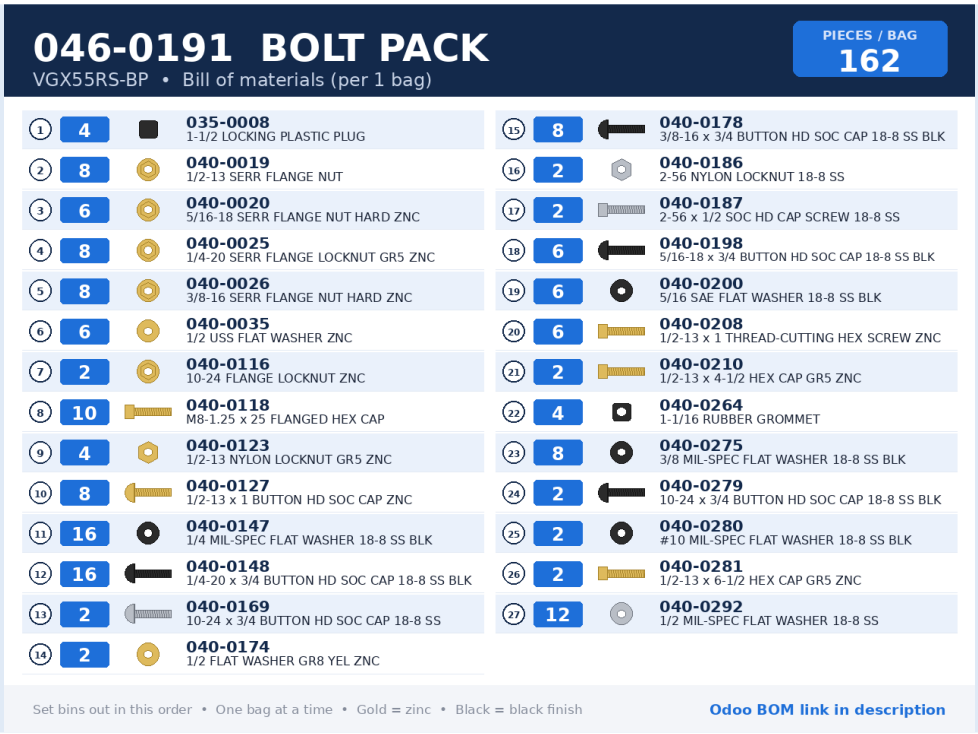
Step 1



Step by step on how to install the EVO Rear Bumper on the Land Cruiser 250! Questions or Support: Phone: 269-353-1184 Email: info@victory4x4.com

Step 2



046-0191 BOLT PACK

VGX55RS-BP • Bill of materials (per 1 bag)

PIECES / BAG 162

1	4	035-0008	1-1/2 LOCKING PLASTIC PLUG
2	8	040-0019	1/2-13 SERR FLANGE NUT
3	6	040-0020	5/16-18 SERR FLANGE NUT HARD ZNC
4	8	040-0025	1/4-20 SERR FLANGE LOCKNUT GR5 ZNC
5	8	040-0026	3/8-16 SERR FLANGE NUT HARD ZNC
6	6	040-0035	1/2 USS FLAT WASHER ZNC
7	2	040-0116	10-24 FLANGE LOCKNUT ZNC
8	10	040-0118	M8-1.25 x 25 FLANGED HEX CAP
9	4	040-0123	1/2-13 NYLON LOCKNUT GR5 ZNC
10	8	040-0127	1/2-13 x 1 BUTTON HD SOC CAP ZNC
11	16	040-0147	1/4 MIL-SPEC FLAT WASHER 18-8 SS BLK
12	16	040-0148	1/4-20 x 3/4 BUTTON HD SOC CAP 18-8 SS BLK
13	2	040-0169	10-24 x 3/4 BUTTON HD SOC CAP 18-8 SS
14	2	040-0174	1/2 FLAT WASHER GR8 YEL ZNC
15	8	040-0178	3/8-16 x 3/4 BUTTON HD SOC CAP 18-8 SS BLK
16	2	040-0186	2-56 NYLON LOCKNUT 18-8 SS
17	2	040-0187	2-56 x 1/2 SOC HD CAP SCREW 18-8 SS
18	6	040-0198	5/16-18 x 3/4 BUTTON HD SOC CAP 18-8 SS BLK
19	6	040-0200	5/16 SAE FLAT WASHER 18-8 SS BLK
20	6	040-0208	1/2-13 x 1 THREAD-CUTTING HEX SCREW ZNC
21	2	040-0210	1/2-13 x 4-1/2 HEX CAP GR5 ZNC
22	4	040-0264	1-1/16 RUBBER GROMMET
23	8	040-0275	3/8 MIL-SPEC FLAT WASHER 18-8 SS BLK
24	2	040-0279	10-24 x 3/4 BUTTON HD SOC CAP 18-8 SS BLK
25	2	040-0280	#10 MIL-SPEC FLAT WASHER 18-8 SS BLK
26	2	040-0281	1/2-13 x 6-1/2 HEX CAP GR5 ZNC
27	12	040-0292	1/2 MIL-SPEC FLAT WASHER 18-8 SS

