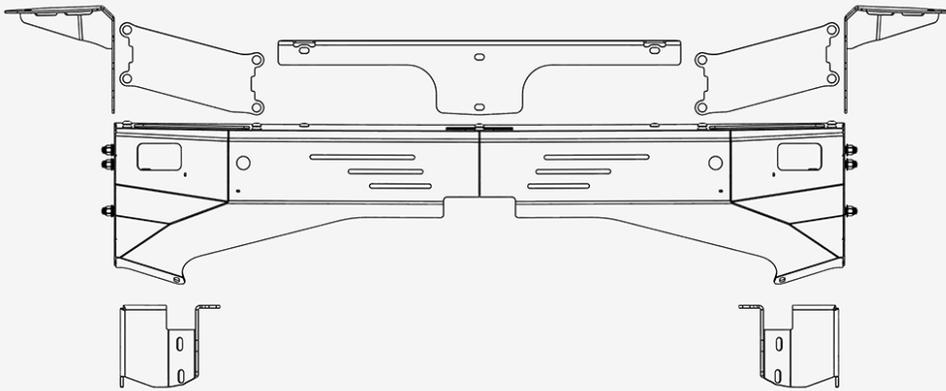


## CENTER MOUNT REAR BUMPER

2024-UP/LEXUS GX 550

R840255090103



### TOOLS REQUIRED

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

### SKILL LEVEL

- Skilled

### TIME REQUIRED

- Approximately 4.5 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: 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

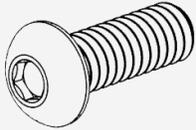
performance of these components and the safety of the vehicle. Inspect all contents of this package to make sure product is not damaged and all installation hardware has been included. If parts are missing from kit, please be prepared to provide the following information:

