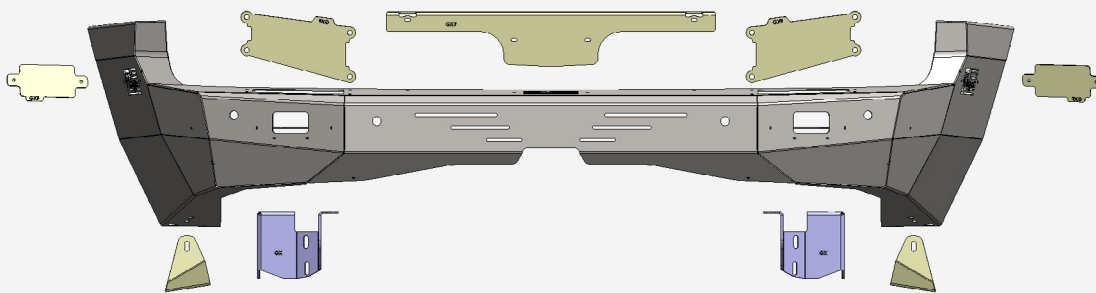


FULL WIDTH REAR BUMPER

2024-UP/LEXUS GX 550

R840235090103



TOOLS REQUIRED

- 10mm, 12mm, 7/16, 9/16 sockets
- 10mm, 12mm, 7/16, 9/16 wrenches
- Pushpin Puller or Flathead Screwdriver
- 7/32, 5/32 Hex
- Plastic Pry Tool
- Cutting Tools
- Razor Blade
- Heat Gun

SKILL LEVEL

- Skilled

TIME REQUIRED

- Approximately 4.5 Hours (This installation guide covers the installation of the product only. It does not include instructions and time for wiring)

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: 830-896-7571
Rago Fabrication 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

HARDWARE

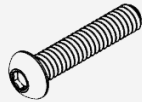
A.



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

QTY: 16

A1.



1/4-20 X 1" BUTTON HEAD BOLT

QTY: 2

A2.



1/4" FLAT WASHER

QTY: 12

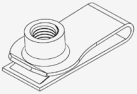
A3.



1/4-20" NYLON LOCK NUT

QTY: 8

A4.



1/4-20" U-NUT

QTY: 8

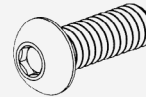
A5.



1/4-20" RIVET NUT

QTY: 2

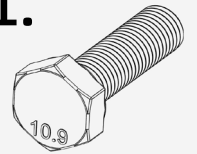
B.



3/8-16 X 1" BUTTON HEAD BOLT

QTY: 6

B1.



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

QTY: 8

B2.



3/8" FLAT WASHER BLACK

QTY: 12

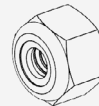
B3.



3/8" FLAT WASHER YELLOW

QTY: 8

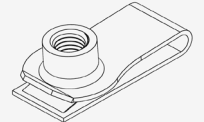
B4.



3/8-16" NYLON LOCK NUT

QTY: 6

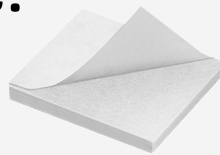
B5.



3/8-16" U-NUT

QTY: 8

C.



3M DOUBLE SIDED TAPE

QTY: 8

Reference this page throughout the install

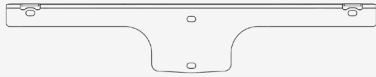
NEED HELP?



(830) 896-7571

PARTS

D.



SPL1038

QTY: 1

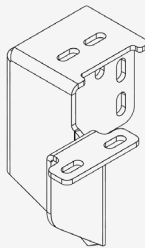
E.



SPL1035

QTY: 2

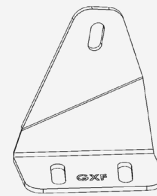
F.



Mount Plates

QTY: 2

G.



SPL1047, SPL1047-M

QTY: 2

H.



SPL1048

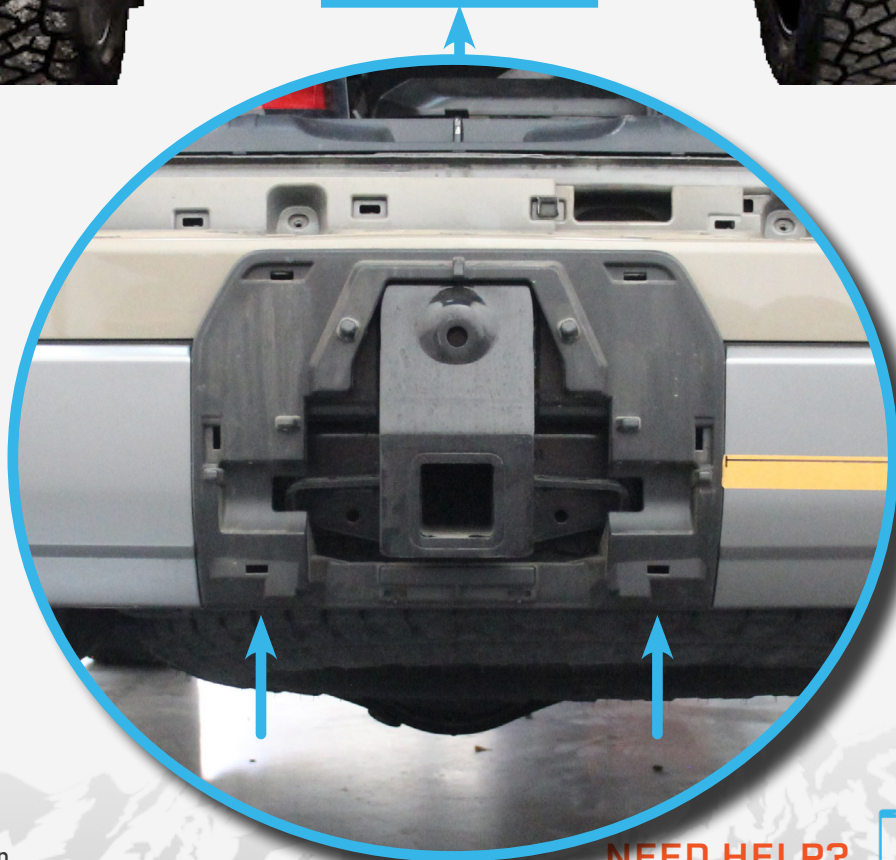
QTY: 2

Reference this page throughout the install



□ STEP 1

Remove the 2x push pins located on the bottom of the cover using a (fastener remover tool) or a (flathead screwdriver) and remove the receiver cover as shown below.



□ STEP 2

Using a (plastic pry tool), remove the top plastic cover. Then, Unplug the wire harness both on driver and passenger side.



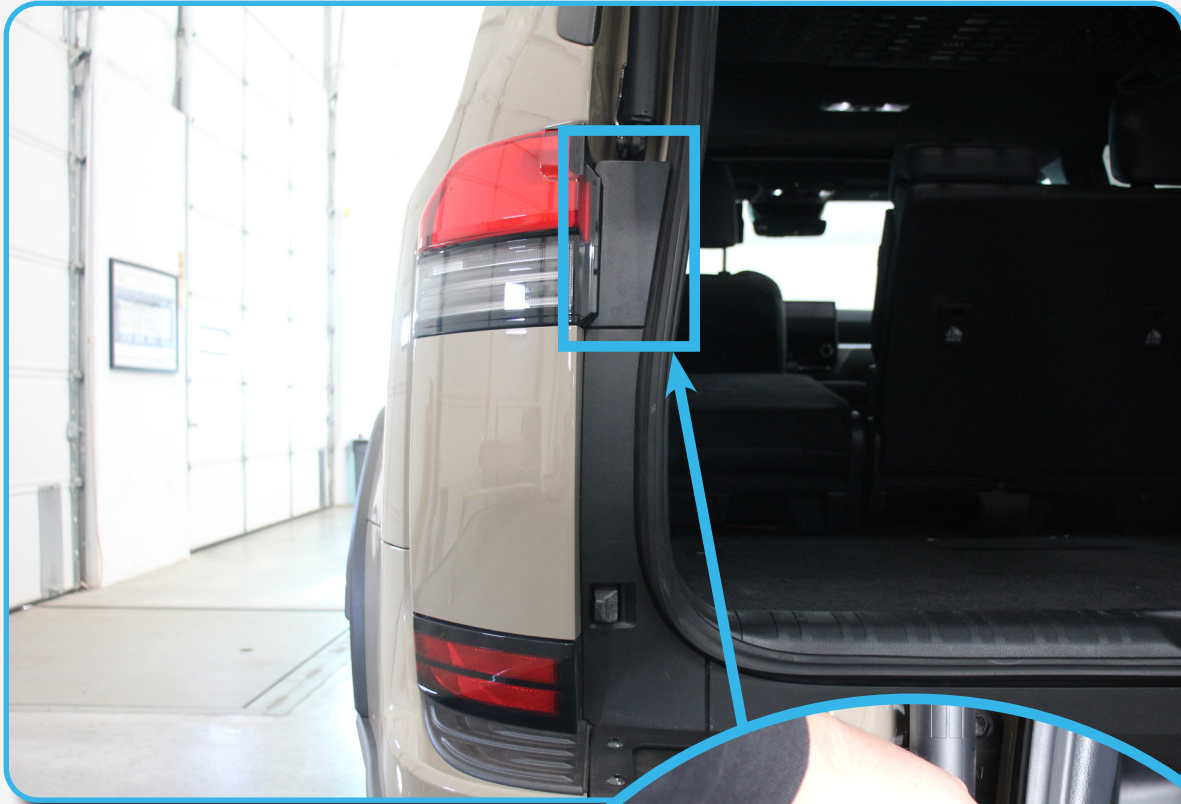
□ STEP 3

Mark your top cut line following the plastic as your edge as shown below.



□ STEP 4

Remove the plastic cover as shown below by pulling.



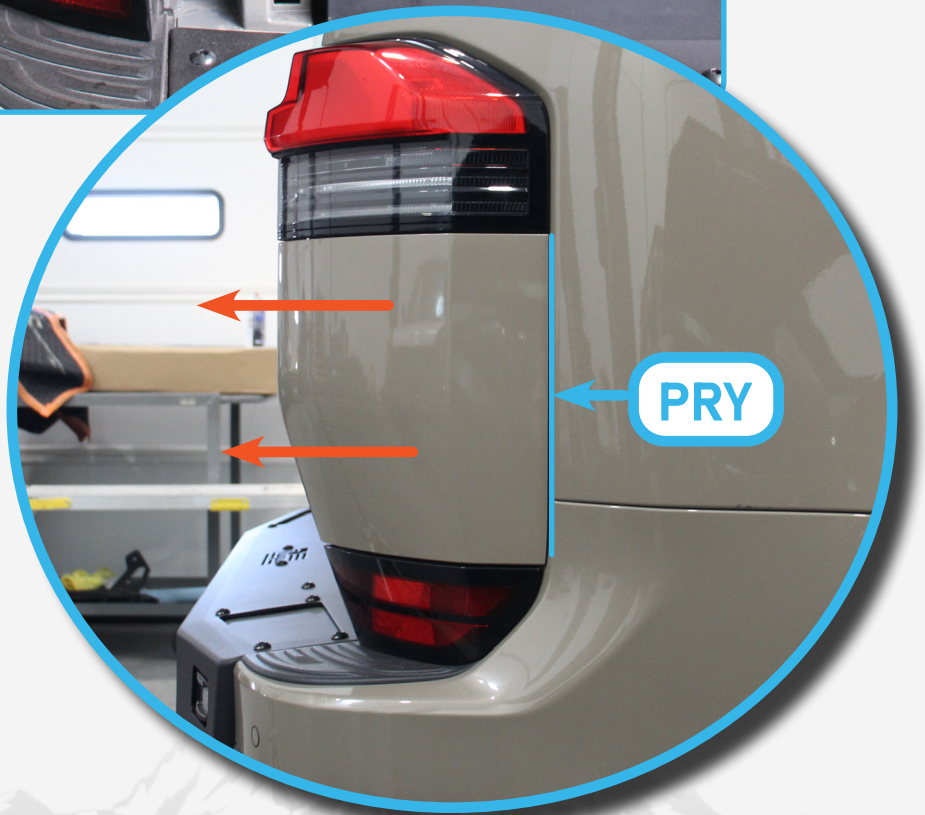
STEP 5

Remove the plastic cover as shown below by pulling.