Set bins out in this order • One bag at a time • Gold = zinc • Black = black finish

Odoo BOM link in description

Included Hardware:

Step 3

046-0210 BOLT PACK

VLC250RS-BP • Bill of materials (per 1 bag)

PIECES / BAG 38

BIN	QTY	PART #	DESCRIPTION
1	6 ×	040-0143	ALUM SPACER 1 OD x 3/4 L (1/2 SCR)
2	6 ×	040-0273	#14 x 1-1/2 SHEET METAL SCREW
3	8 ×	040-0148	1/4-20 x 3/4 BUTTON HD SOC CAP 18-8 SS BLK
4	8 ×	040-0147	1/4 MIL-SPEC FLAT WASHER 18-8 SS BLK
5	8 ×	040-0025	1/4-20 SERR FLANGE LOCKNUT GR5 ZNC
6	2 ×	VRS-BSMP1	BLIND SPOT MONITOR COVER #1

Set bins out in this order • One bag at a time • Gold = zinc • Black = black finish

Odoo BOM link in description

Included Hardware:

Step 4

Link to camera relocation install guide. https://gembadocs.com/stdop/pdf/54dc17995-172f442ab4e2-1774874372

Step 5



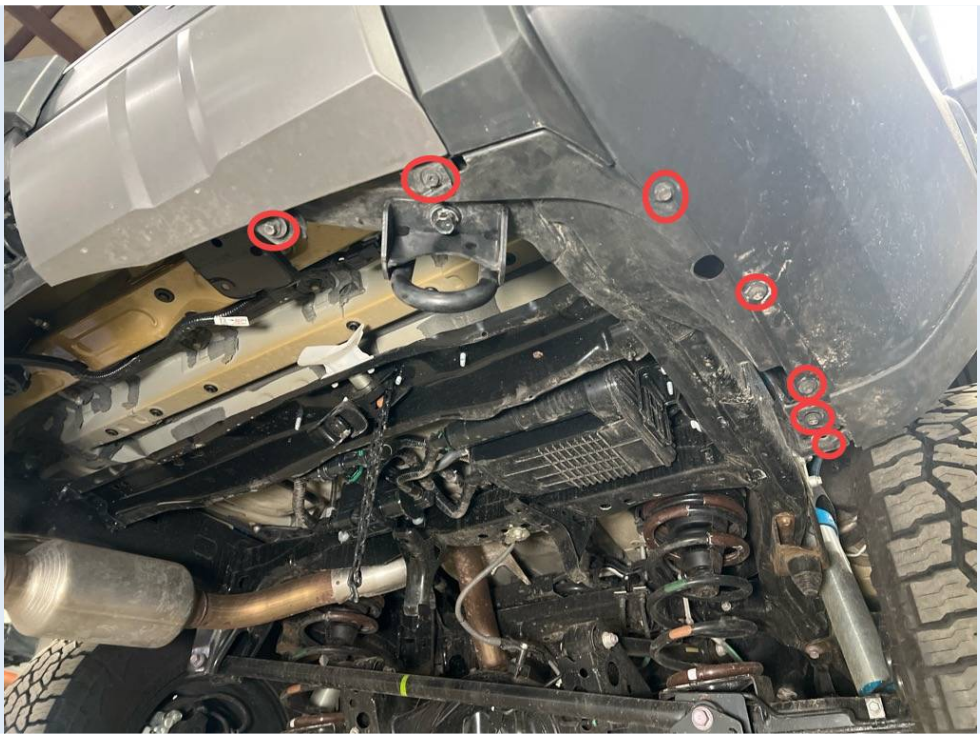
First, remove fasteners shown in the rear wheel well. There should be (7) fasteners in this area. They may be a 10mm hex head, a 4 mm allen head, or a push clip, depending on your year and model. Repeat on other side of vehicle.

Step 6



Remove the remaining two fasteners shown above located toward the top of the wheel opening. Repeat on other side of vehicle.

Step 7



Moving from the wheel well to the hitch, remove the (7) fasteners shown above. Repeat this on the other side of the vehicle.

Step 8



With the inner splash guard removed from the wheel well, remove the two square clips shown above. This is done by pinching them from the top side with pliers and working them out from below the vehicle.

Step 9



Remove the lower hitch cover by pulling straight backwards. Then remove the two clips shown above.

Step 10



With the upper hitch trim removed, remove the two clips shown above and remove the third hitch trim piece.

Step 11



Remove the top plastic tread plate from the factory fascia. This works best starting from the front corner, working your way across, then working backward.

Step 12



Next remove the rear sill trim using a plastic pry tool. Remove the upper pieces first just inside the tail lights, then the bottom pieces. The driver side overlaps the passenger side so it should be removed first.