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.**



3/8-16 X 1" BUTTON HEAD BLACK

**QTY: 12**

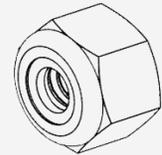
**A1.**



3/8" FLAT WASHER BLACK

**QTY: 10**

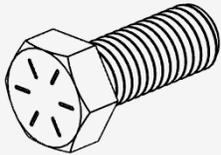
**A2.**



3/8-16" NYLON LOCK NUT BLACK

**QTY: 10**

**B.**



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

**QTY: 8**

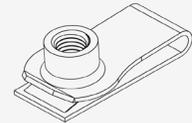
**B1.**



3/8" FLAT WASHER YELLOW ZINC

**QTY: 8**

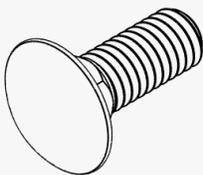
**B2.**



3/8-16" U-NUT

**QTY: 16**

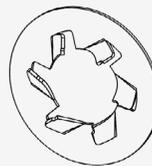
**C.**



3/8-16 X 1" CARRIAGE BOLT

**QTY: 6**

**C1.**



3/8" RETAINING WASHER

**QTY: 6**

**D.**



3M DOUBLE SIDED TAPE 1X1

**QTY: 4**

Reference this page throughout the install



## PARTS

**E.**



SPL1038

**QTY: 1**

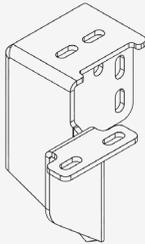
**F.**



SPL1035

**QTY: 2**

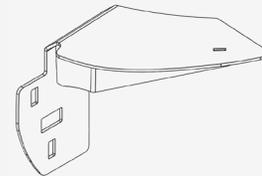
**G.**



Mount Plates

**QTY: 2**

**H.**



Side supports

**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.



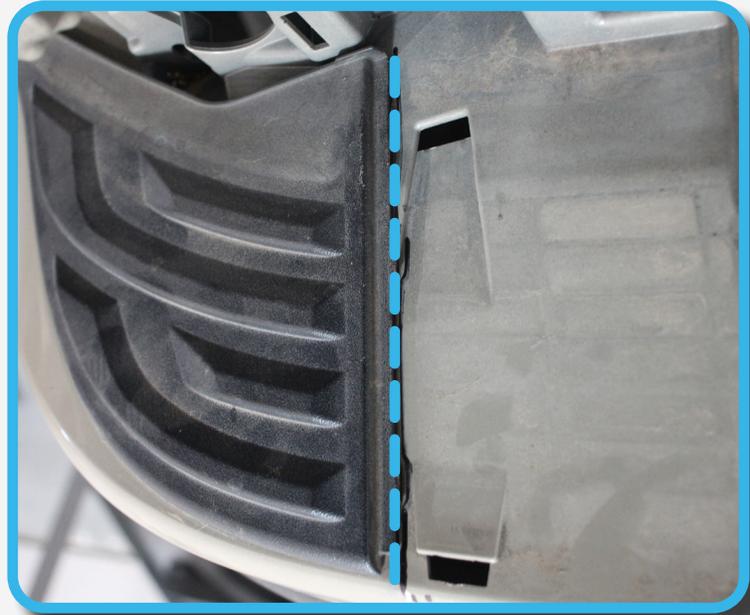
## □ STEP 2

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



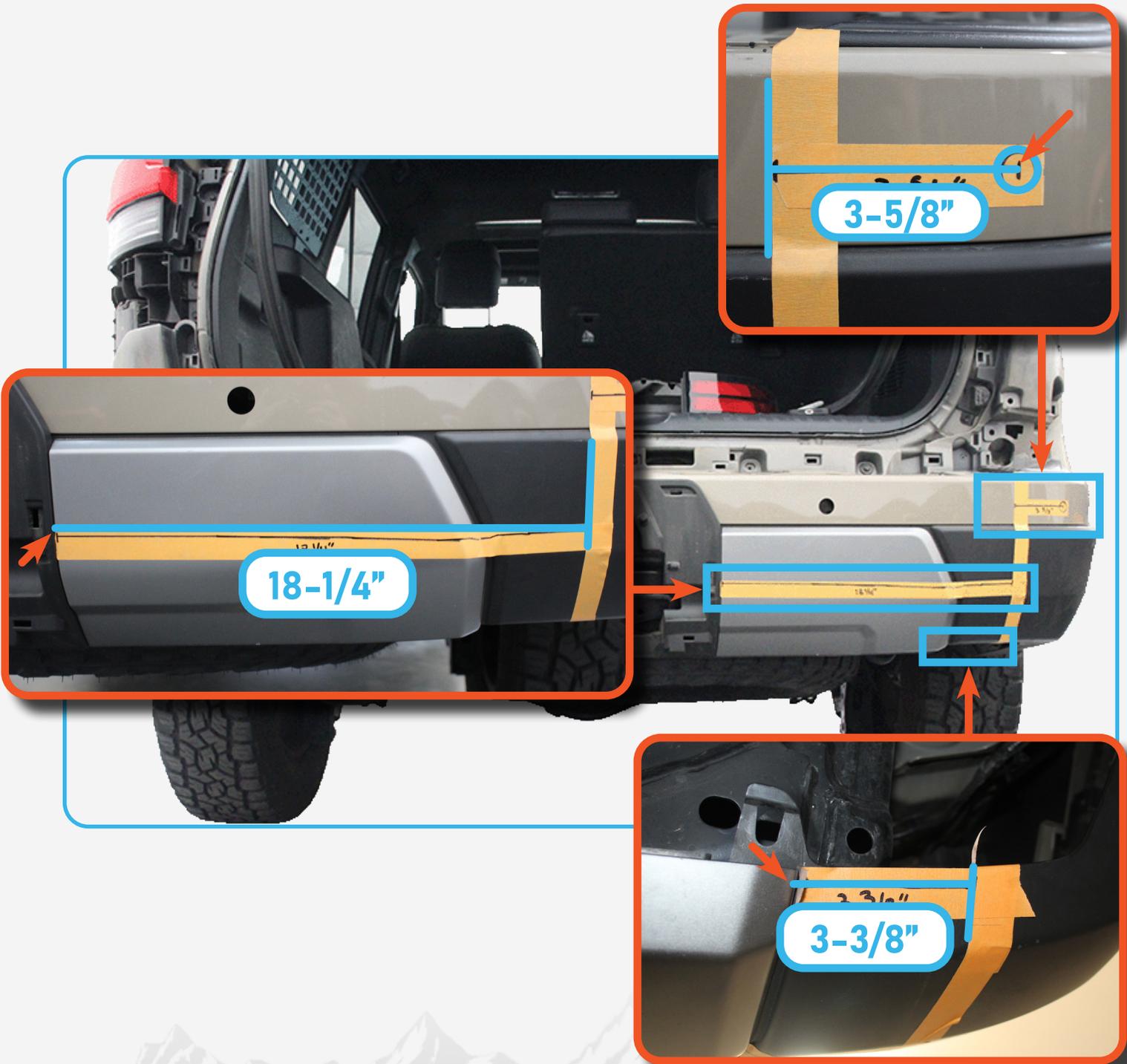
**STEP 3**

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



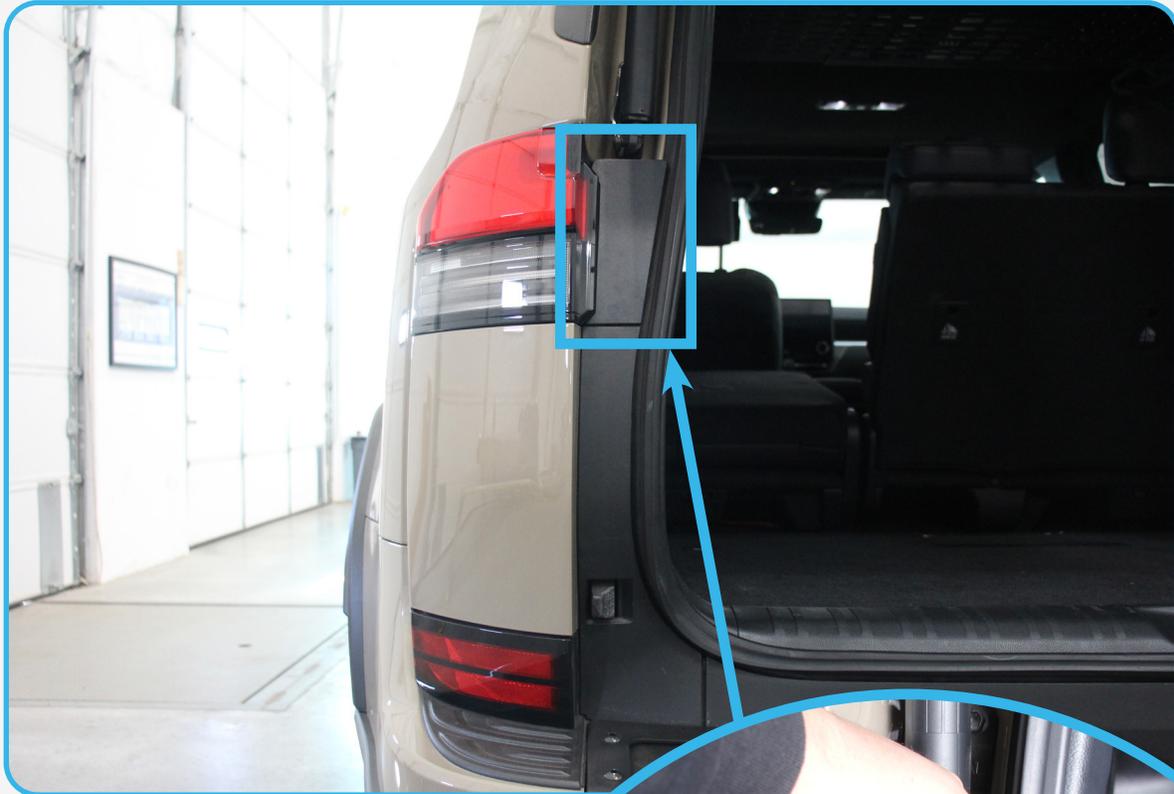
## □ STEP 4

Mark out your cut line going from the sensor hole in 3-5/8". Next mark the middle going from the edge of the bumper next to the receiver out 18-1/4". Next mark the bottom from the plastic cover in the middle of the bumper out 3-3/8". Using a straight edge connect the marks for your cut line. Repeat on other side.



## □ STEP 5

Remove the plastic cover as shown below by pulling.



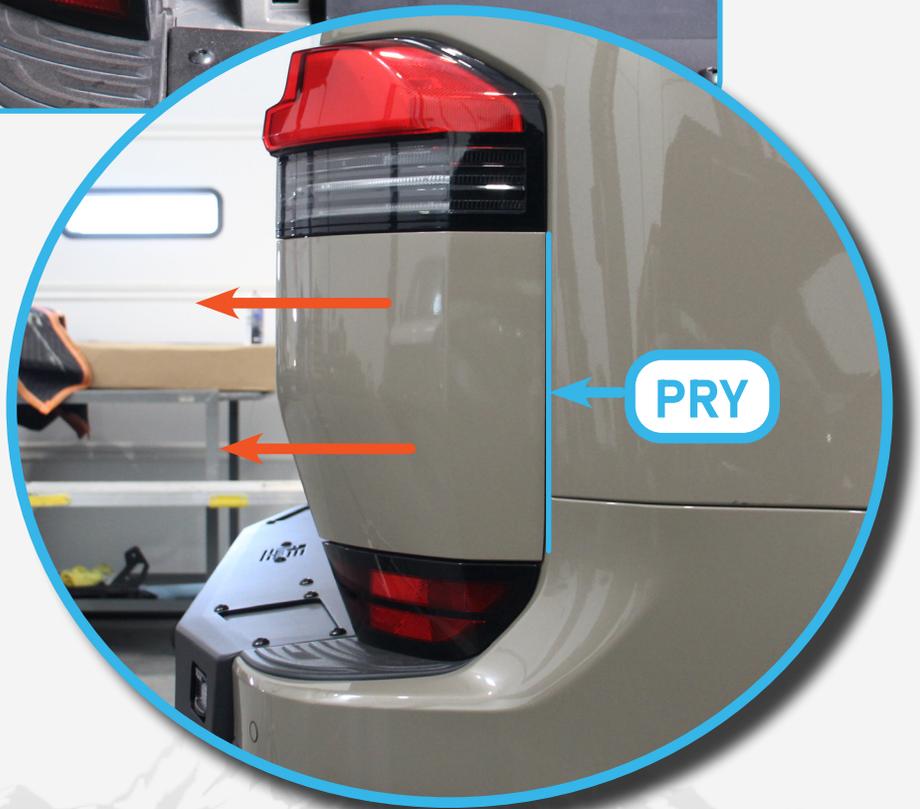
**STEP 6**

Remove the plastic cover as shown below by pulling.



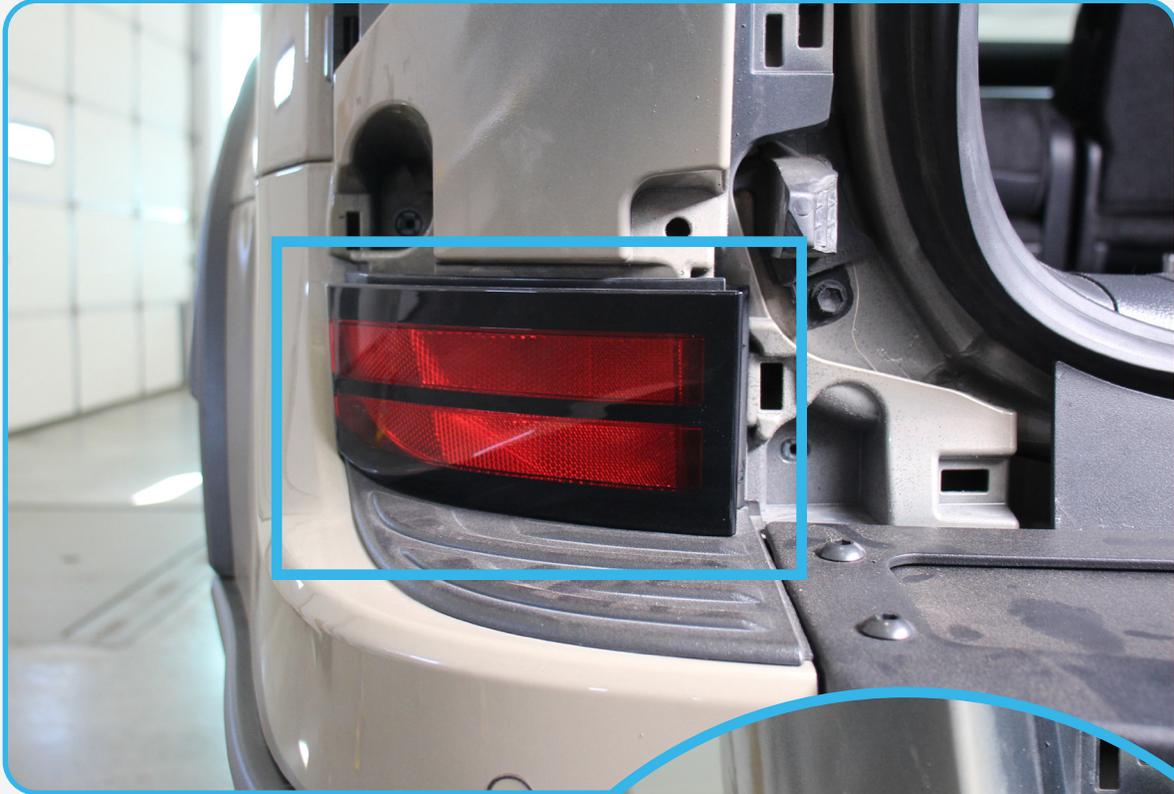
## □ STEP 7

Remove the plastic cover as shown below by pulling.



## □ STEP 8

Remove the plastic cover as shown below by pulling.



