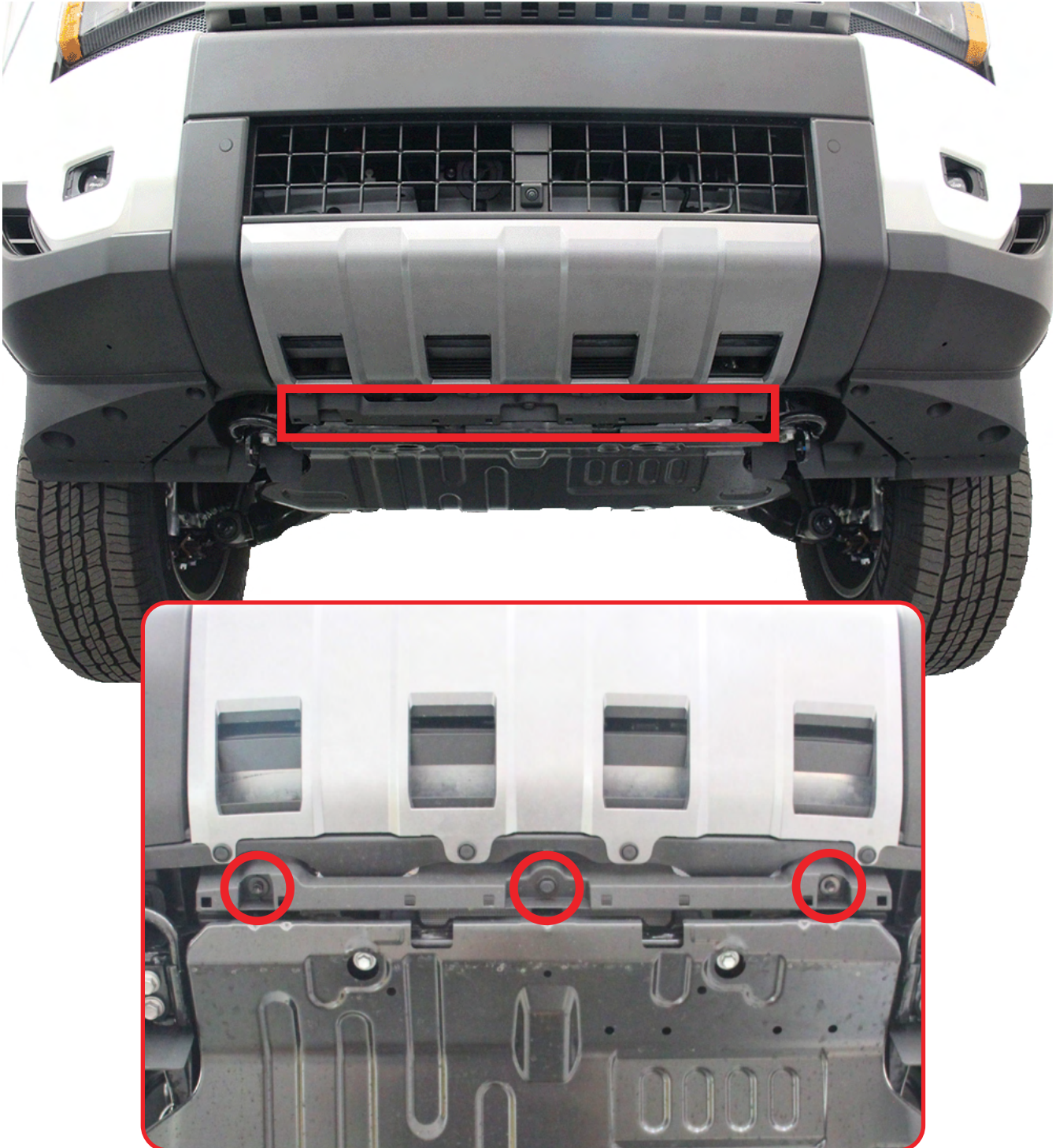
□ STEP 4

Using a (10mm socket) remove the bolt indicated below.



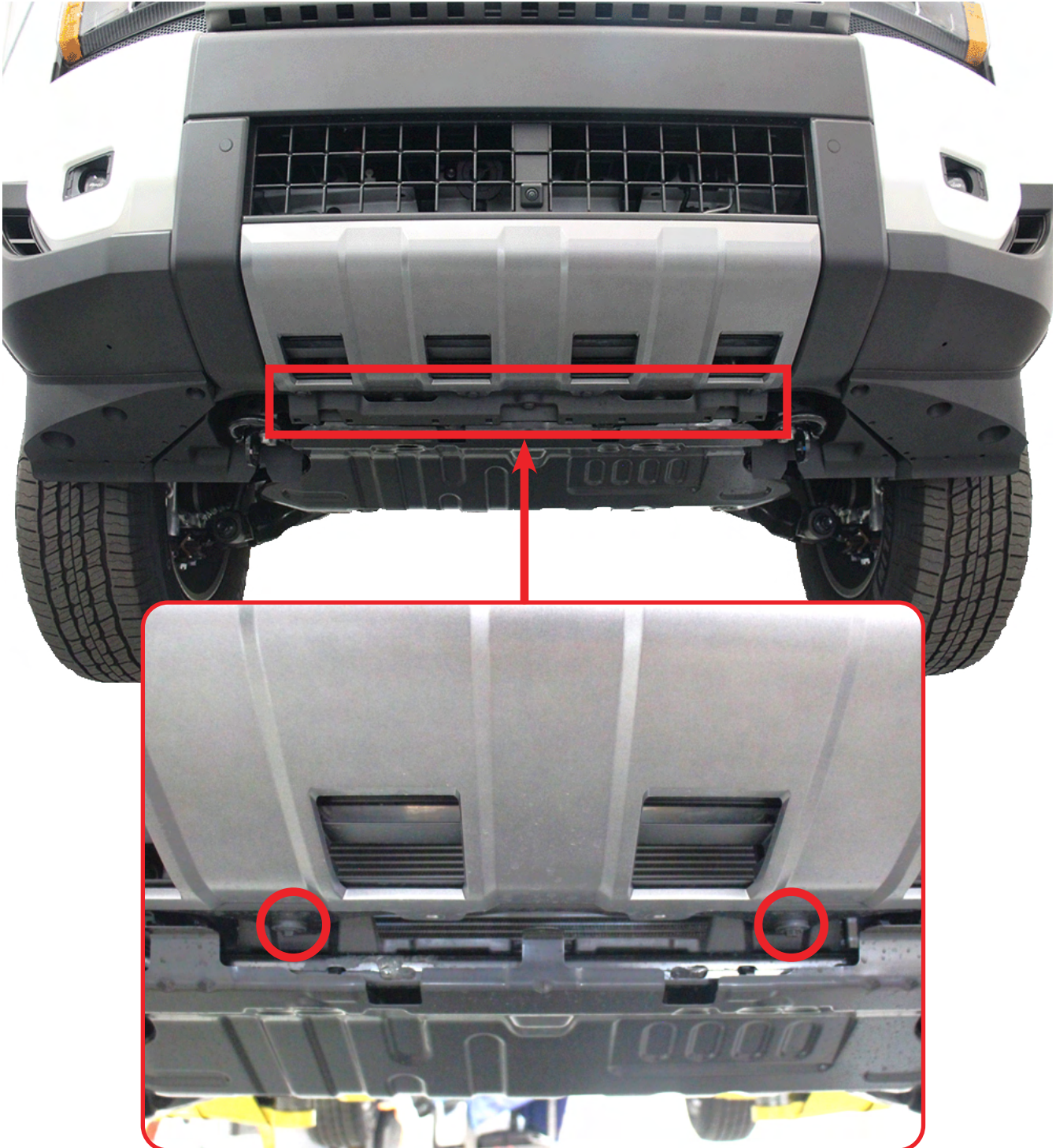
□ STEP 5

Using a (10mm socket) remove the 3x bolts holding the plastic cover located underneath the center of the bumper.



□ STEP 6

Next, using a (10mm socket) remove the bolts located underneath the plastic removed from **step 4**.



□ STEP 7

Remove the hardware holding the fender flairs located inside the wheel well using a (flathead screwdriver) and a (10mm socket).



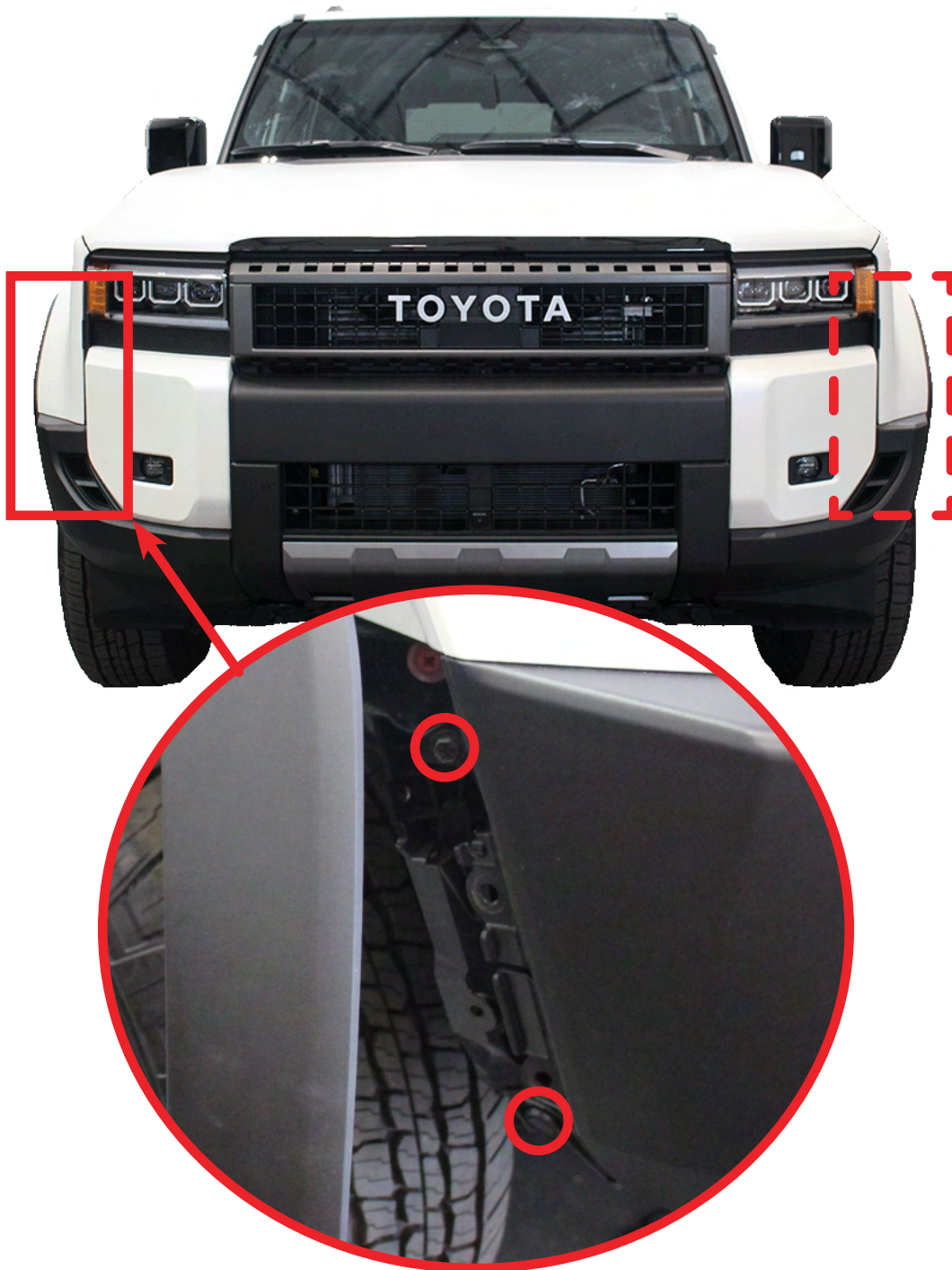
□ STEP 8

Pull the fender flairs outwards as shown below.



□ STEP 9

Using a (10mm socket) and a (flathead screwdriver) remove the push pins and bolts holding the valence.



□ STEP 10

Unplug the (2) harness connections indicated below, then remove the grille assembly from the vehicle.



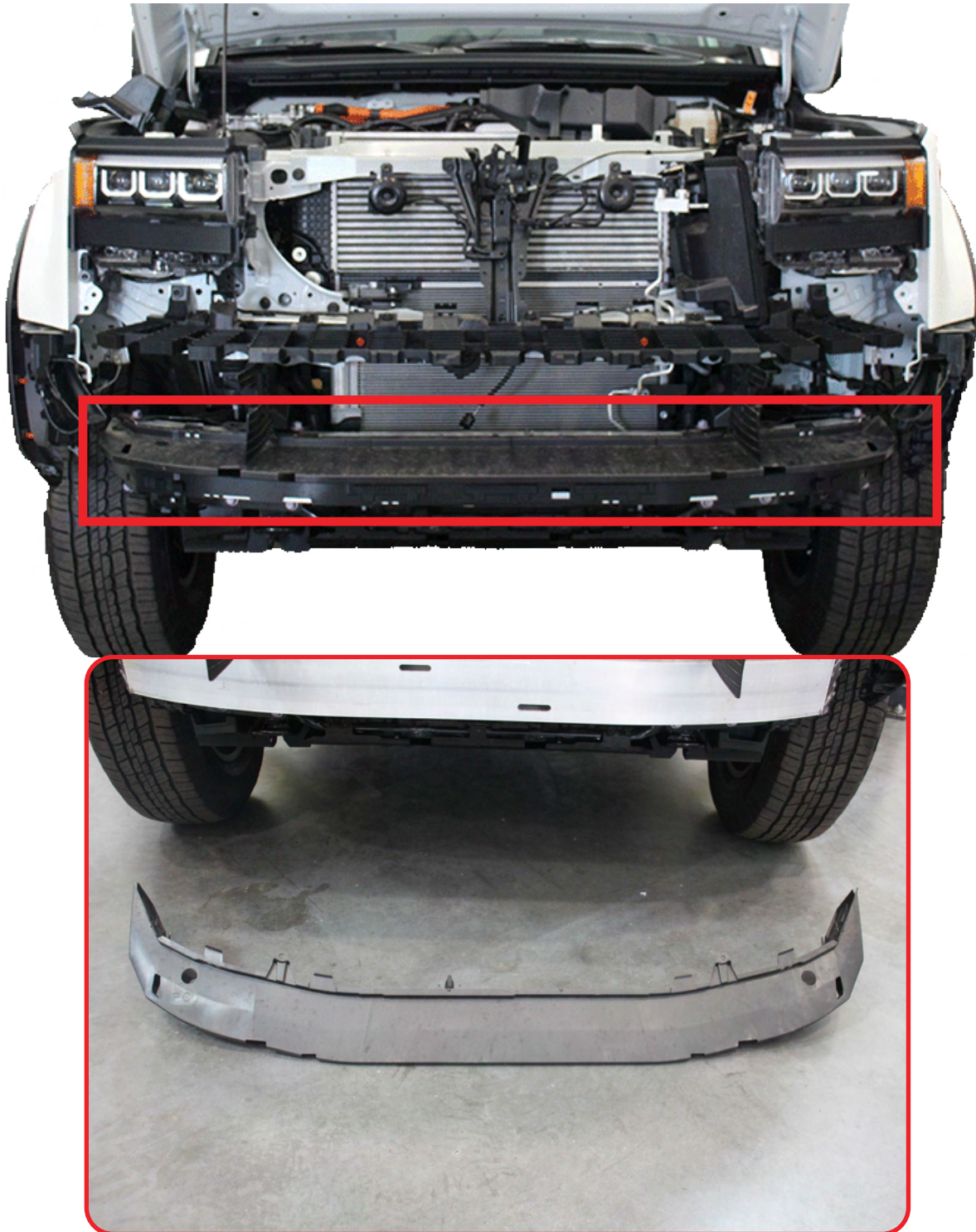
**MAIN BUMPER
CONNECTION**



**CAMERA HARNESS
CONNECTION**

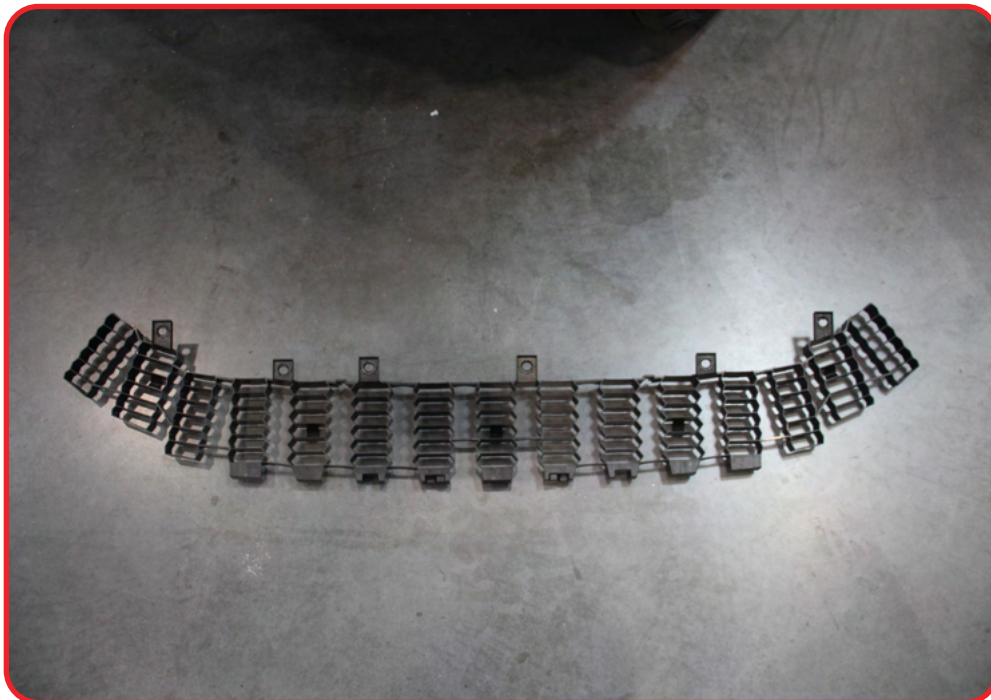
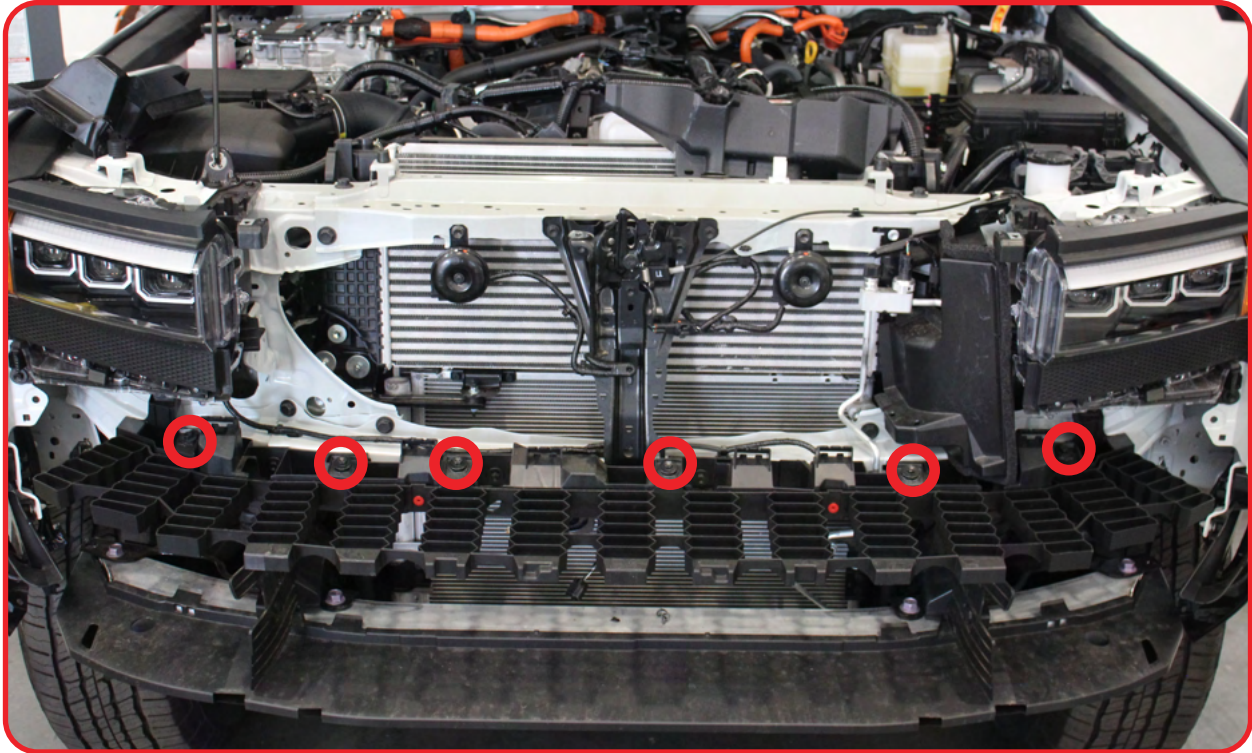
□ STEP 11

Working from one end to the other, remove the crash bar cover by pulling firmly to release each retaining clip.



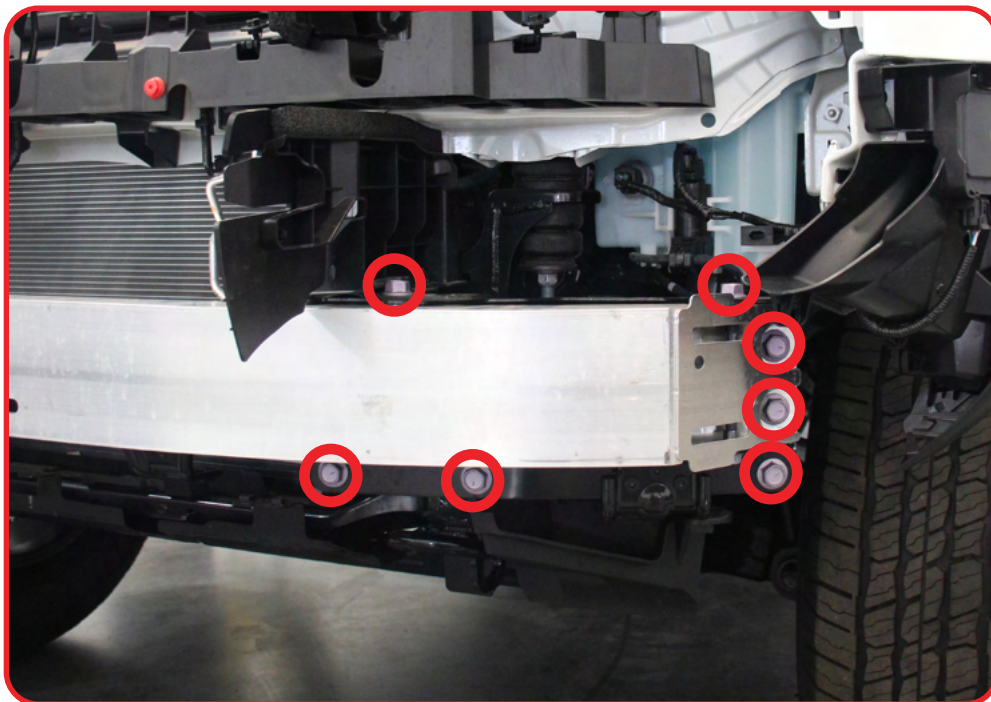
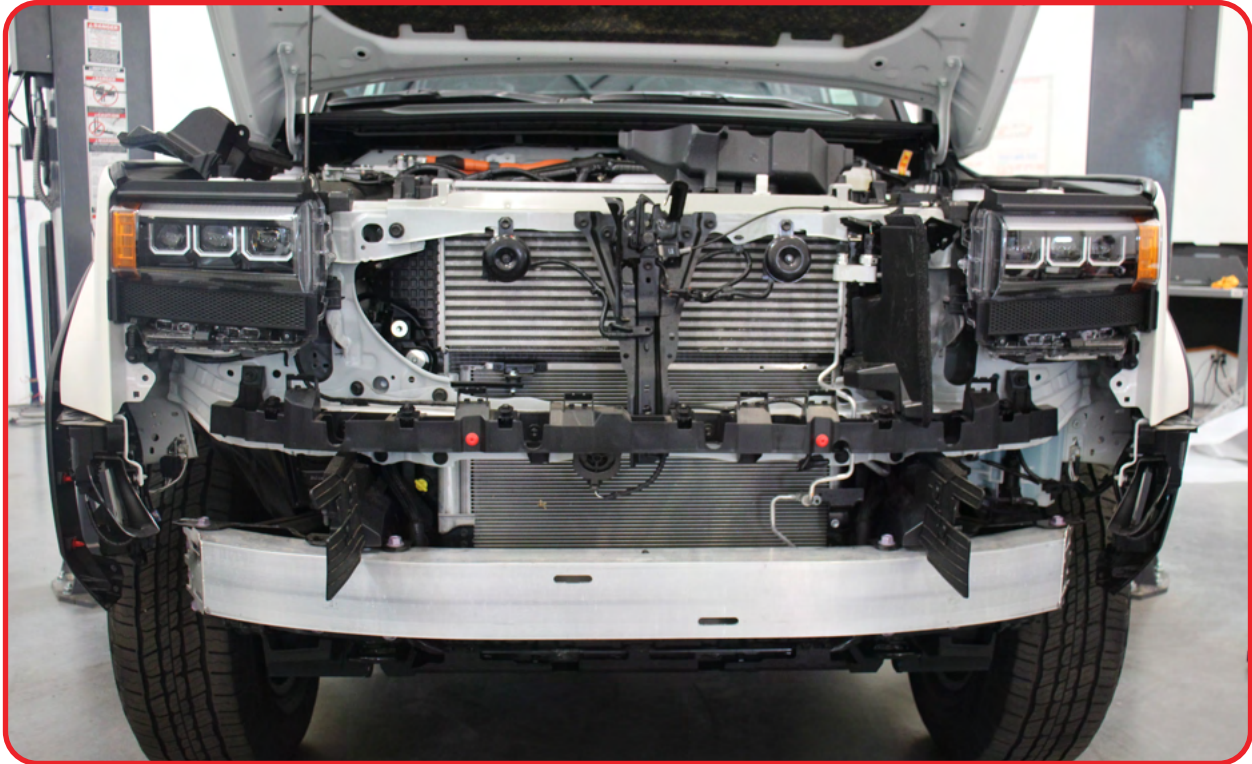
□ STEP 12

Using a (10mm socket) remove each of the indicated bolts to remove the plastic paneling shown below.