Step 13



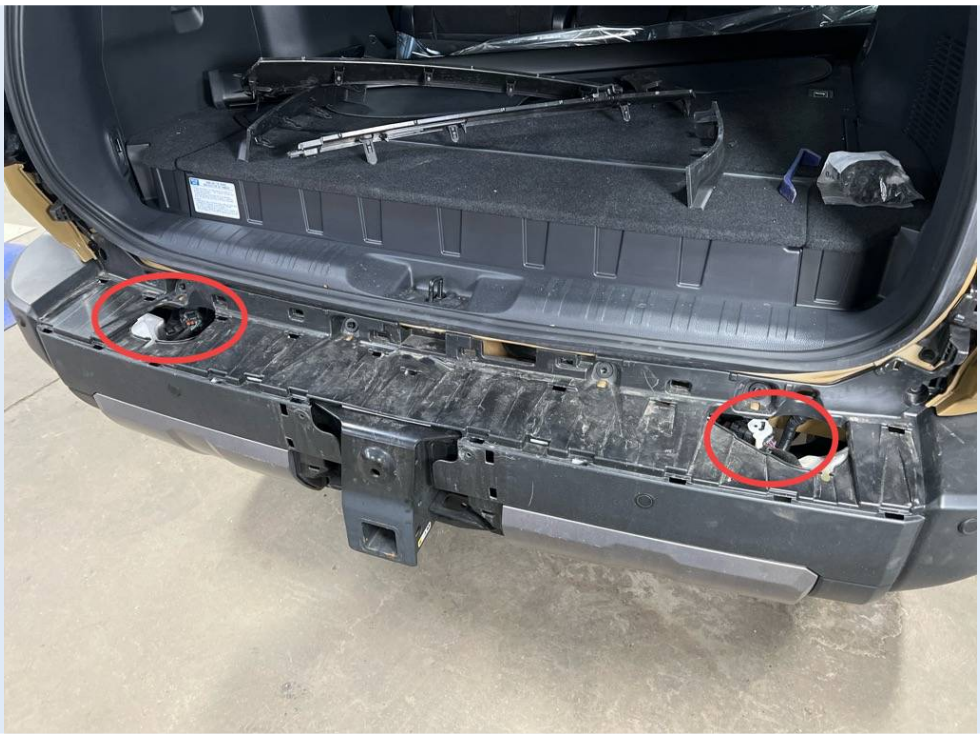
Remove the trim pieces under the tail lights by pulling them straight backwards from the rear of the vehicle. A plastic pry tool can make this process easier to get started. Repeat on the other side of the vehicle.

Step 14



With the sill trim removed, remove the (10) fasteners holding the rear fascia to the body using a 10 mm socket.

Step 15



Unplug the two harnesses shown above. There's should left harness is a simple push clip to separate, the right harness has a push clip and then a white lever that must be opened to remove the plug.

Step 16



Working from the bottom to the top, carefully pull the plastic fender flare away from the vehicle to release the clips until you can remove the flare.

Step 17



Remove the clip shown above. Repeat on the other side of the vehicle.

Step 18



With all the fasteners removed, the fascia can be removed by releasing the clips along the sides by pulling straight out at each wheel well and working your way to the back of the vehicle. The fascia will be completely removed in this step.

Step 19



Remove the remaining inner splash guards by removing the two clips shown above. Do this on both sides on the vehicle.

Step 20



Remove the impact foam from the top of the rear crossmember.

Step 21



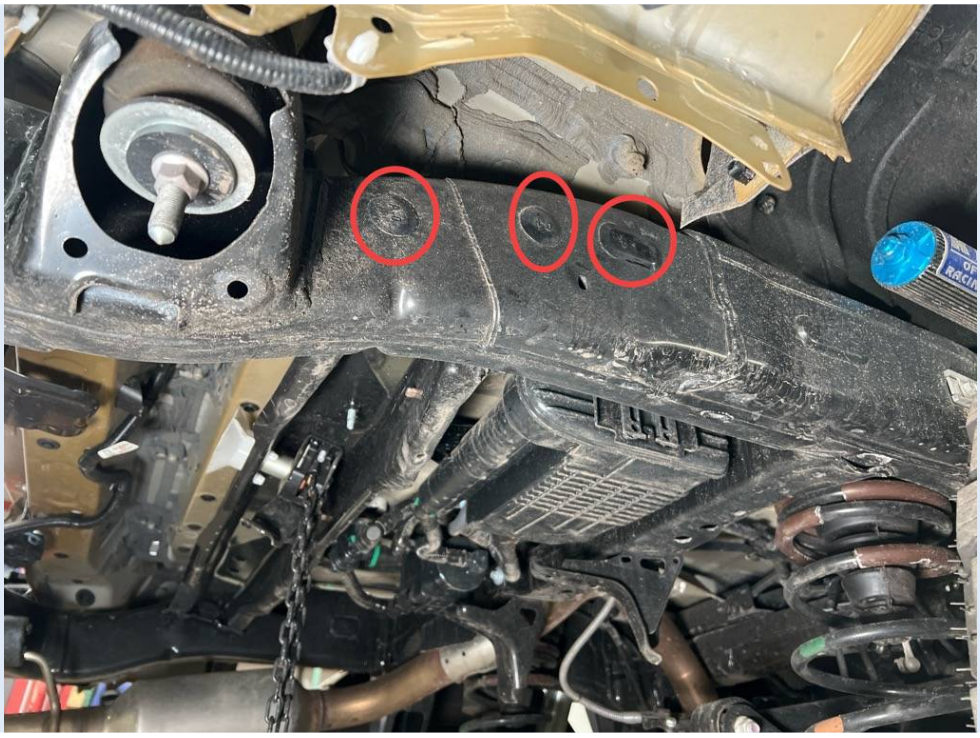
Using a 12 mm socket, remove the (5) fasteners per side to remove the crash bar brackets.