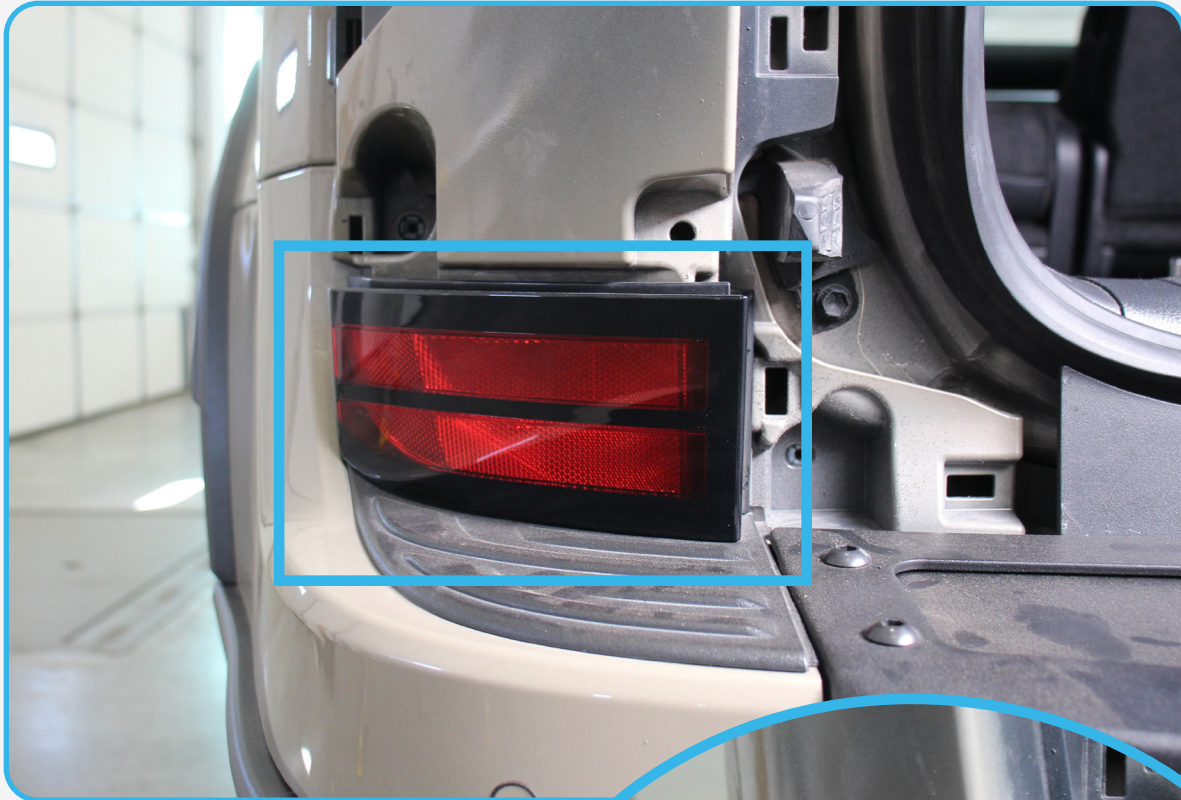
□ STEP 6

Remove the plastic cover as shown below by pulling.



STEP 7

Remove the plastic cover as shown below by pulling.



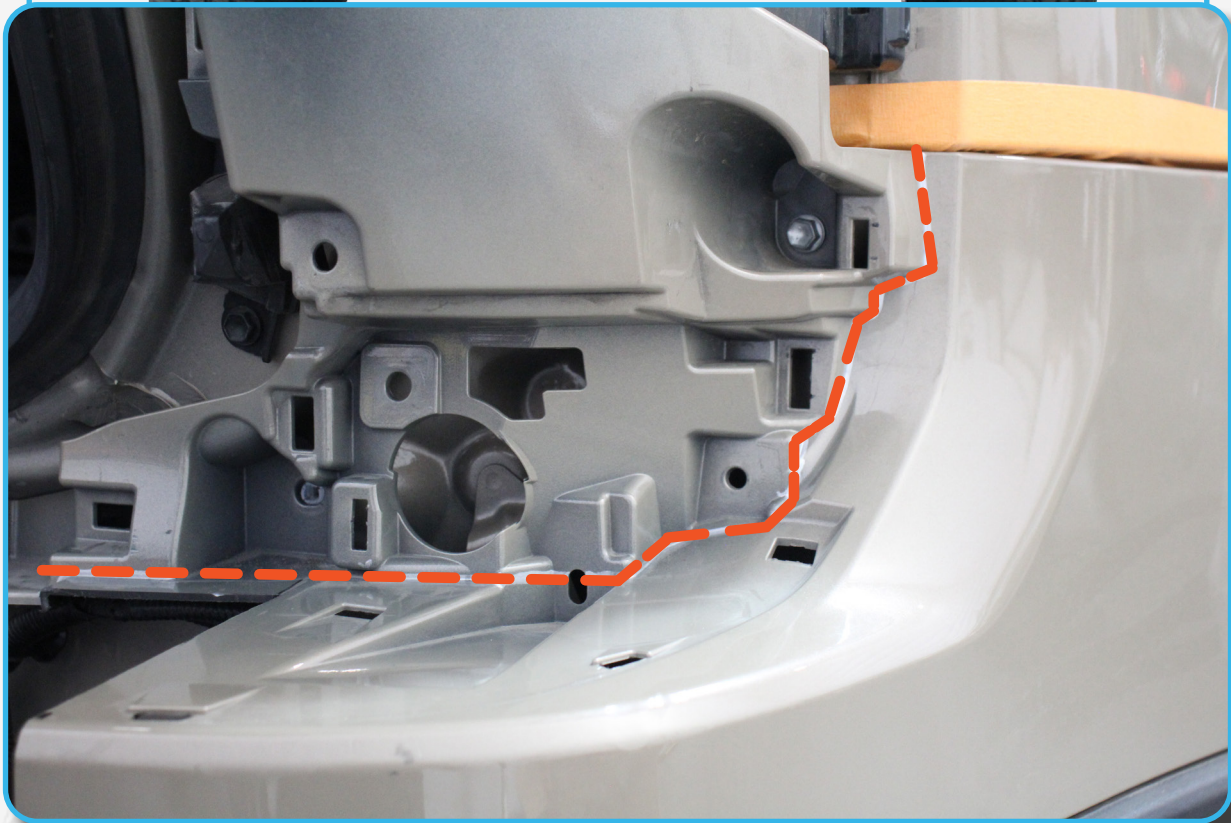
STEP 8

Using a (10mm socket), remove the OEM hardware as shown below. ****KEEP HARDWARE****



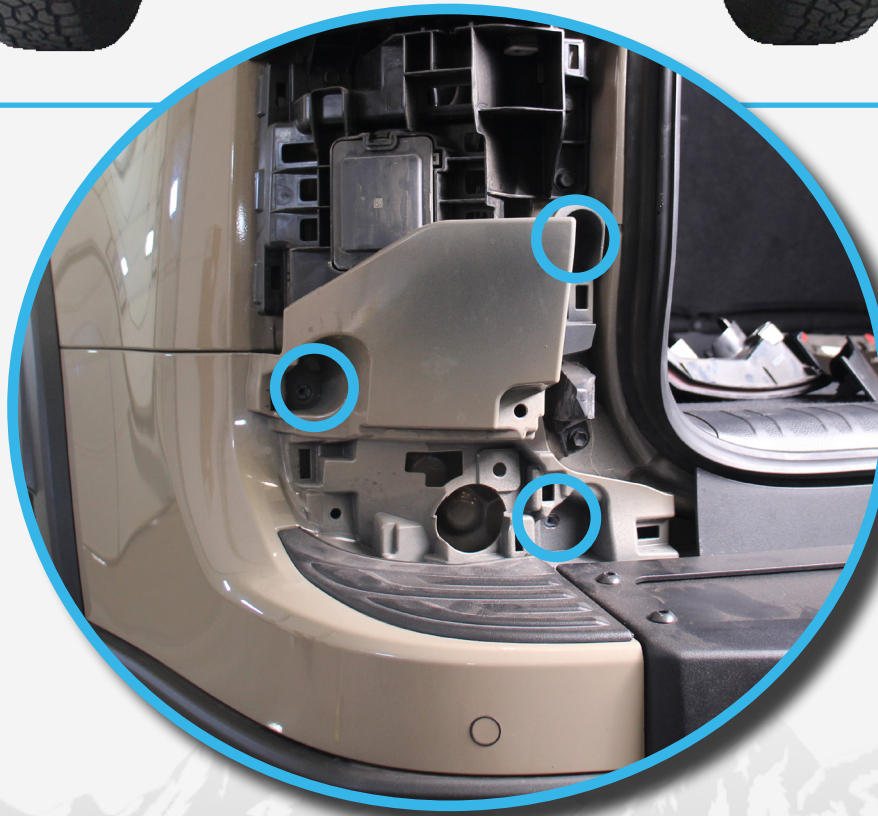
STEP 9

Mark the cut line as shown below.