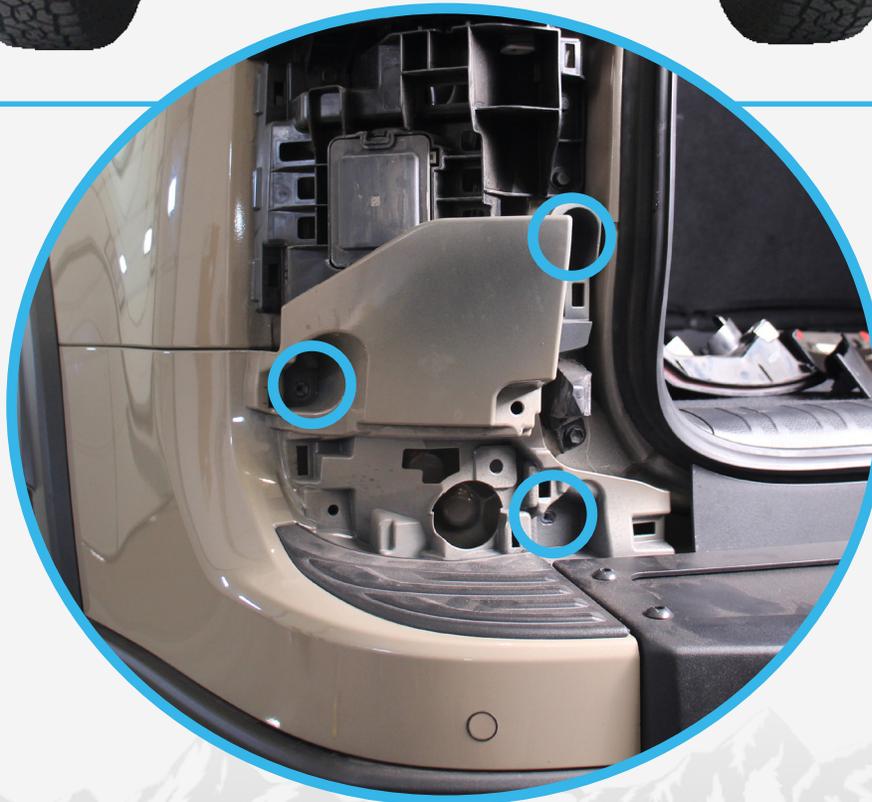
**STEP 9**

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



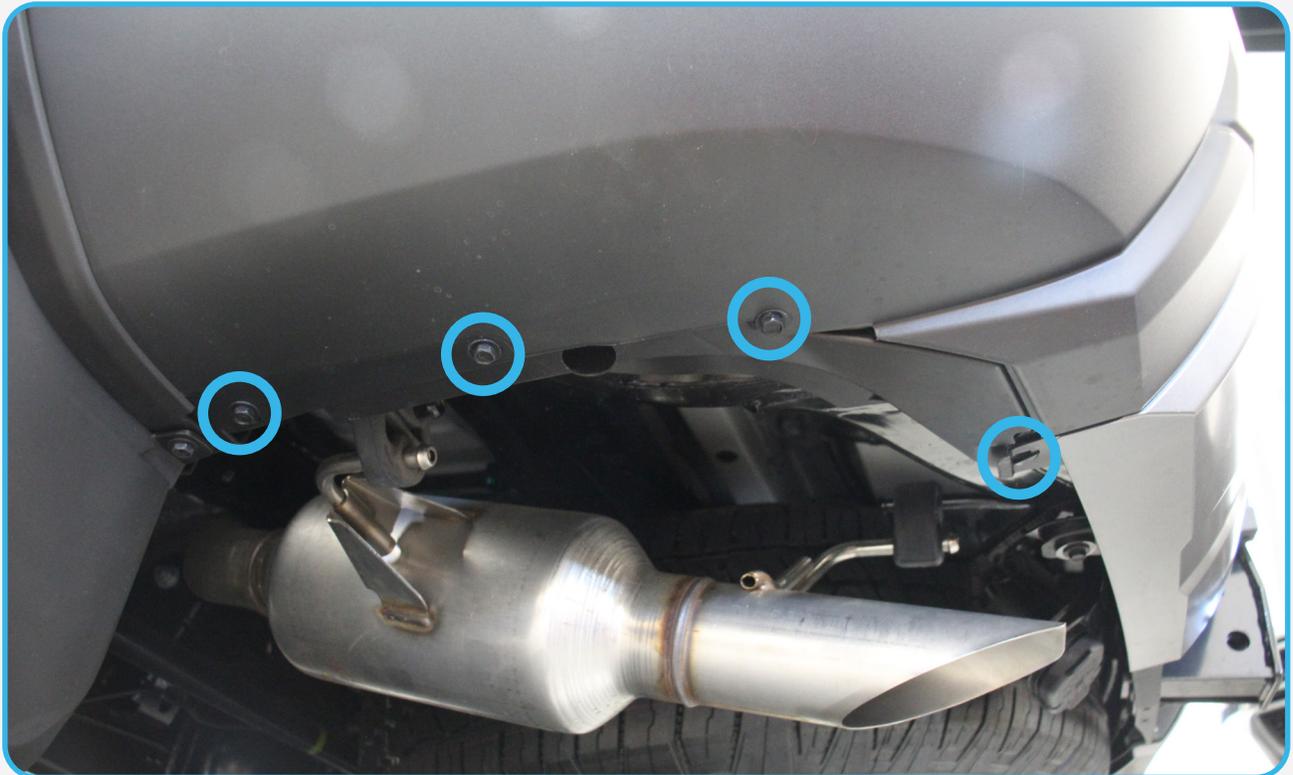
**STEP 10**

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\*\***



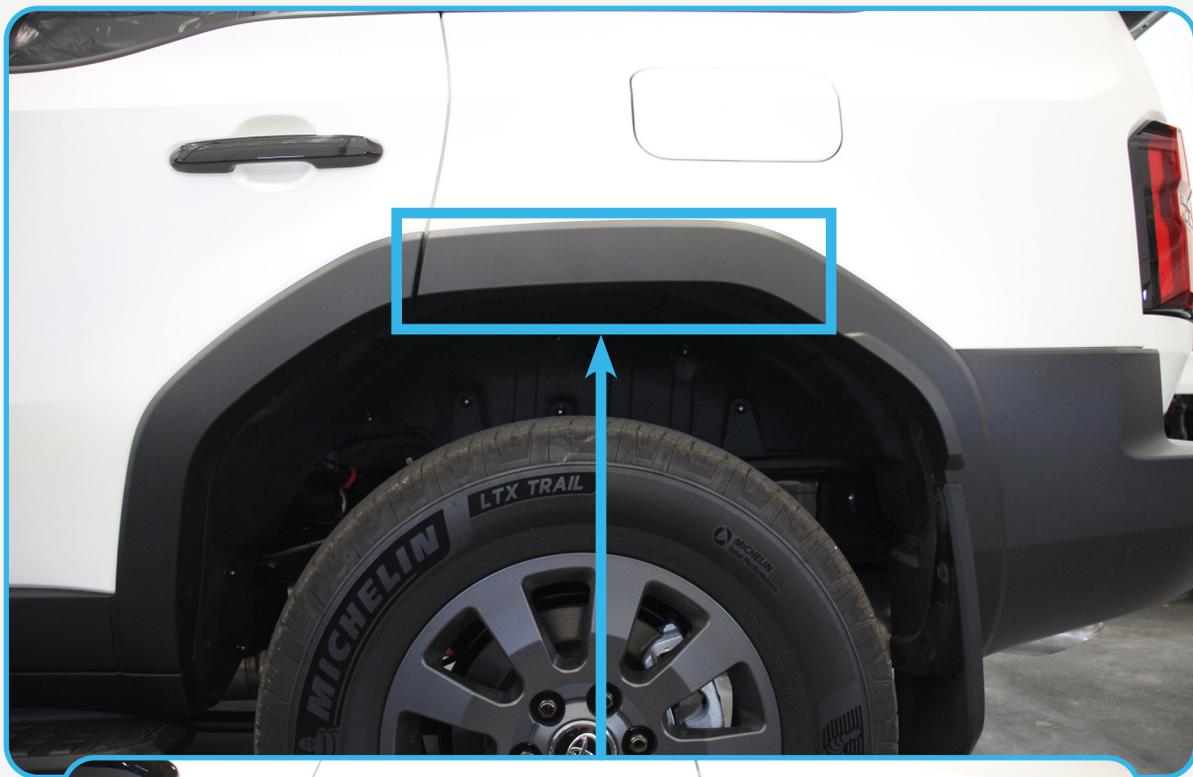
## □ STEP 13

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.



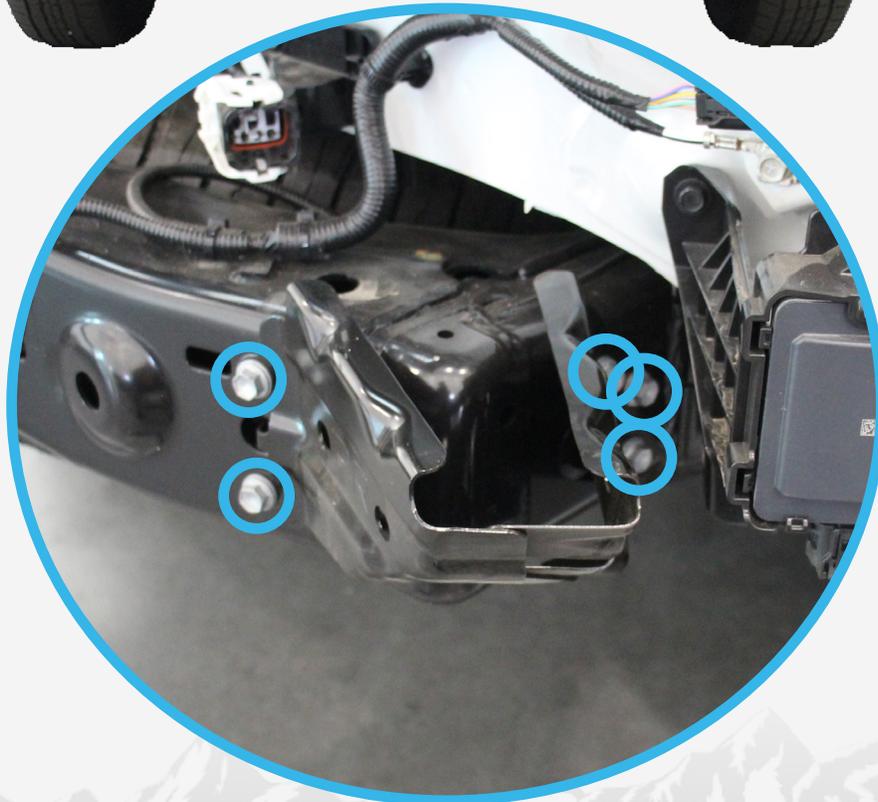
**STEP 19**

Remove the foam located on top of the hitch.