Step 22



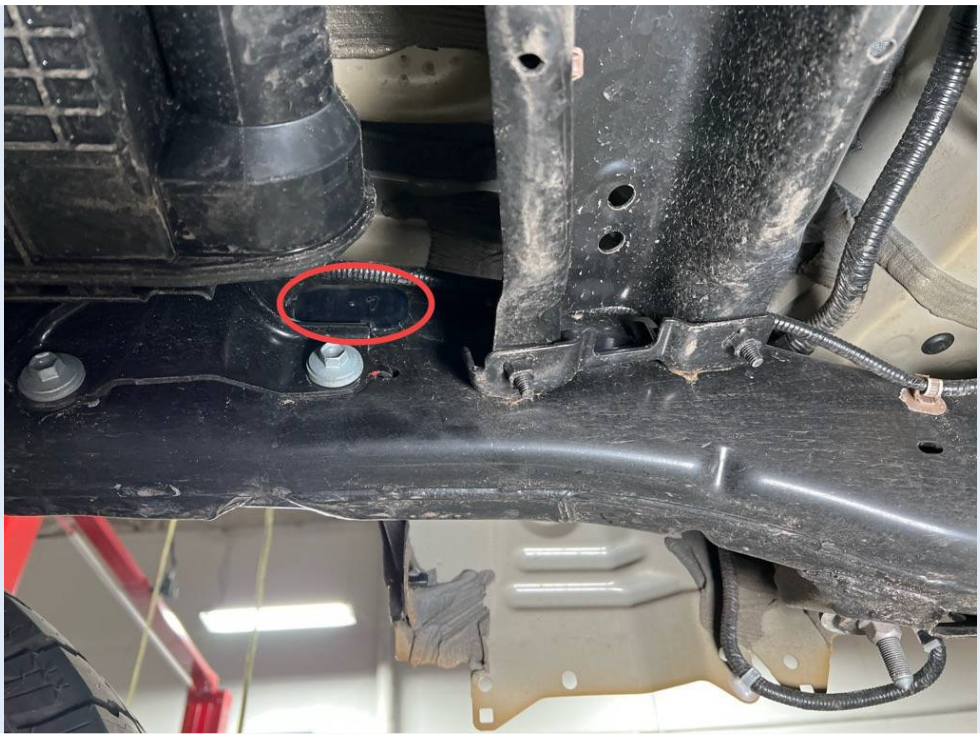
Using a 17mm socket, remove the factory tow point on the passenger side of the frame.

Step 23



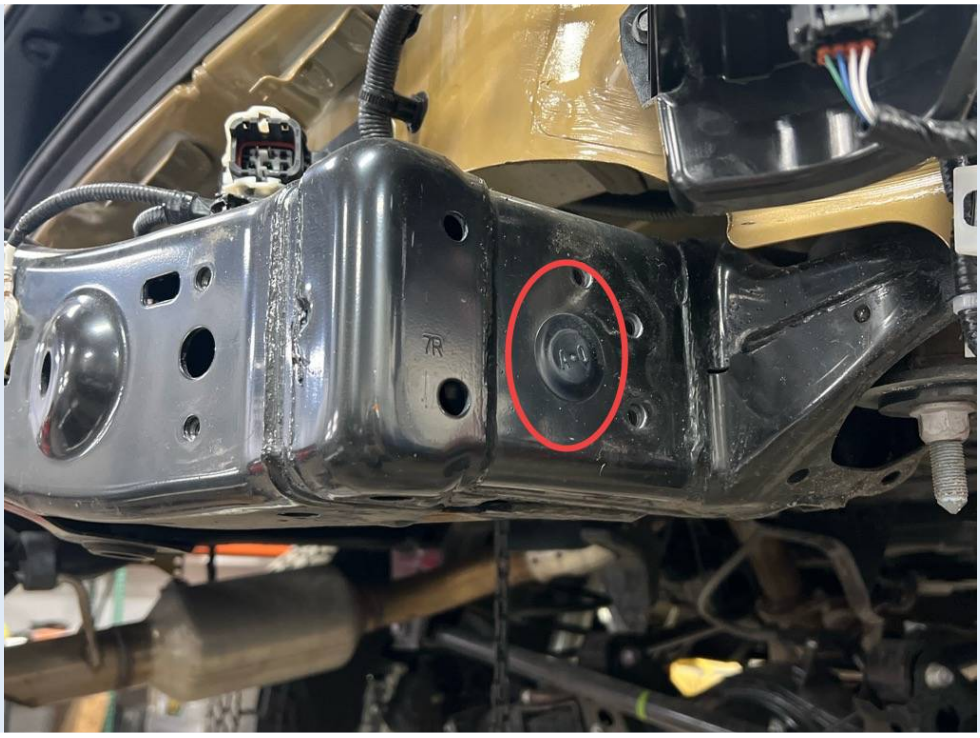
Remove the (3) plastic caps in the frame just ahead of the rear body mount. Repeat on the other side of the vehicle.