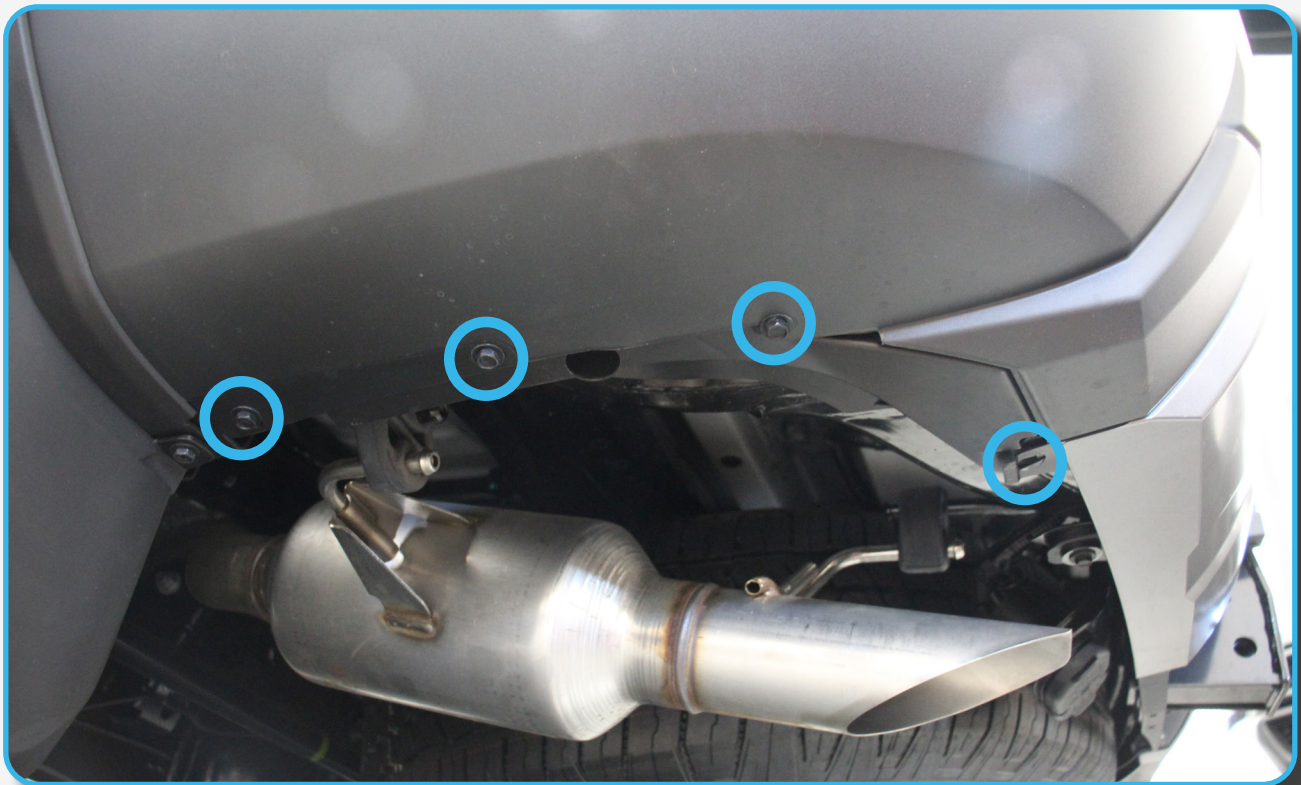
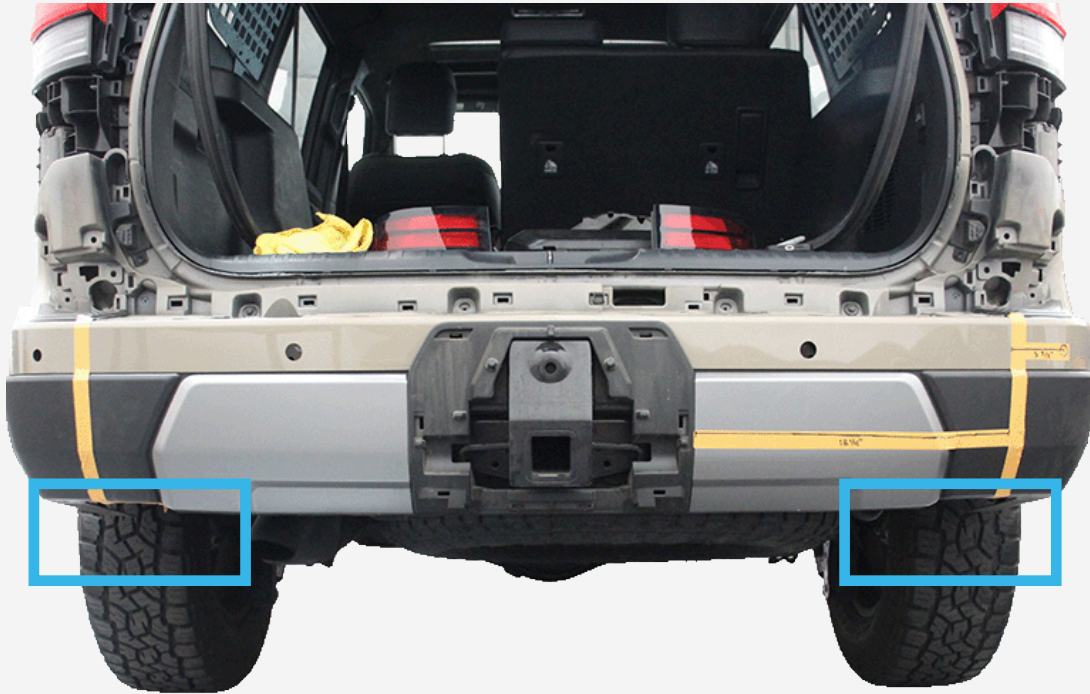
STEP 10

Using a (10mm socket) remove the OEM hardware shown below. ****KEEP HARDWARE****



□ STEP 11

Using a (10mm Socket), remove the plastic trim located on the bottom of the OEM bumper.
****KEEP HARDWARE****



STEP 12

Using a (10mm socket) remove the mud flap hardware as shown below. ****KEEP HARDWARE****



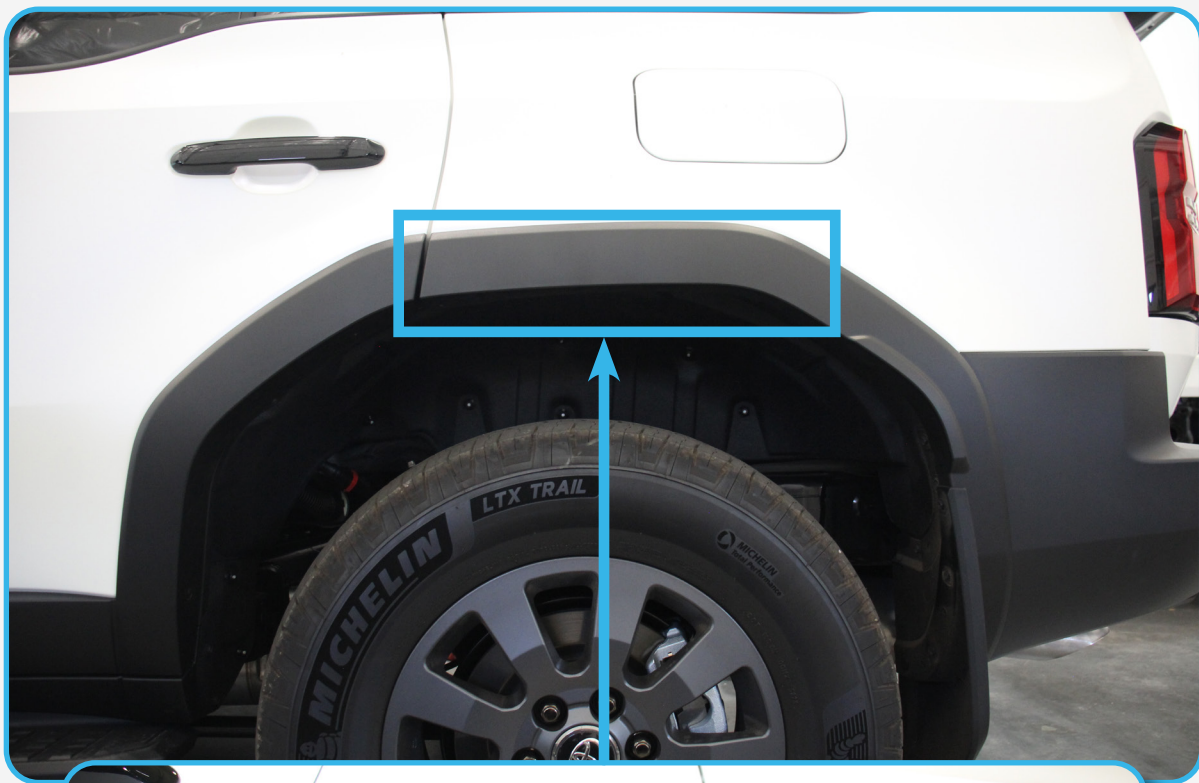
STEP 13

Using a (10mm socket) remove the mud flap hardware located inside the wheel well as shown below. ****KEEP HARDWARE****



STEP 14

Using a (fastener removal tool), Remove the push pins located inside the wheel well as shown below. ****KEEP HARDWARE****



STEP 15

Remove the fender flare by pulling. Set aside.



STEP 16

Next, Remove the push pin as shown below using a (fastener removal tool).



□ STEP 17

Located inside the bumper on the sides push in all four sides of the clips and push out.



STEP 18

Pull the sides out as shown below.



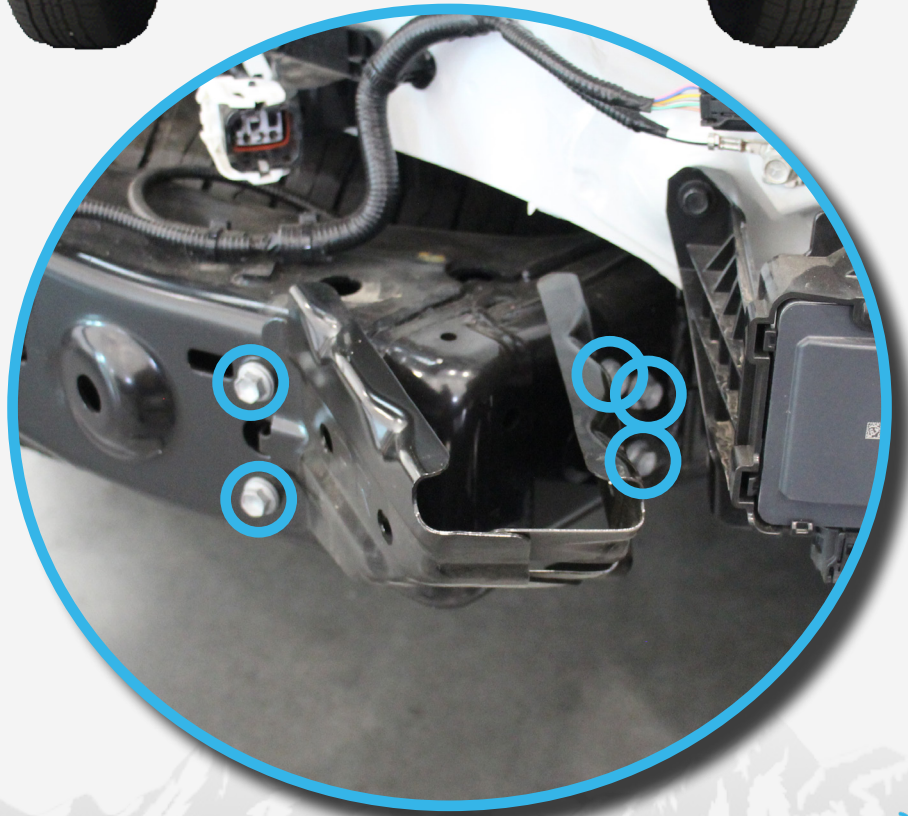
STEP 19

Remove the foam located on top of the hitch.