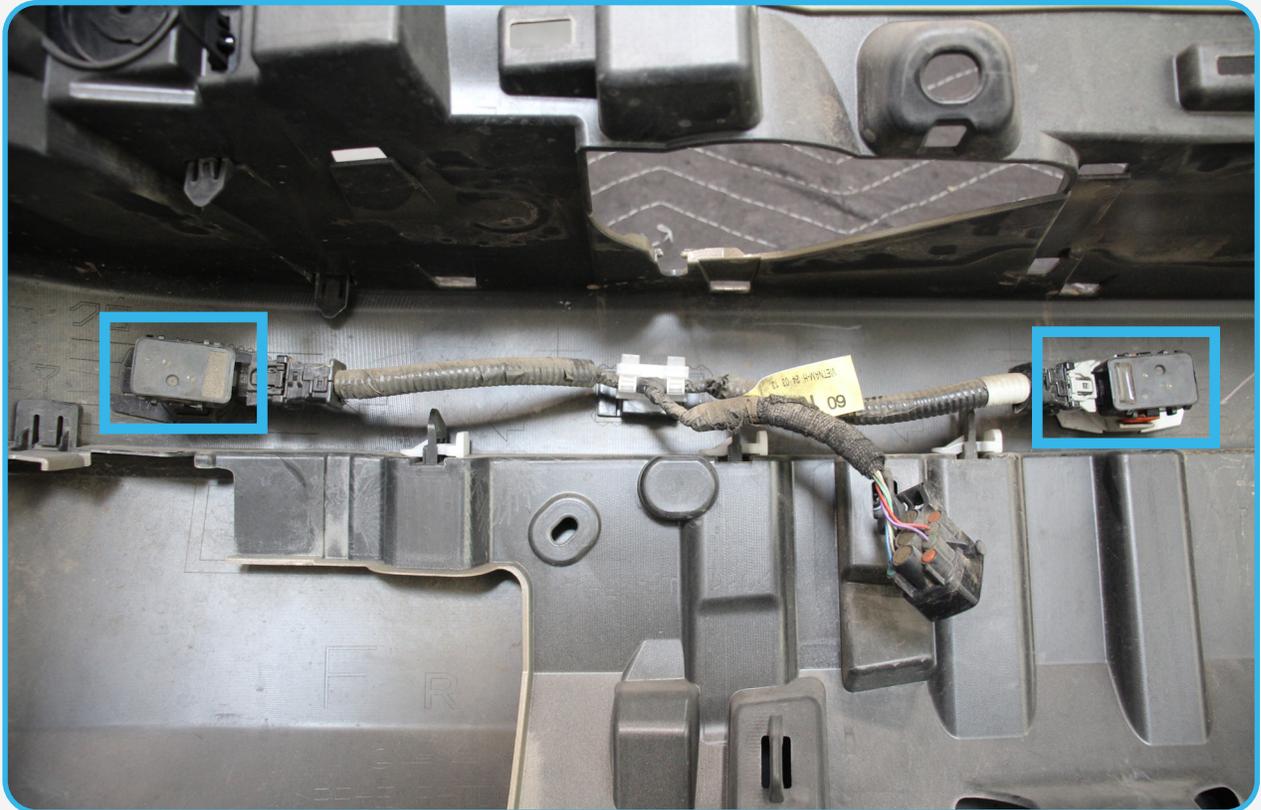
## □ STEP 20

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. This cut will be fine tuned later on in the install.



## □ STEP 24

Install the provided **(G)** mounting plate with the OEM hardware removed from **step 20** using a **(12mm socket)**. Next, install the provided **(B2)** nut clips on top of the mounting plate as shown below.



## □ STEP 25

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



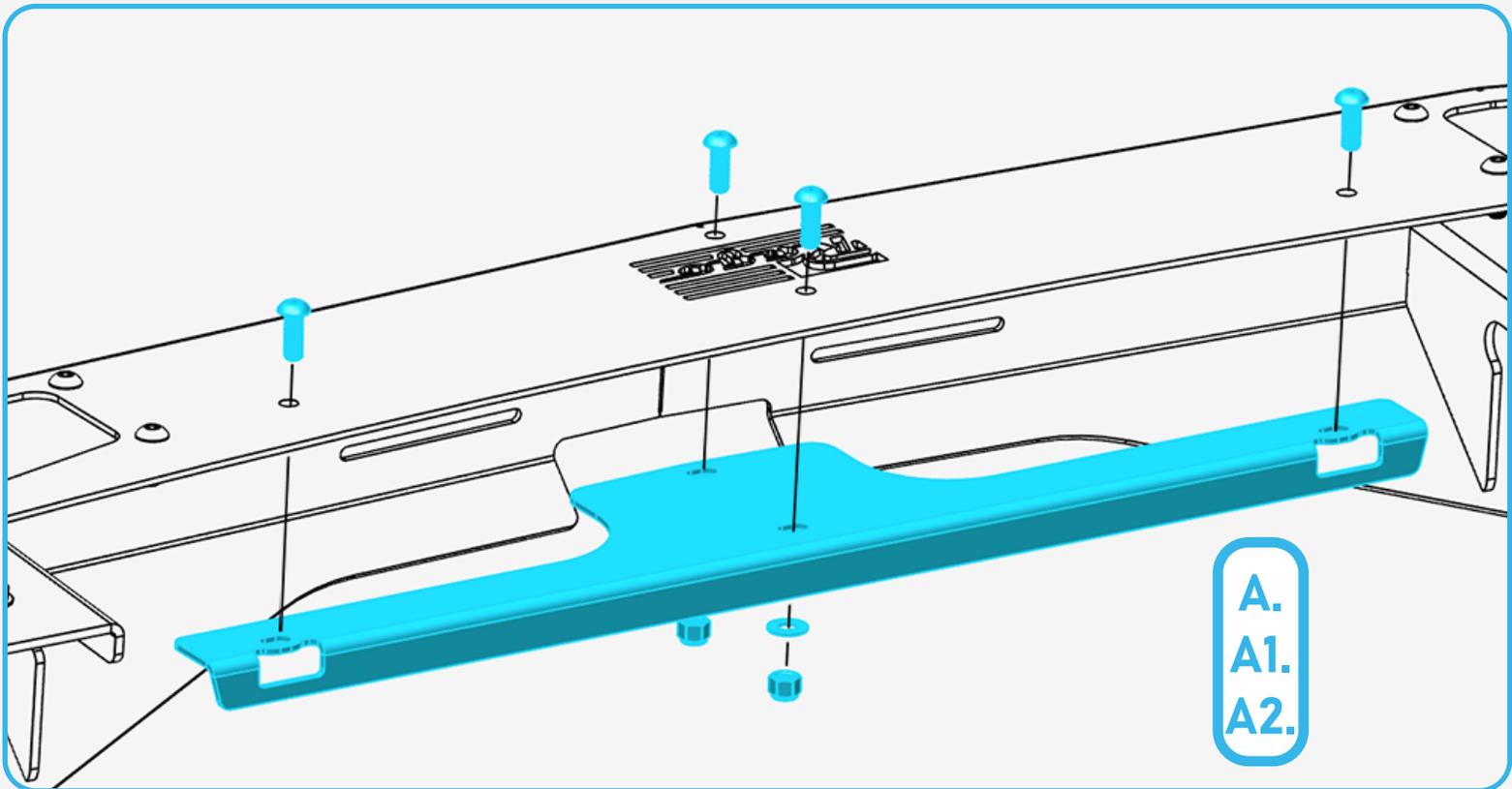
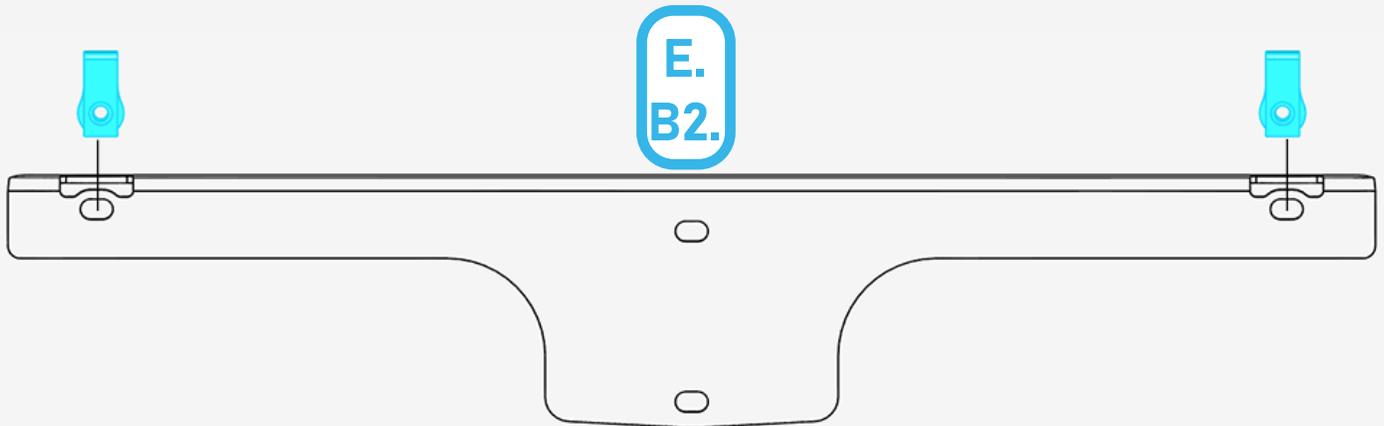
**STEP 26**