Step 24



Remove the large rectangle plastic cap inside the frame rail as shown above. Repeat on the other side.

Step 25



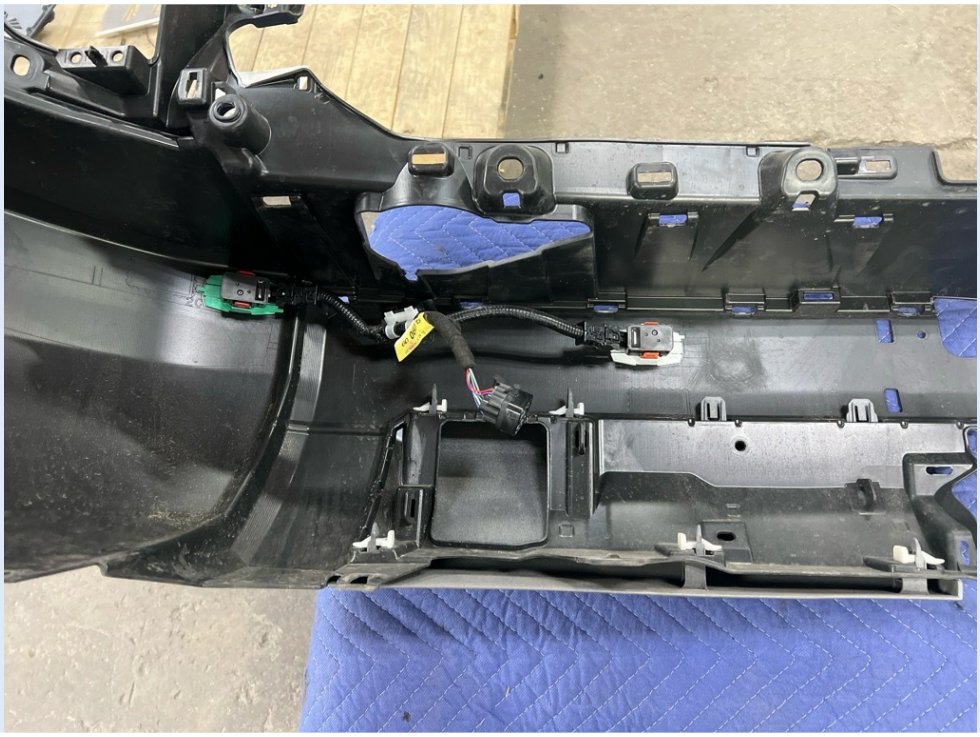
Remove the large plastic cap located behind the rear body mount, as shown above. Repeat on the other side.

Step 26



Remove the harness from the inside of the factory fascia by spreading the clips and carefully pulling rearward on the sensors. The antenna can be removed from the fascia using a pry tool to remove the oval shaped push connector.

Step 27



Remove the passenger rear sponsor harness from the factory fascia using the same method from the previous step.

Step 28



For the next step, locate the aluminum spacers and longer coarse thread screws from the hardware pack.

Step 29



Temporarily remove the (3) mounting fasteners for the blind spot monitor as shown above. You will be using the hardware from the previous step to space the brackets out on both sides.

Step 30



Using a 3/8" socket, fasten the blind spot monitor brackets back to the vehicle with the spacers as shown above. BE SURE to not overtorque these fasteners.

Step 31



Next, find the steel mounts labeled 1L and 1R. Place the mount onto the frame and loosely secure it in place using the provided M8 bolts as shown. Be sure to slip the spacer (labeled SP) between the outside of the frame and the inside of the mount and line the holes up. Repate on the other side.

Step 32



With the mounts loosely in place, use an angle finder to position the top of the mount so that it is parallel with the center of the frame. Tighten all bolts into place, making sure that the mount remains close to parallel throughout. This may require loosening and re-tightening some hardware to dial it in. Anything under half a degree will is fine.

Step 33



Grab the mounts labelled 2L and 2R. Loosely install the first one onto the frame as shown. Use the 1/2"-13 x 4-1/2" bolt to pass through the existing hole frame. Make sure to use a washer between the bolt head and mount on the outside and a square washer followed by a washer followed by a flange nut on the inside of the frame, in that order. Repeat on the other side.

Step 34



Using the supplied 1/4-20 button heads, washers, and flange nuts, install the provided blind spot monitor covers as shown above.