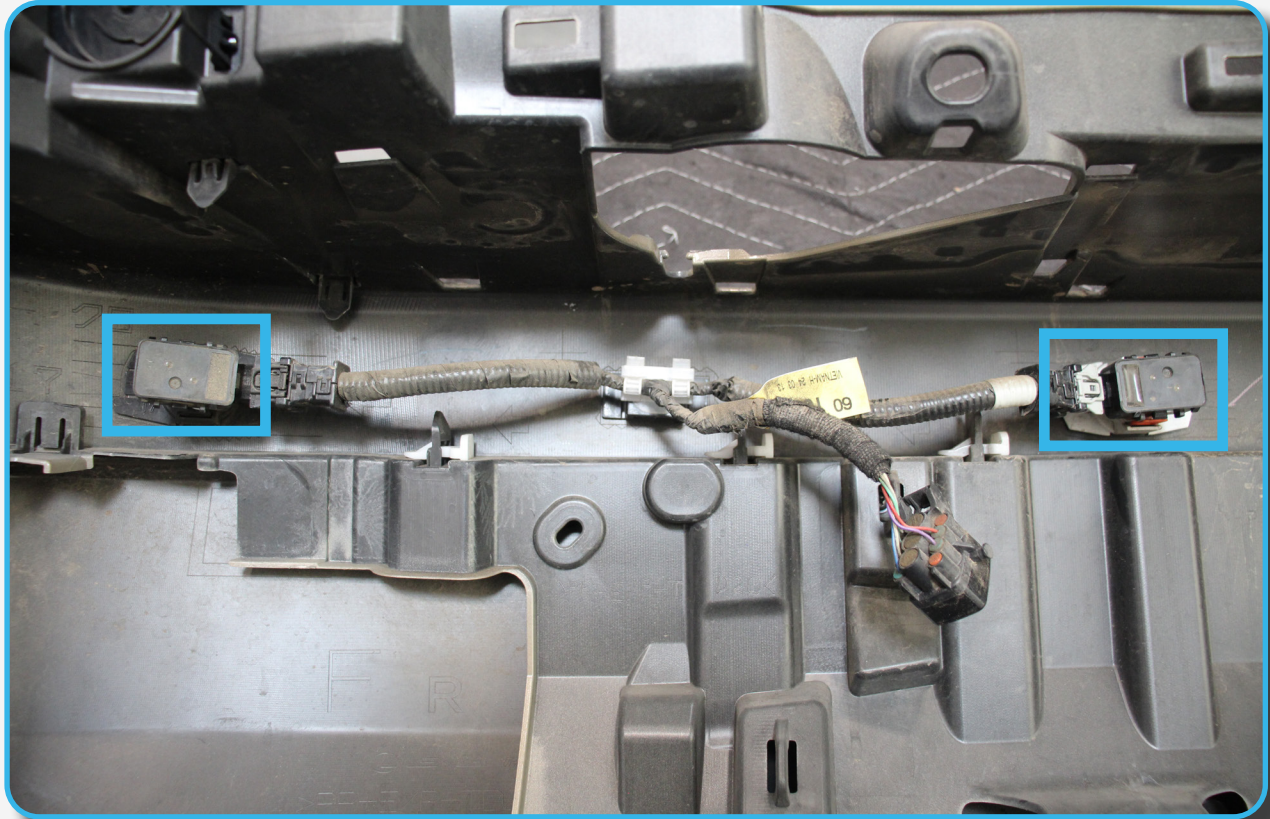
□ STEP 20

Using a (12mm socket), remove the crash supports located on the hitch. ****KEEP HARDWARE****



STEP 21

Remove the parking sensors from the bezels by prying outwards on the tabs. ****CAUTION: TABS ARE FRAGILE, PRY GENTLY****



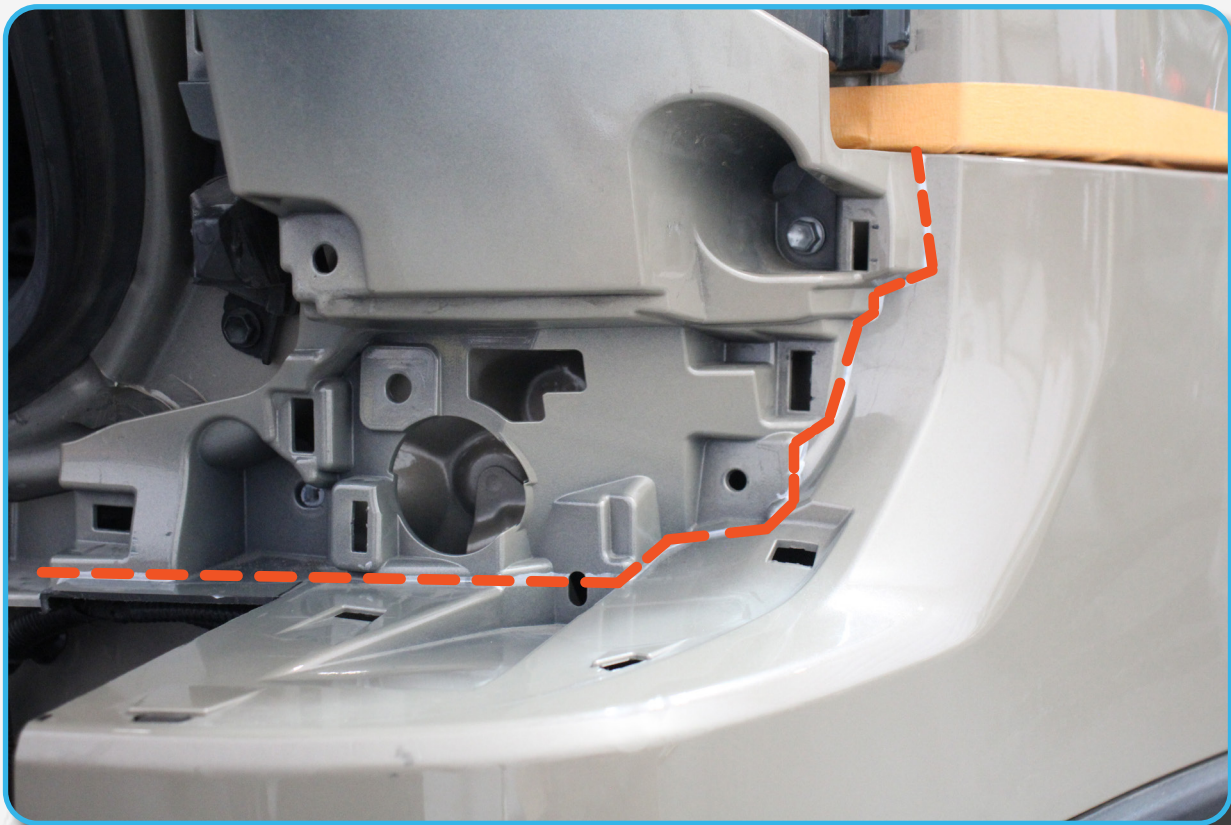
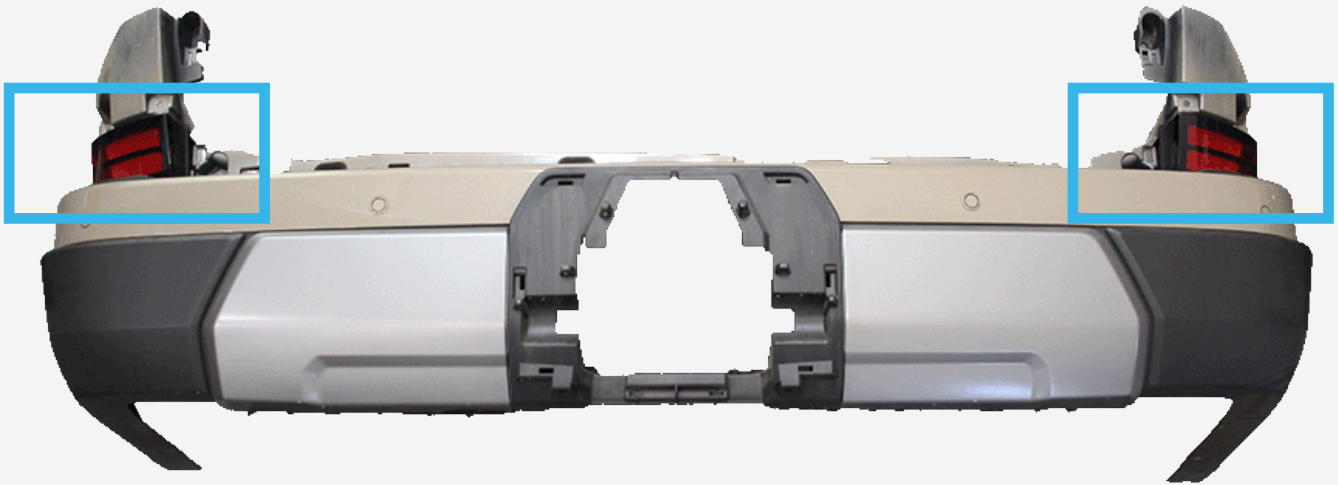
□ STEP 22

Using your choice of cutting tools, cut along the top line highlighted below.



□ STEP 23

Using your choice of cutting tools, cut along the line highlighted below.



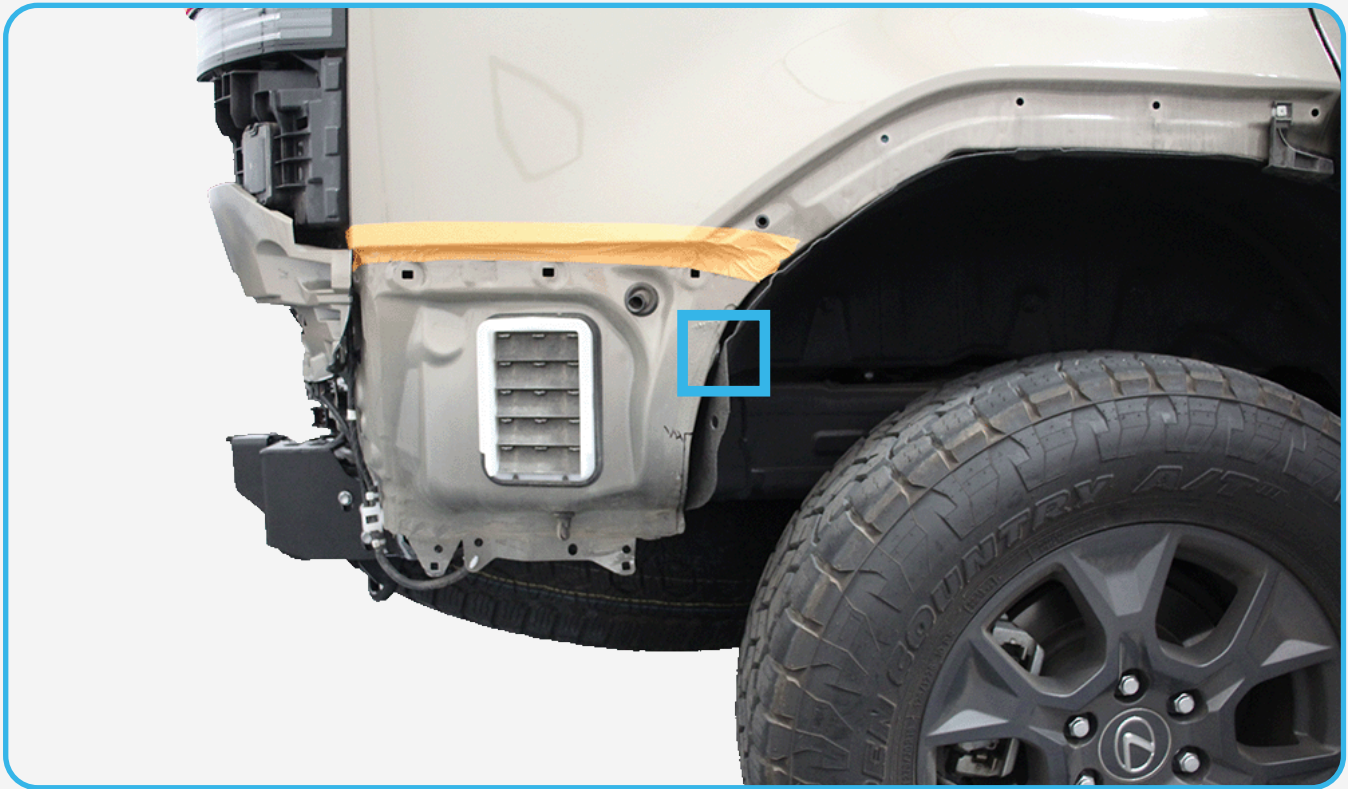
□ STEP 24

Using your choice of cutting tools, cut along the line highlighted below.