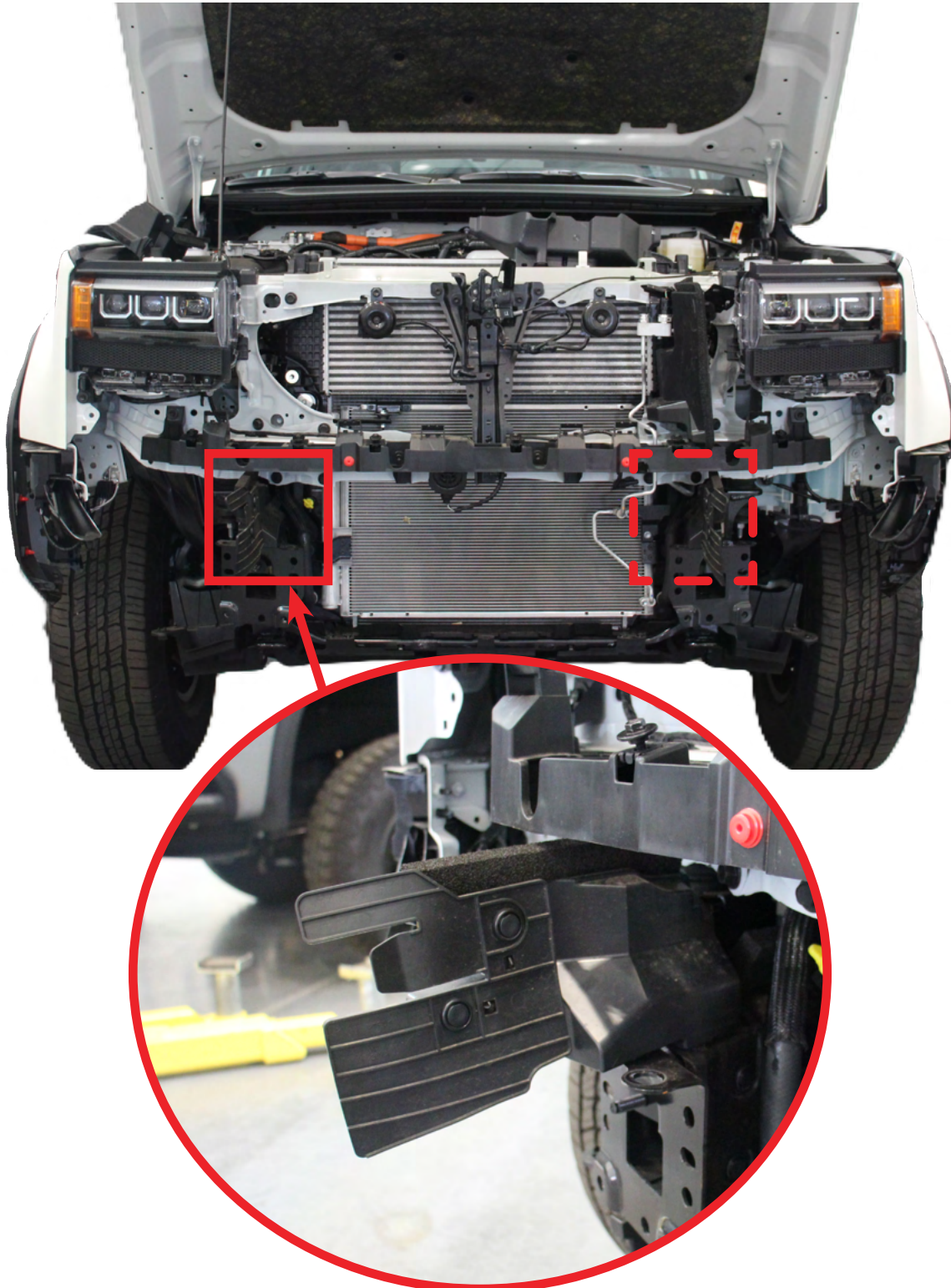
□ STEP 13

Using a (17mm socket) remove the hardware indicated below, then remove the crash bar from the vehicle.



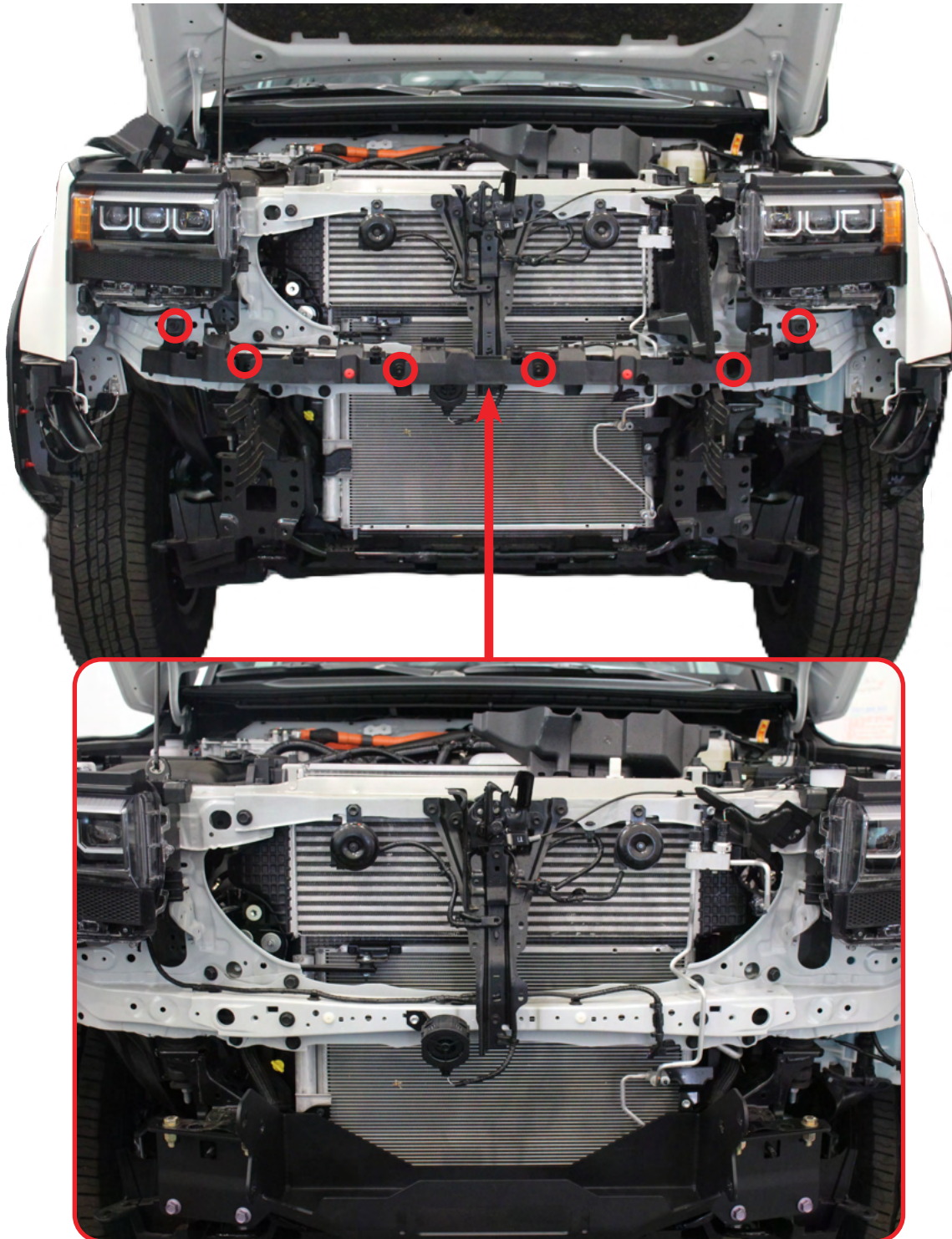
□ STEP 14

Pull firmly to release and remove the paneling indicated below.



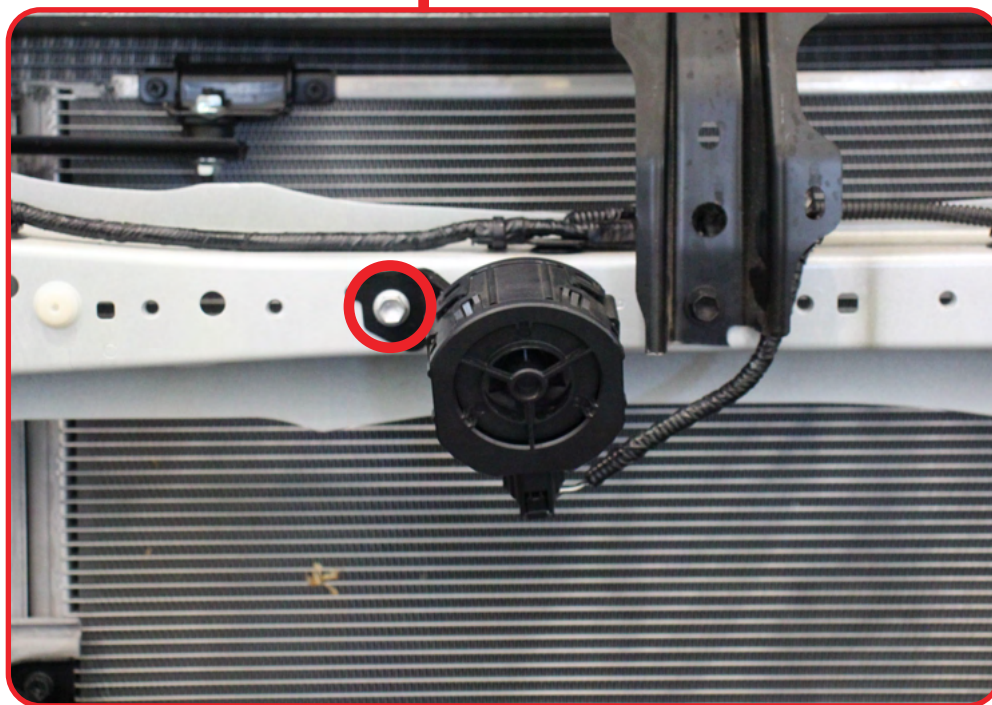
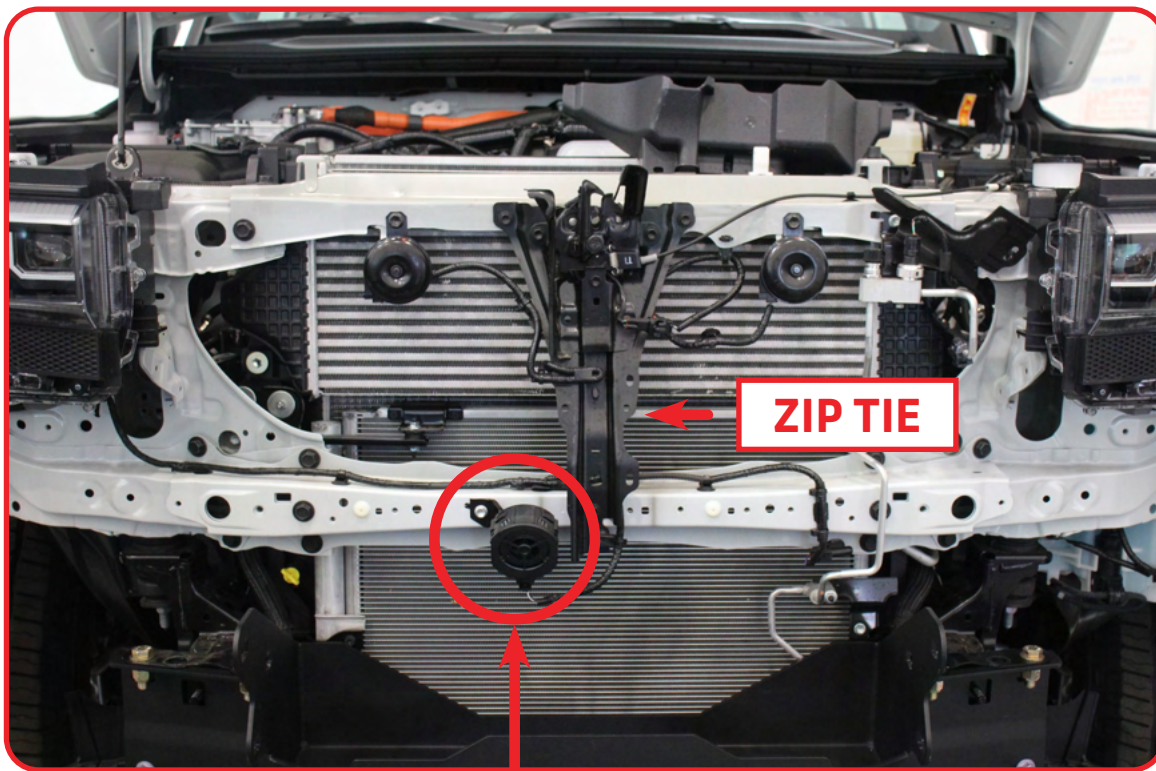
□ STEP 15

Using a (10mm socket) remove the mounting hardware and bracket shown below. Set aside for re-installation later.



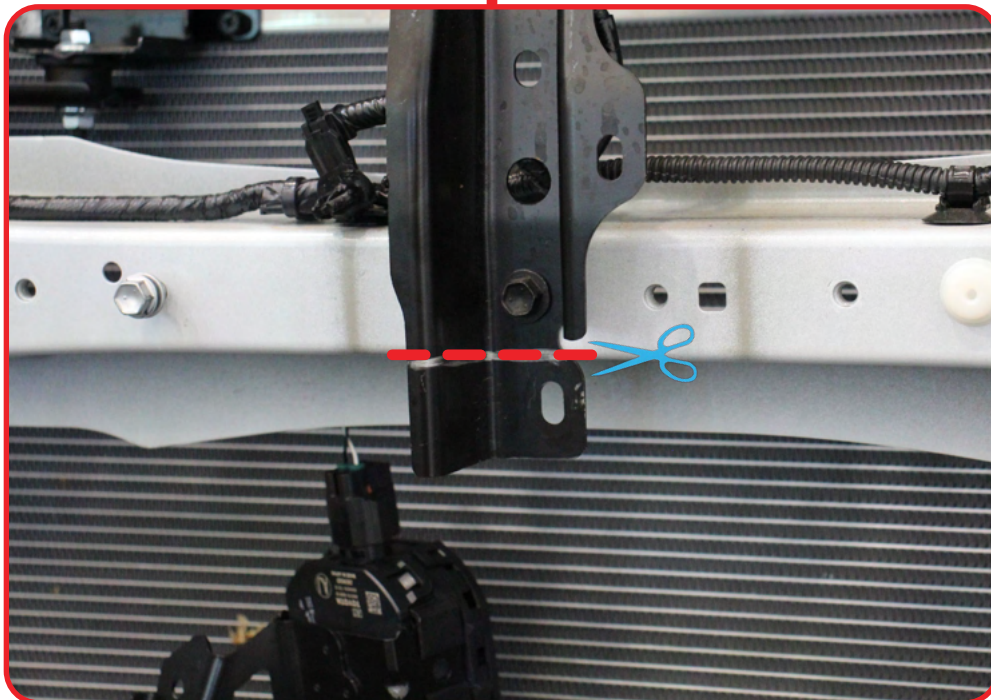
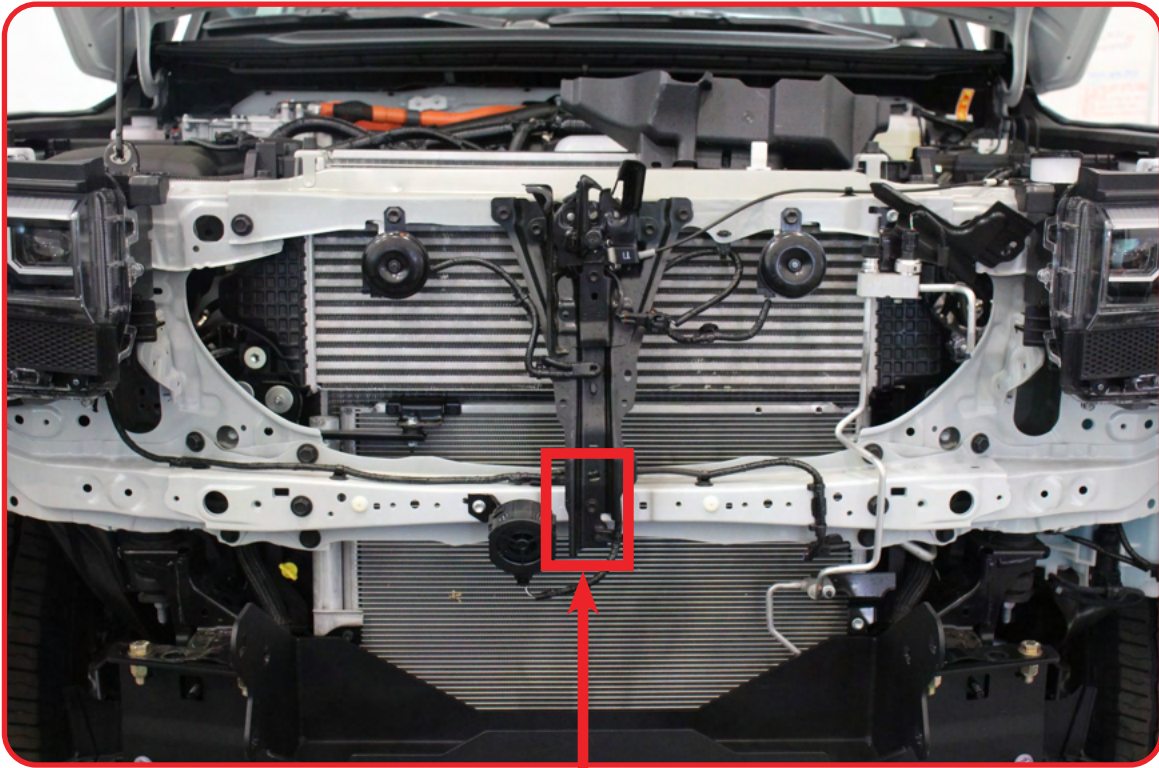
□ STEP 16

Using a (10mm socket) remove the pedestrian speaker shown below and use zip ties to relocate it behind the center support bracket.



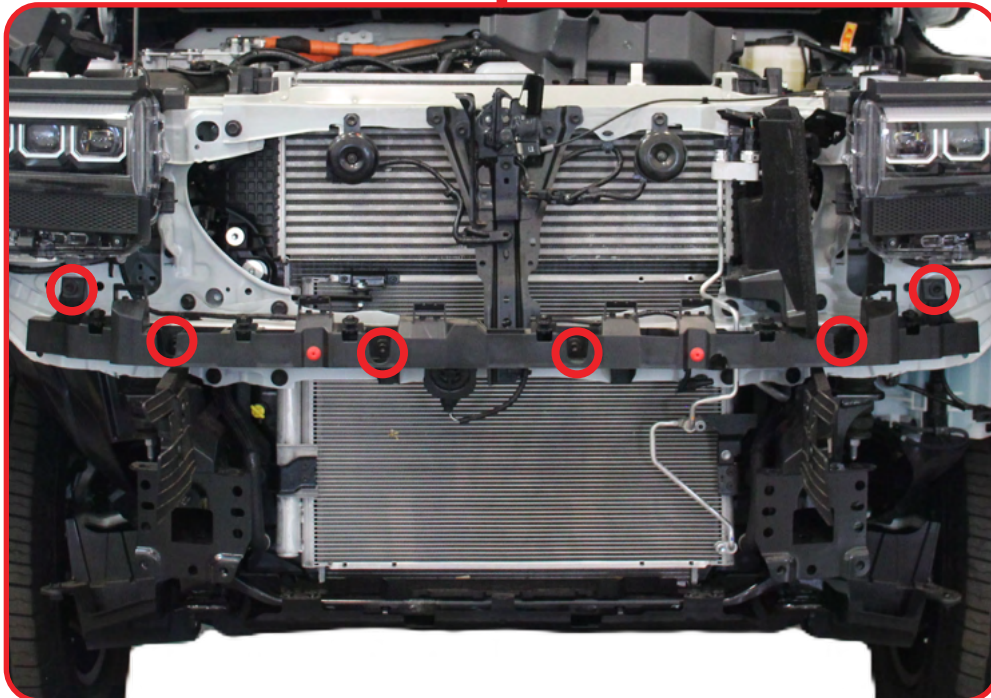
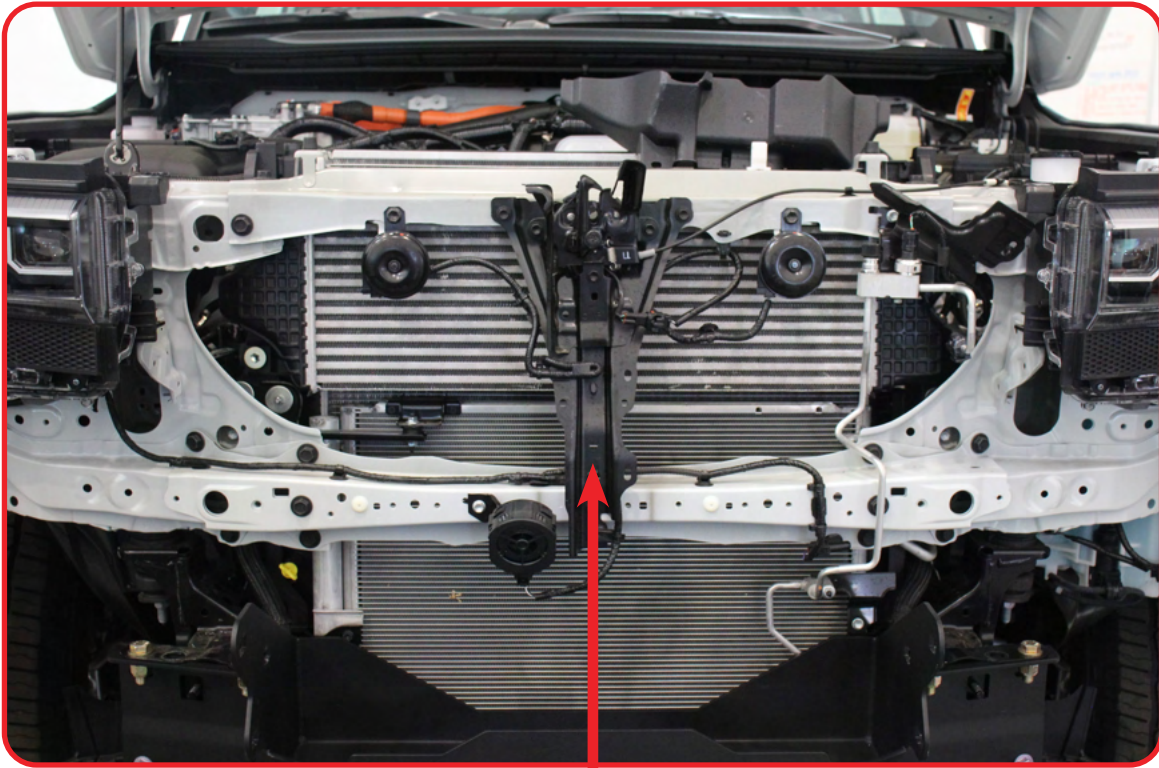
□ STEP 17

Using a cutting tool of your choice, trim the over hanging portion of the center support bracket as shown below.



□ STEP 18

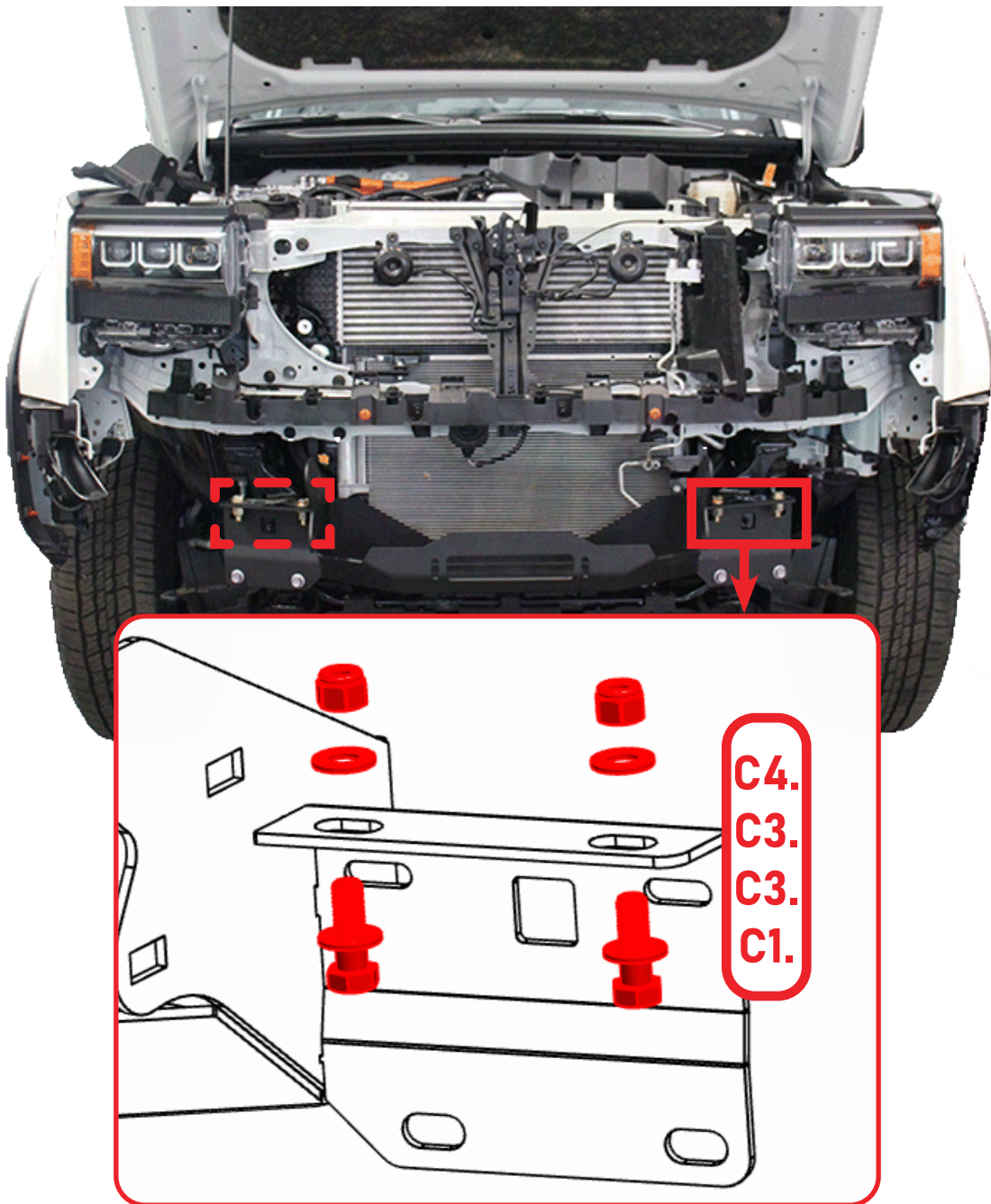
Using a (10mm socket) and previously removed factory hardware, re-Install the plastic mounting bracket from **step 14**.