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



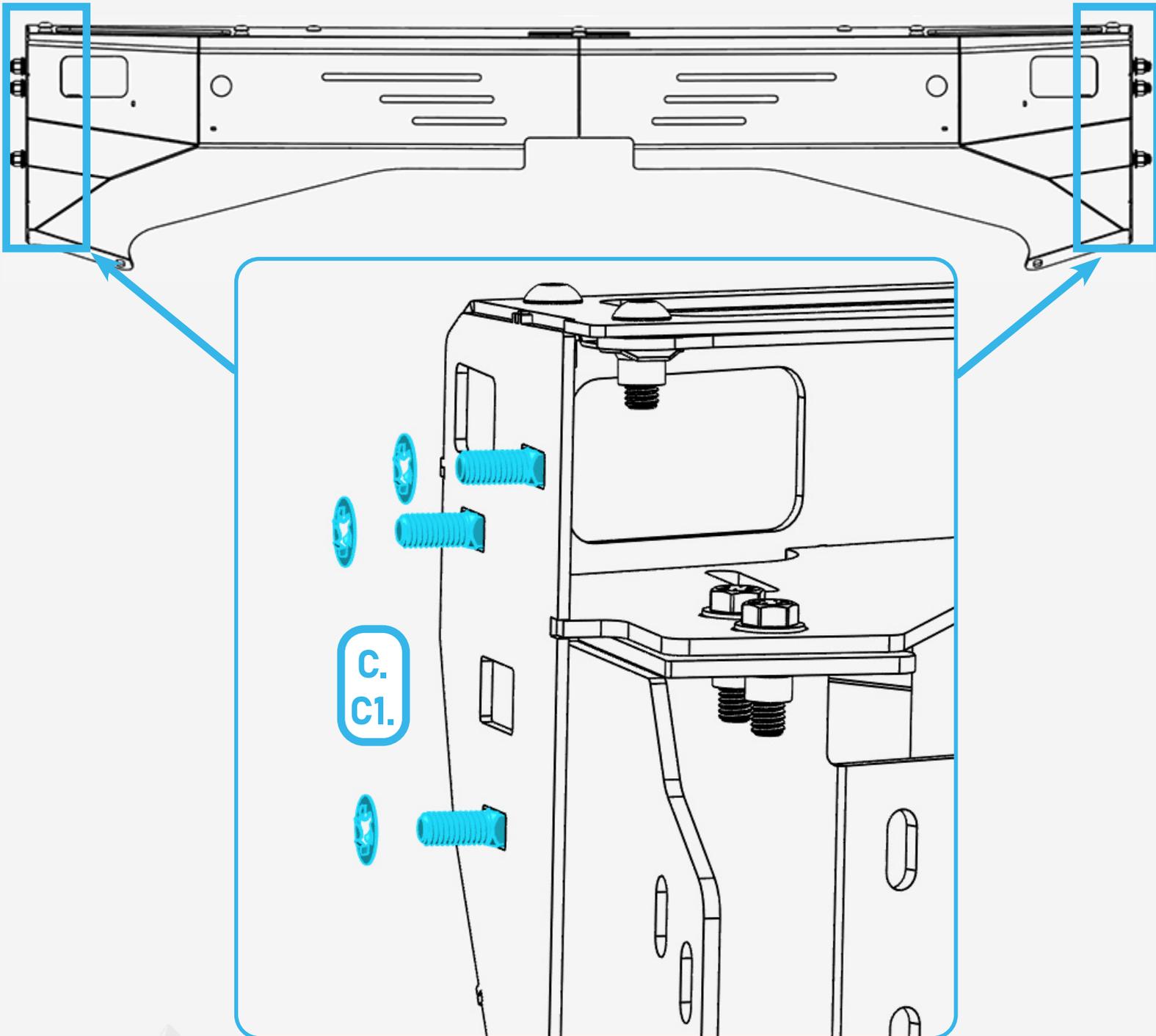
## □ STEP 27

Install the provided **(B2)** nut clips onto the **(E)** 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, A1, A2)** 3/8" hardware.



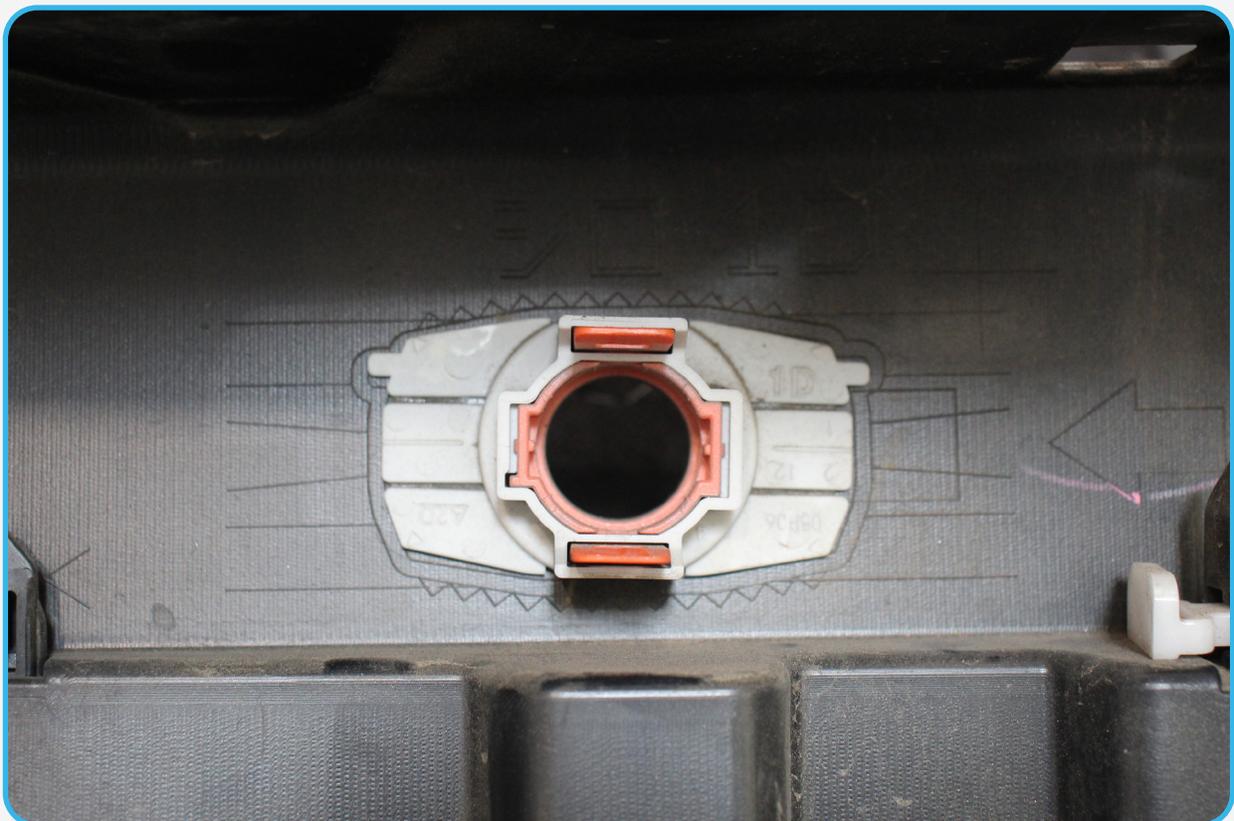
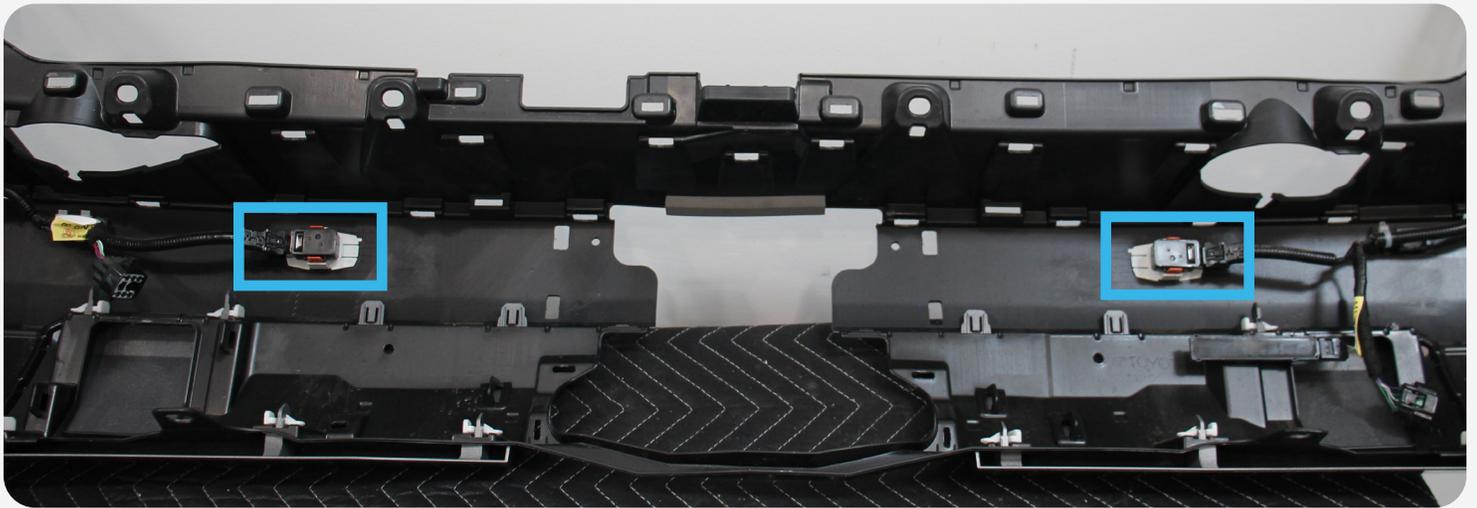
**STEP 28**

Install the provided **(C, C1)** 3/8" carriage bolts and retaining washers into the side of the bumper pointing outwards as shown below.



## □ STEP 29

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



## □ STEP 30

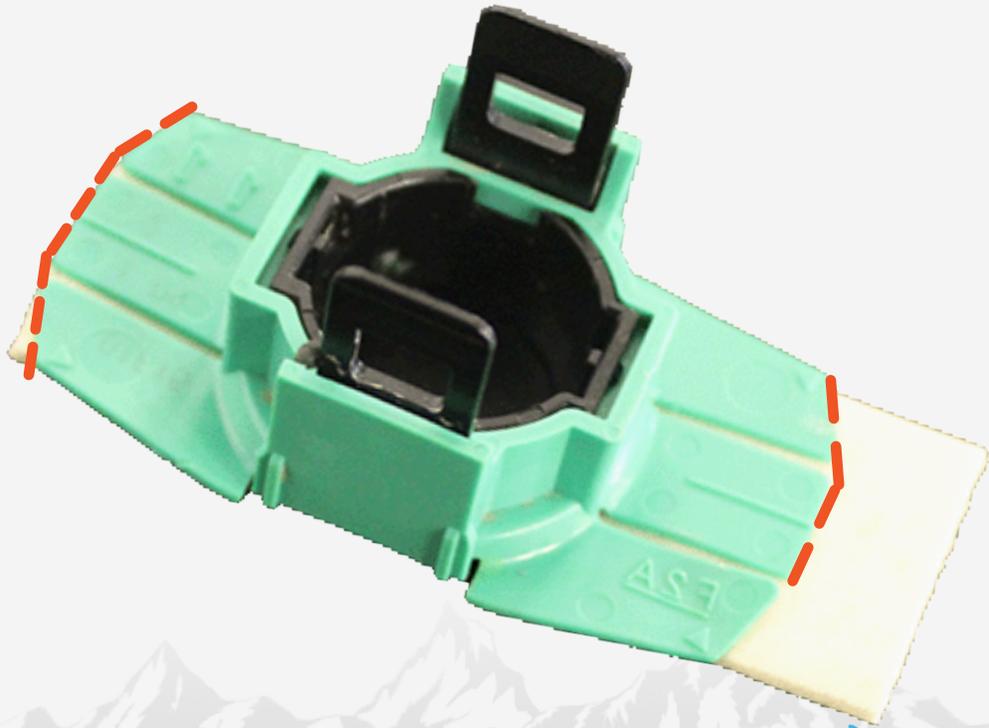
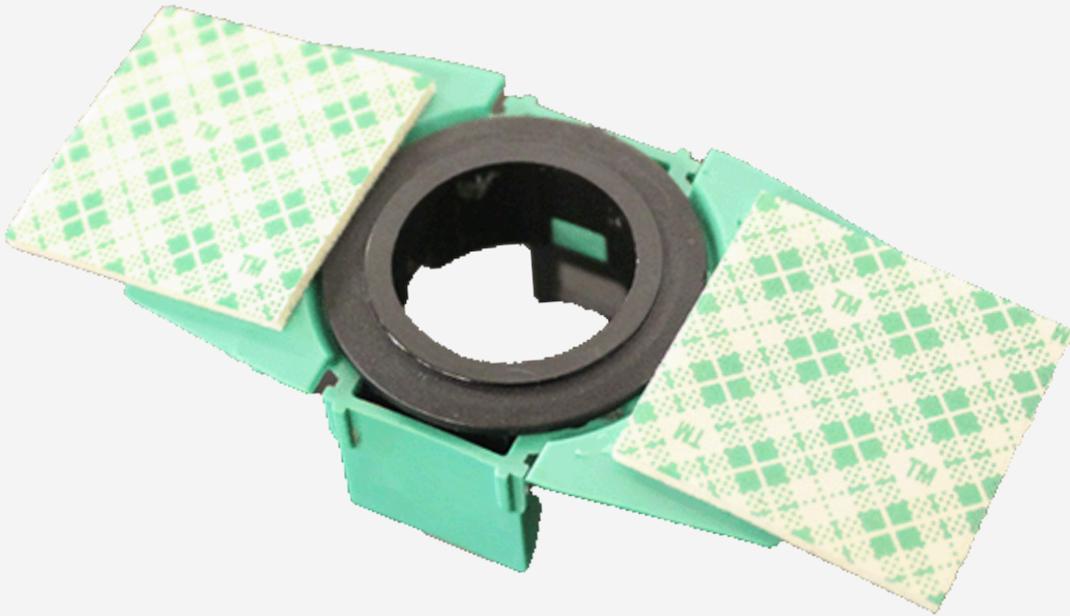
Remove double sided tape from the bezel until the surface is clear of residue.