STEP 25

Remove the plastic clip shown below and install the provided **(A5)** using a **(Rivet Nut Hand Tool)**.



□ STEP 26

Install the provided (G) mounting plate with the OEM hardware removed from **step 20** using a (12mm socket). Next, install the provided (B5) nut clips on top of the mounting plate as shown below.



STEP 27

Now would be a good time to install the OEM plastic bumper with the hardware removed from step 9.



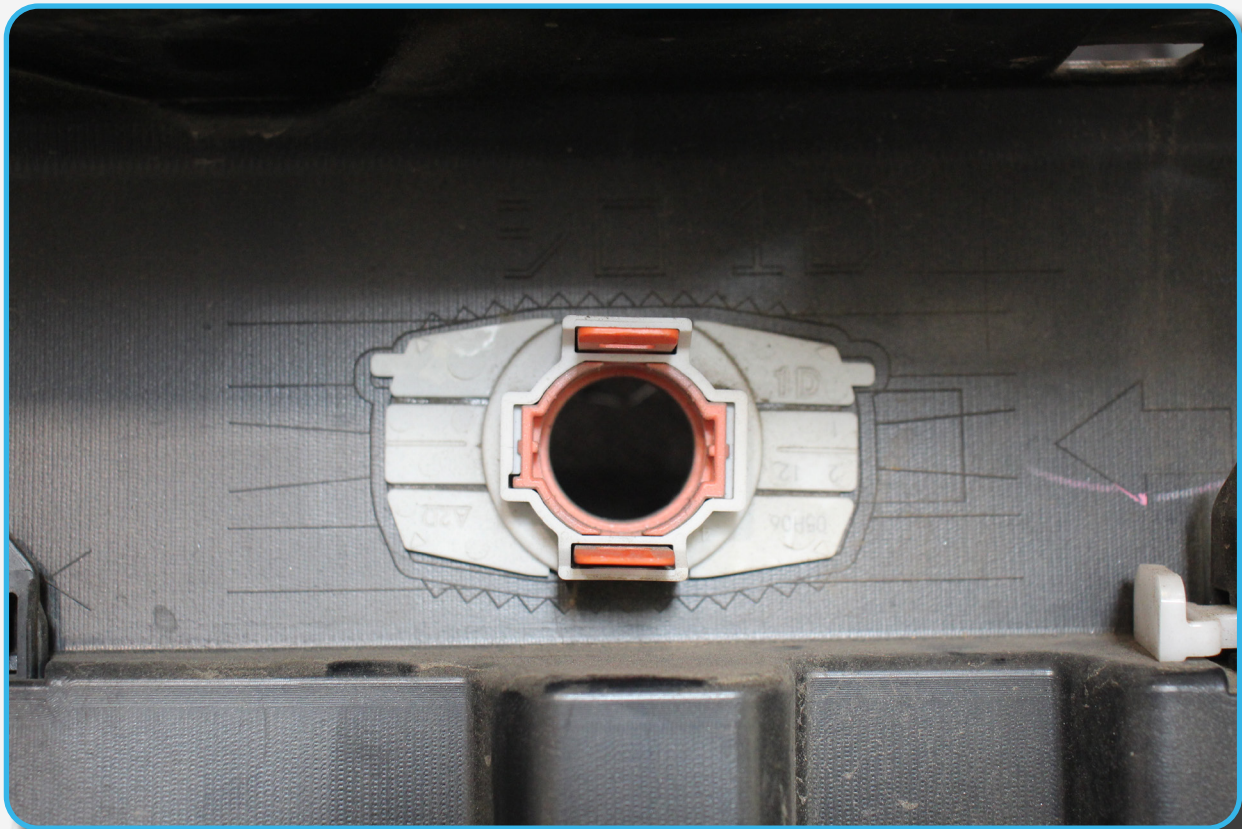
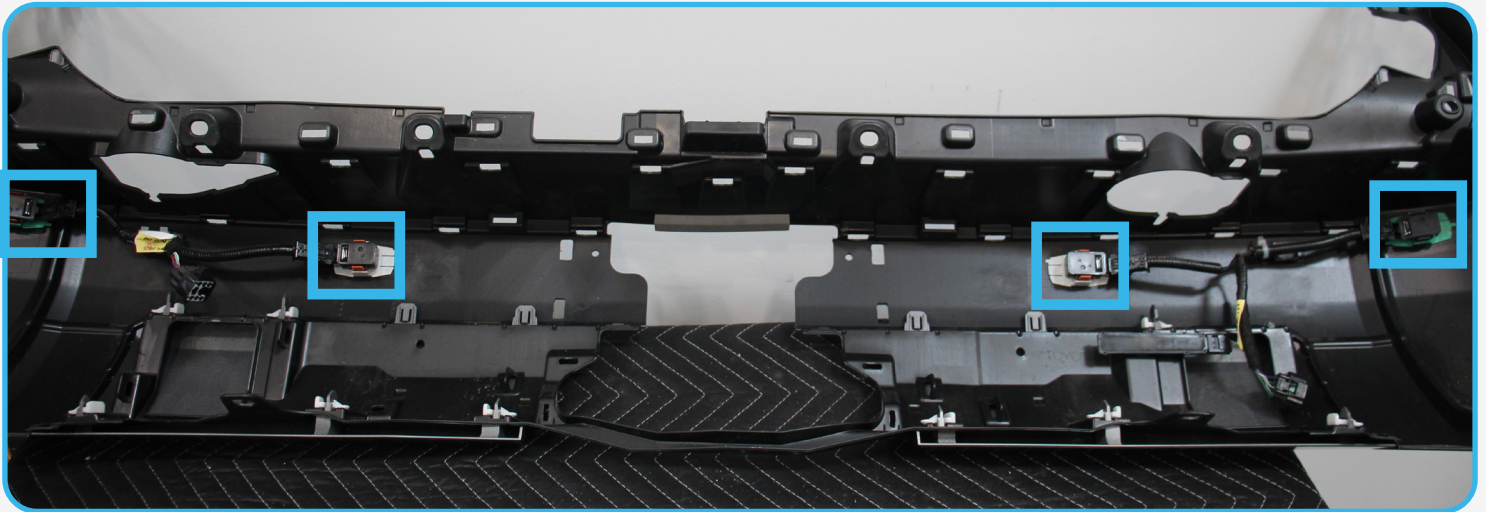
STEP 28

Install the plastic trim and covers/indicator lights removed from **steps 5-8**.



□ STEP 29

Use a (heat gun) to soften adhesive and use (flathead screwdriver) remove the sensor bezels from the OEM bumper. ****Keep for install****



□ STEP 30

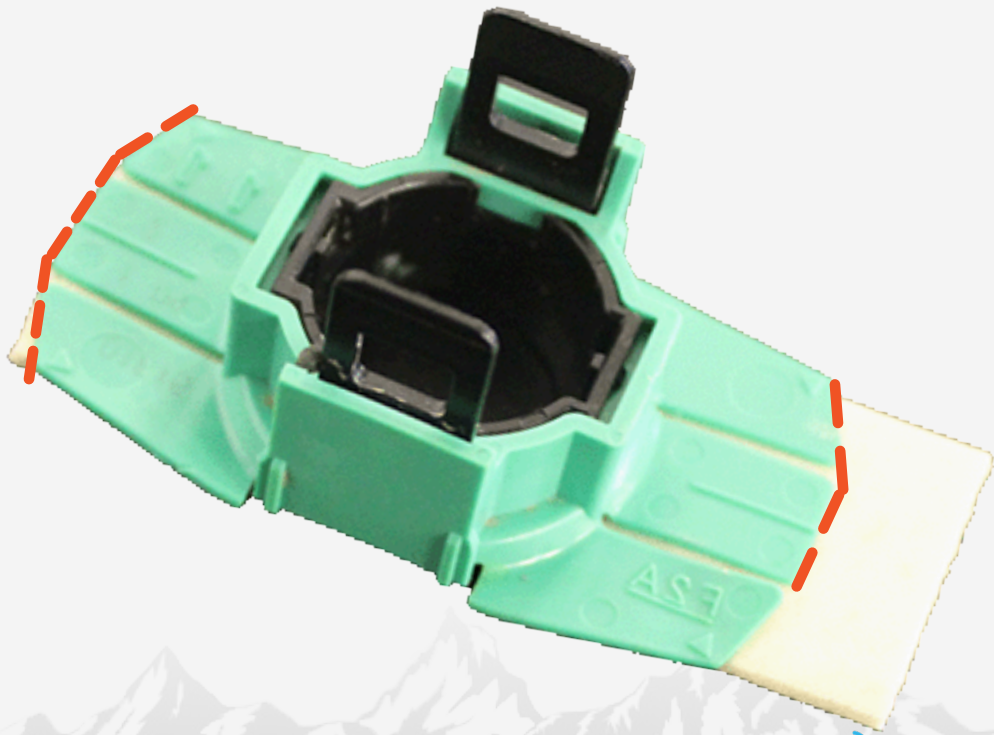
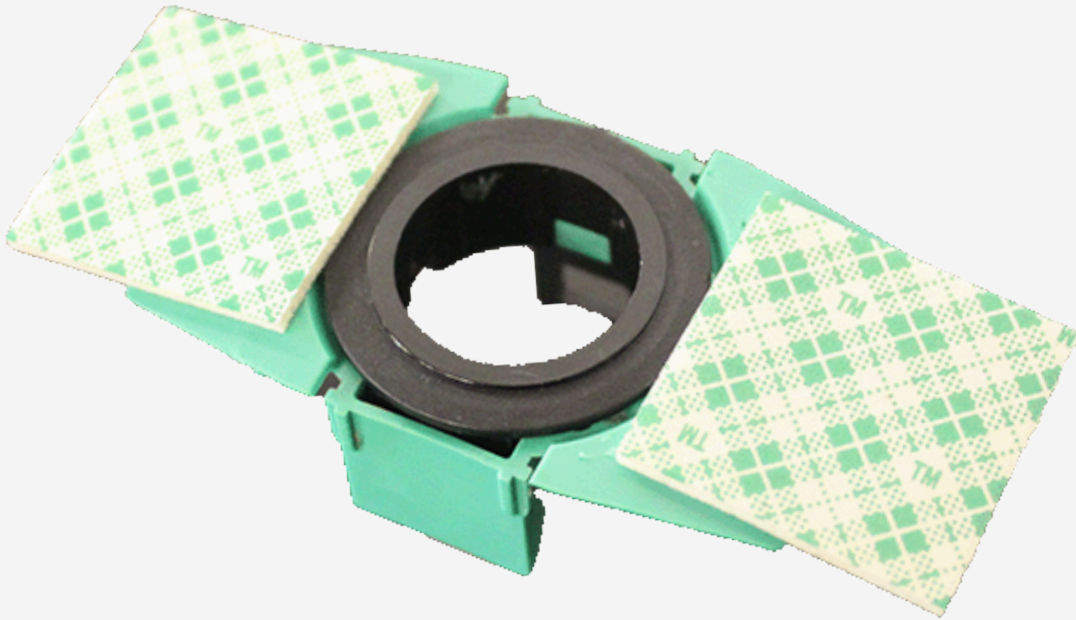
Remove double sided tape from the bezel until the surface is clear of residue.