□ STEP 19

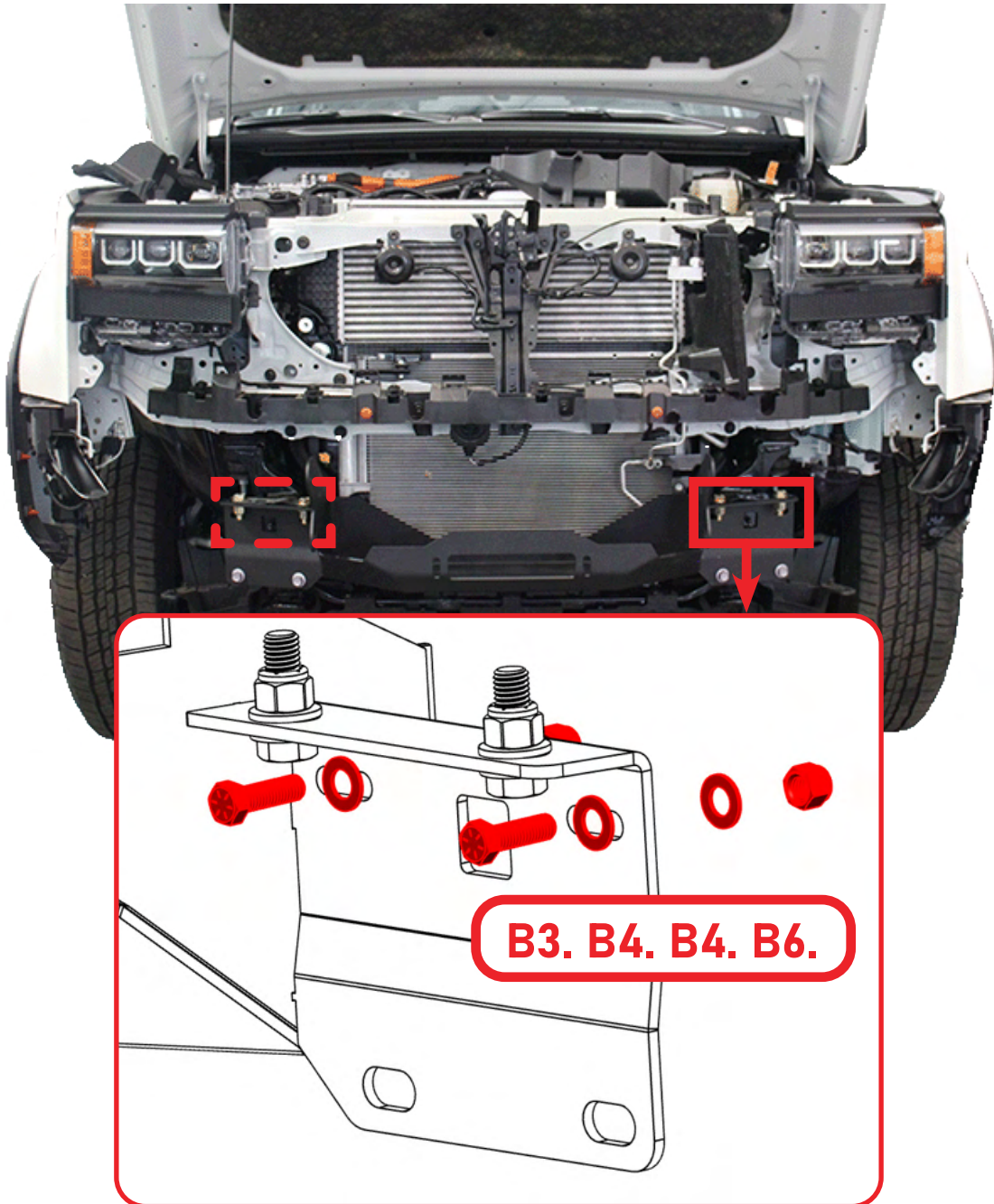
If you plan to install a winch, loosely mount it into the supplied winch mounting bracket at this time, then using a (3/4 wrench), (3/4 socket) along with the supplied hardware (C1, C3, C4), install the winch mount into the vehicle as shown below.

***** Ensure Adequate Clearance Between All Components Prior To Final Tightening. Improper Installation And Interferences May Result In Vehicle Damage. Make Any Necessary Adjustments At This Time*****



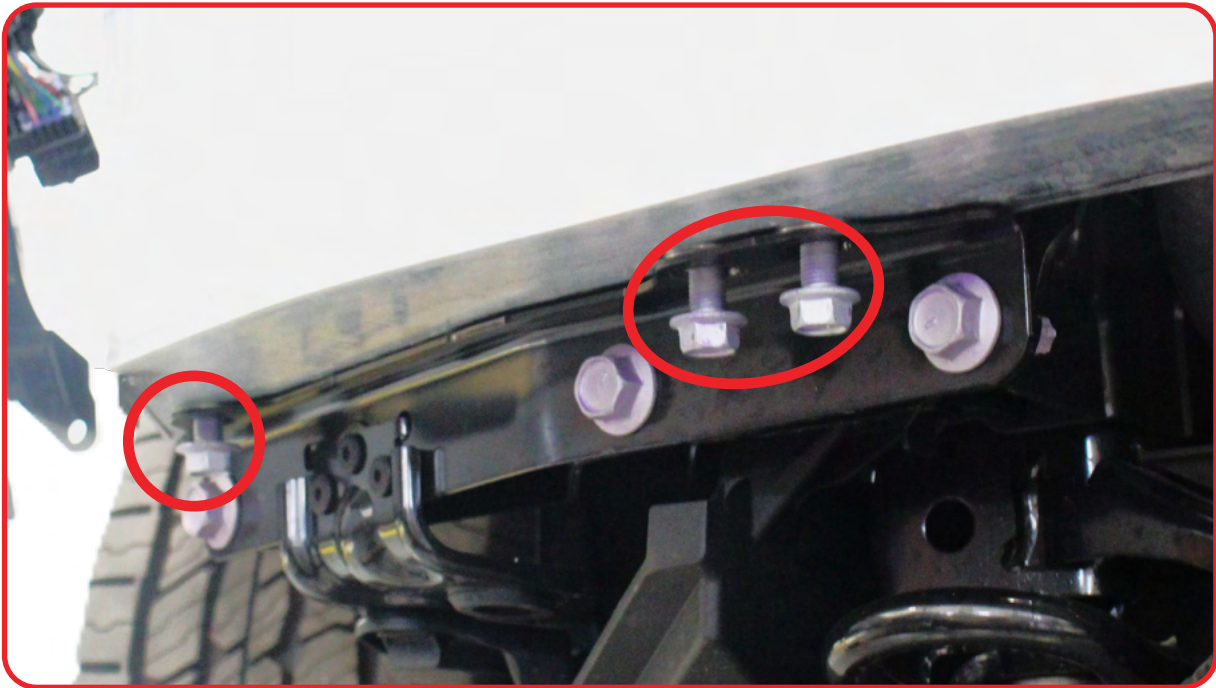
□ STEP 20

Using a (9/16 wrench) and (9/16 socket) install the supplied hardware (B3, B4, B6) as shown below.



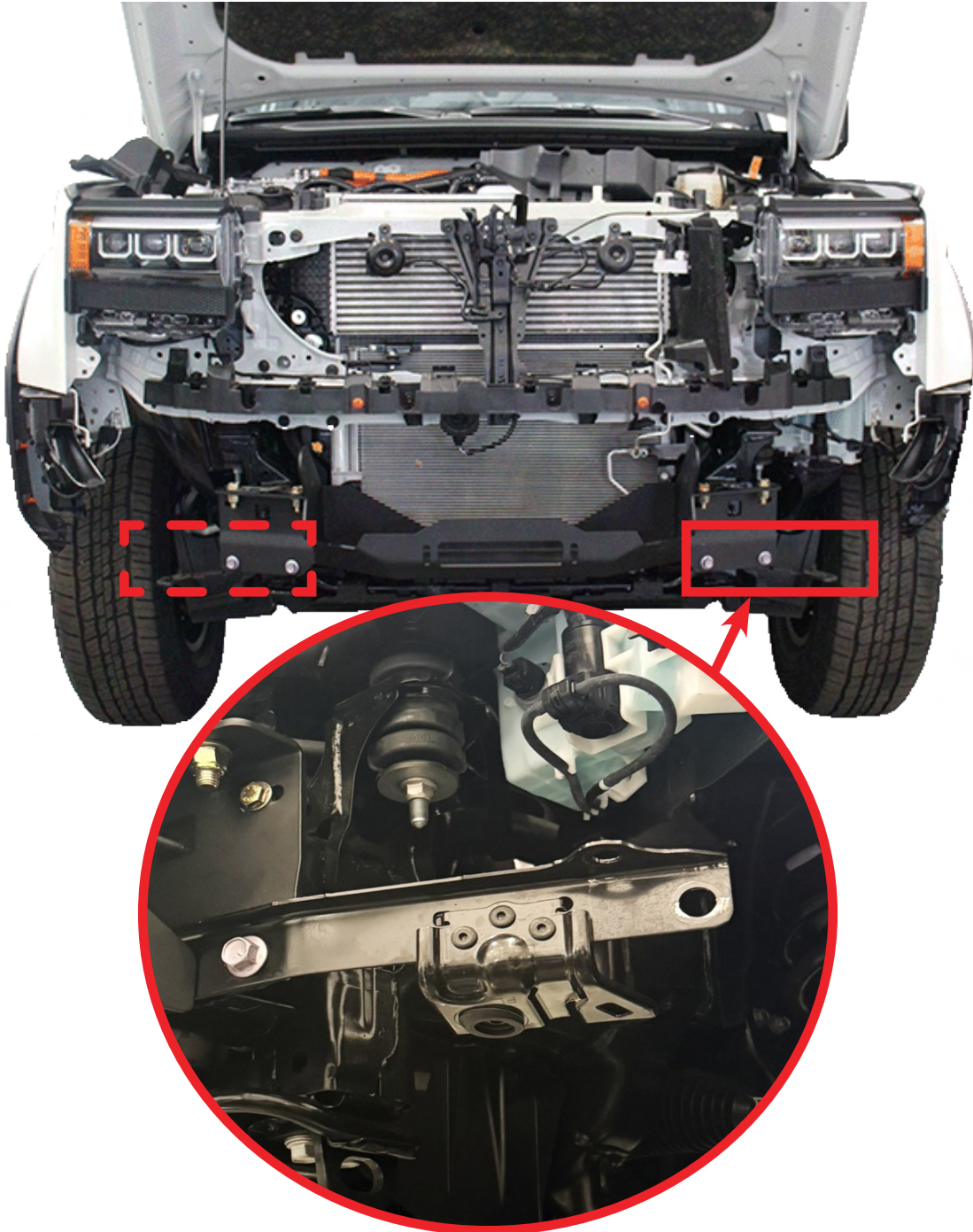
□ STEP 21

Locate the lower crash bar mounting brackets shown below, then remove the indicated bolts to disassemble them from the crash bar assembly. Using your preferred cutting tool, trim the tabs from the mounting bracket as shown.



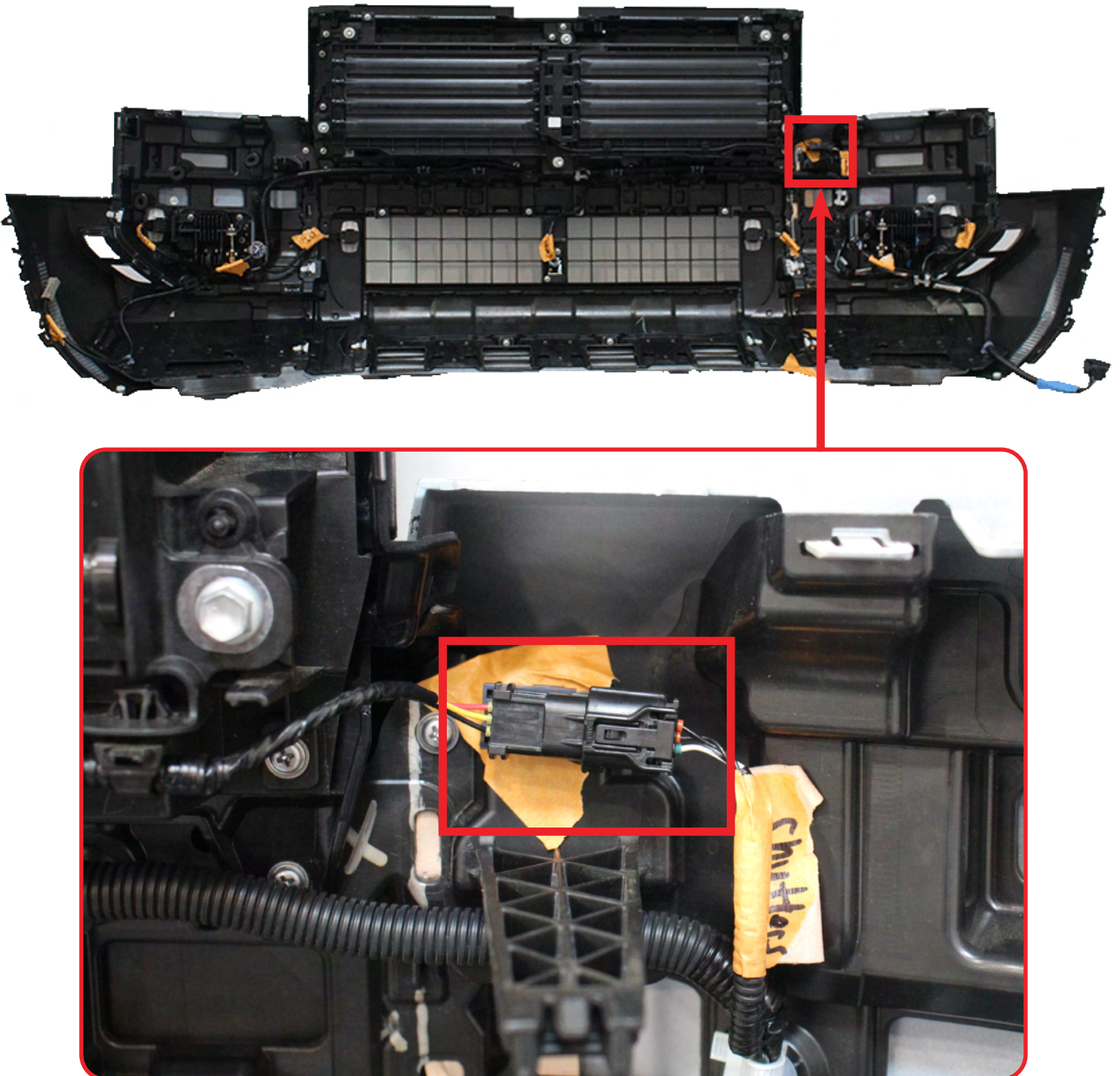
□ STEP 22

Reusing the factory mounting hardware, reinstall the trimmed brackets to the vehicle, on the front side of the winch mount, in their original location and orientation.



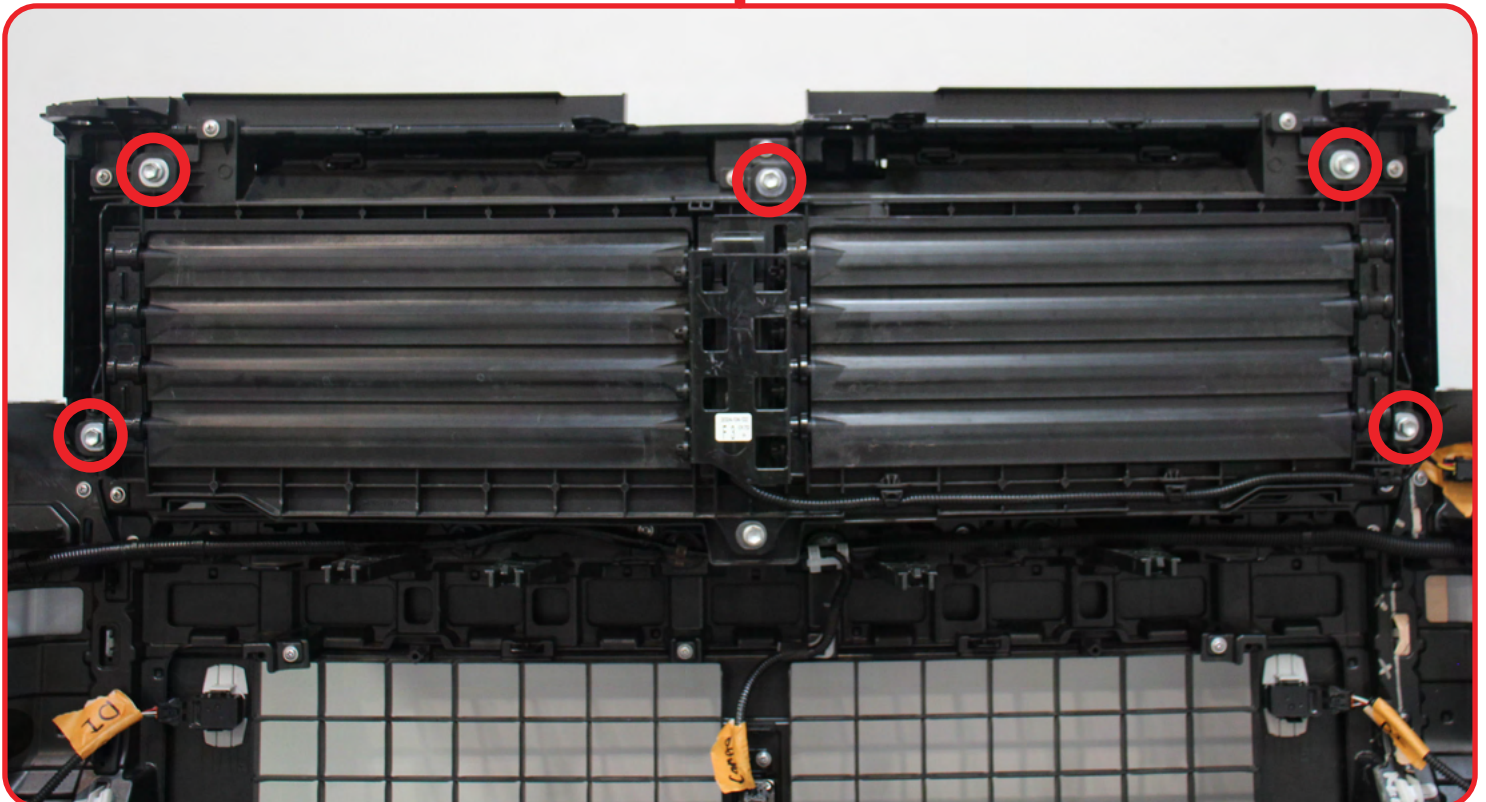
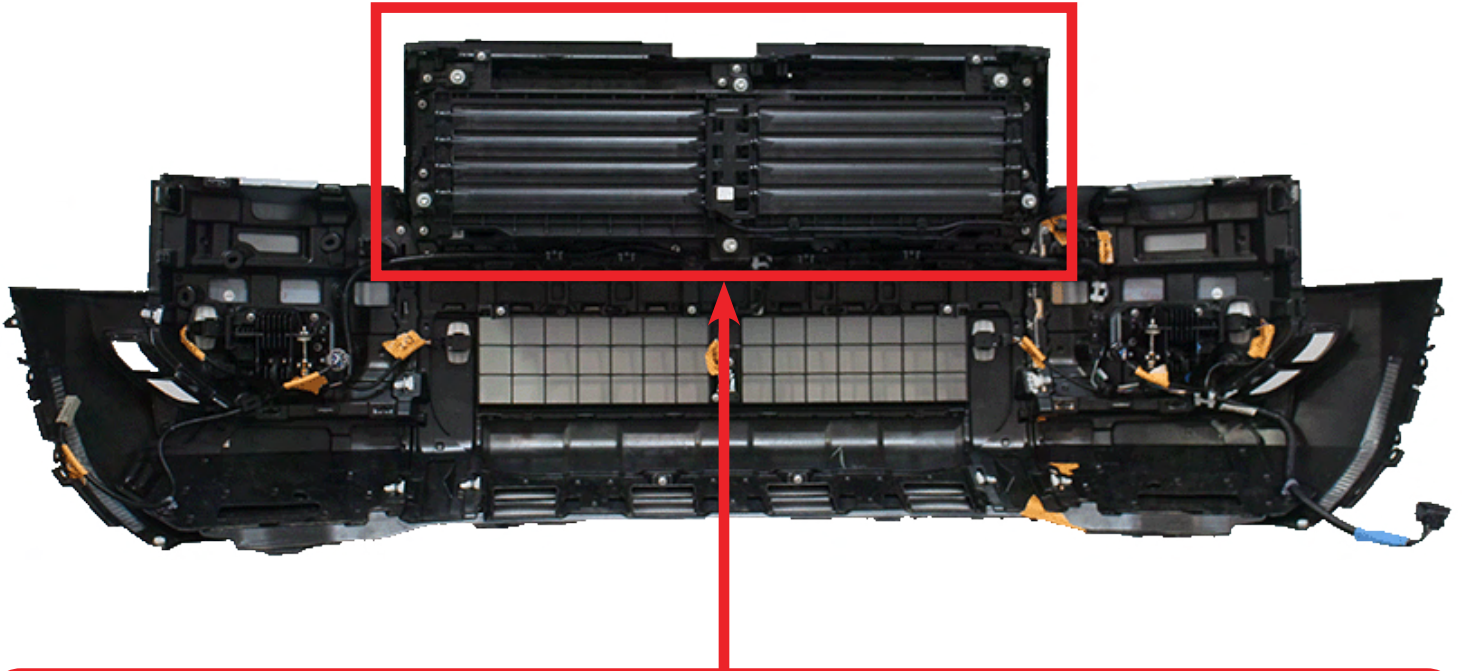
□ STEP 23

Locate and disconnect the indicated shutter motor connector from the backside of the assembly.



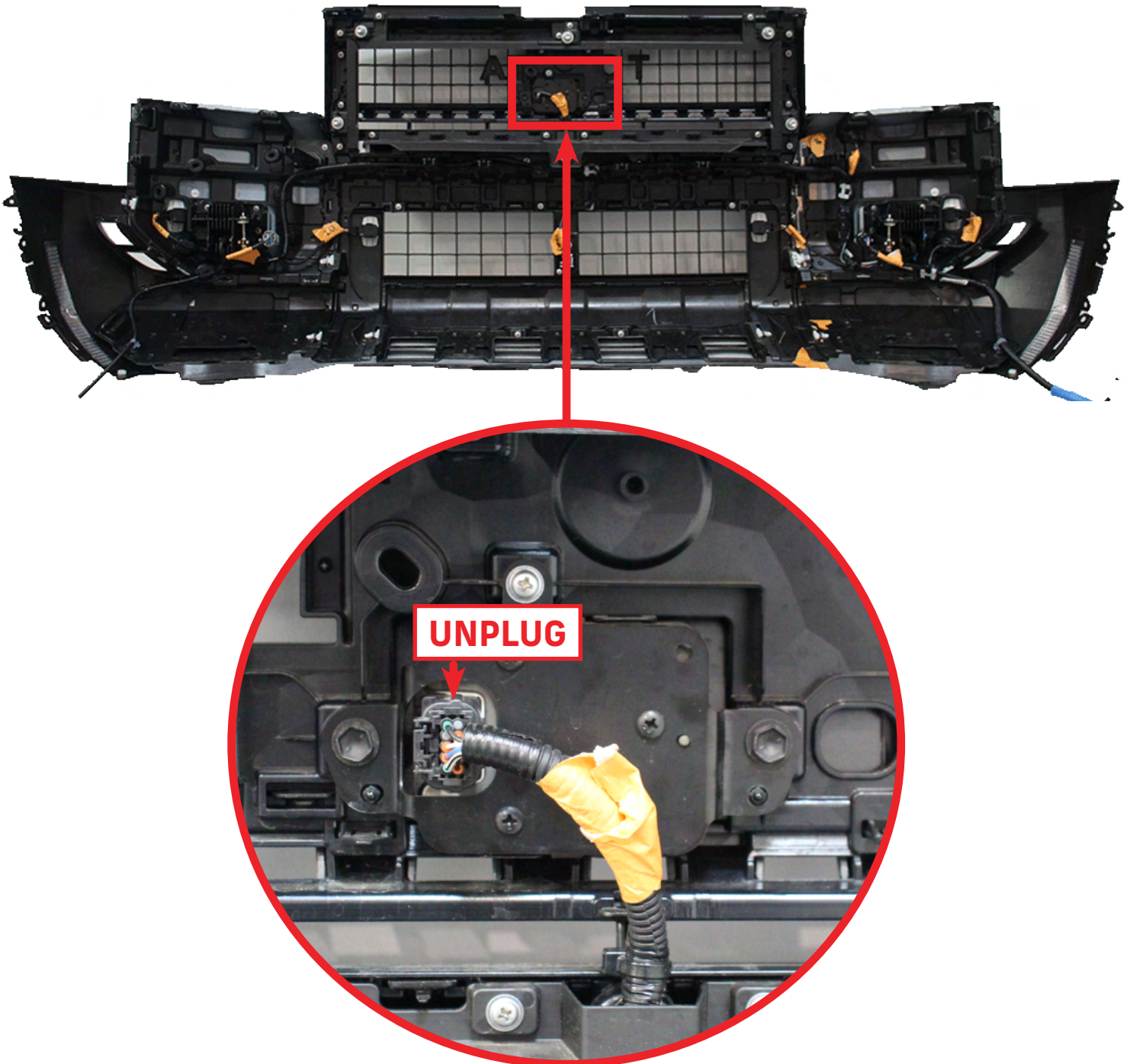
□ STEP 24

Using a (10mm socket) remove the top grill shutter assembly as shown below. **(Do not remove shutters from the assembly, this OEM assembly will be re-used later in the install)**



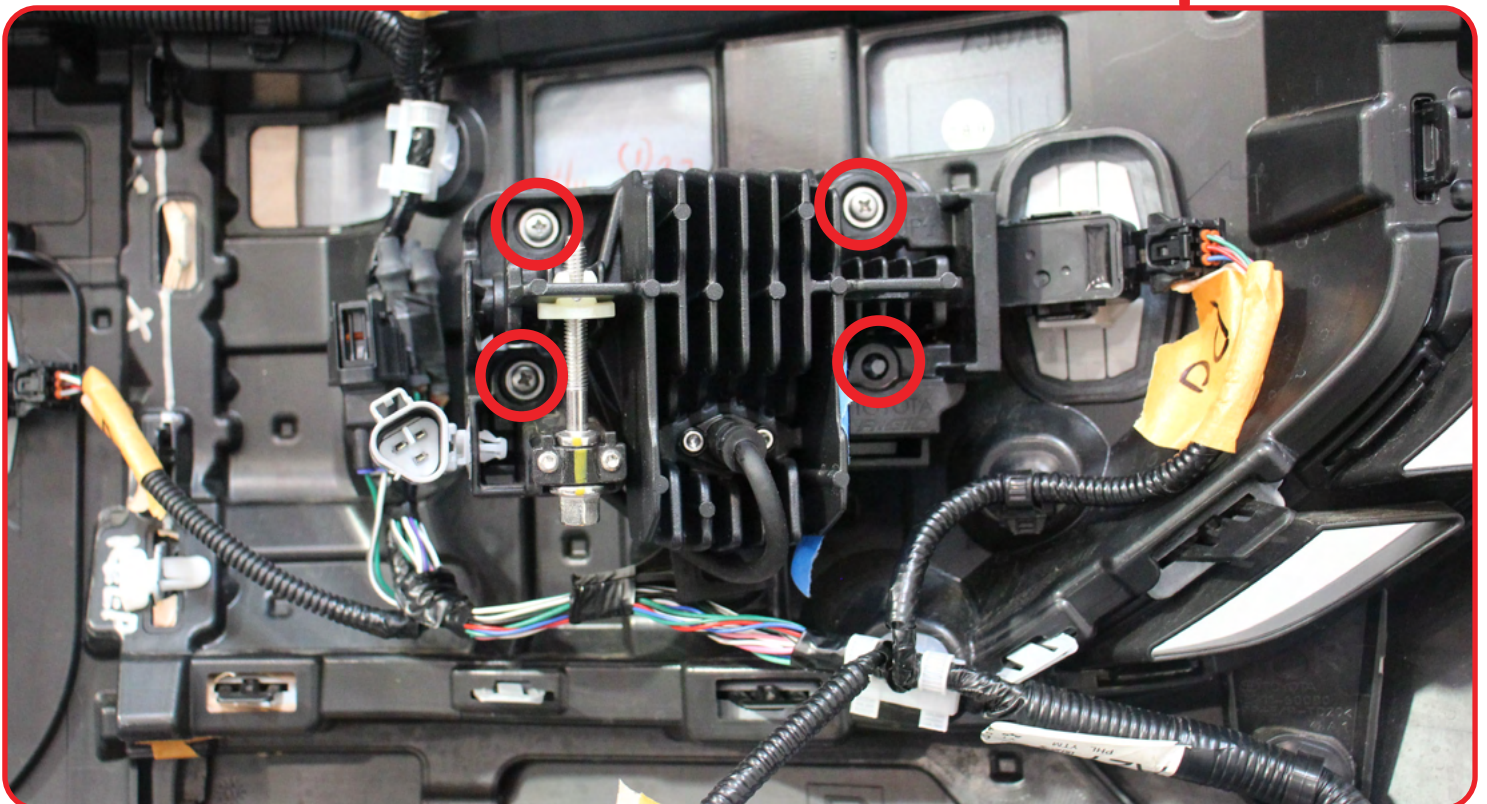
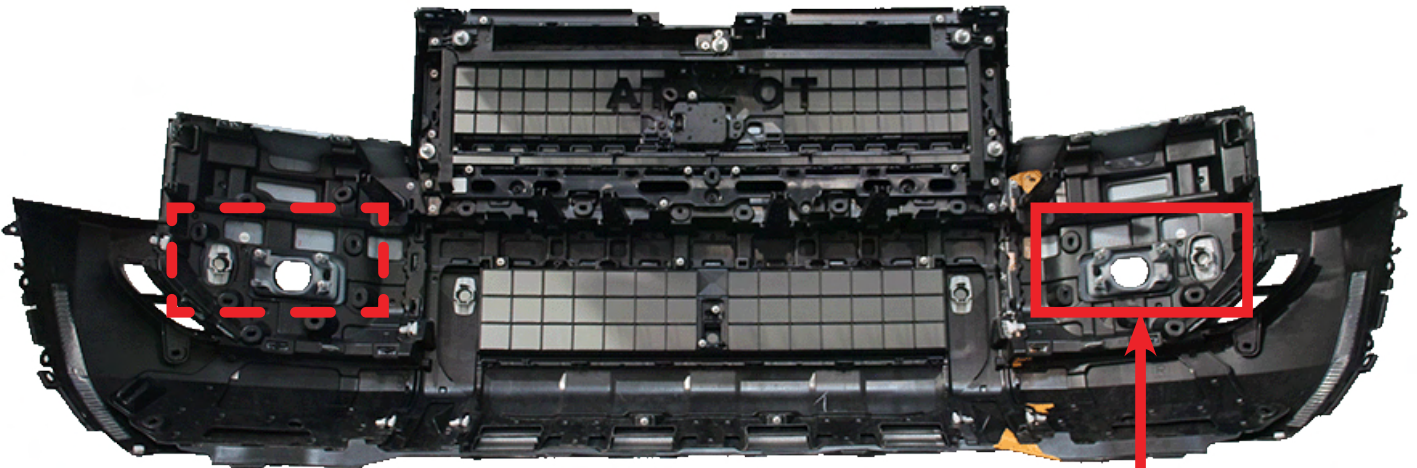
□ STEP 25

Locate and disconnect the indicated TSS sensor connector from the backside of the assembly.