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



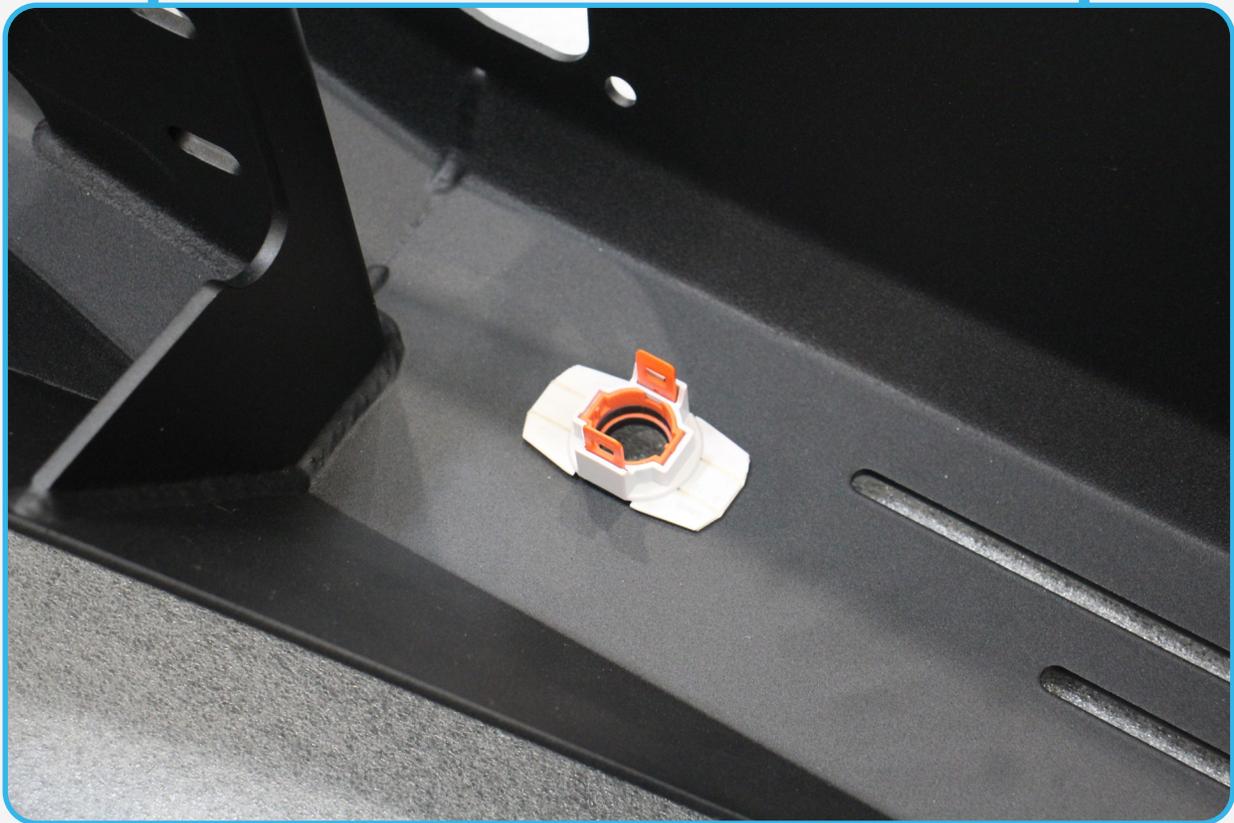
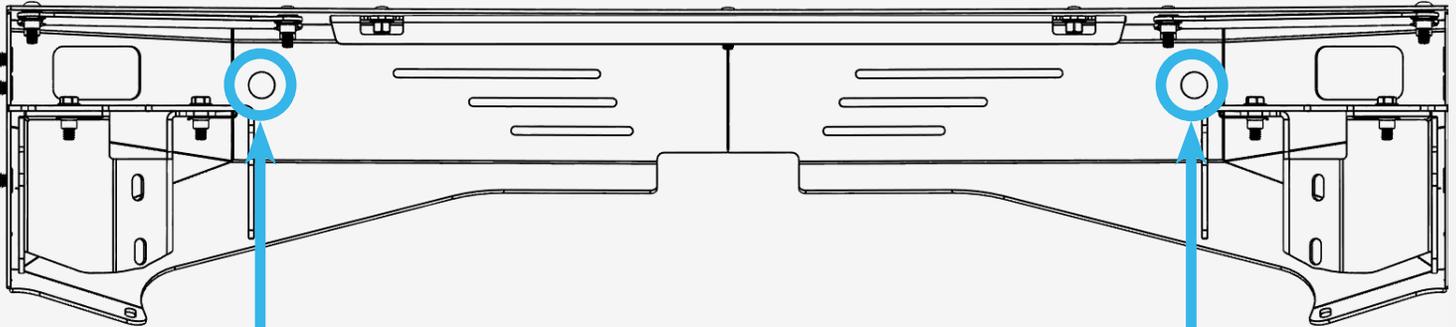
## □ STEP 31