Tec tip: Use a razor blade or brake clean to remove adhesive.



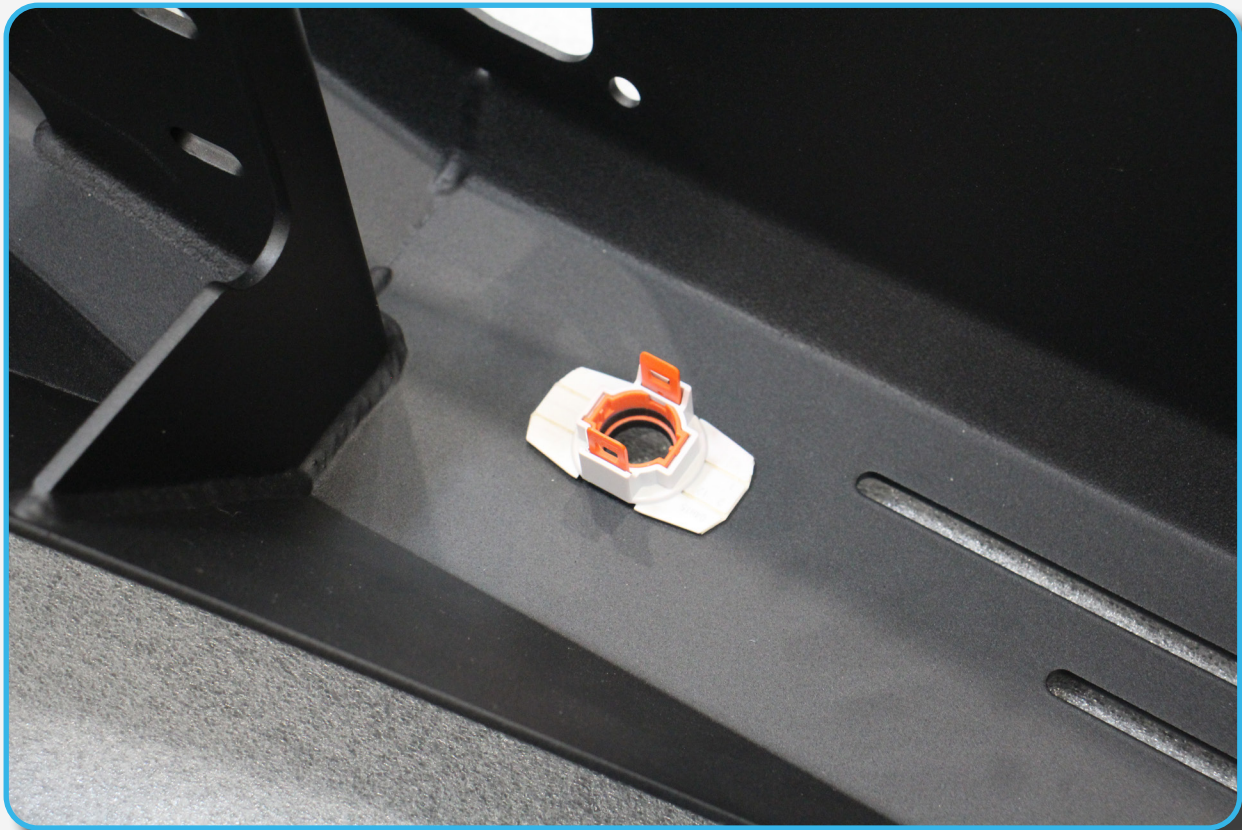
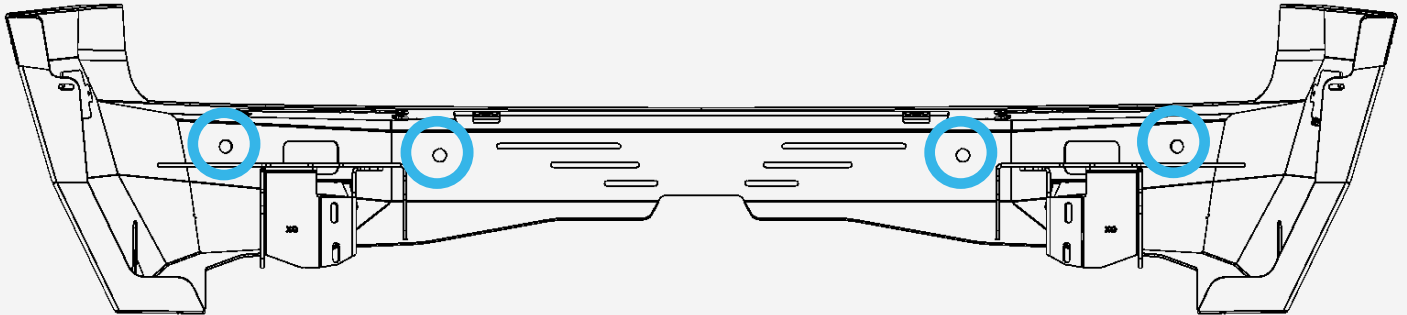
□ STEP 31

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



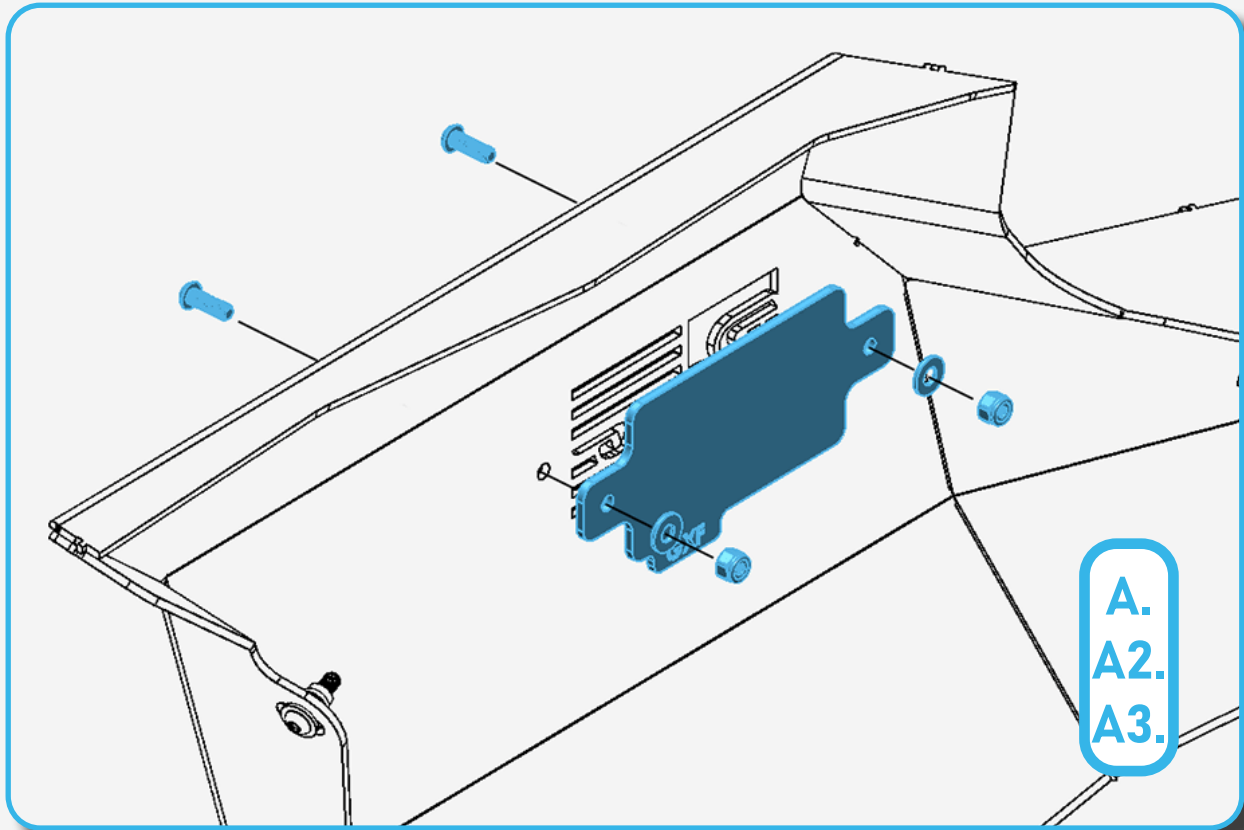
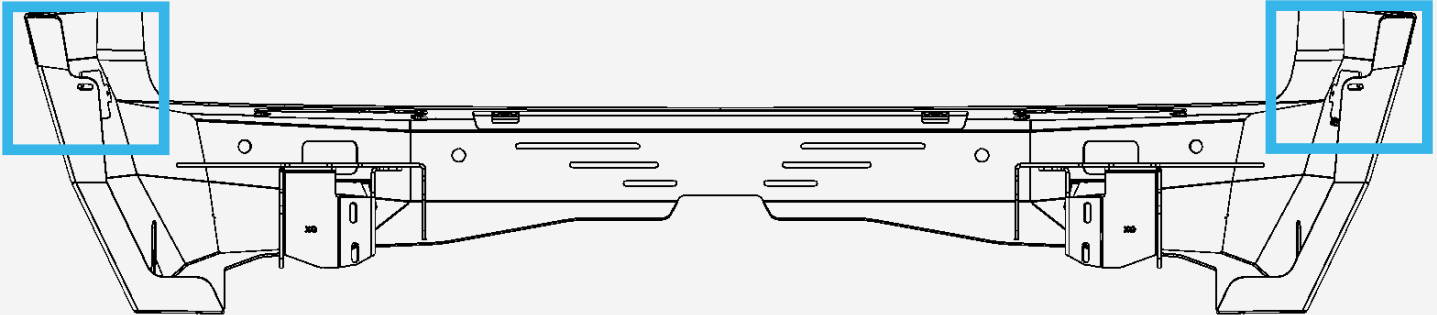
□ STEP 32

Install the sensor bezels in the orientation shown below. ****CAUTION: DOUBLE SIDED TAPE TAKES UP TO 72 HOURS TO CURE FULLY. ENSURE TO CLEAN THE SURFACE FOR BEST RESULTS****