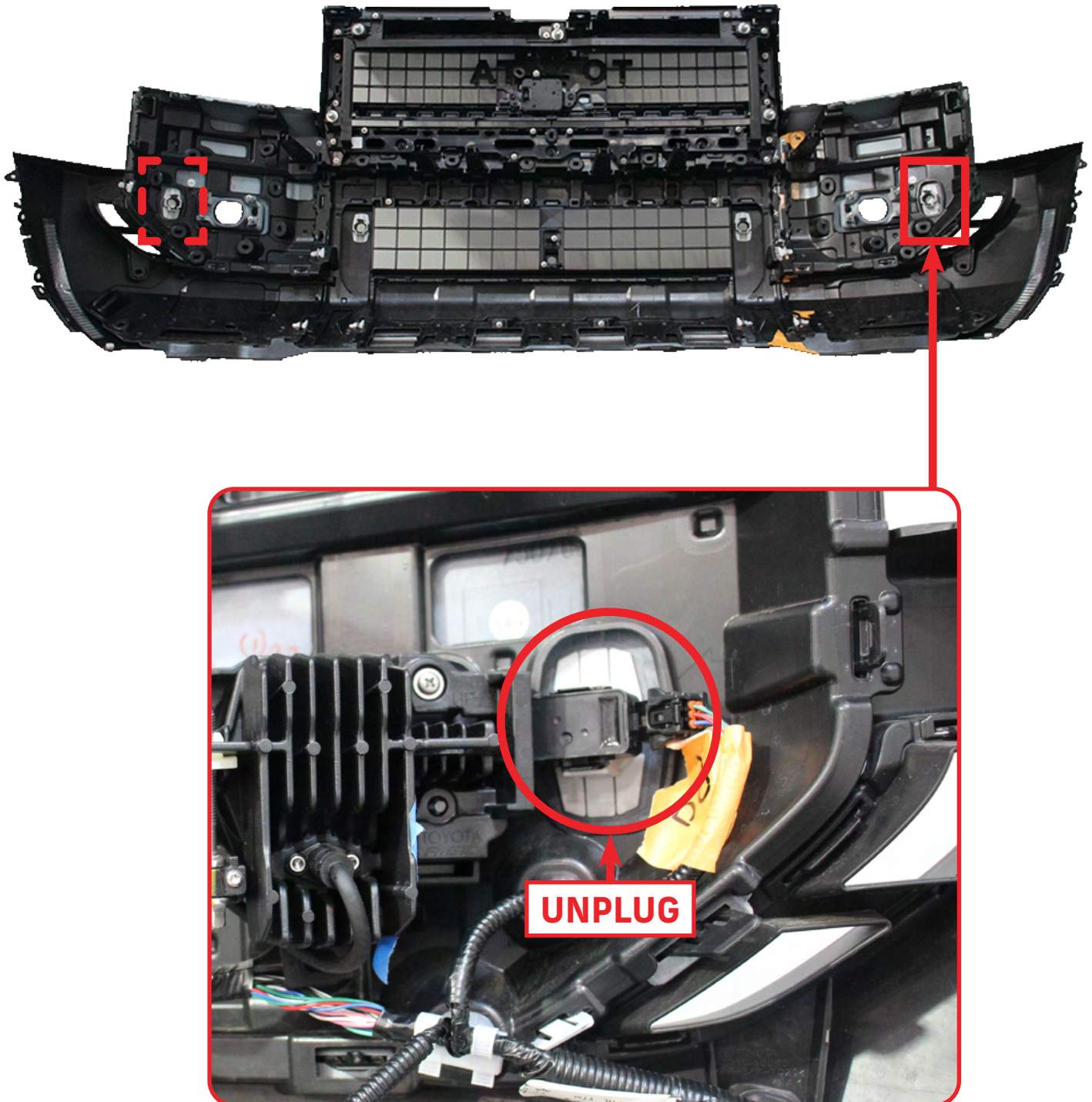
□ STEP 26

Using a (phillips screwdriver) remove the indicated mounting screws and remove the fog lights from the assembly.



□ STEP 27

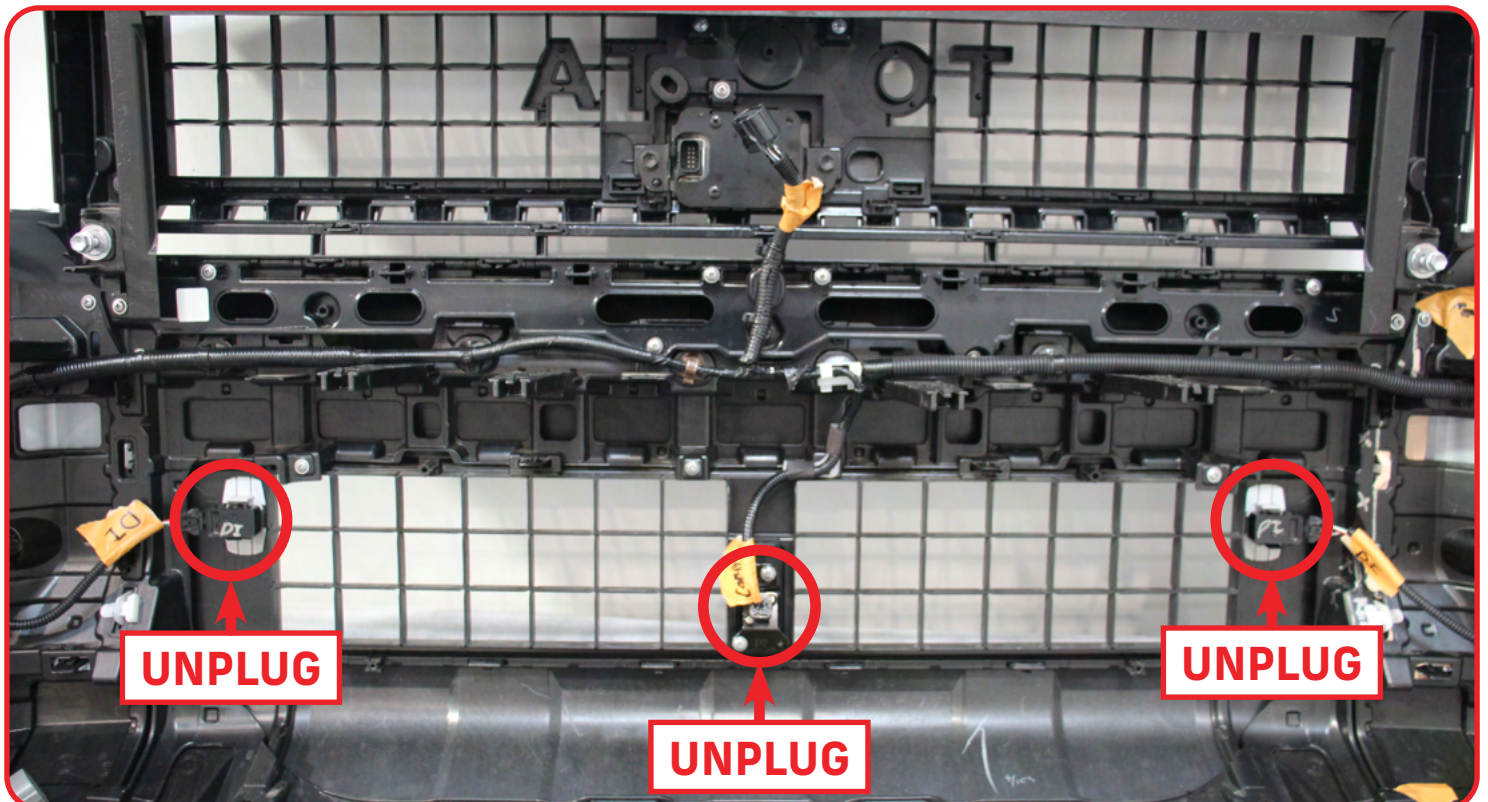
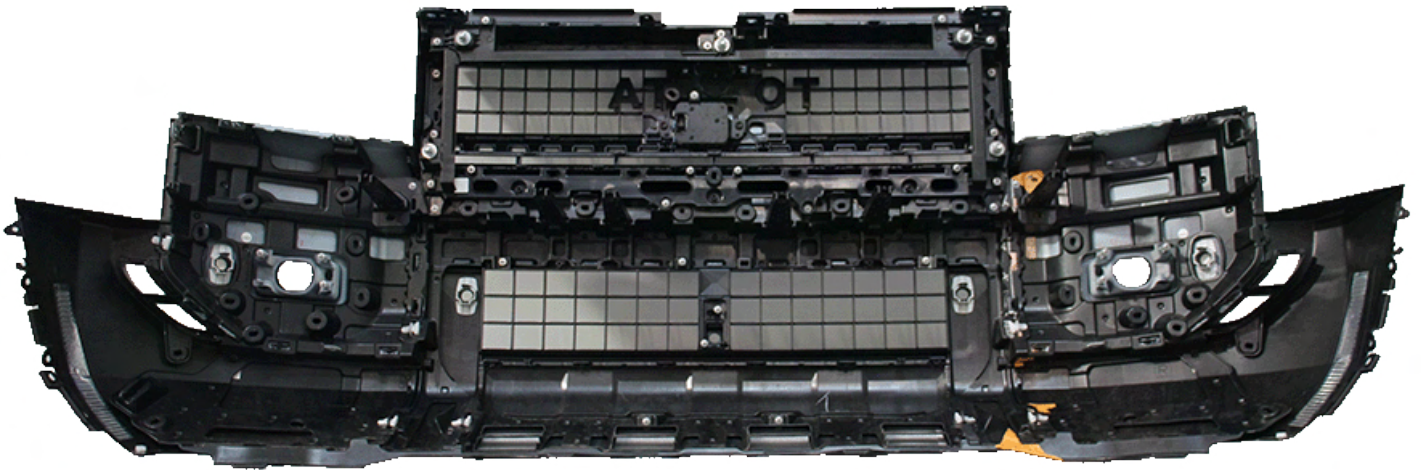
Locate and unplug the parking sensor indicated below.



□ STEP 28

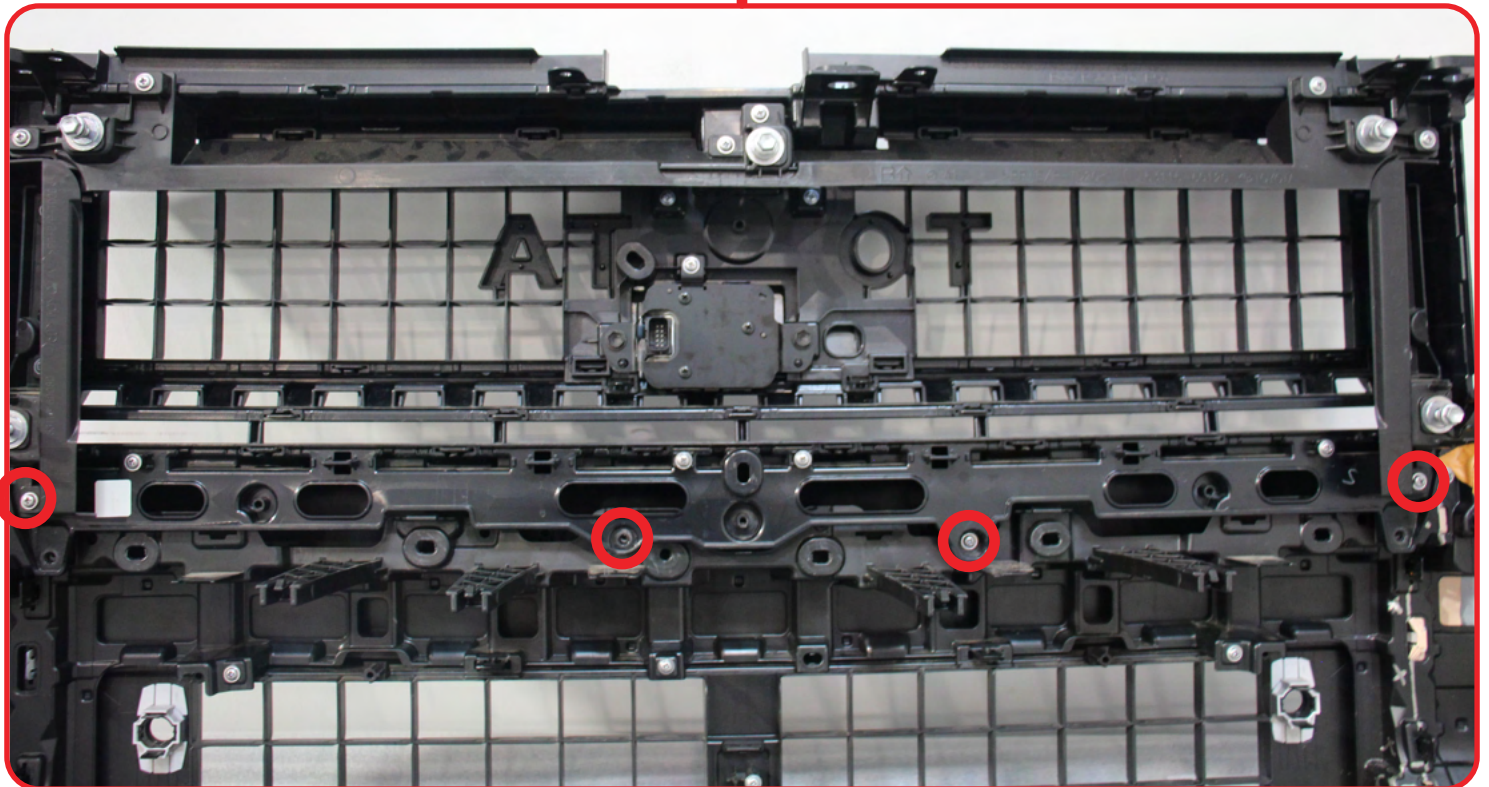
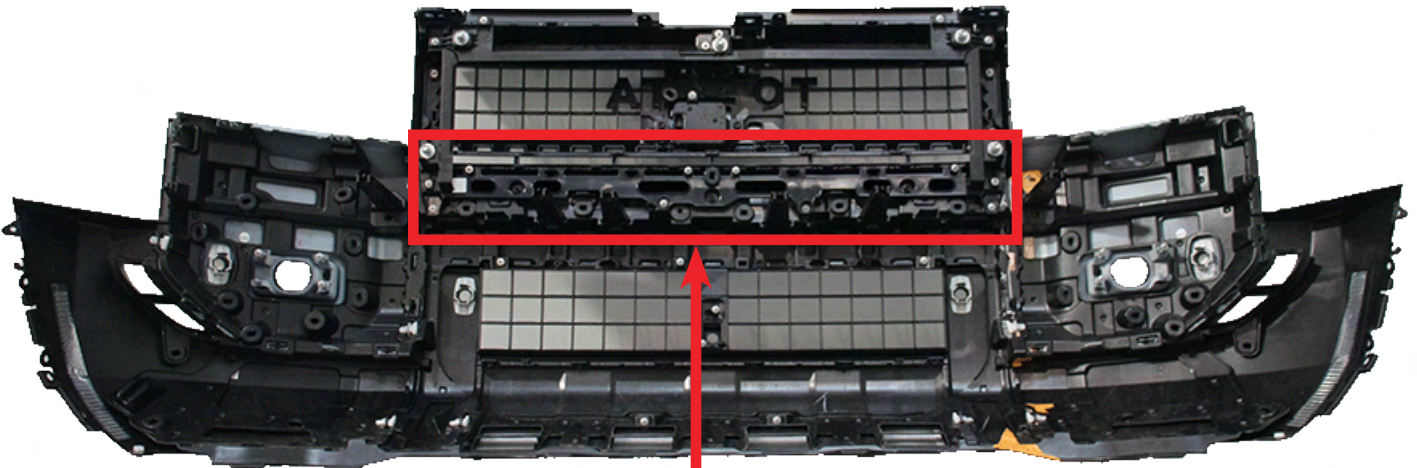
Unplug the front camera and parking sensors, then remove the wire harness from the grill assembly.

Note: Keep track of each specific sensor location. This will be important for reassembly



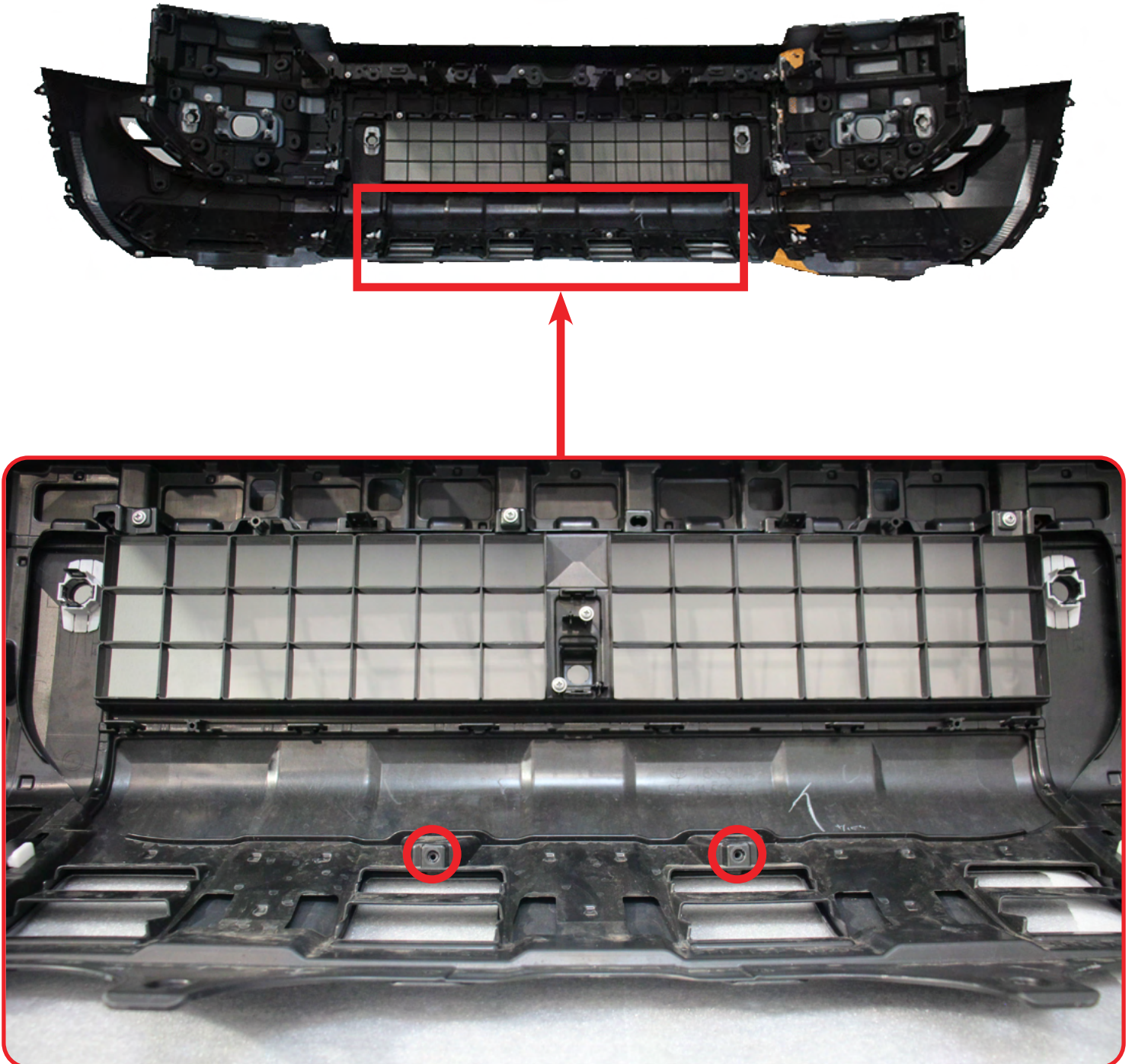
□ STEP 29

Next, using a (phillips screwdriver) remove the 4x bolts highlighted below, then remove the grille from the assembly.



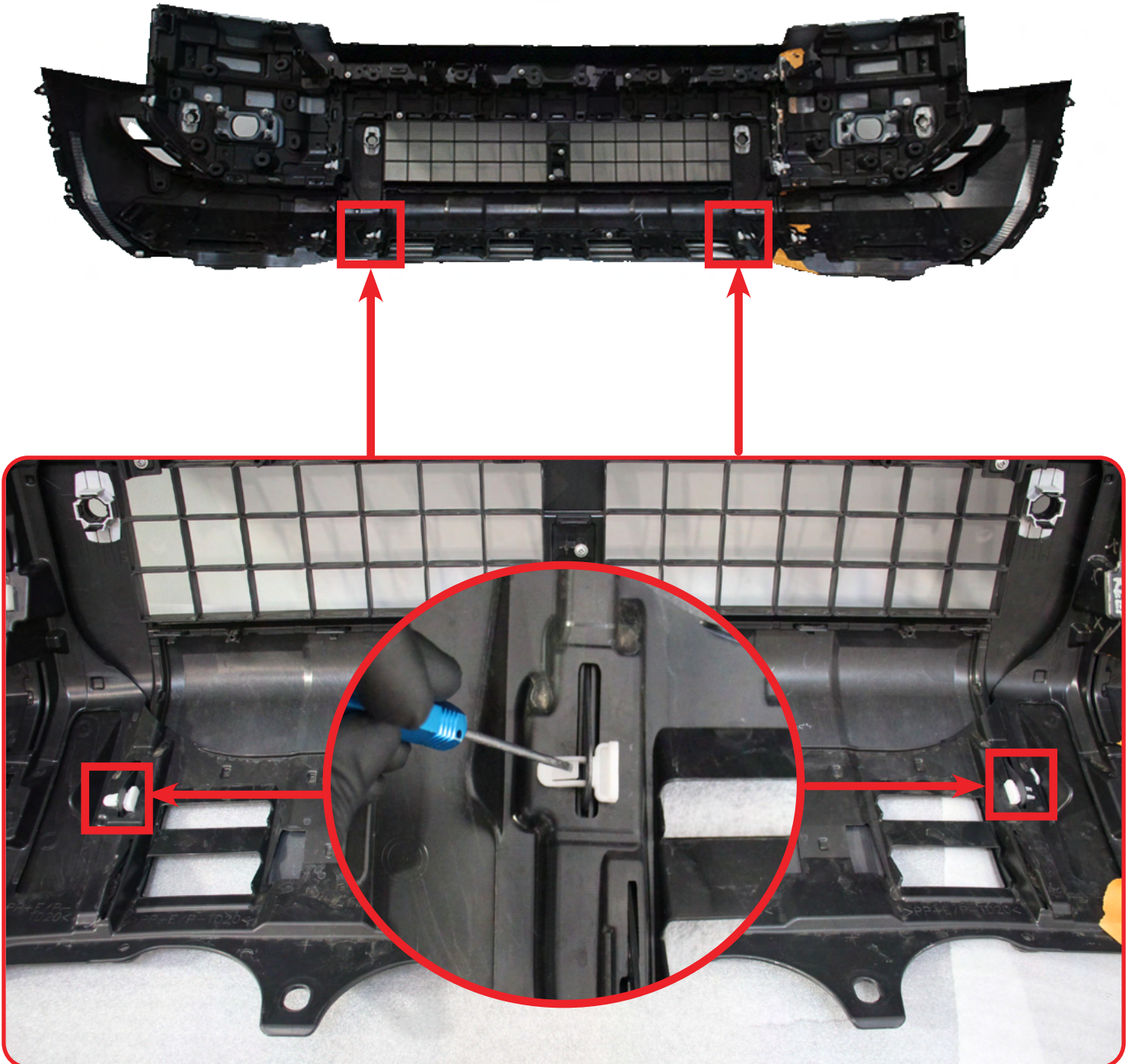
□ STEP 30

Using a (phillips screwdriver) remove the bottom 2x screws as shown below.