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



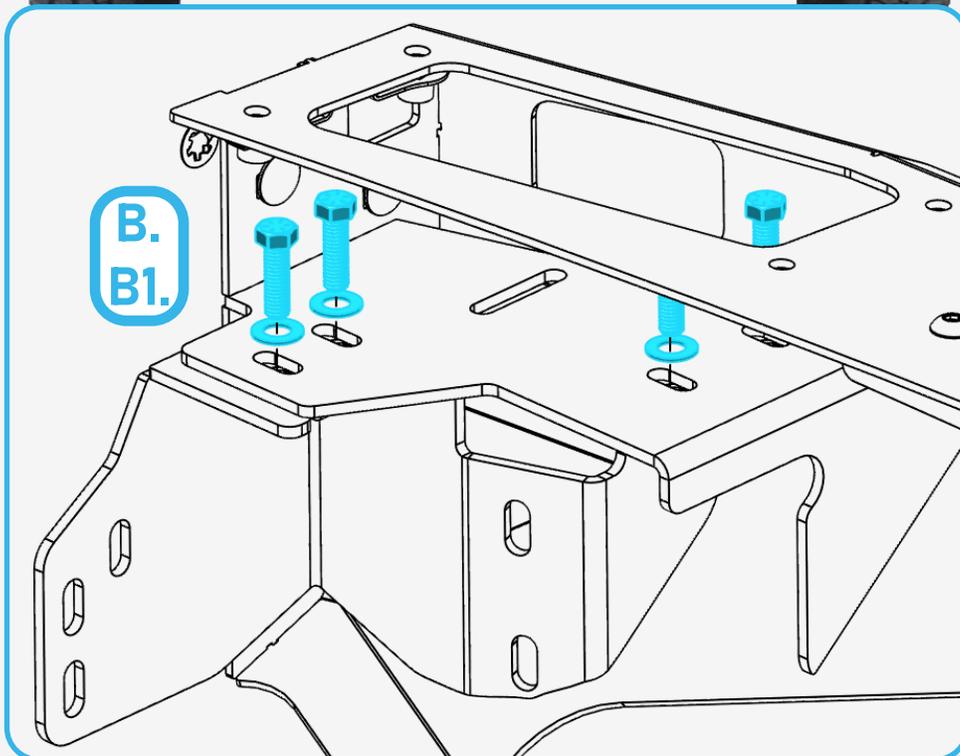
## □ STEP 32

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\*\***



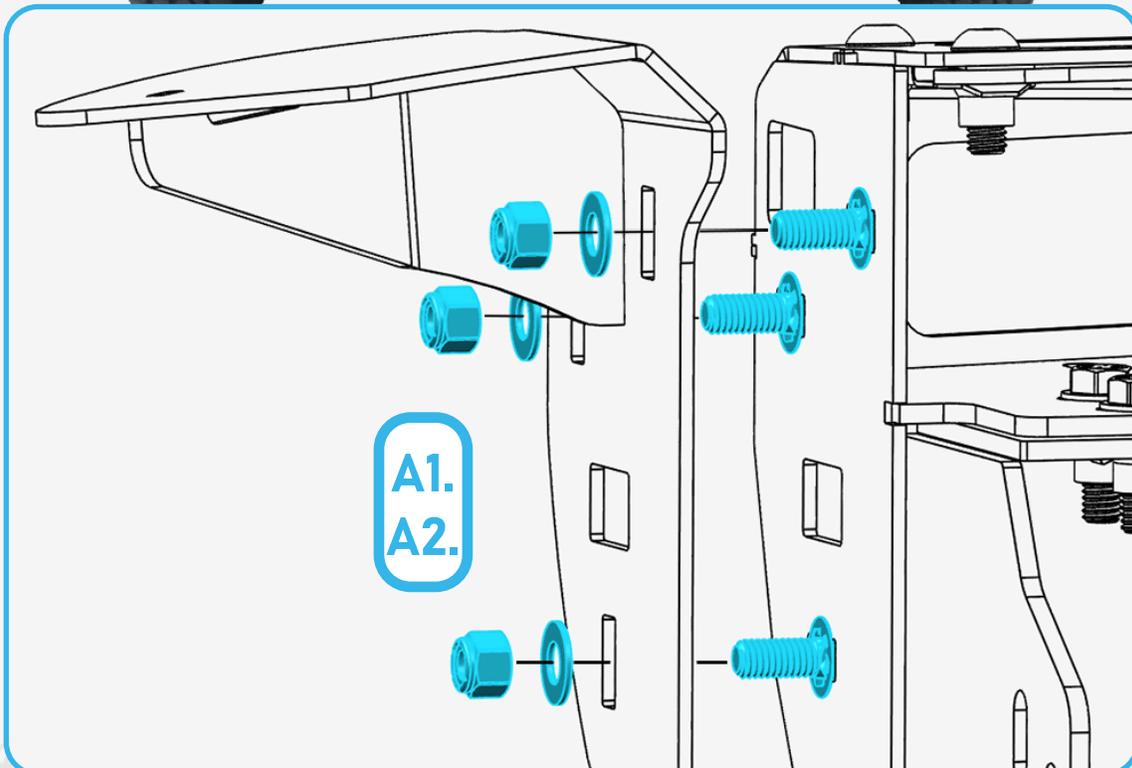
**STEP 33**

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



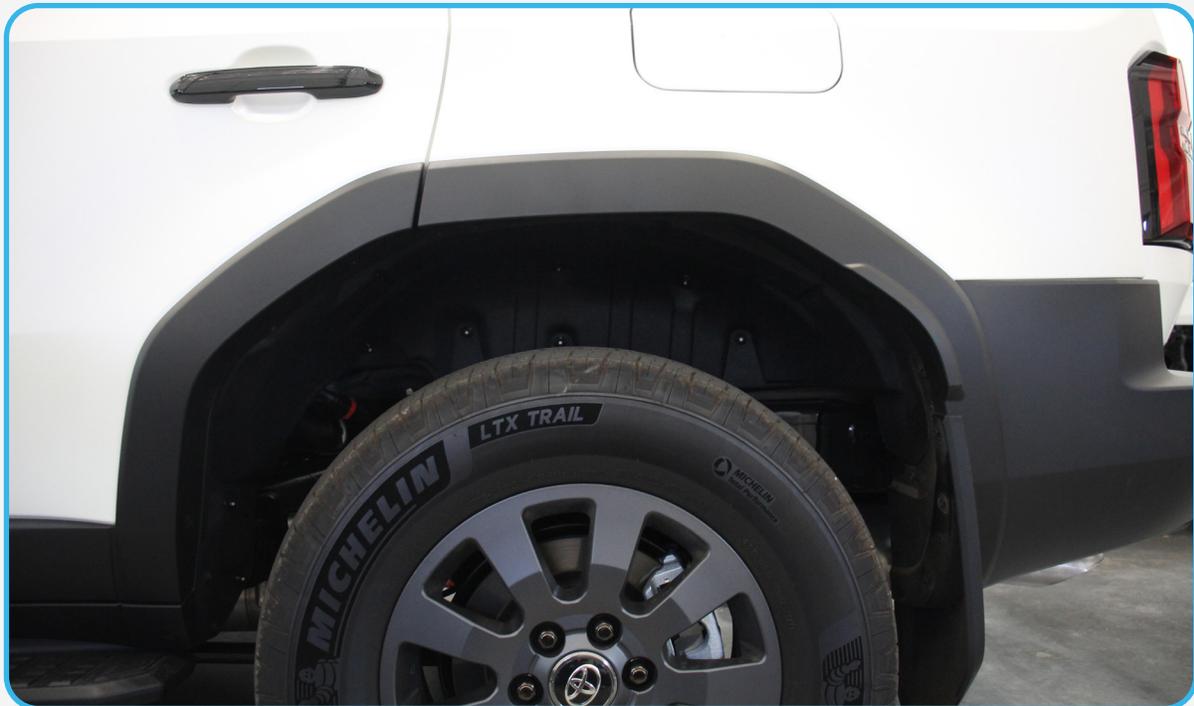
## □ STEP 34

Slip the support bracket (H) inside the bumper and into the hardware installed on **step 28**. Next, install the provided (A1, A2) 3/8" hardware using a (9/16 wrench). **\*\*THIS STEP IS OPTIONAL FOR STEP SUPPORT\*\***



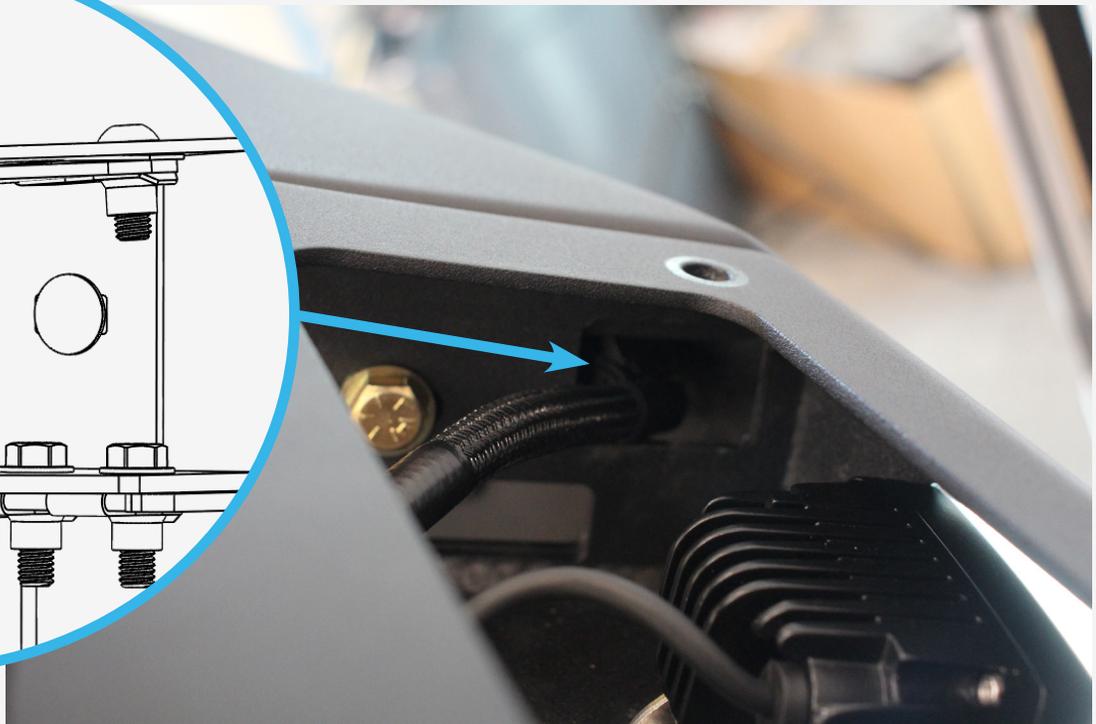
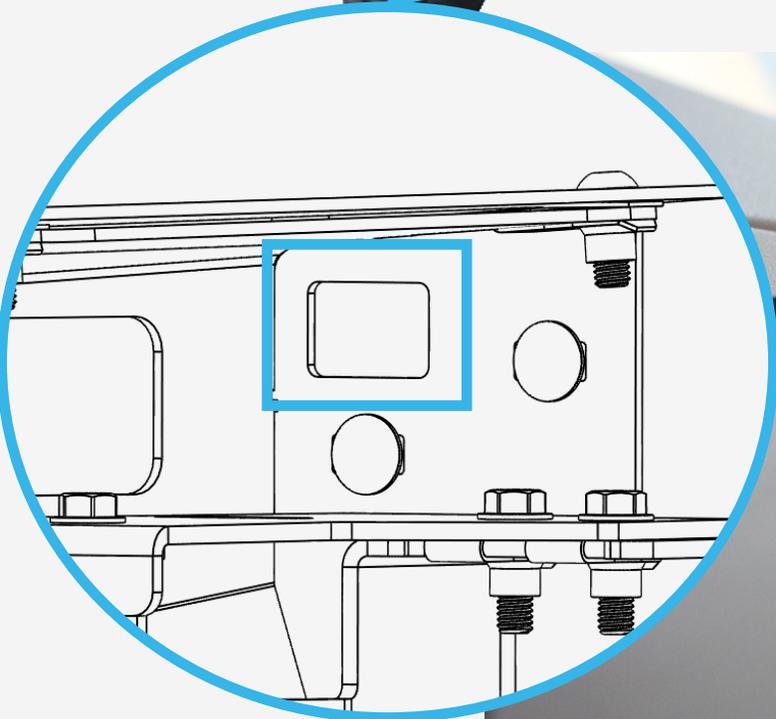
## □ STEP 35

Once you are satisfied with the fitment, repeat **steps 11-12** to mount the sides and bottom plastic.