Step 35



With the mounts in place, the wings can be installed. Slide the wing over the top of mount 1. Loosely secure it in place using the 1/2" button head down through the top.

Step 36



Align the holes in the front of the wings with the holes in the mount 2 and loosely mount them together using more of the 1/2" button heads.

Step 37



Insert the provided 1/2"-13 x 6-1/2" bolt up through the bottom of the wing and frame with a washer on the head. Pass it through the frame and fasten a washer and nylock nut on top.

Step 38



A square hole is located near the mounting hole to help position the bump with, if necessary. A pry tool or screw driver can be inserted through that hole and into the frame to pry against and act as a guide to assist with installing the bolt.

Step 39



With all hardware loosely in the wing, adjust the position until it is satisfactory and then tighten the hardware. The main thing to keep an eye on prior to tightening is that the hole in the wing for the spindle is aligned with the hole in the spindle sleeve on mount 1. Repeat on the other side.

Step 40



With the wings in place slide the D-Ring through the slot from the inside and secure it using the 1/2"-13 x 2-1/4" bots and nylock nuts. Use a yellow washer on the head side as well as the nut side of the bolt. Make sure the D-Ring is centered vertically in the slot and then tighten the hardware fully. Repeat on the other side.

Step 41



Before installing the center section, mount the grey accent panel to the inside of the center shell as shown using the 5/16" hardware.

Step 42



Install the rubber grommets into each of the large holes in the bumper. There are two in the center section and one in each wing.

Step 43



Insert the back up sensors into the grommets on the center section as shown. Double check that each is on the correct side by comparing the connectors to the ones on the vehicle.

Step 44



Slide the center section onto the wings and install the 3/8" hardware to secure them together. Be careful to not clamp the harnesses for the back up sensors between the pieces of the shell. Center it on the vehicle and then tighten all hardware into place.

Step 45

The hardware through the top of the shell can be accessed from under the vehicle, over the top of the frame. The hardware through the access holes in the side of the bumper.

Step 46



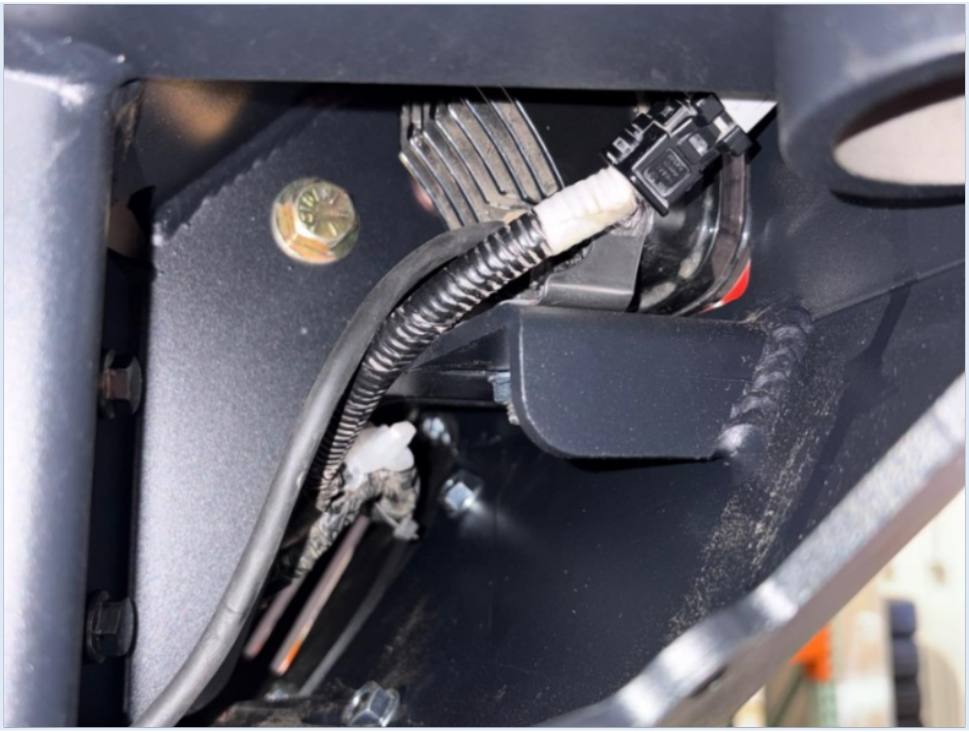
With everything in place, center punch the holes in the bottom of mount 2 and then drill them out to 7/16" to accept the 1/2 self tapping bolts. It is best to start with a smaller drill bit and work up to the 7/16". Repeat on both sides.

Step 47



Once the holes are drilled, install the 1/2" self tapping bolts and tighten them fully.

Step 48



Route the backup sensor under mount 1 and insert it into the grommet in the wing through the access hole as shown.

Step 49



With the bumper installed, now is the best time to install lights if doing so. Slide the light in through the back and mount it to the tab inside the bumper. The holes in the bumper are sized so that the majority of lights can be installed this way but it may be more difficult with some than others.