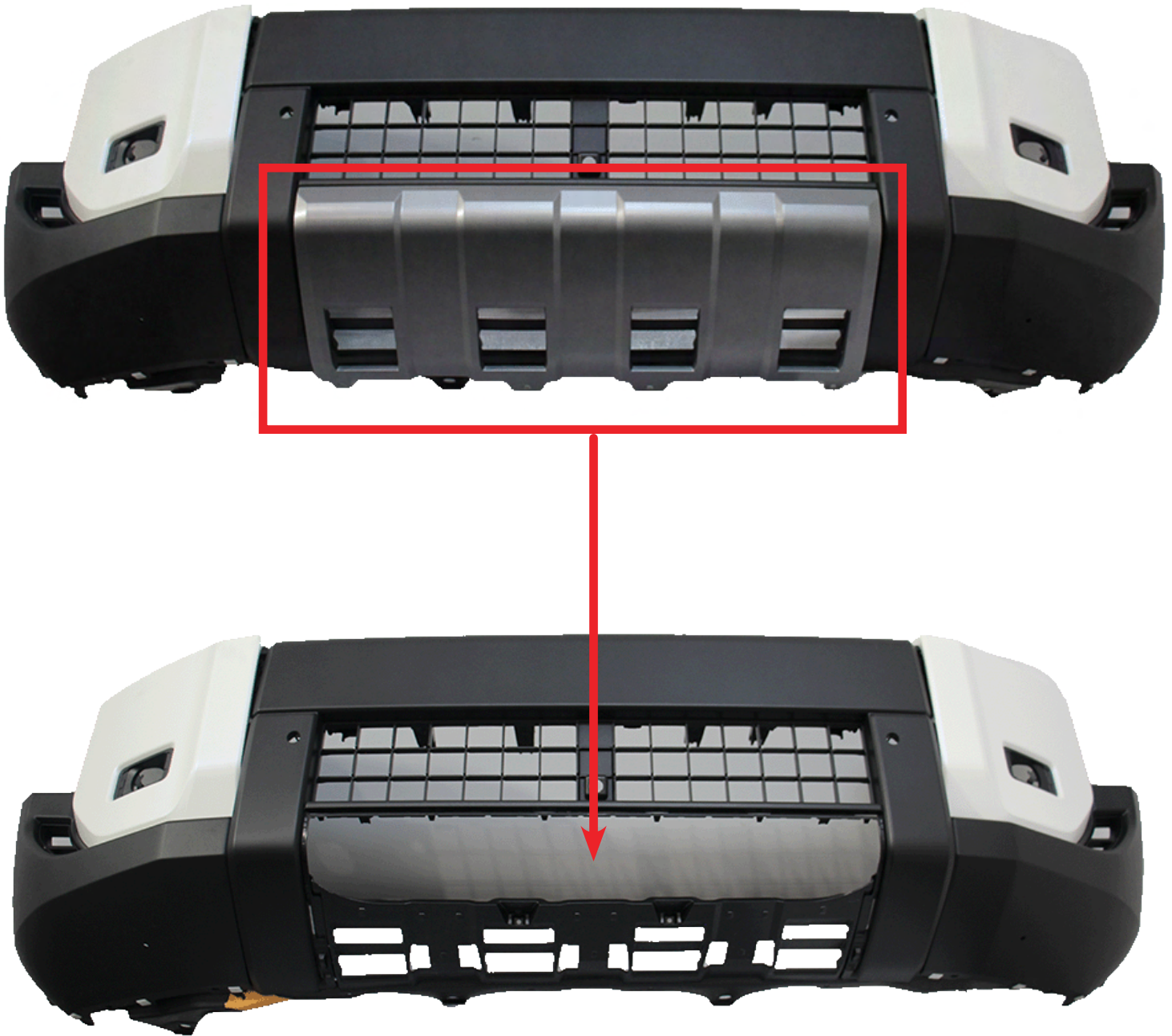
□ STEP 31

Remove the plastic retaining clips using a (flathead screwdriver).



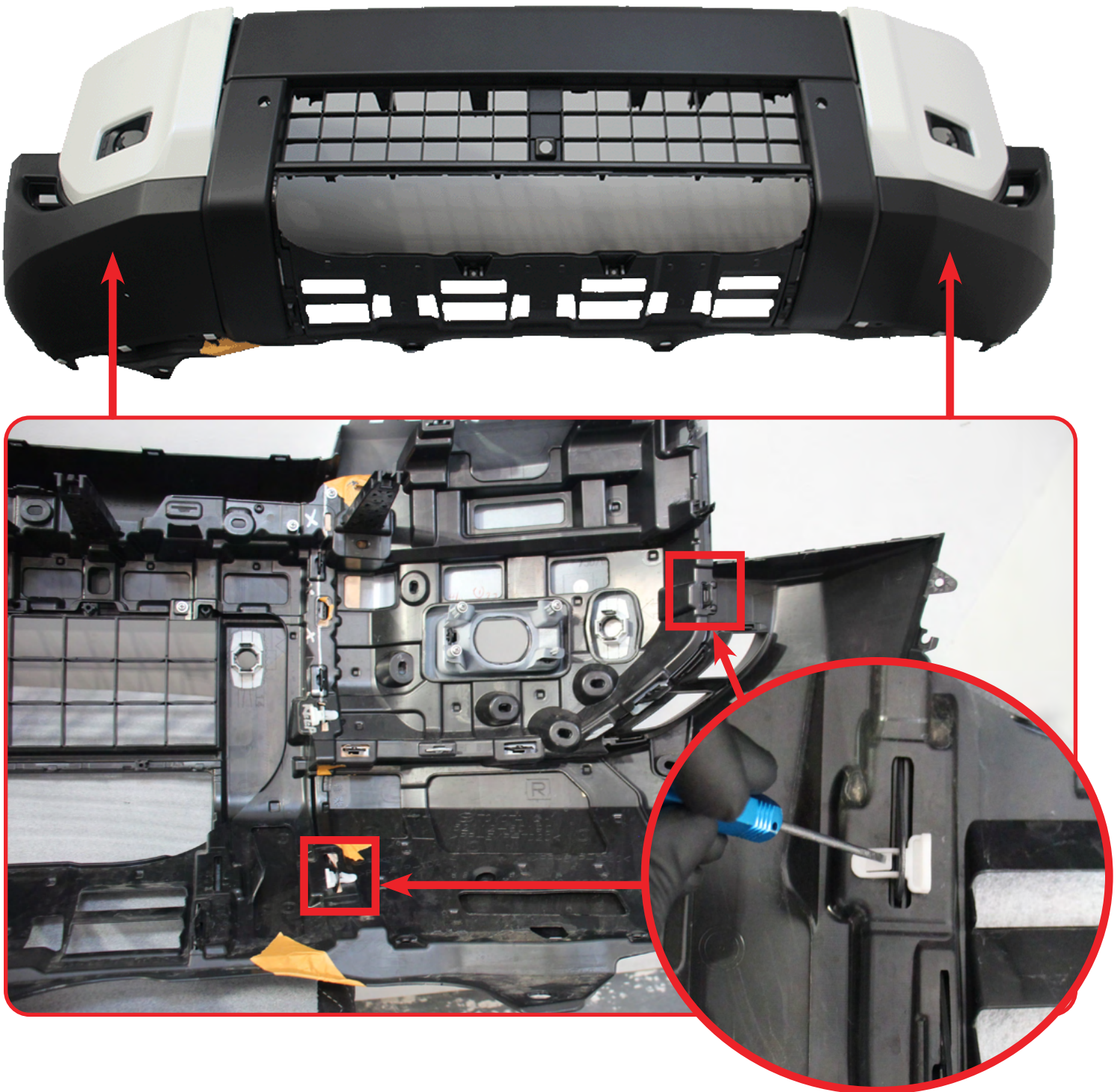
□ STEP 32

You can now remove the plastic cover by pulling.



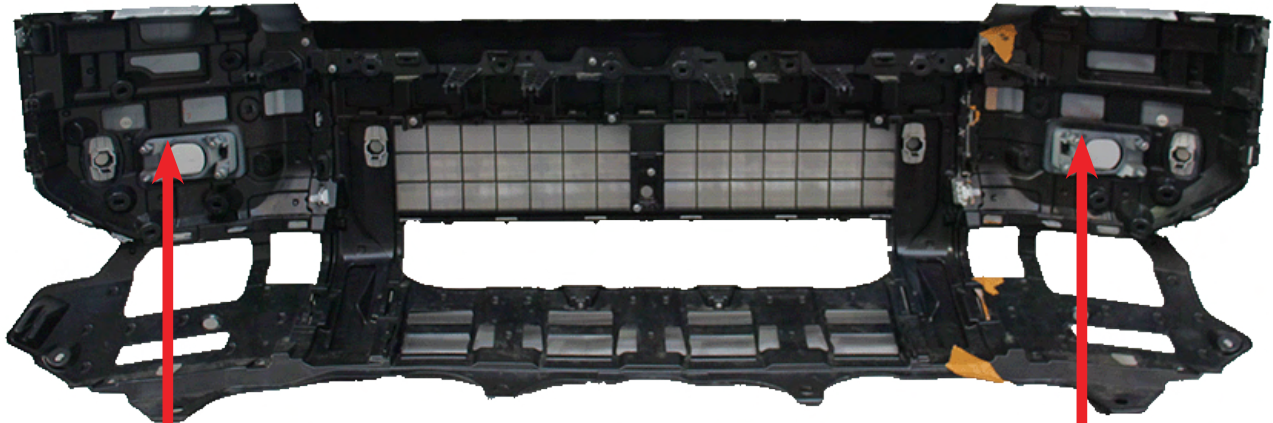
□ STEP 33

Next, remove the 4x plastic retaining clips for the bottom side covers and remove by pulling.



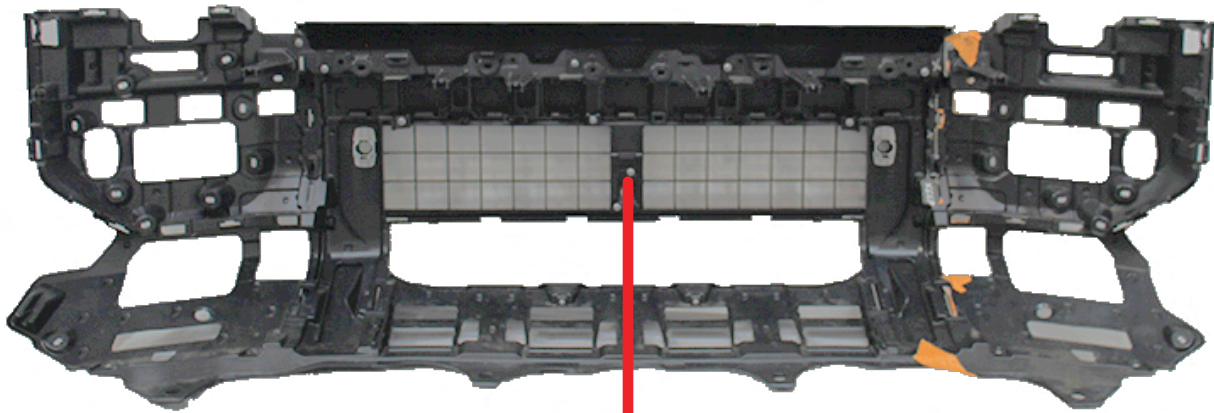
□ STEP 34

Using a (flathead screwdriver) remove the 2x plastic retaining clips holding the top side pieces to the grill. Remove by pulling.



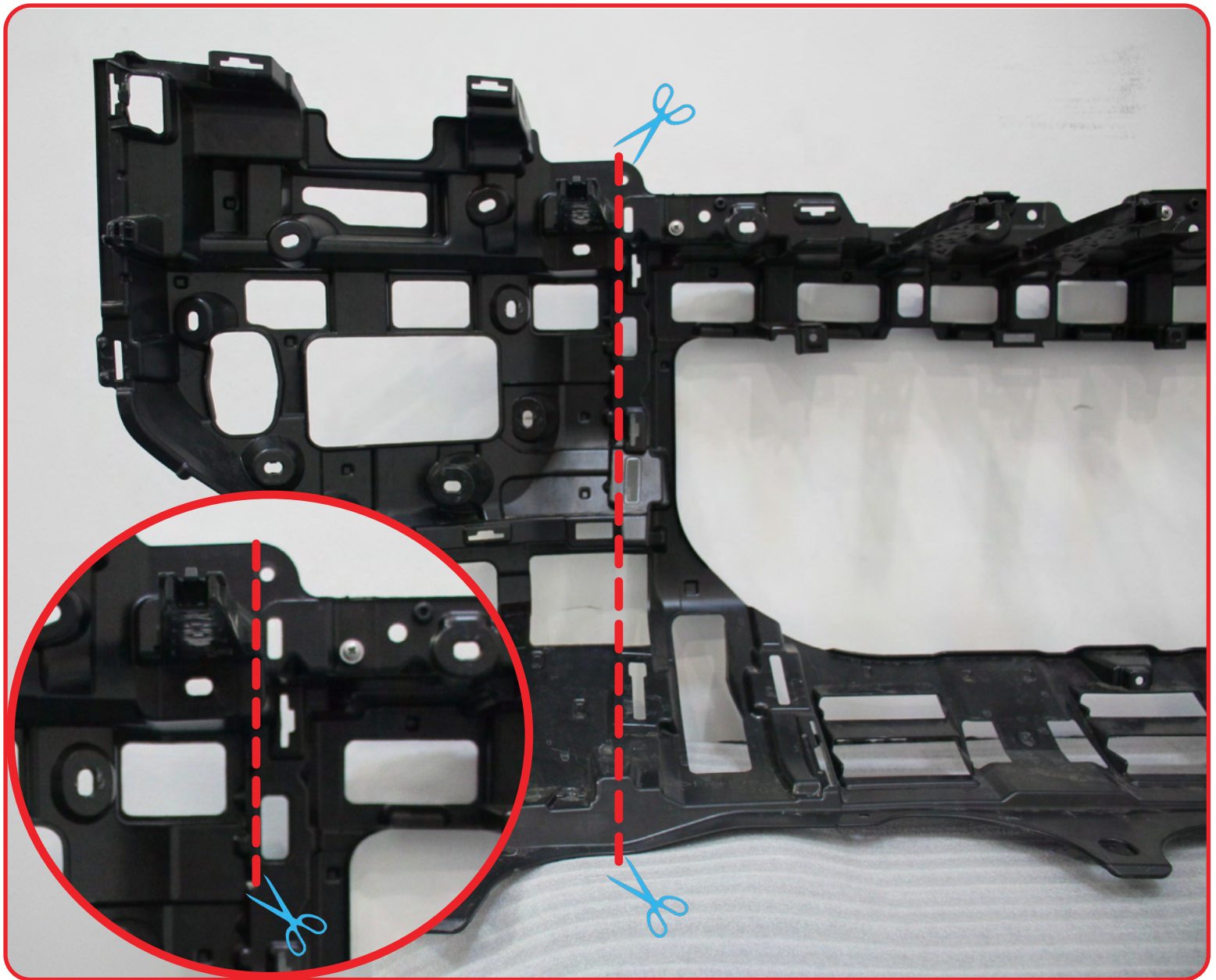
□ STEP 35

Next, remove the center plastic by pulling.



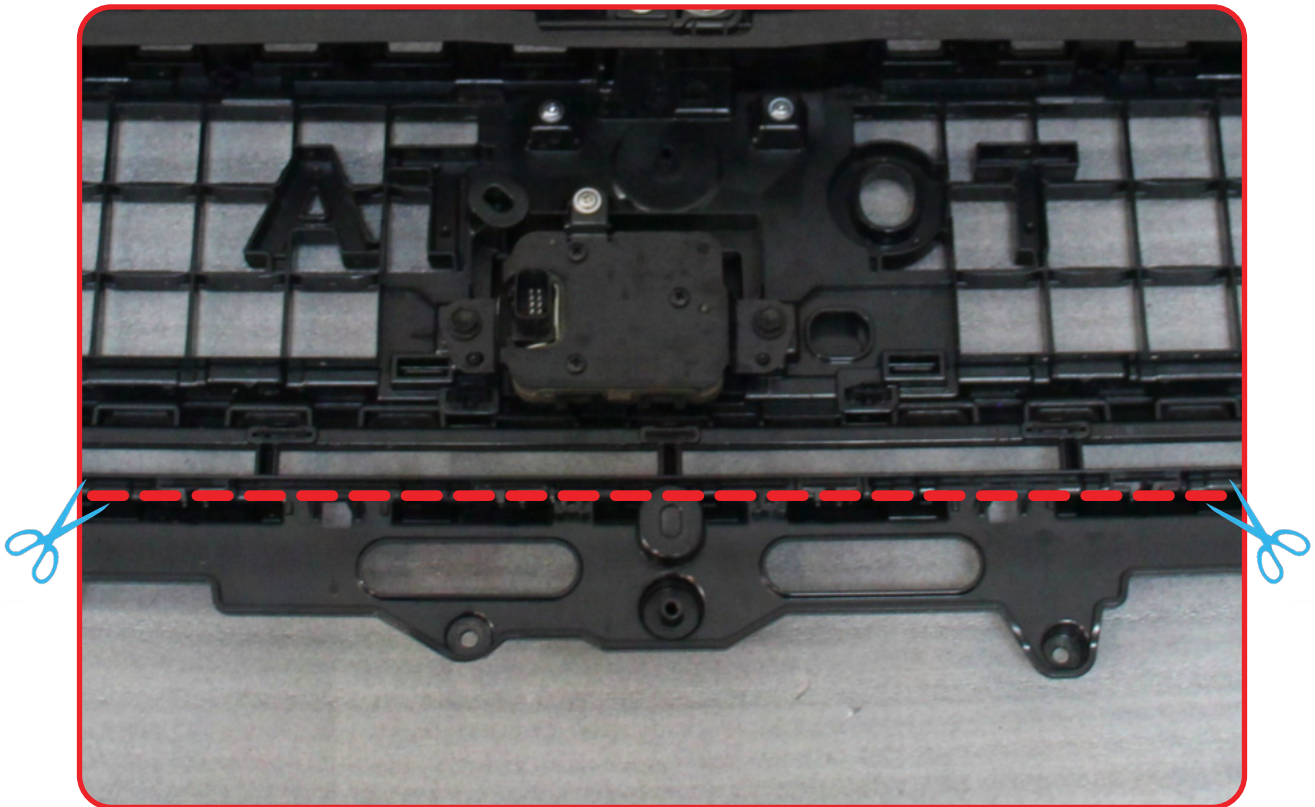
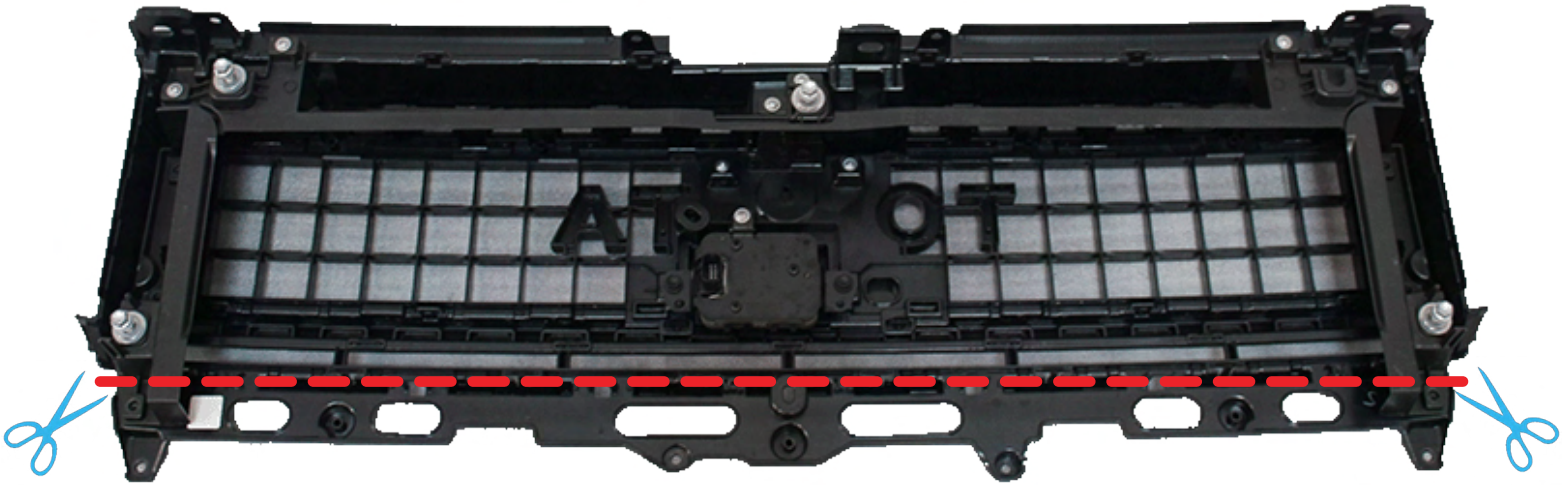
□ STEP 36

With your choice of cutting tools, cut along the outside edge where the center plastic removed from **step 32** clipped in. ****This step may need adjustments later on in the install****



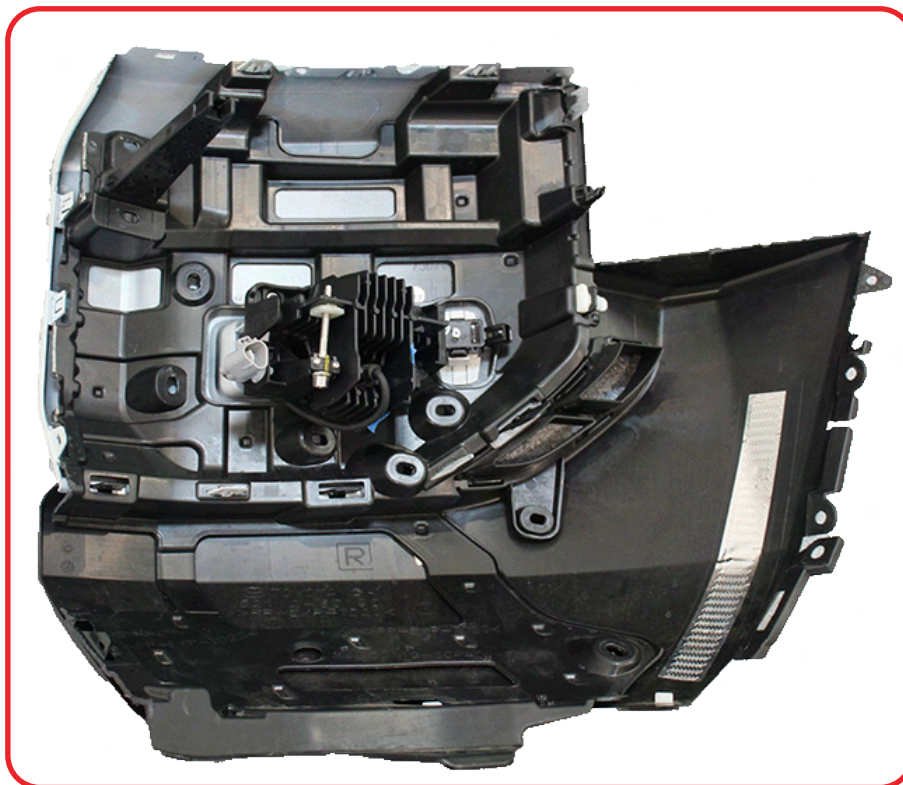
□ STEP 37

With your choice of cutting tools, cut the bottom edge just below the window cutouts are on the top grille removed from **step 26**.



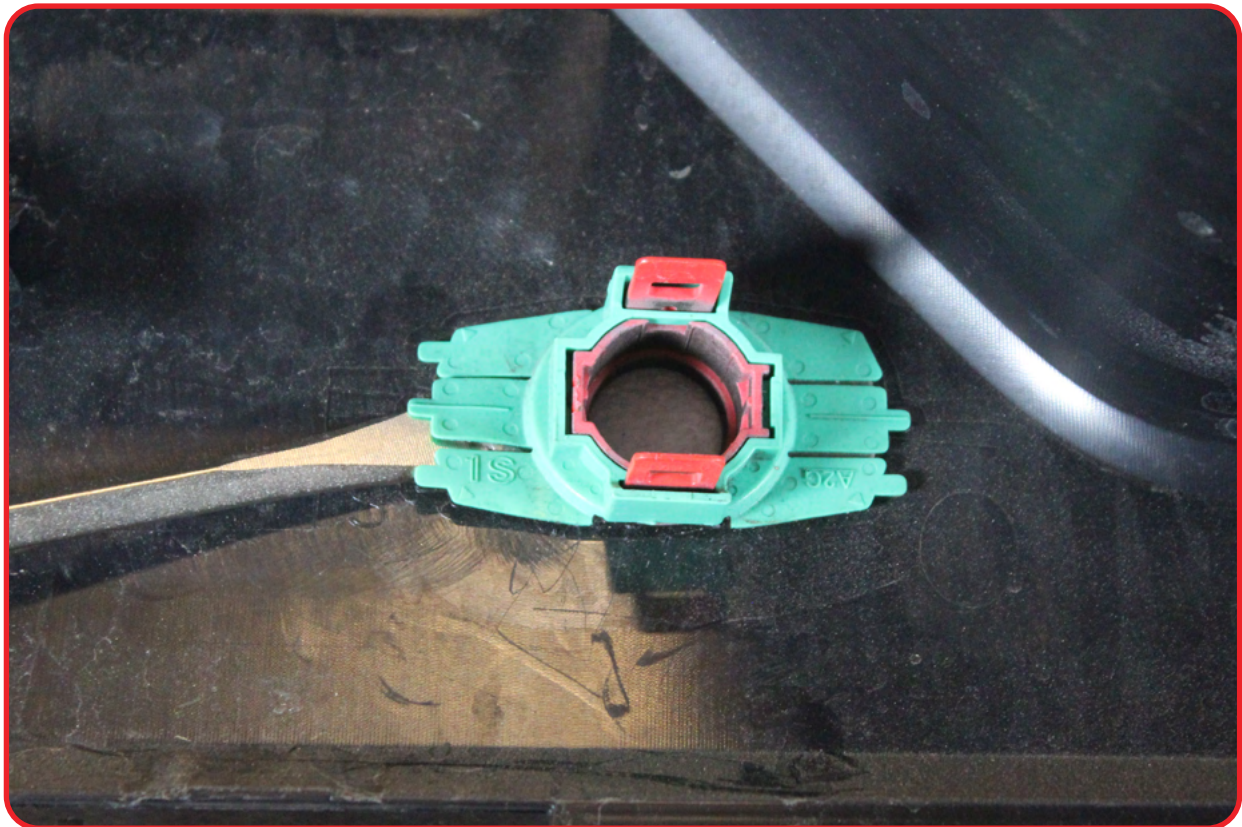
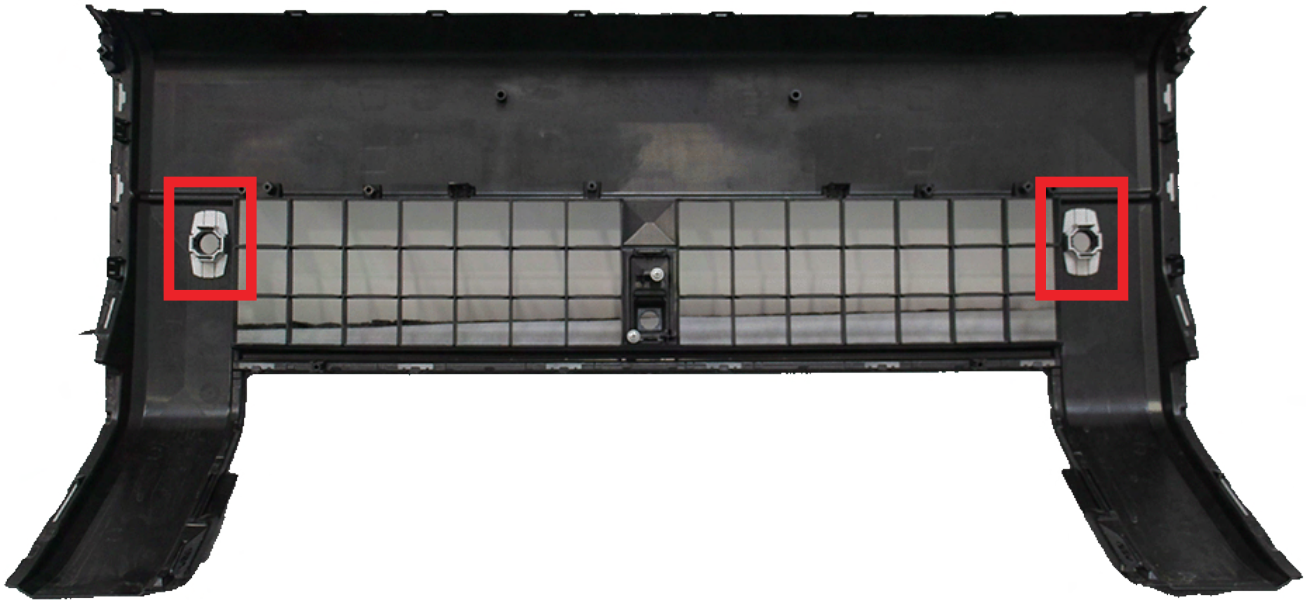
□ STEP 38

Repeat **steps 30-31** to re-install the trimmed plastic to the side fascia paneling.