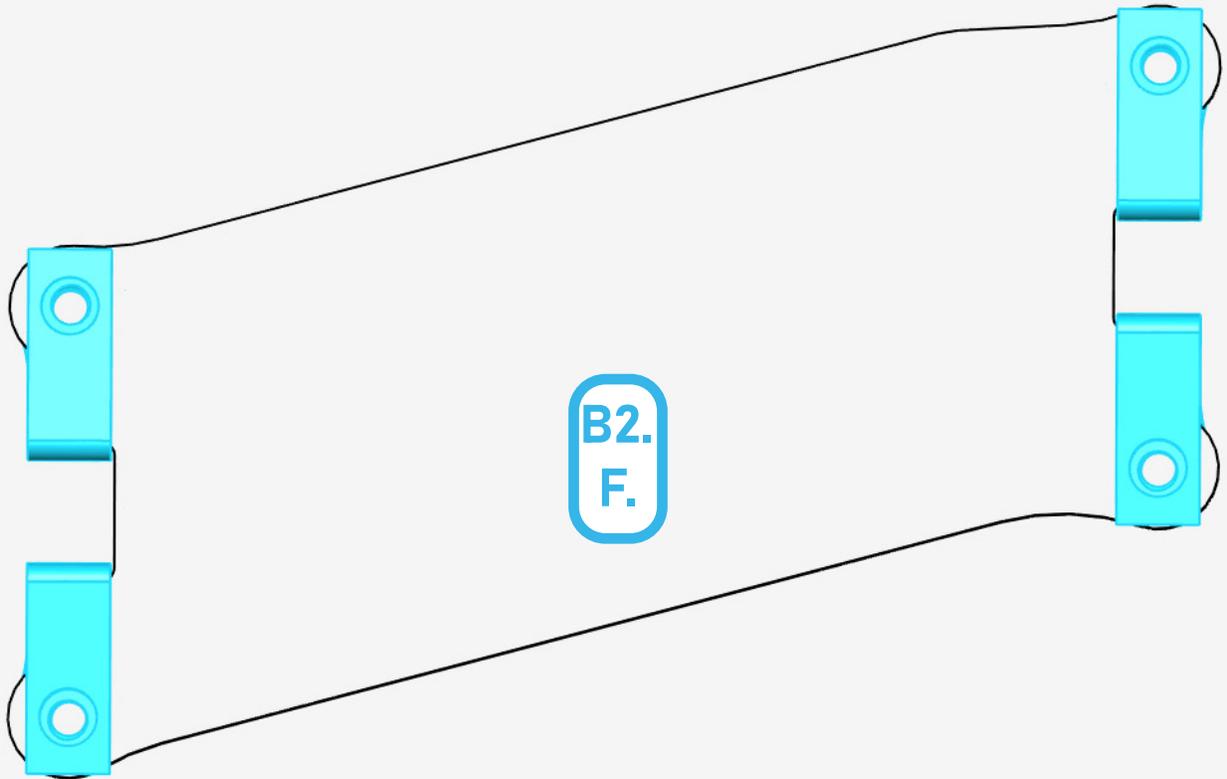
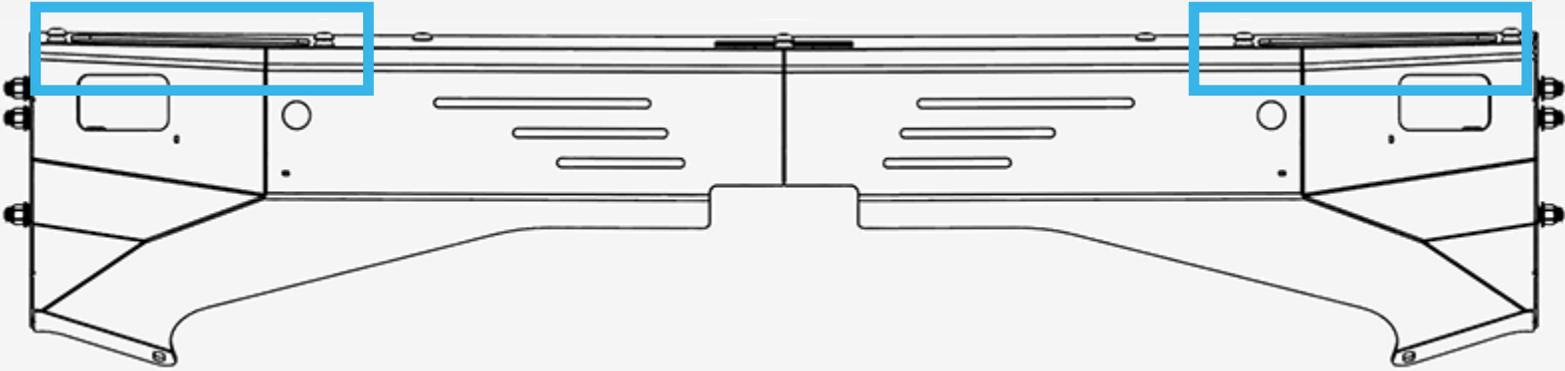
## □ STEP 36

Install your sensors into the bezels. For installing the outer sensors, insert into the window cutout located on the side of the bumper as shown below.



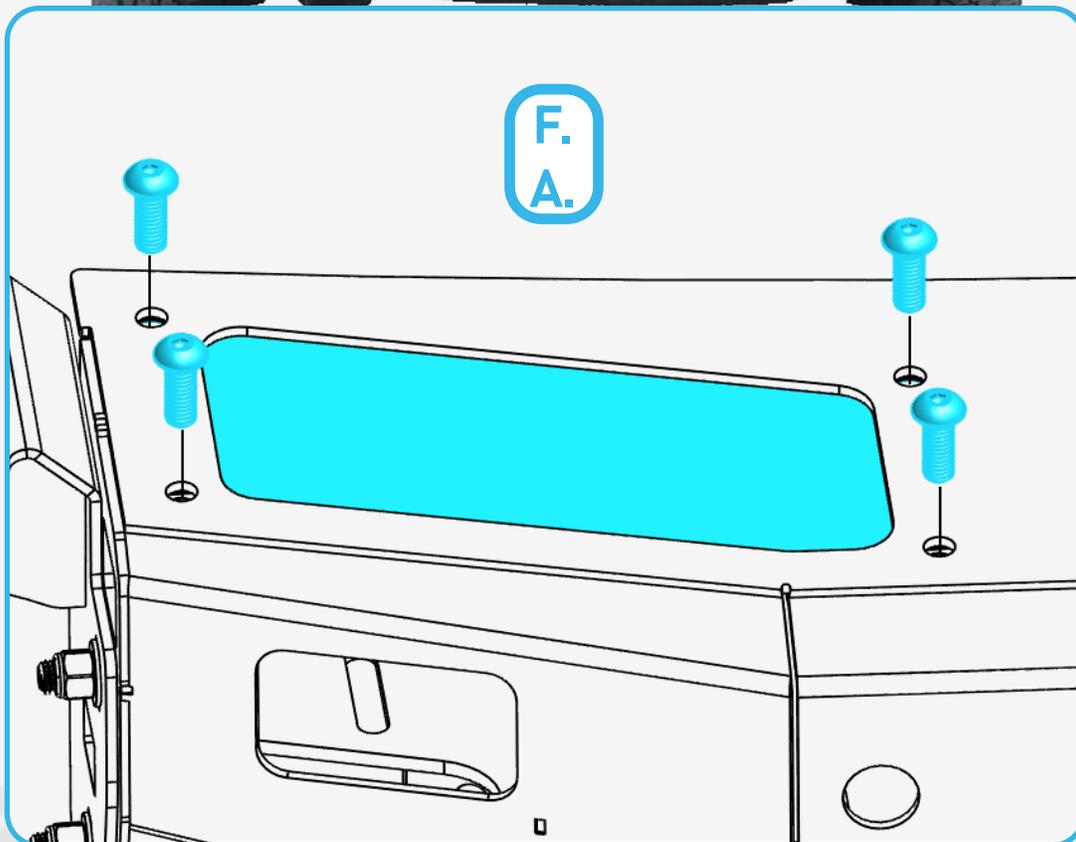
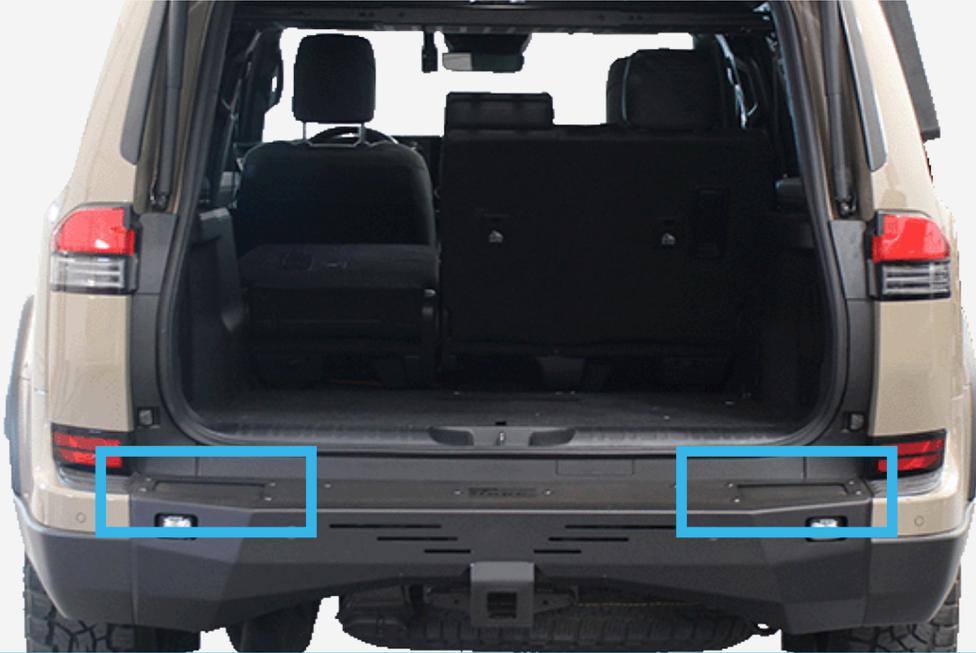
## □ STEP 37

Install the provided (B2) nut clips onto the provided (F) cover plate as shown below.



## □ STEP 38

Next, install the provided (F) cover plate on top of the bumper and using a (7/32 allen), install the provided (A) 3/8" hardware.



## □ STEP 39

Located on the bottom of the bumper, install the OEM hardware using a (10mm socket).



## STEP 40

Stand back and enjoy your new RAGO Center Mount Rear Bumper.

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