Step 50



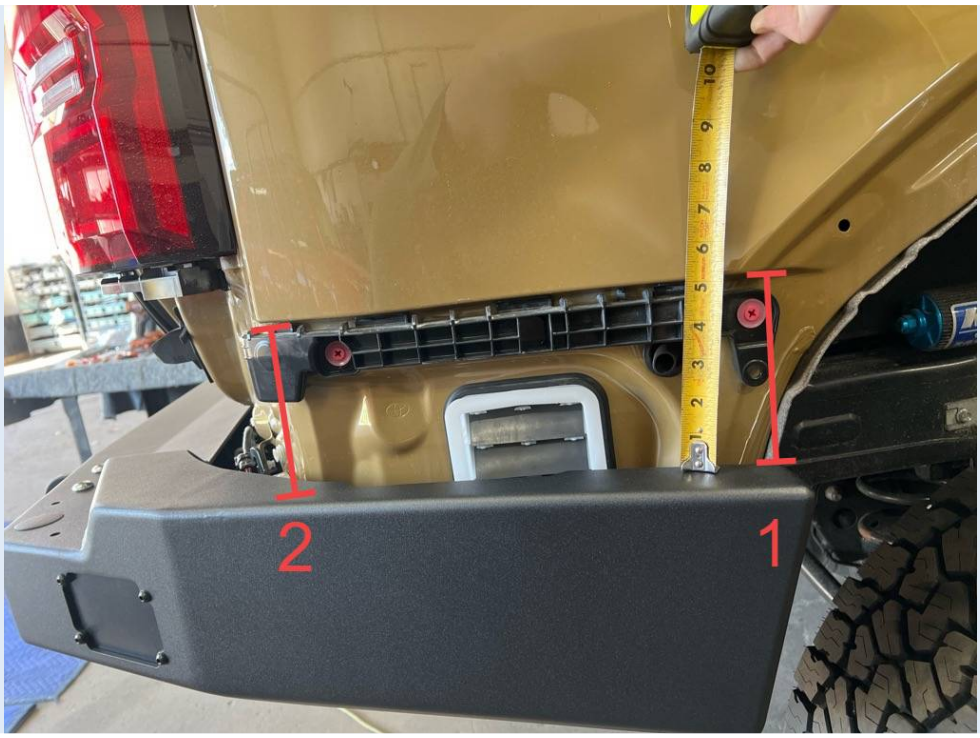
Once all hardware is tight and access to the inside of the bumper is no longer required, install the cover panels from the inside of the bumper using the 1/4" hardware as shown.

Step 51



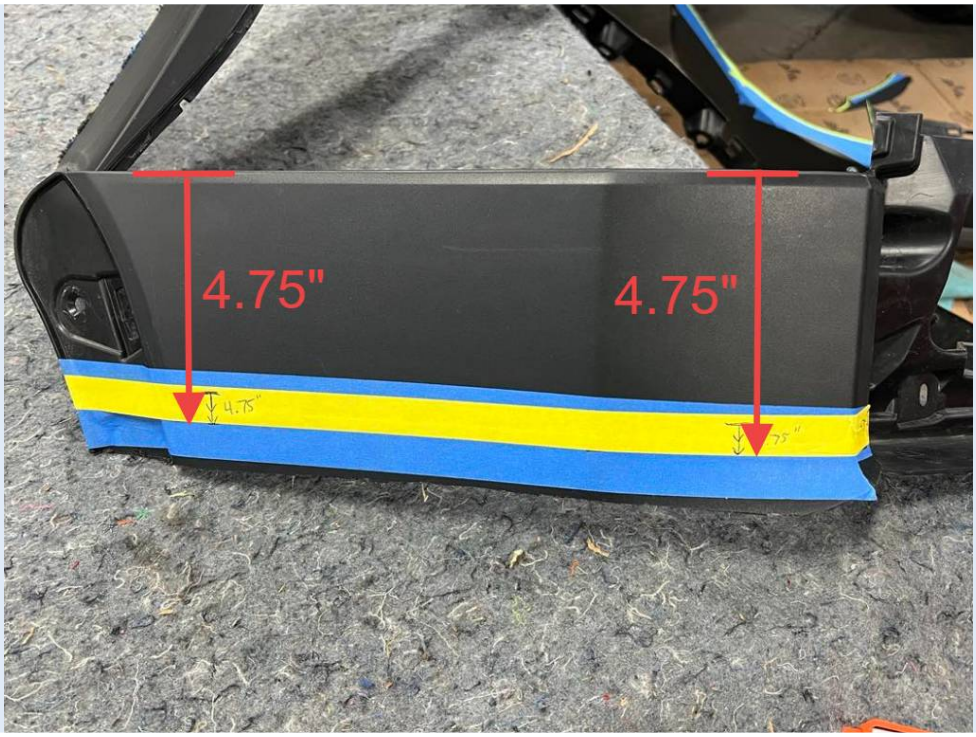
If not installing carriers, pop the plastic caps into the top and bottom of the spindle sleeve. It is best to put some RTV sealant on the caps prior to popping them in. This helps to protect the spindle sleeve from corrosion in case carriers are desired in the future.