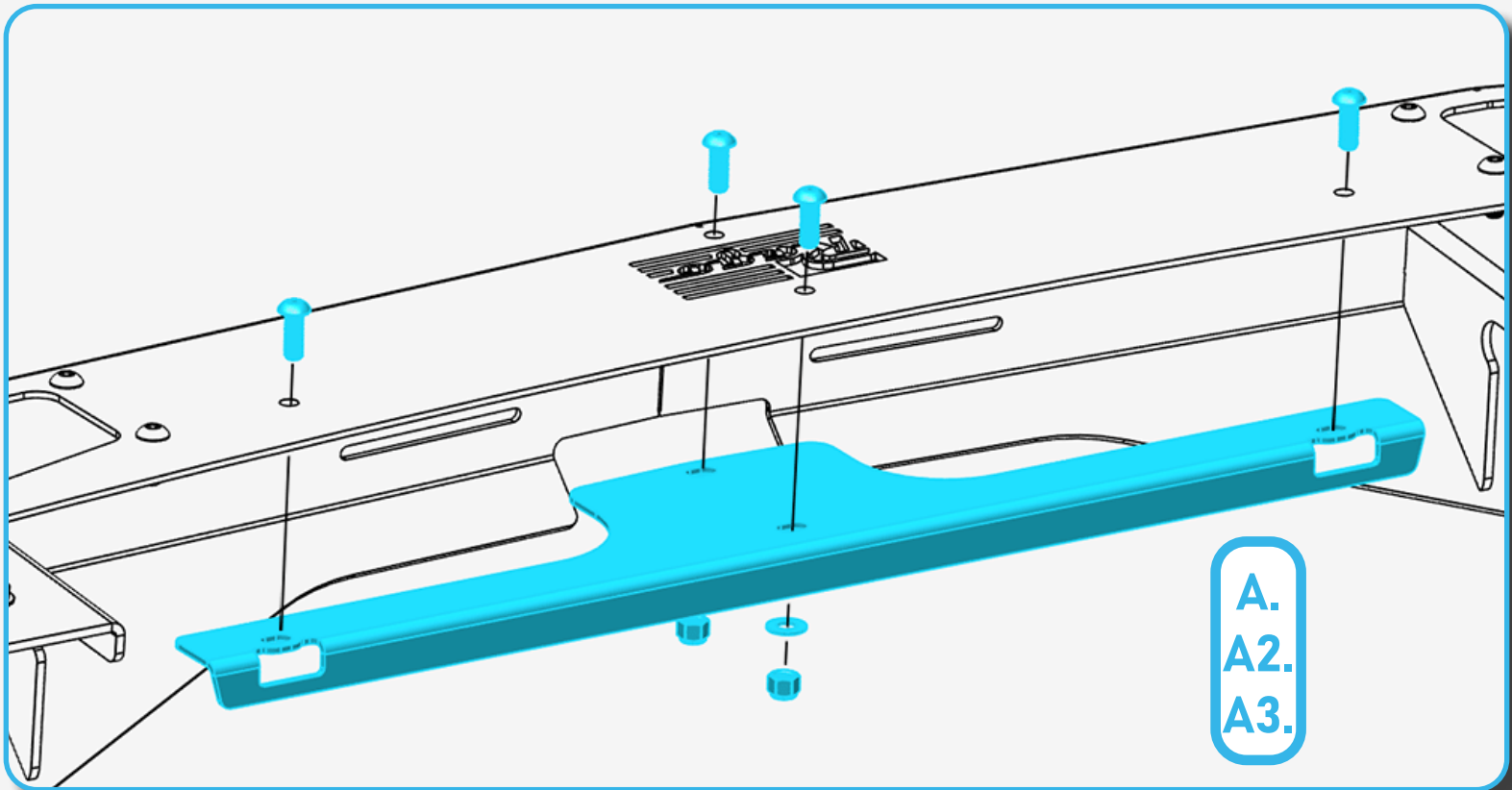
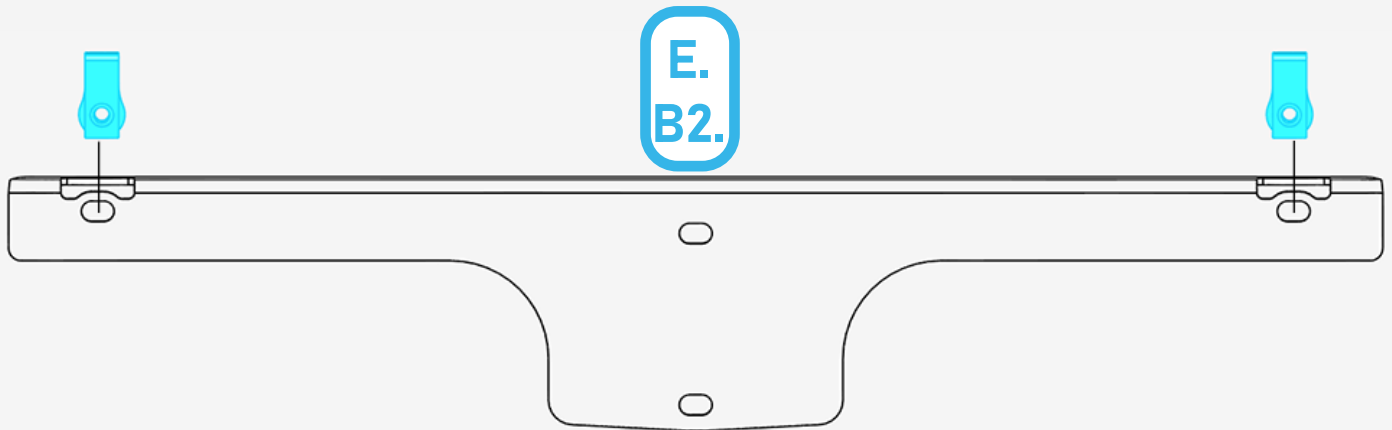
□ STEP 33

Install the cover panel (H) with the provided (A, A2, A3) 1/4" hardware using a (5/32 allen) and a (7/16 wrench).



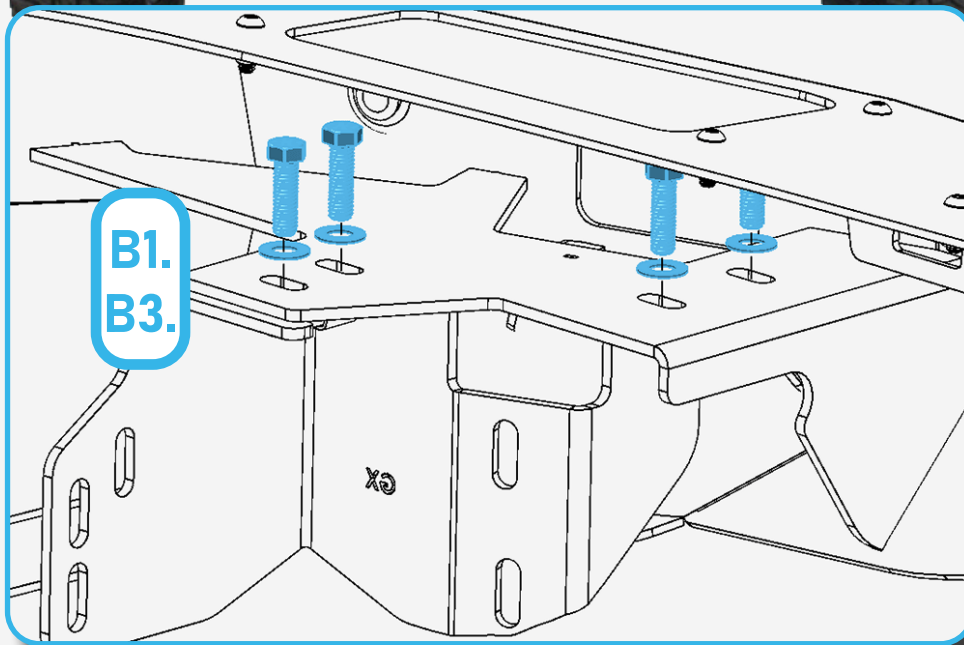
□ STEP 34

Install the provided (A4) nut clips onto the (D) support bracket. Next, Using a (7/32 allen) and a (9/16 wrench), install the (E) support bracket on the bumper as shown below with the provided (A, A2, A3) 3/8" hardware.



STEP 35

You can now install the bumper with the provided **(B1, B3)** 3/8" hardware using a **(9/16 socket)**.



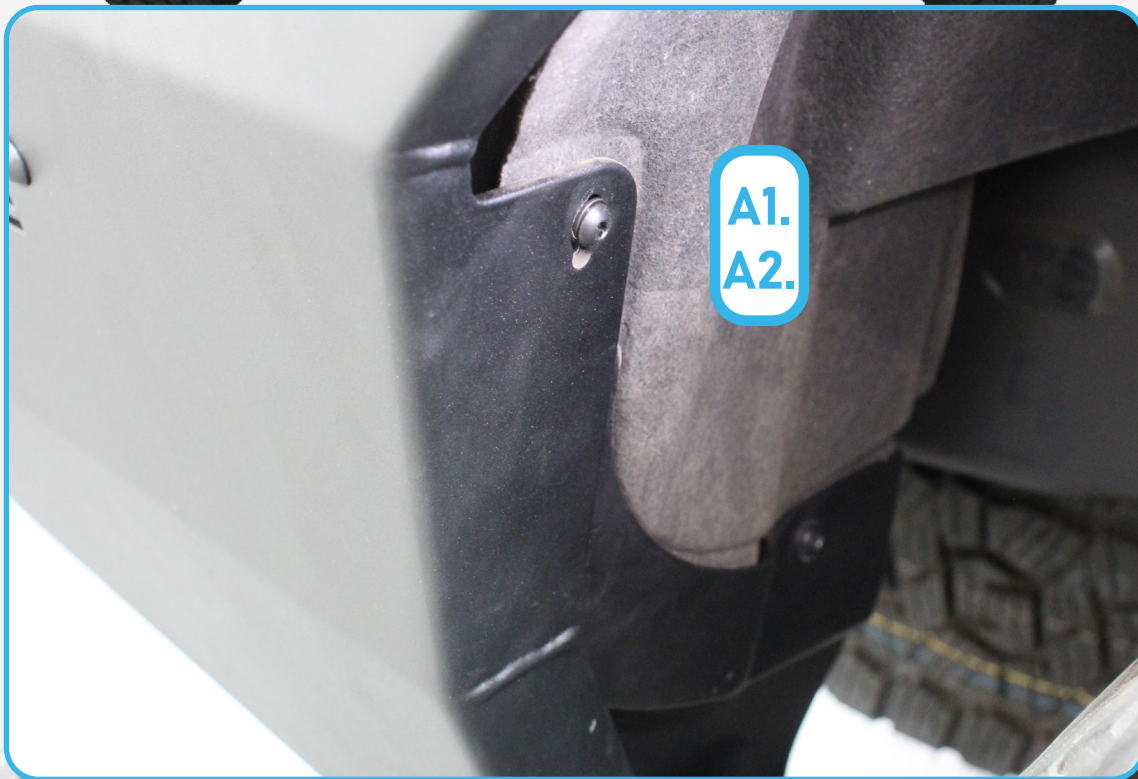
□ STEP 36

Trim the plastic shown below with your choice of cutting tools.



□ STEP 37

Insert the plastic trimmed in step 36 between the bumper and fender liner and install the provided (A1, A2) 1/4" hardware using a (5/32 allen).