□ STEP 39

Use a (heat gun) to soften adhesive and use (flathead screwdriver) remove the sensor bezels from the plastic removed from step 32. ****Keep for install****



□ STEP 40

Remove double sided tape from the bezel until the surface is clear of residue.

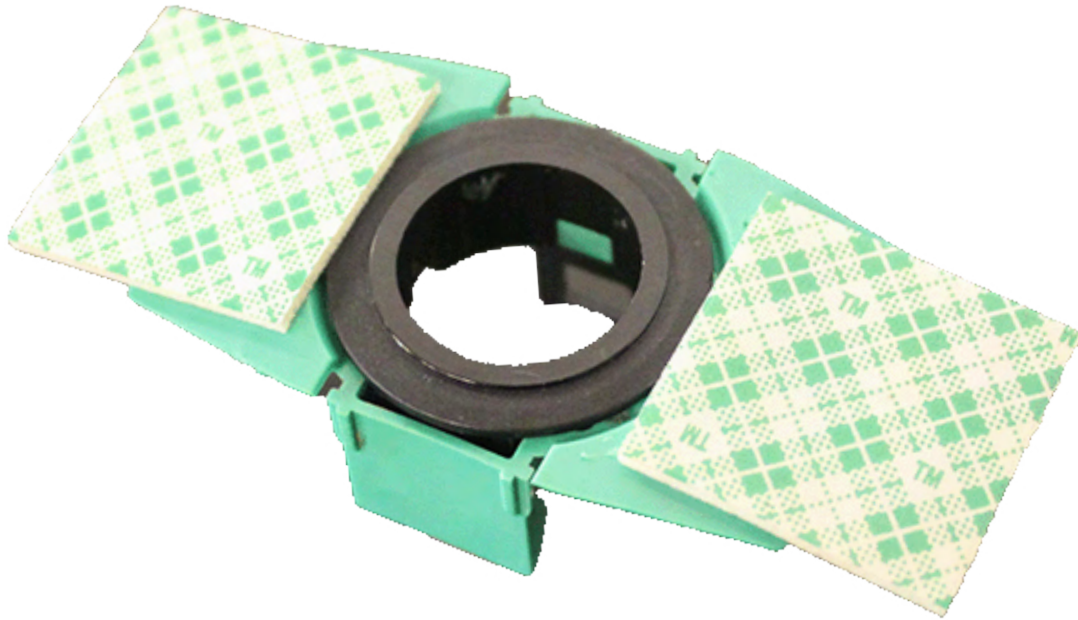
Tech tip: Use a razor blade and adhesive remover to help remove all adhesive.



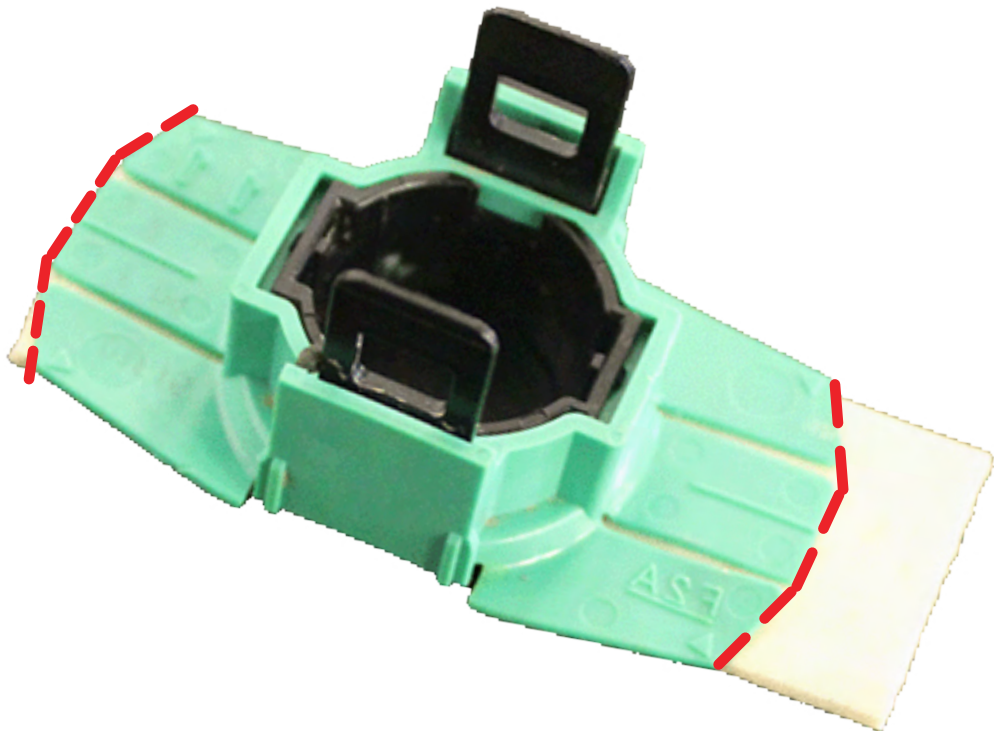
□ STEP 41

Install the provided (D1) 3m double sided tape to each side of the bezel wings and trim excess with a (razor blade).

Tech Tip: **For Best Results** use a 2-Part Epoxy in place of tape. Do **NOT** apply Epoxy until sensor bezels are ready to be bonded into the bumper

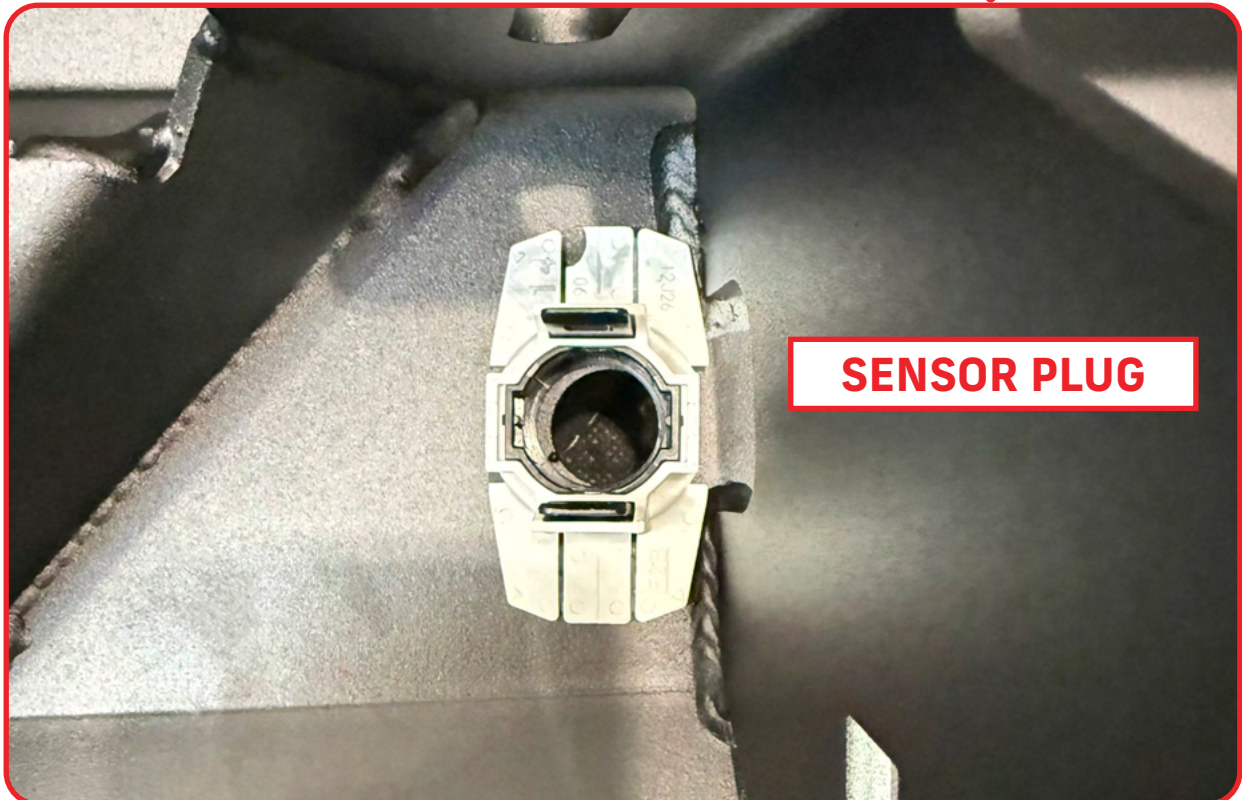
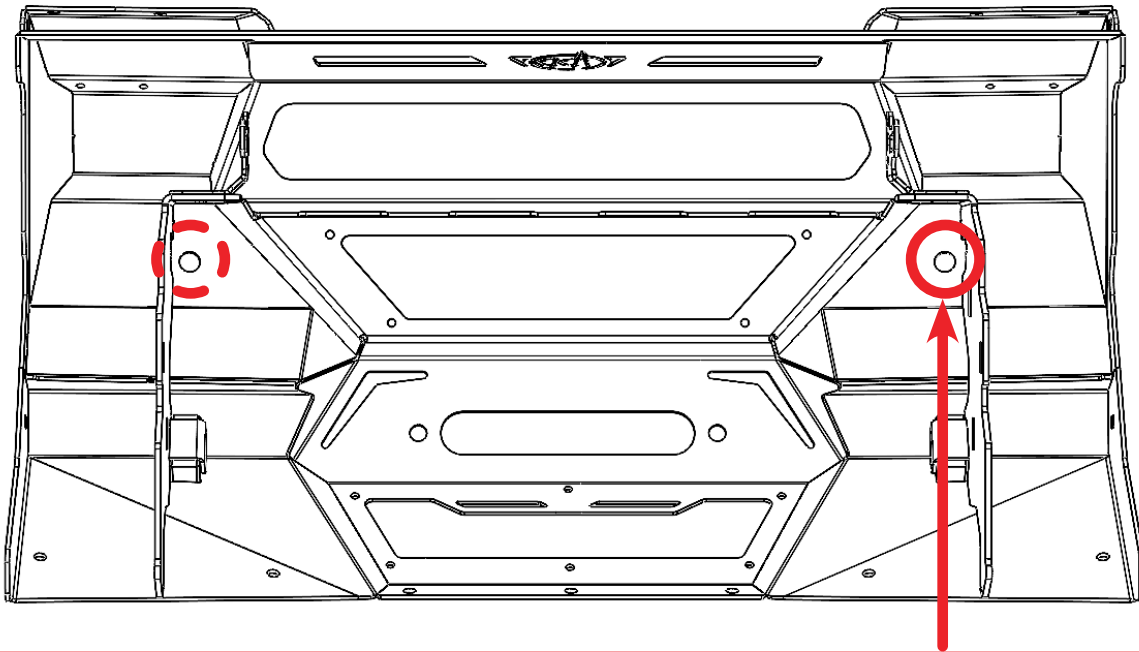


D1.



□ STEP 42

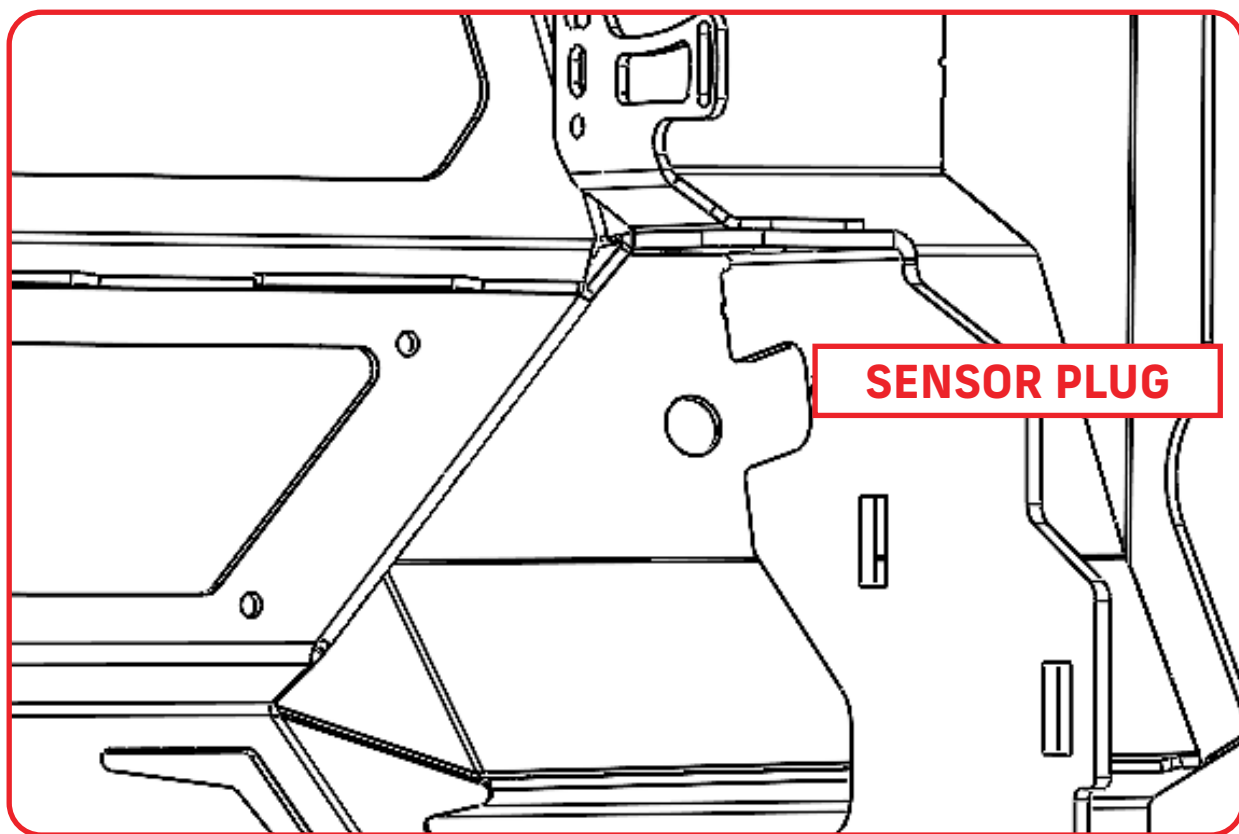
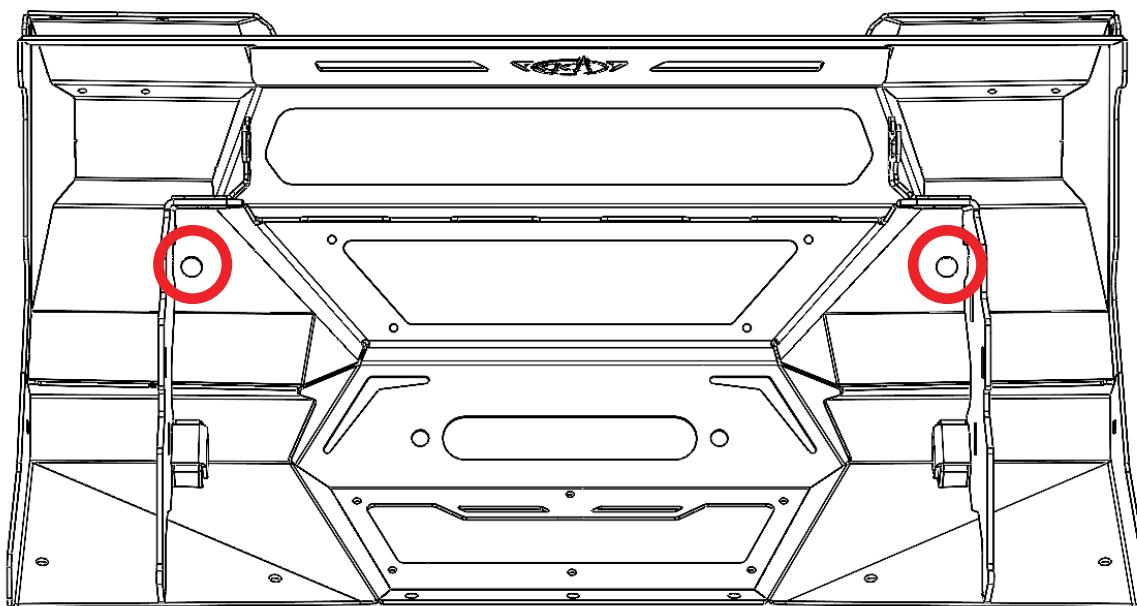
Bond the inner sensor bezels into the bumper in their original orientation, with the sensor plugs oriented towards the outside of the vehicle. Trim the sensor bezel flanges as needed to achieve flat fitment and maintain a concentric alignment between the bezel and cutout in the bumper.



□ STEP 43

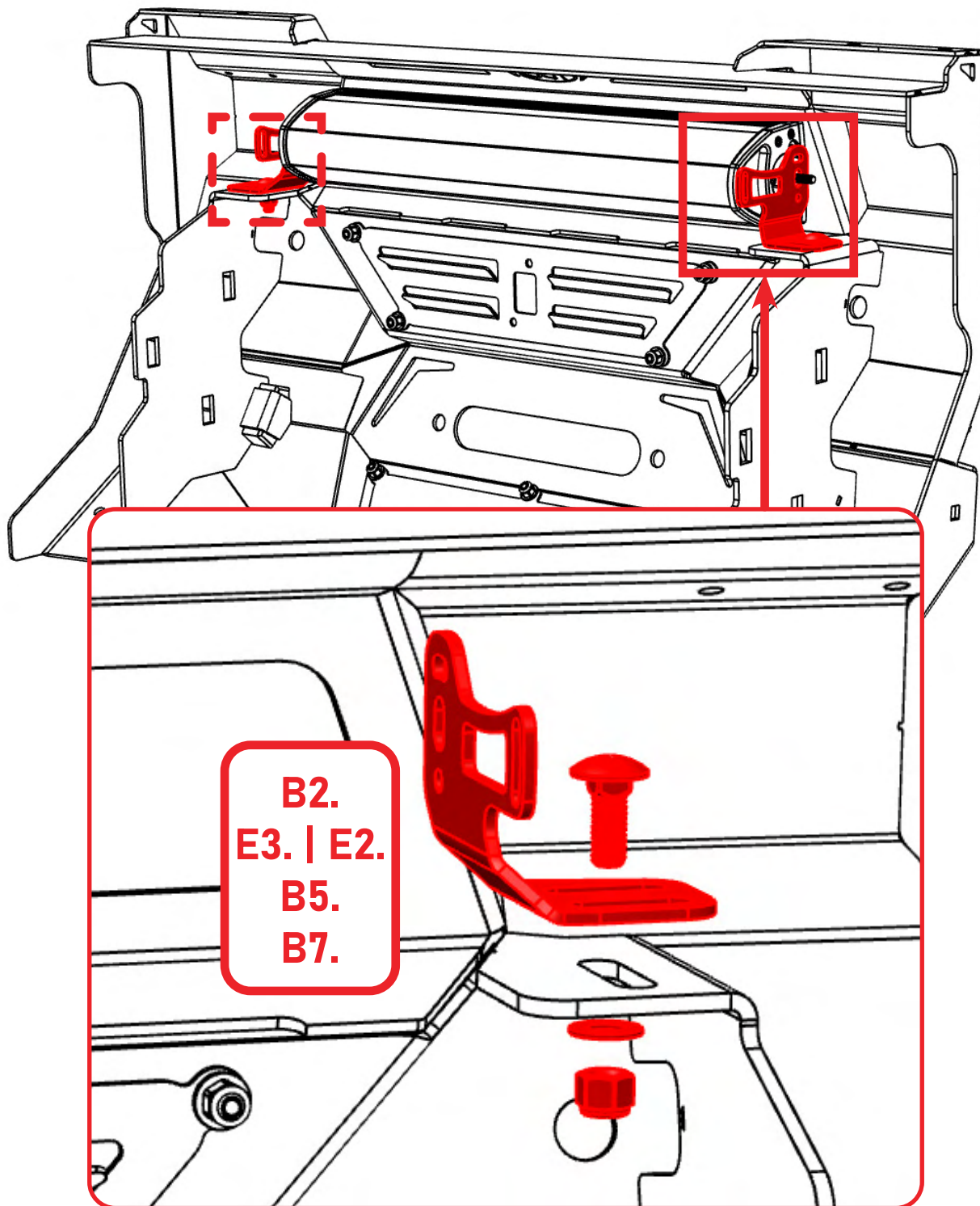
Re-install and connect the parking sensors ensuring that the plugs are oriented towards the outside of the vehicle,

Note: Sensors must be reinstalled in their original locations



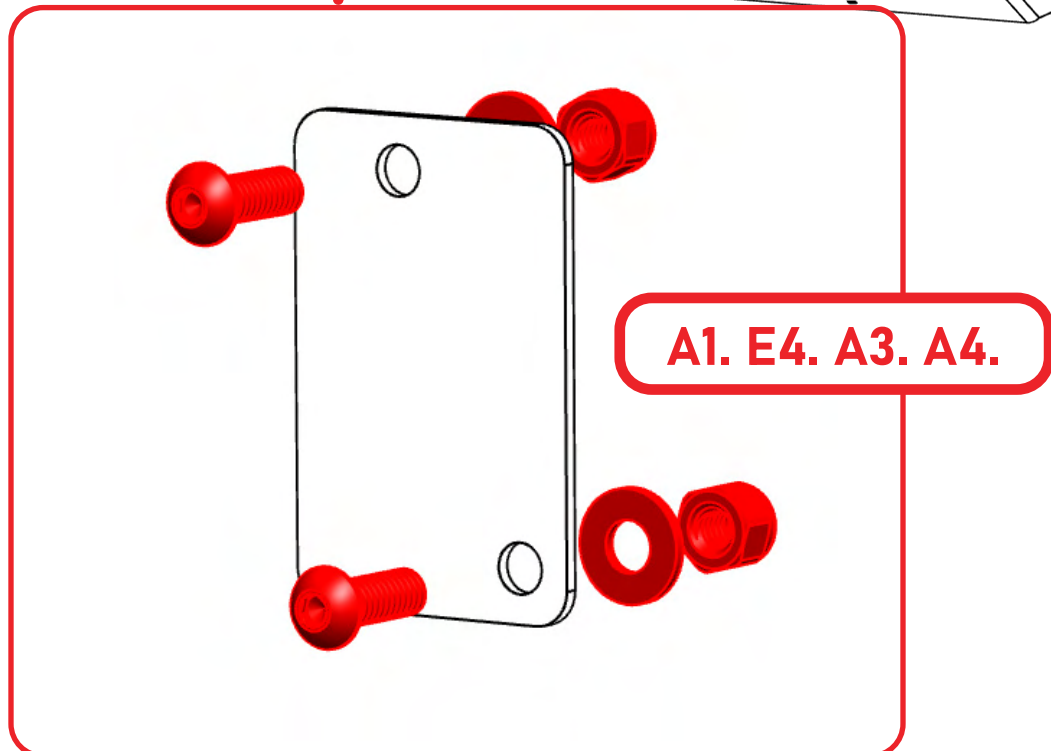
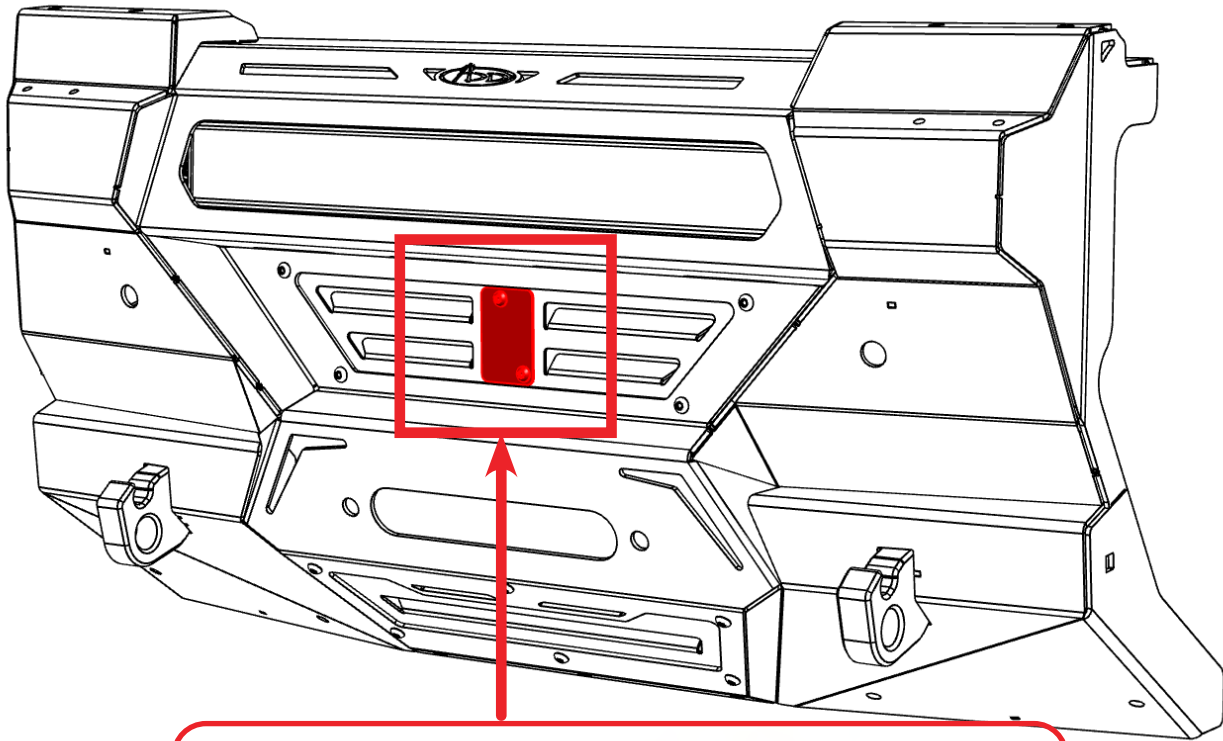
□ STEP 44

If installing a light, attach the supplied light mount tabs (E2, E3) to your light bar, utilizing the hardware that came with your light, then using a (9/16 socket) and the provided hardware (B2, B5, B7) install the light into the bumper as shown below.