Step 52



With the bumper installed and tightened properly, take measurements for cutting the plastic fascia. Start by measuring from the bumper to the body line on the vehicle at the front and rear of the wing. Repeat on the other side. It is not uncommon to have different measurements from side to side with vehicle variance!

Step 53



Layout the cut with masking tape as shown. This is when you will choose your body gap to the bumper. We recommend 3/8" as a starting point. Subtract your desired body gap from your measurements in the previous step and mark out your cut at the front and rear of each wing. Make sure you verify both sides of the vehicle, measure twice, cut once! NOTE: our measurement was 4.75" but yours may vary.

Step 54



Carry your side measurement around the corner and into the area where the trim panel installs underneath the tail light. NOTE: our measurement was 4.75" but yours may vary.

Step 55



Starting from the circle in the photo above, follow the cut line as shown by the arrows. The important information here is that you KEEP all the mounting locations that run along the bottom of the hatch.

Step 56



Snap the fascia back onto the vehicle and check your cuts. This may require some trial and error. Remember, you can always cut more, but you can't put any back on if you cut too much. We are looking for a minimum of 3/8" here to account for body flexing and movement.

Step 57



Once you are happy with your fitment, install the fascia with the factory hardware. You should have one push clip per side under the fender flare, three coarse thread fasteners under the tail light, and four machine screws along the bottom of the hatch.

Step 58



Reinstall the plastic covers under the tail lights.

Step 59



Before reinstalling the plastic sill trim, you must trim the tab off from the right lower piece cut at the red line shown above.

Step 60



Reinstall the (4) sill trim pieces.

Step 61



Before re-installing the fenders, they must be cut at the red line shown above. Due to the complexity of measuring this cut, we just recommend partially snapping it back onto the vehicle and then marking the cut to maintain your body gap to the bumper. Your cut should be somewhere near the bottom of the rear most mounting tab. Be sure to keep that tab connected for mounting.

Step 62

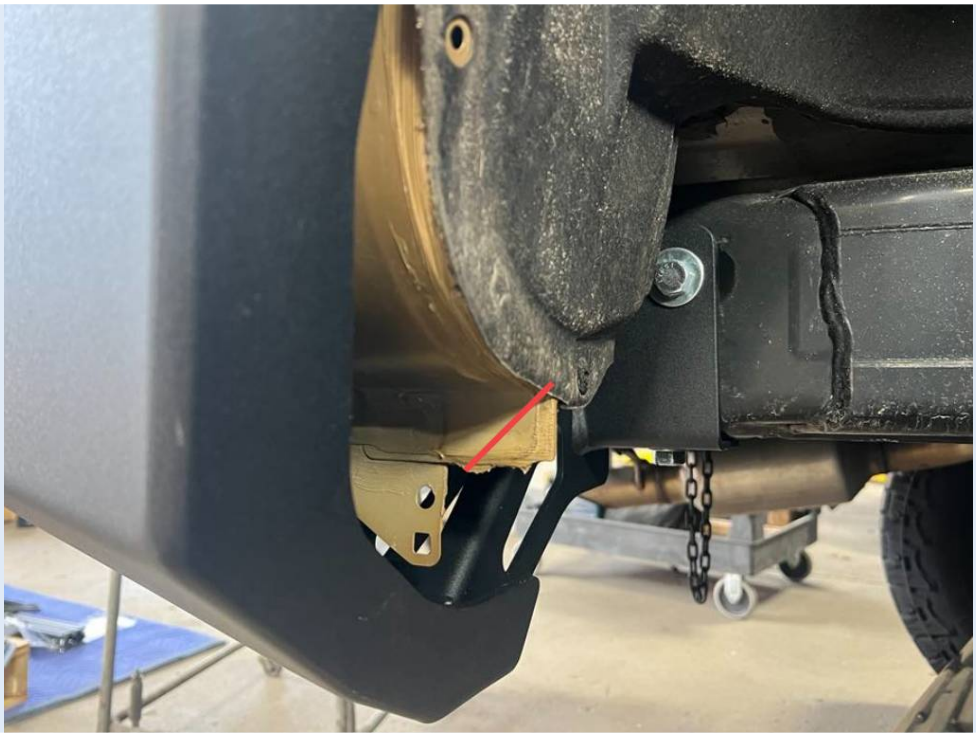
Once the fender is cut appropriately, reattach it to the vehicle with the snaps and the three push clips you removed earlier. Repeat on the other side of the vehicle.

Step 63



Before reinstalling the plastic splash guard, cut the bottom as shown. Be sure to hold the piece up before you cut and leave enough material for it to tuck inside the bumper.

Step 64



Before installing the splash guards, the pinch weld must be bent or cut to provide clearance. Remove the material as shown above.

Step 65



Reinstall the splash guards using the factory hardware in the two locations shown above.

Step 66



Confirm all hardware is tightened. Congrats! Your installation, is now complete. Enjoy!