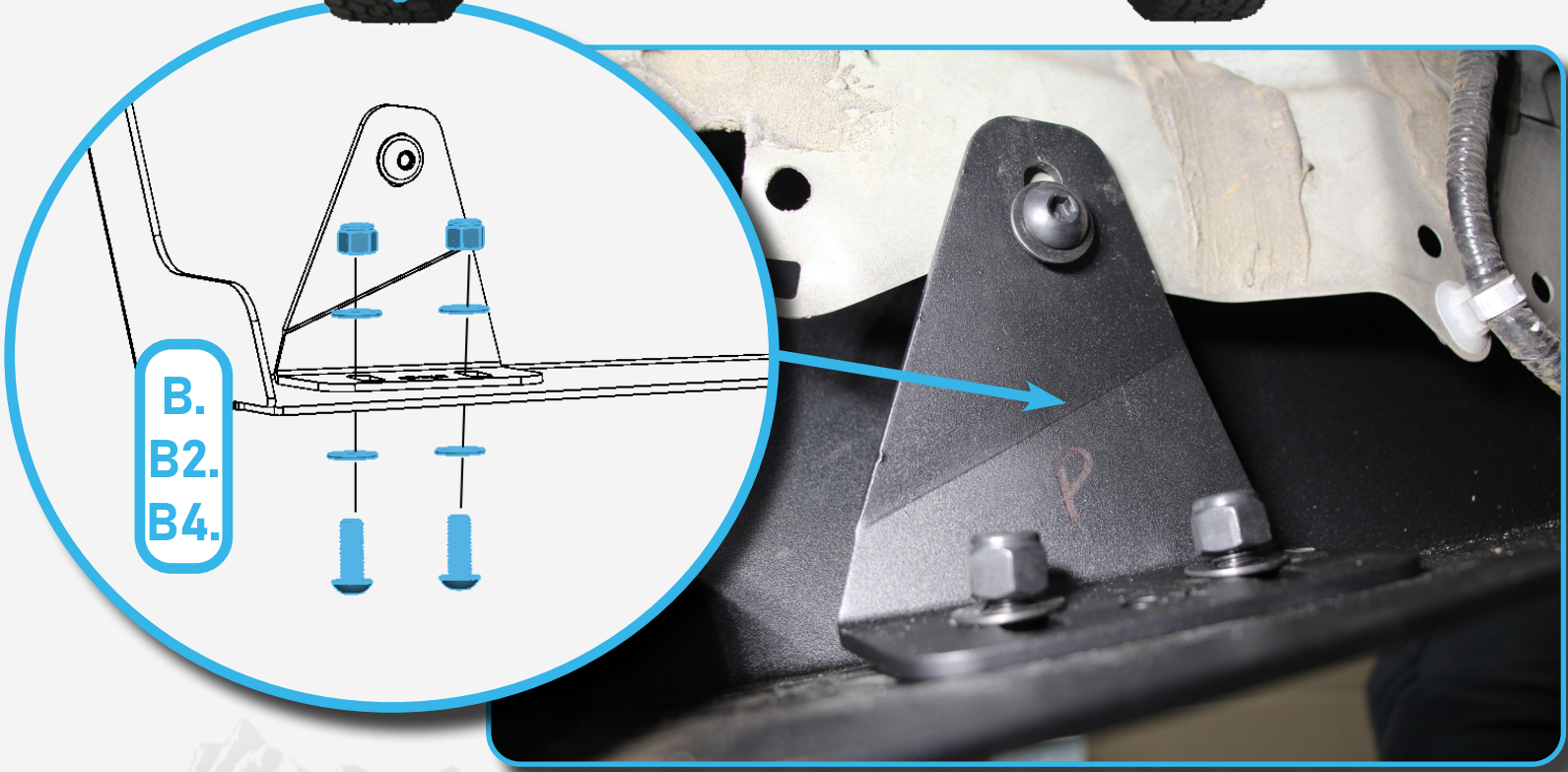
□ STEP 38

Trim the fender flair to match the top of the side of the bumper shown below.



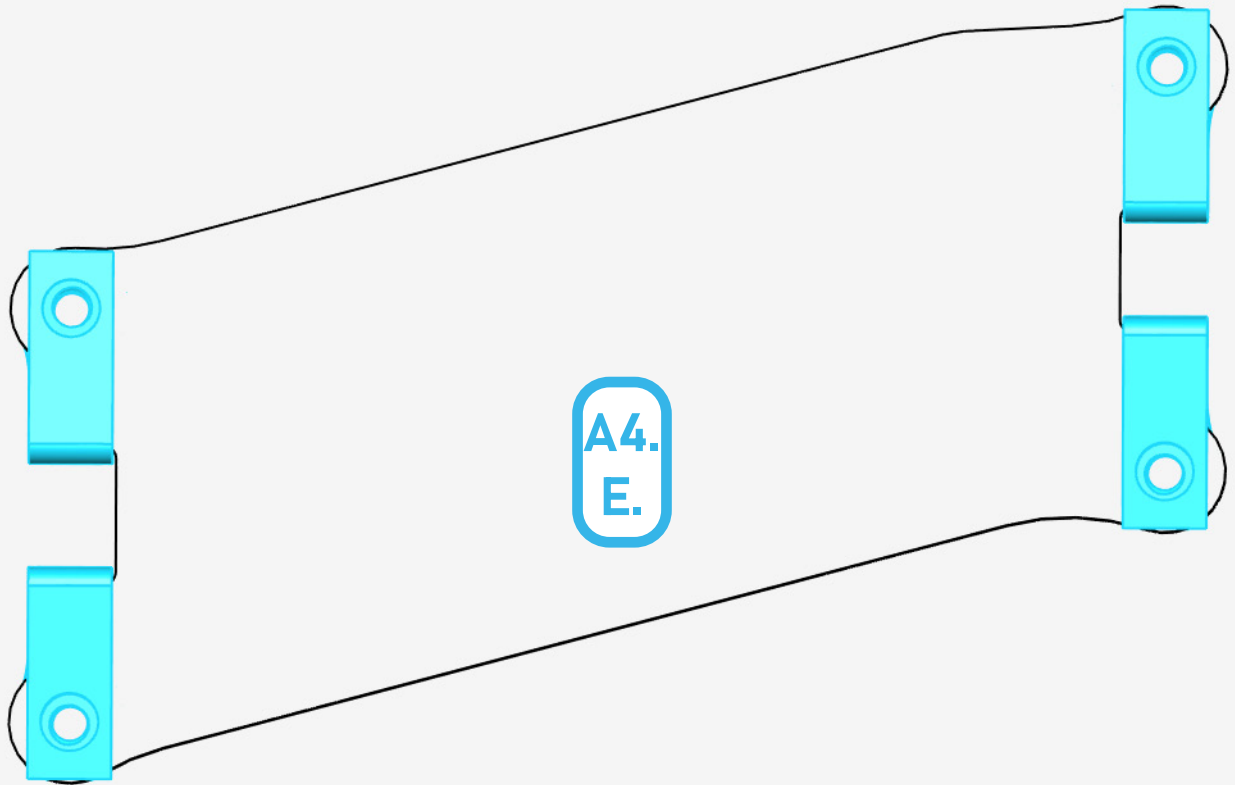
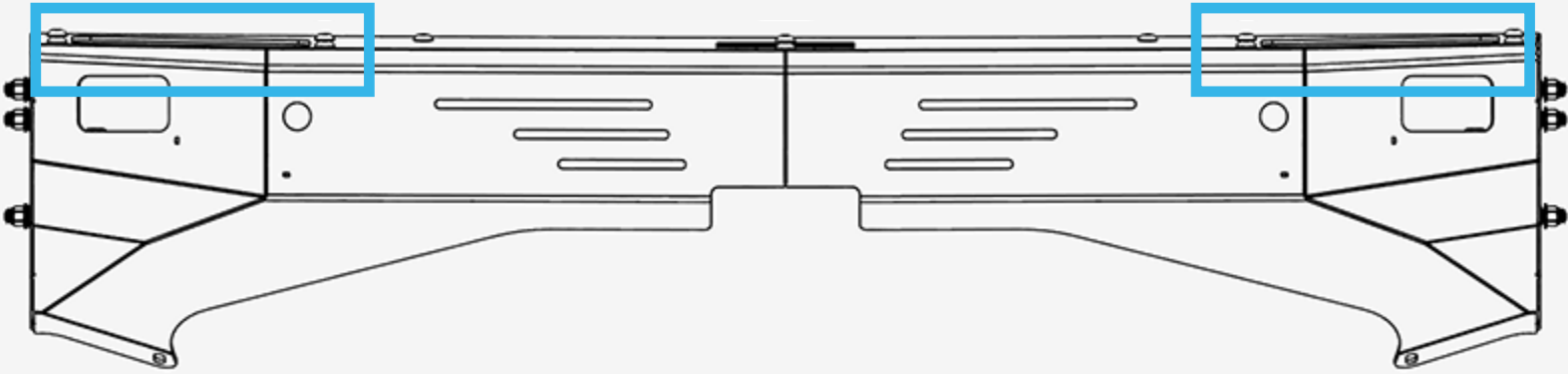
STEP 39

Install the provided (G) support bracket on the side of the bumpers located on the underside with the provided (B, B2, B4) 3/8" hardware using a (7/32 allen) and a (9/16 wrench).



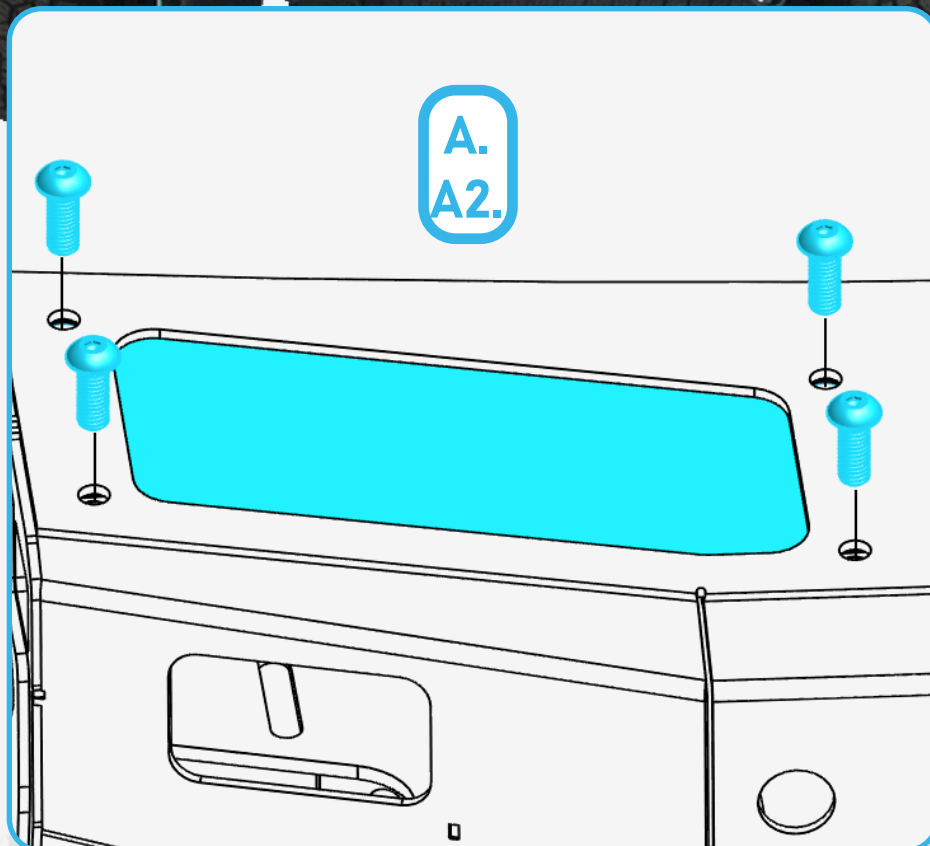
STEP 40

Install the provided (A4) nut clips onto the provided (E) cover plate as shown below.



STEP 41

Next, install the provided (E) cover plate on top of the bumper and using a (5/32 allen), install the provided (A, A2) 3/8" hardware.



STEP 42

Stand back and enjoy your new RAGO Rear Bumper.

Check and re-tighten all mounting bolts after 100 miles and periodically thereafter.