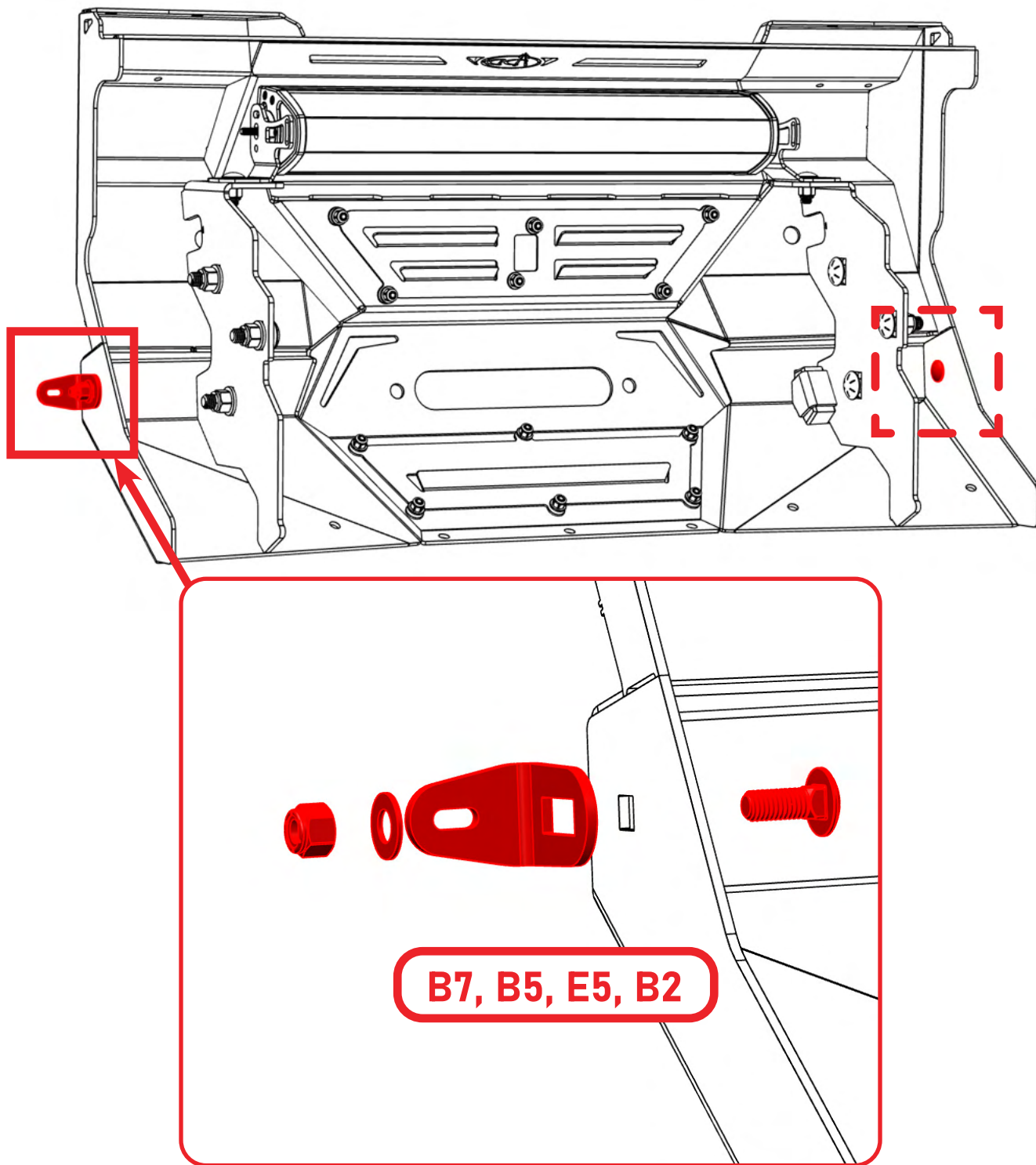
□ STEP 45

Using a (5/32 allen), (7/16 socket) and the supplied hardware (A1, A3, A4) relocate the front camera to the location indicated below, inserting it through the panel from the back side. If your vehicle did not come equipped with a front camera, install the supplied camera cover panel (E4) in it's place.



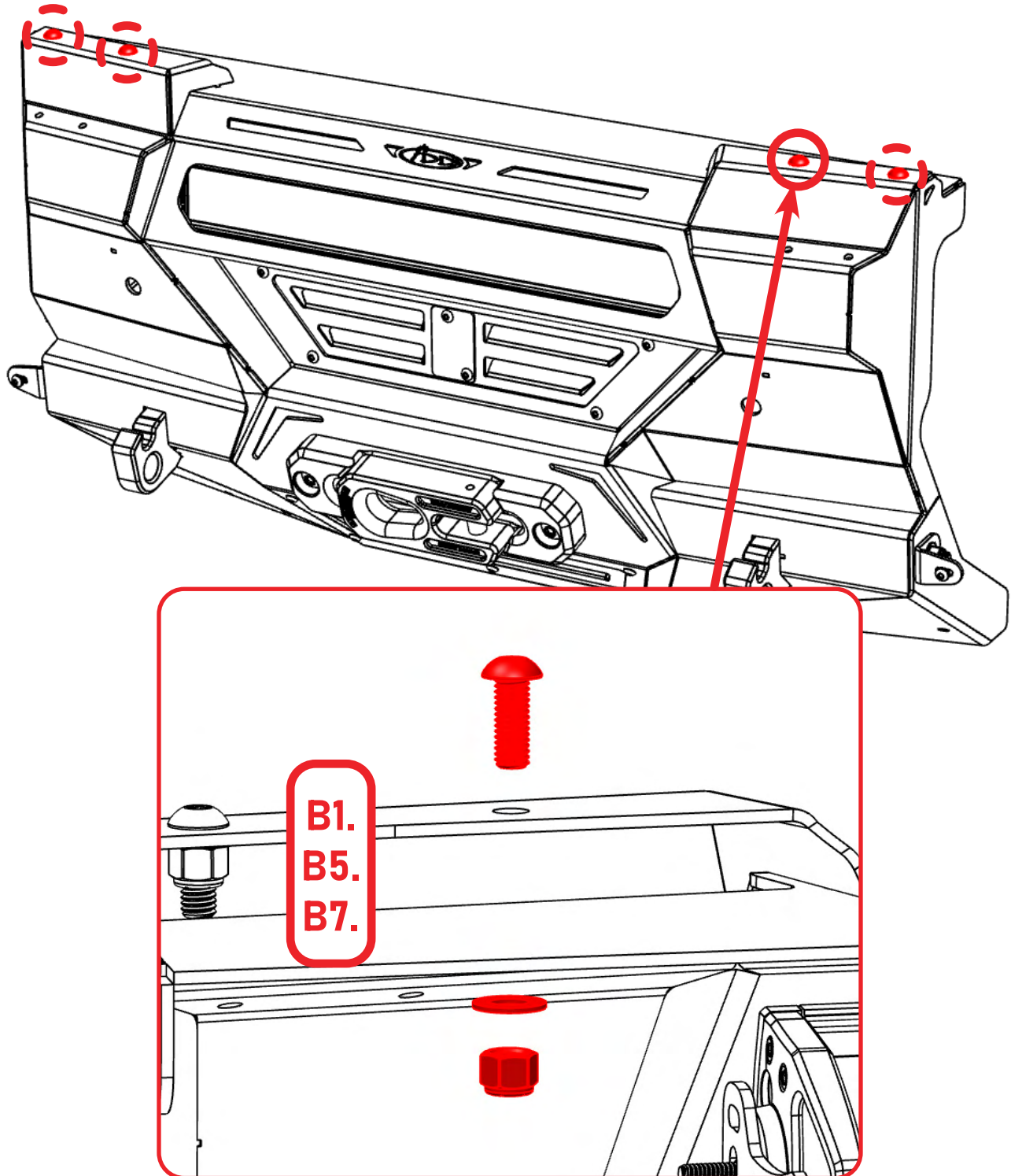
□ STEP 46

Using a (9/16 socket) and the supplied hardware (B2, B5, B7) install the supplied valance support brackets (E5) as shown below.



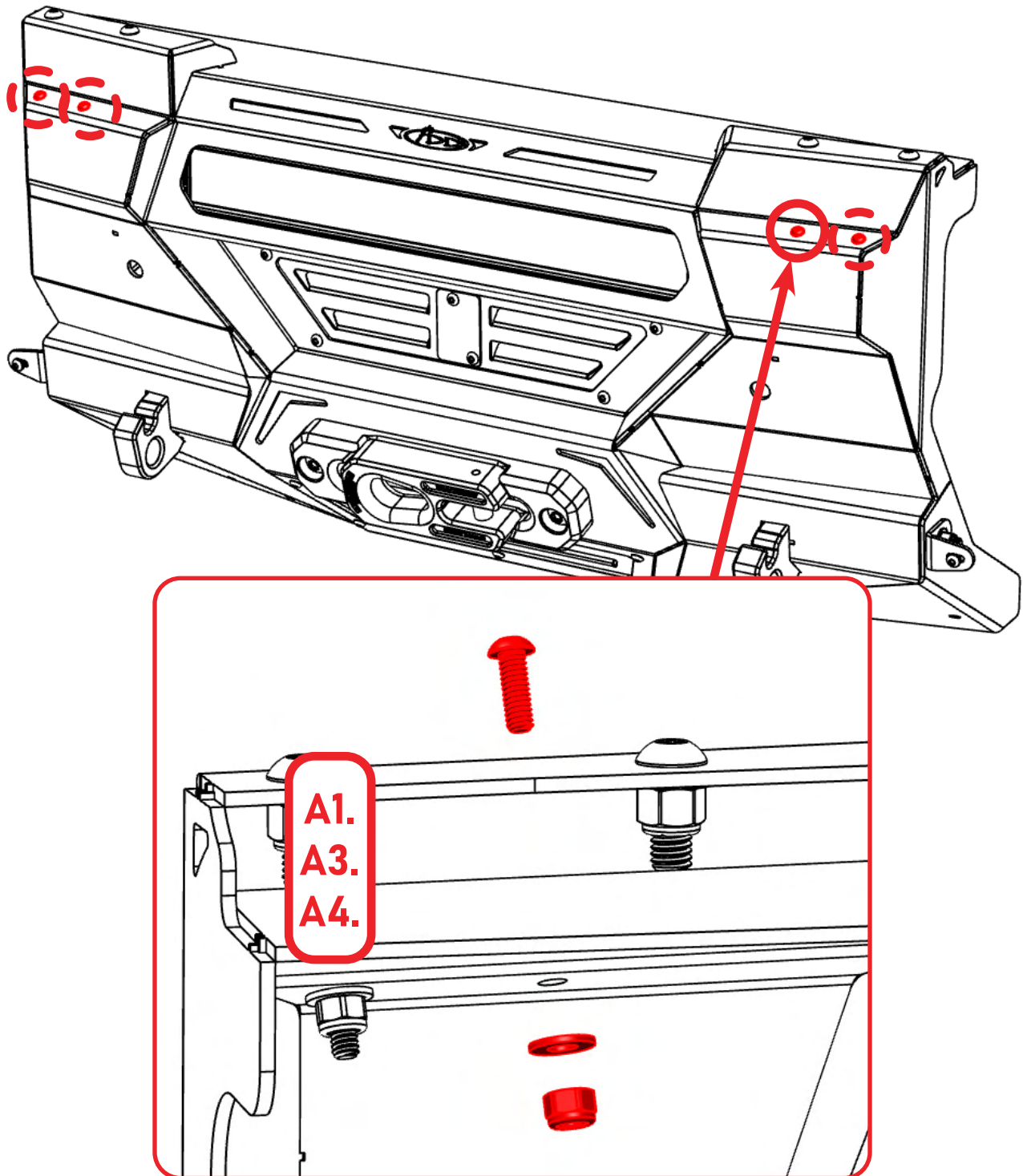
□ STEP 47

Using a (7/32 allen) and a (9/16 socket) install the supplied hardware (B1, B5, B7) as shown below.



□ STEP 48

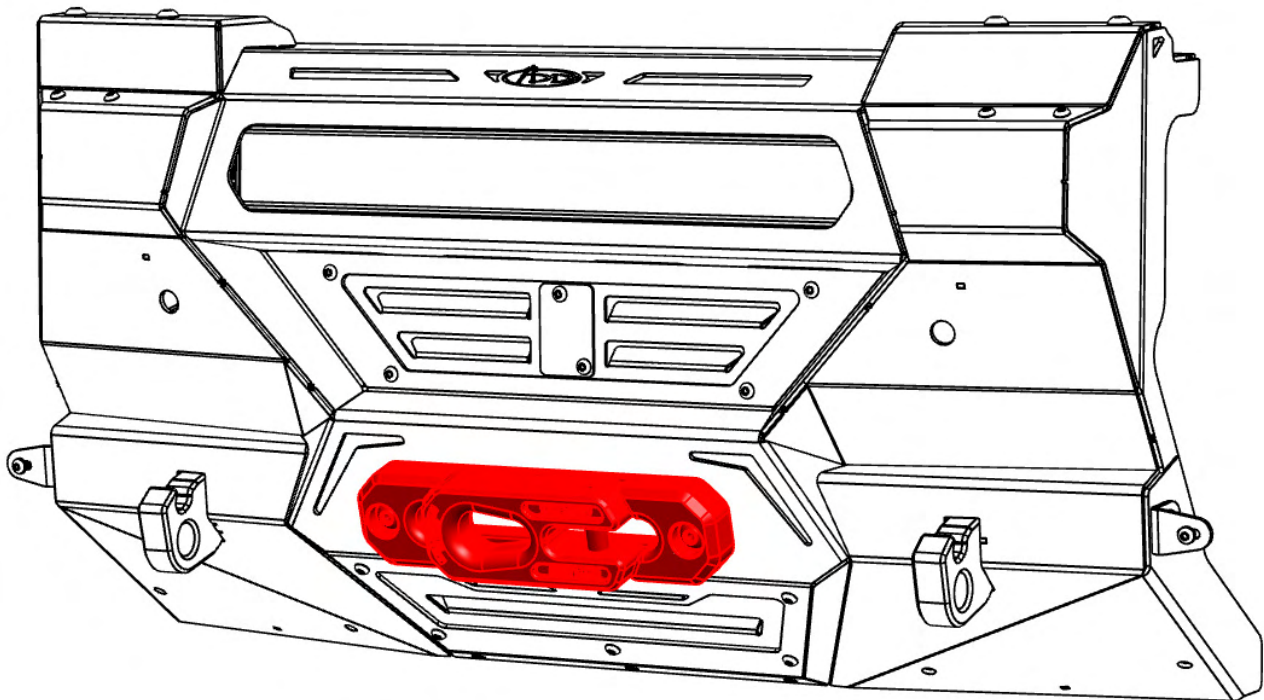
Using a (5/32 allen) and a (7/16 socket) install the supplied hardware (A1, A3, A4) as shown below.



☐ STEP 49

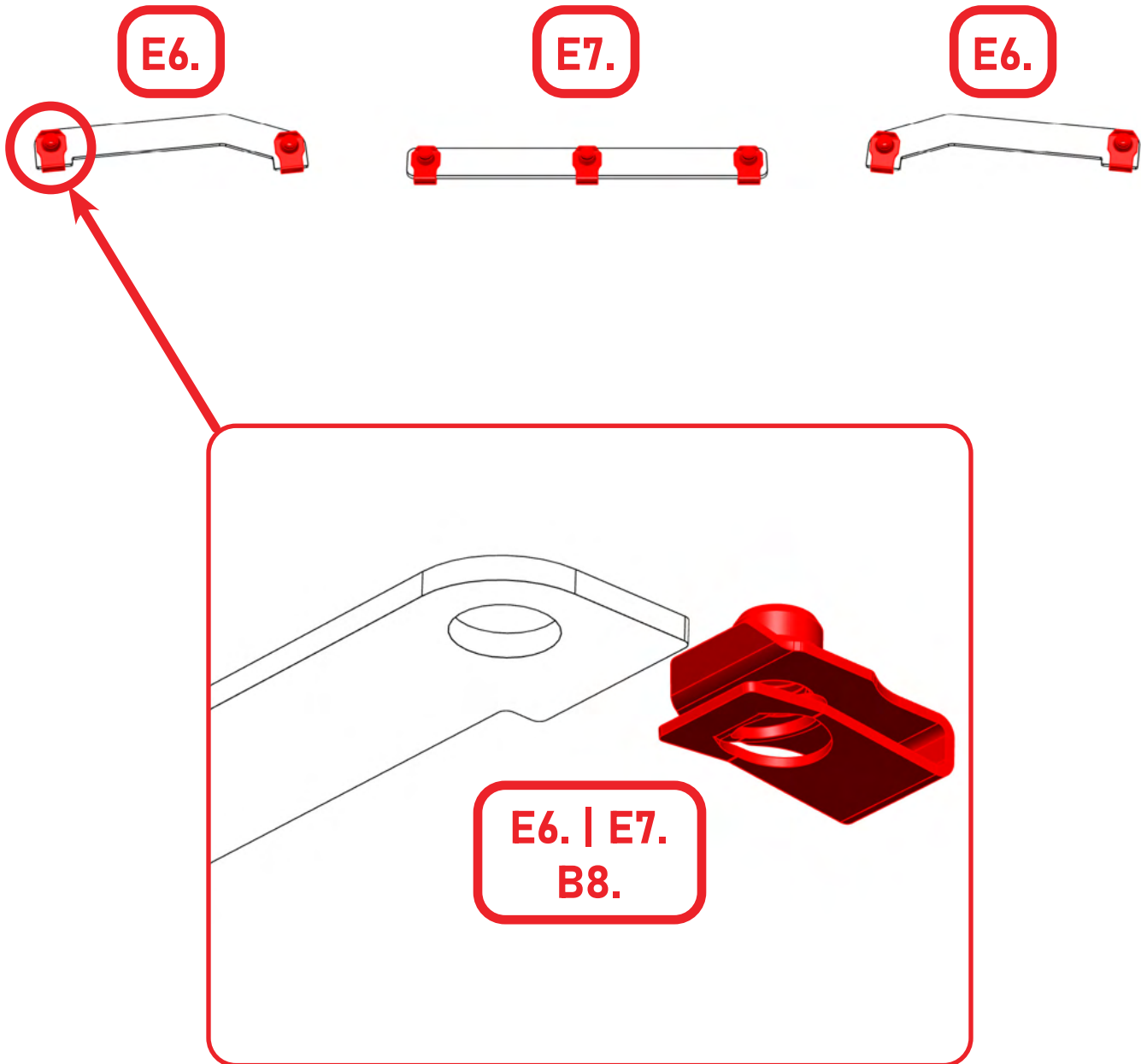
If you're installing a winch fairlead, do so at this time.

Note: Ensure proper alignment to avoid cable/line rubbing with the bumper



□ STEP 50

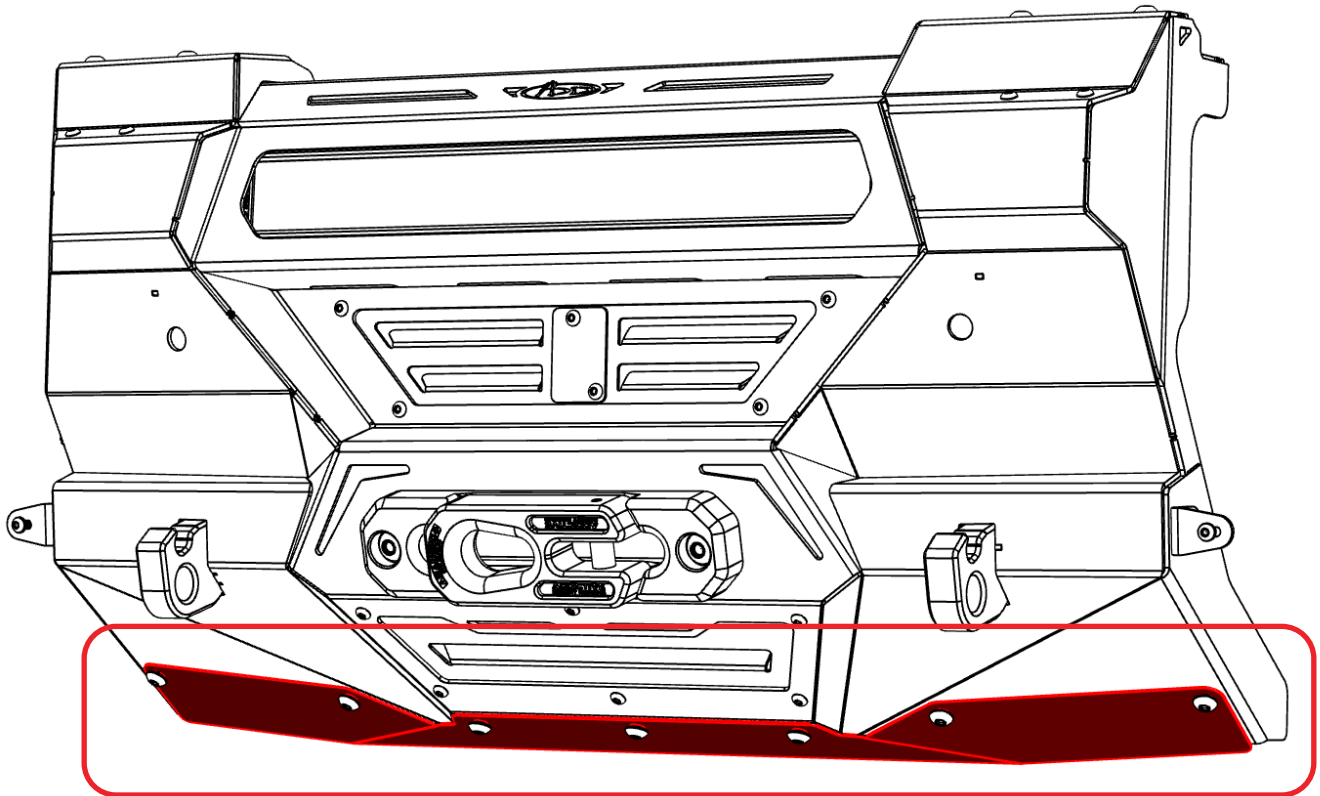
Locate the nut plates (E6, E7) shown below and install the supplied hardware (B8) as indicated.



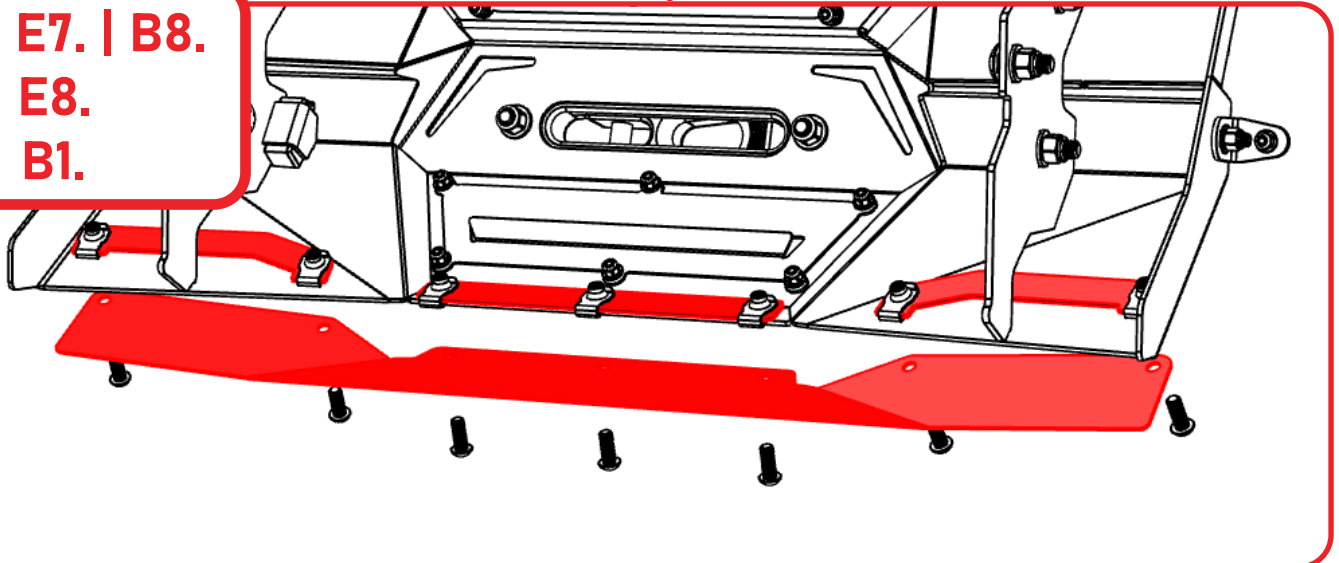
□ STEP 51

Using a (7/32 allen), the (3) previously assembled mounting plates and the supplied hardware (B1), install the rock guard (E8) as shown below.

NOTE: Skip this step if you've purchased the add-on skid plate (Part# AC770560303)

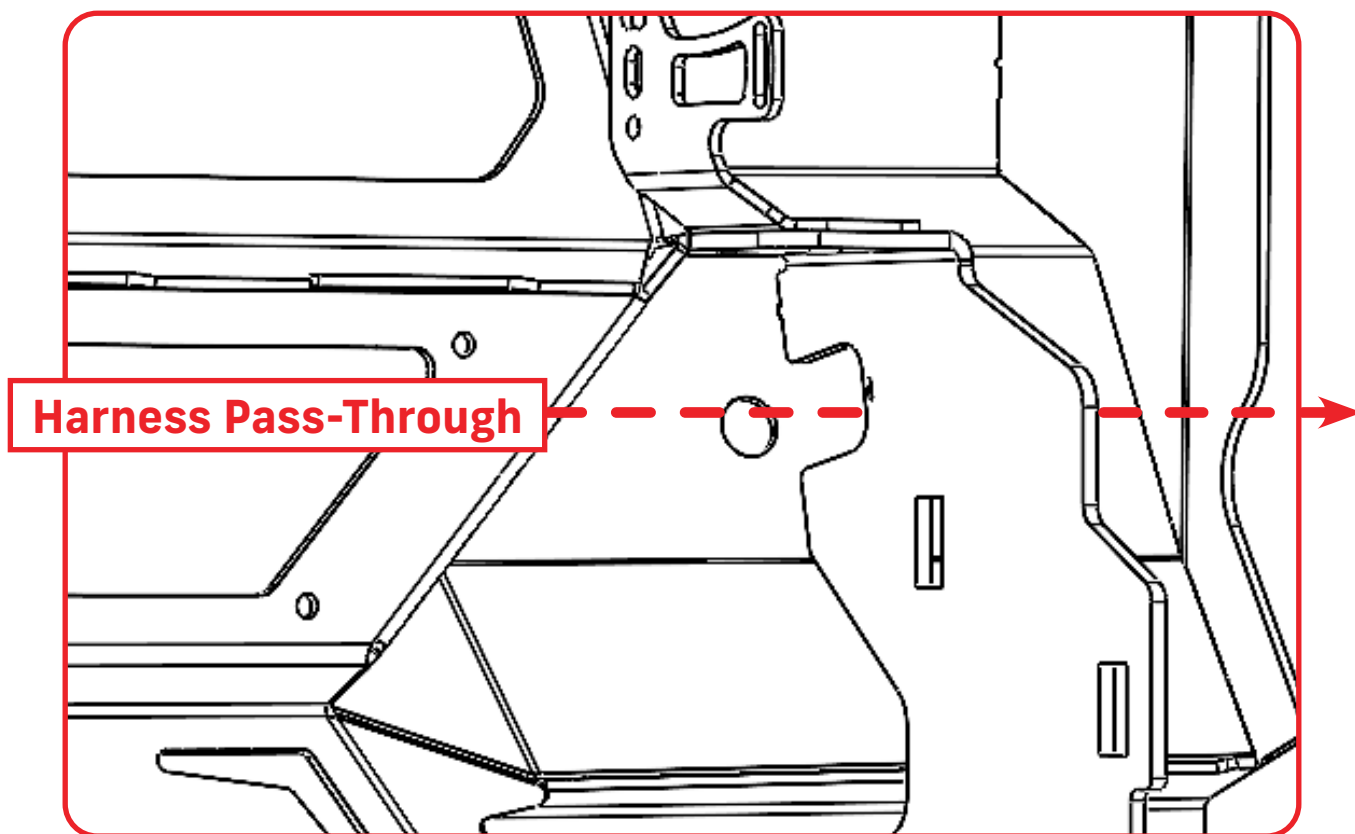
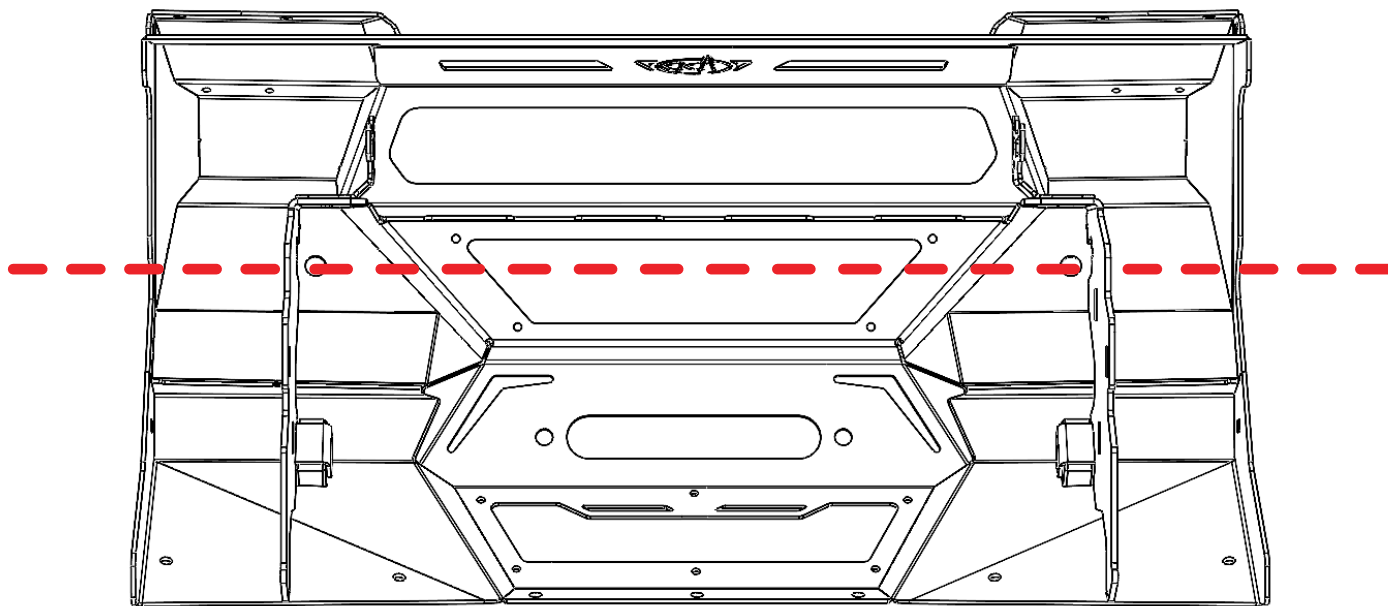


E6. | E7. | B8.
E8.
B1.



□ STEP 52

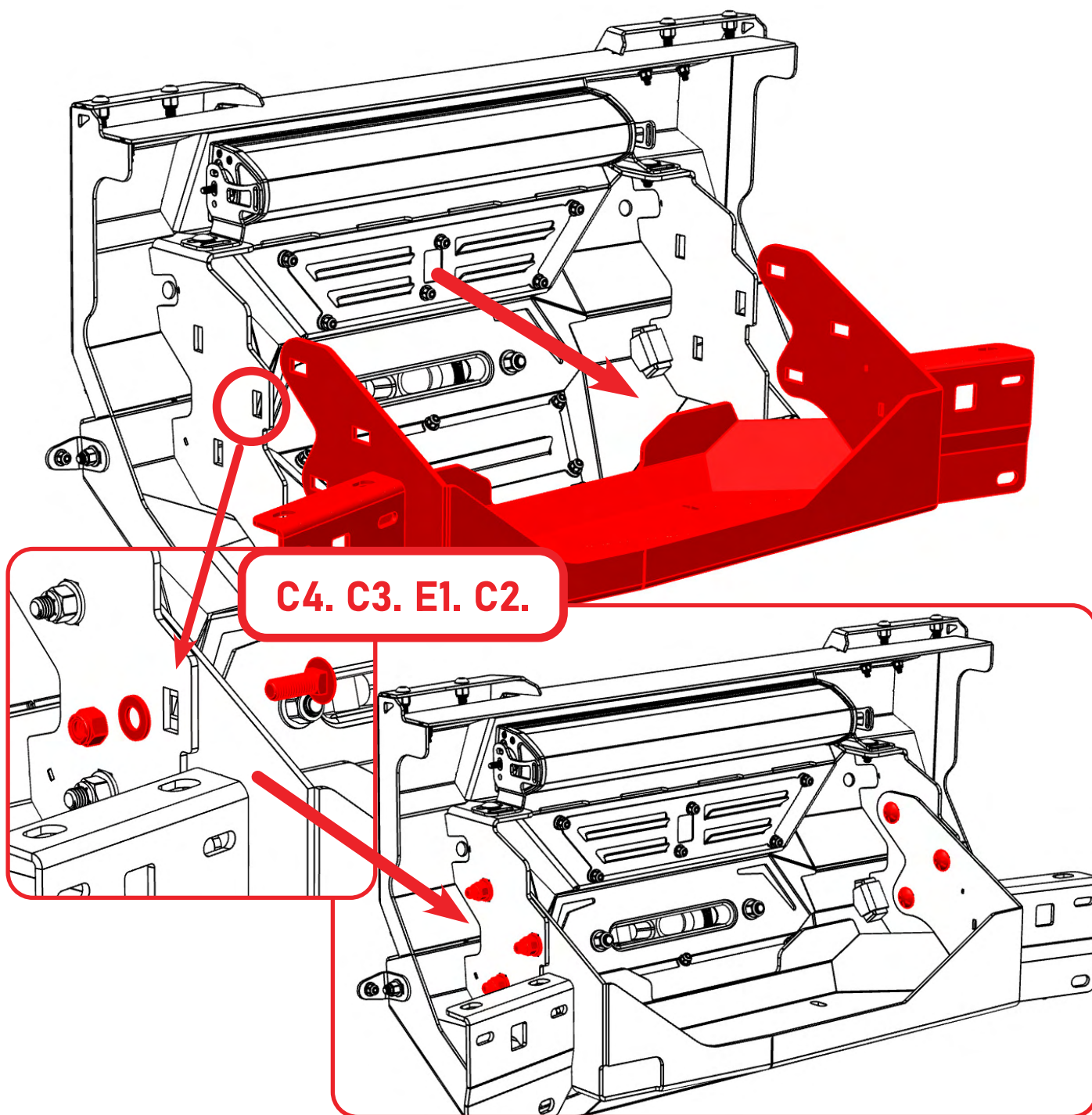
Install the factory wire harness into the bumper in the same orientation that it came out of the OE assembly, passing the wire harness through the sensor ports to ensure the necessary length is achieved for each connection.



□ STEP 53

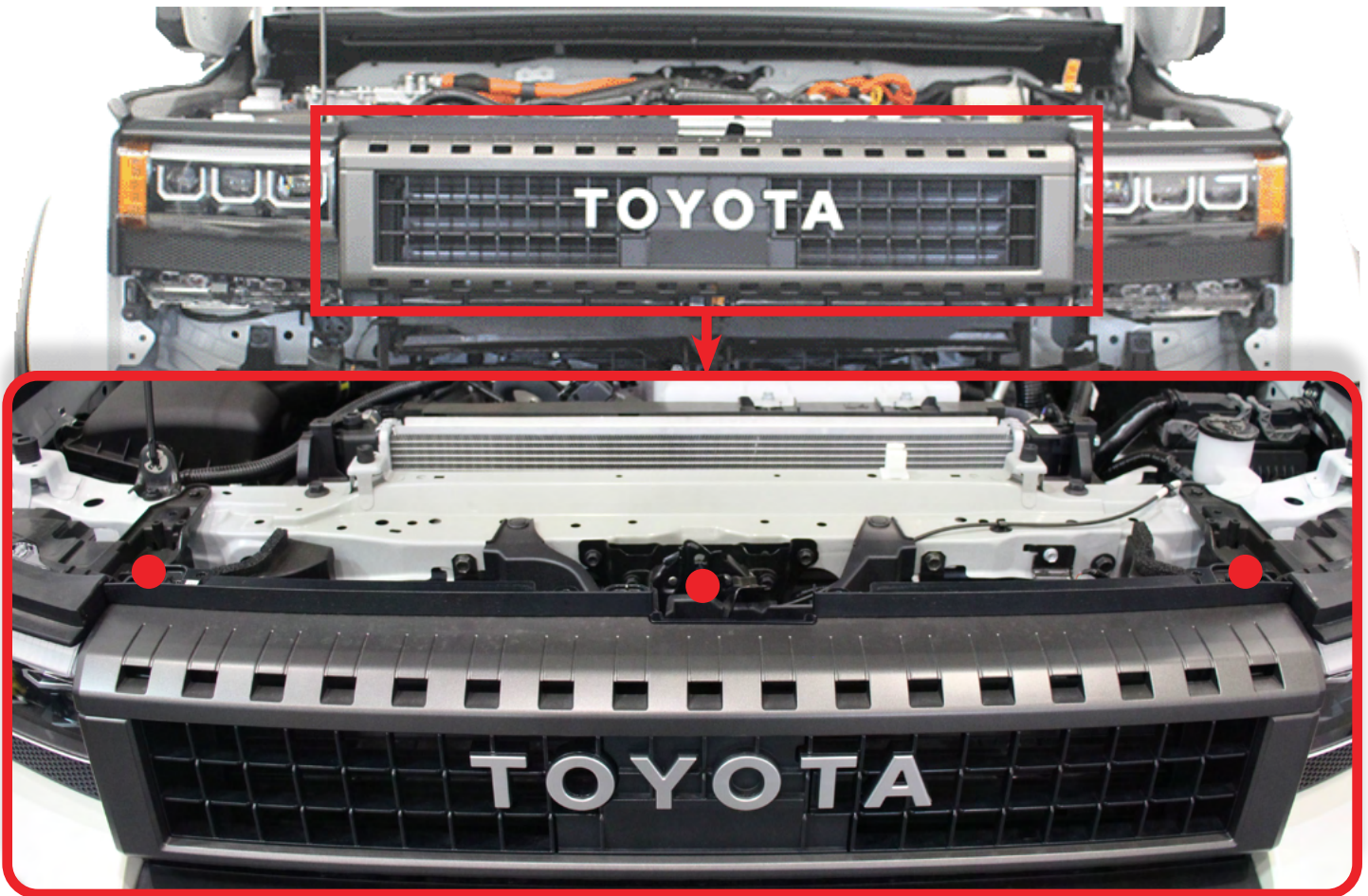
With assistance, position the bumper near the vehicle, fitting it over the previously installed winch mount (E1), then reconnect all factory wire connections. Using a (9/16 socket) along with the supplied hardware (C2, C3, C4), install and attach the bumper to the winch mount as illustrated below.

*****PRIOR TO TIGHTENING ENSURE THAT THERE IS PROPER CLEARANCE BETWEEN ALL FACTORY COMPONENTS AND THE BUMPER. ADJUST AS NEEDED FOR ADEQUATE CLEARANCES*****



□ STEP 54

Bring the grille sections to the vehicle and reconnect the TSS and shutter motor connections. Next reuse the original hardware to reassemble the shutter assembly into the grille and use a (10mm socket) with the factory hardware to install the grille assembly back onto the vehicle as shown below.



□ STEP 55

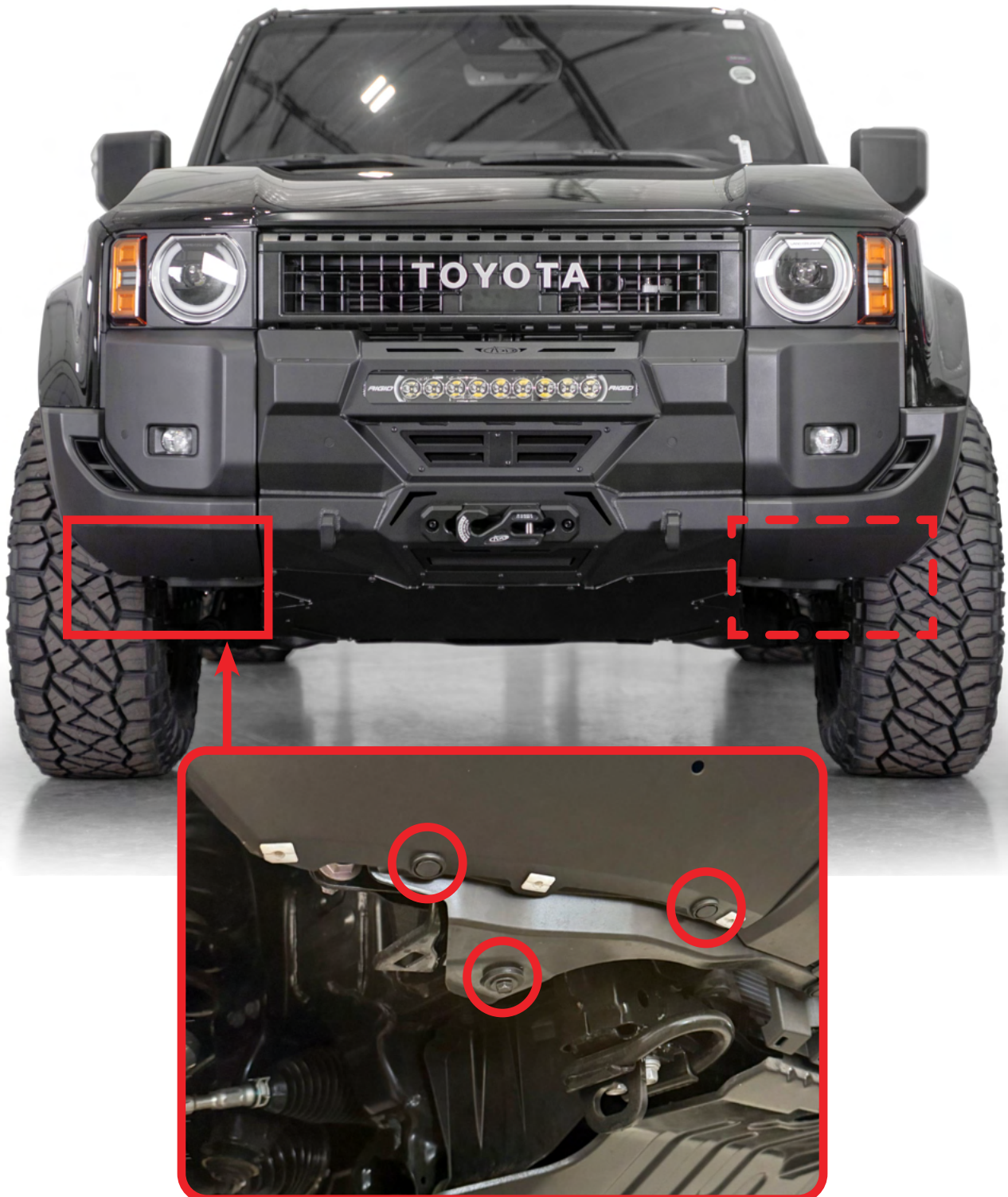
Reinstall the side fascia panels in reverse order of their prior removal.

(Ensure all factory components are reassembled and connected prior to final installation)



□ STEP 56

Reinstall the factory lower plastic retainers and bolts that secure the bottom of the front fascia panels to the previously trimmed lower support brackets.



□ STEP 57

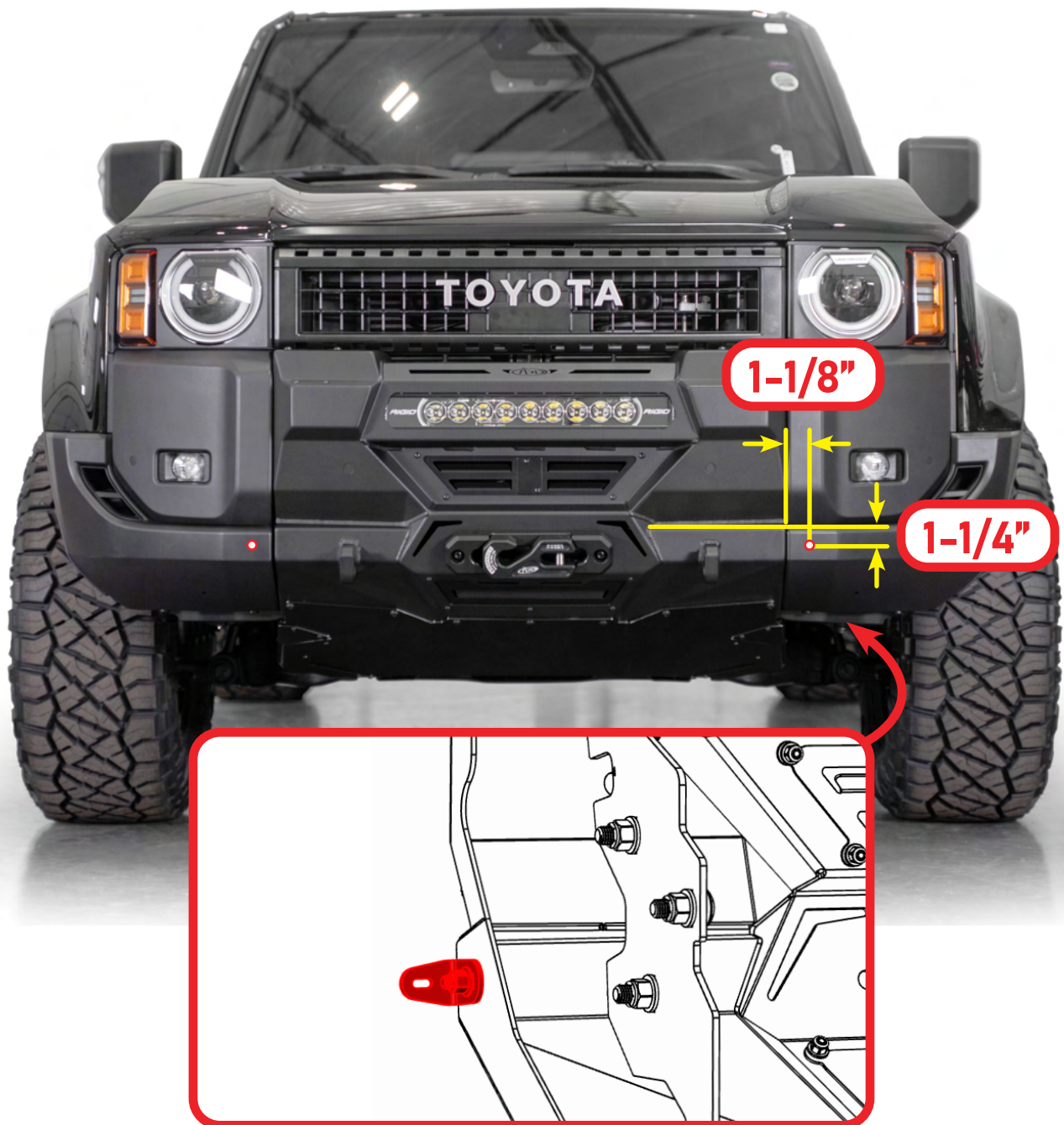
With all components now installed, perform the final alignment of the bumper for the desired fitment. Systematically adjust hardware as needed, utilizing the incorporated slot adjustment at each retention point, then proceed with final tightening of all hardware.



□ STEP 58

Measure down $1\text{-}1/4"$ from the indicated feature line of the bumper, then from the side of the bumper measure $1\text{-}1/8"$ towards the outside of the vehicle, then mark the intersection point on the front fascia paneling as shown below.

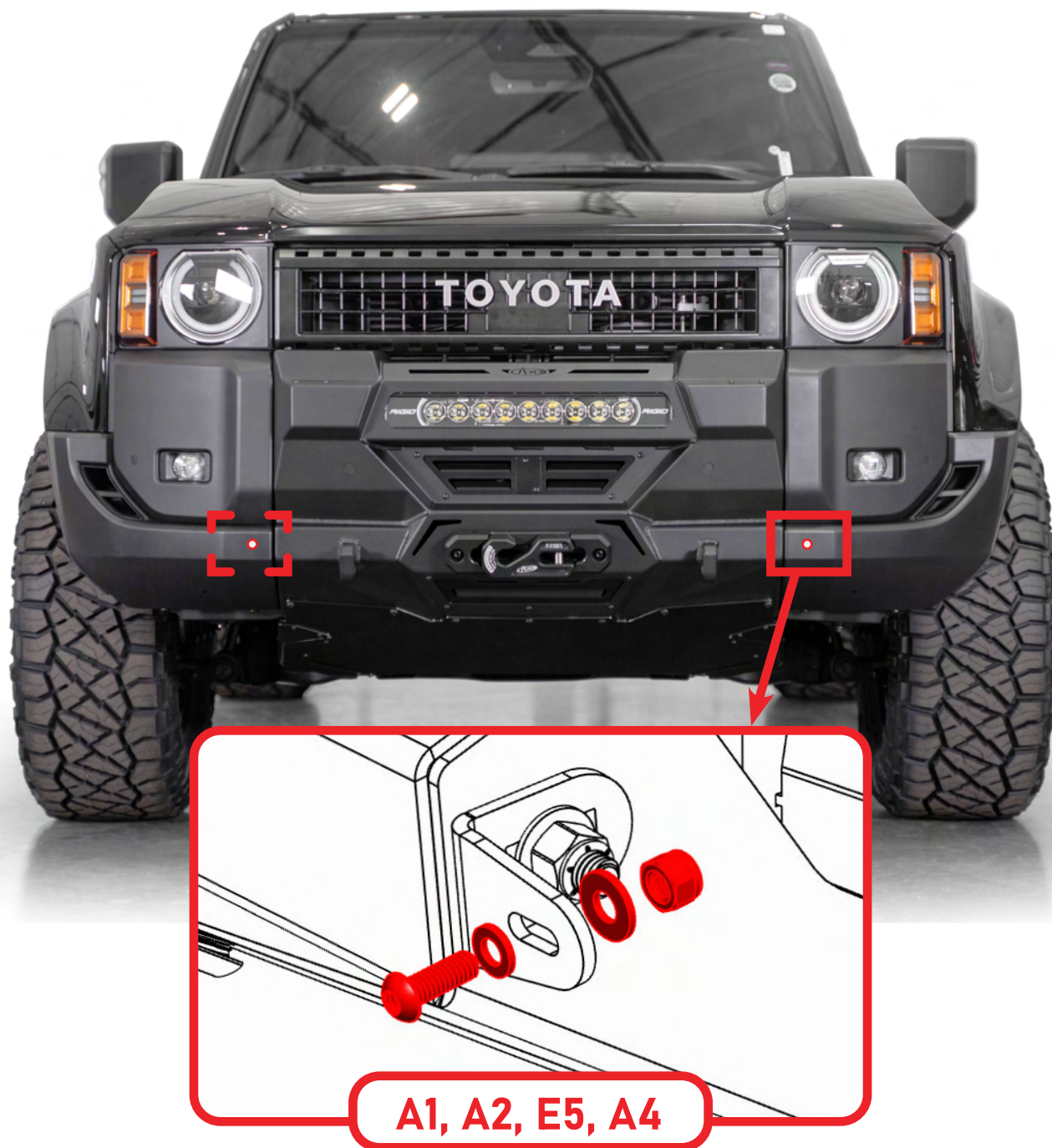
NOTE: Inspect the point from both the front and back side of the panel to ensure that the layout is aligned with the slot of the indicated support tab. The tab can be adjusted as necessary for fine tuning alignment. Adjust your layout as needed to ensure final alignment.



□ STEP 59

With the alignment of the layout point and mounting slot of the support bracket confirmed, use a (17/64 drill bit) to drill a hole through the plastic fascia panels at the specified point. Then using a (5/32 allen) and (7/16 socket) install the supplied hardware (A1, A2, A4) as shown below to secure the front fascia panels to the valance support brackets (E5).

NOTE: Use a (9/16 socket) to adjust the support brackets as needed to achieve the desired fitment, then fully tighten all hardware.



□ STEP 60

If you've purchased the Stealth Skid Plate, reference the installation guide for that product at

www.addictivedesertdesigns.com





INSTALLATION GUIDE

Stand back and enjoy your new ADD Stealth Front Bumper.
Check and re-tighten all mounting hardware after 100 miles and periodically thereafter.

CHECK OUT OUR FULL LINE OF PRODUCTS AT

www.addictivedesertdesigns.com

