



# INSTALLATION INSTRUCTIONS TRANS4MER MOUNTING SYSTEMS

Part No. 29757 (black)

Part No. 65655 (stainless)

For Ford F-Series Trucks

As you read these instructions, you will see **NOTES**, **CAUTIONS** and **WARNINGS**. Each message has a specific purpose. **NOTES** are additional information to help you complete a procedure. **CAUTIONS** are safety messages that indicate a potentially hazardous situation which, if not avoided, may result in minor or moderate injury. A **CAUTION** may also be used to alert against unsafe practice. **WARNINGS** are safety messages that indicate a potentially hazardous situation, which, if not avoided could result in serious injury. **CAUTIONS** and **WARNINGS** identify the hazard, indicate how to avoid the hazard, and advise of the probable consequence of not avoiding the hazard. **PLEASE WORK SAFELY!**

## **WARNING**

USE EXTREME CAUTION WHEN DRILLING ON ANY VEHICLE. MAKE SURE THAT ALL FUEL LINES, BRAKE LINES, ELECTRICAL WIRES AND OTHER OBJECTS ARE NOT PUNCTURED OR DAMAGED WHEN/IF DRILLING ON THE VEHICLE. THOROUGHLY INSPECT THE AREA TO BE DRILLED (BOTH INBOARD AND OUTBOARD SIDE OF FRAME) PRIOR TO DRILLING, AND RELOCATE ANY OBJECTS THAT MAY BE DAMAGED. FAILURE TO INSPECT THE AREA TO BE DRILLED MAY RESULT IN VEHICLE DAMAGE, ELECTRICAL SHOCK, FIRE, OR PERSONAL INJURY.

## **WARNING**

WEAR SAFETY GLASSES WHEN INSTALLING THIS KIT.

**NOTE:** Please read these instructions thoroughly before starting installation of this kit. Minor modifications may be required due to variations between vehicles.

## PART LIST

<u>PART NO.</u>	<u>QUANTITY</u>	<u>DESCRIPTION</u>
29759	2	Side Member (Black)
65648	2	Side Member (Stainless)
29365	1	1-1/2" Tube (Black)
29366	1	2-1/2" Tube (Black)
63688	1	1-1/2" Tube (Stainless)
60326	1	2-1/2" Tube (Stainless)
29761	1	Frame Extension (R.H.)
29762	1	Frame Extension (L.H.)
29989	1	Reinforcing Strap (R.H.)
29990	1	Reinforcion Strap (L.H.)
28653	2	Reinforcing Angle

This **WARN Trans4mer system** can be customized to give your F-series Ford pickup a wide variety of looks, front end protection and winch mounting capability. The system starts with this strong two-tube grille guard that attaches to the truck's frame with brackets designed by Warn engineers to handle up to a 12,000 lb winch. It is durable and good looking, even as a stand alone grille guard, but can be easily upgraded with some great options! You can add a third large size tube (light bar) that adds even more protection and includes tabs for mounting auxiliary lights. The tubes can be mounted in a variety of positions to achieve the look and function that you desire. You can mount a winch carrier bracket that provides a permanent mount for a Warn winch. You may also add a receiver bracket that will handle the Warn Multi-mount winch system, a draw bar or any other accessory that fits the standard 2 inch receiver tube. Finally, brush guards that protect the headlights and front corners of the truck that can be easily added to any of the options above.

**WARN PART NUMBERS FOR AVAILABLE OPTIONS**

29395	Light Bar Kit, (black)
63325	Light Bar Kit (stainless)
29394	Winch Carrier Kit
30030	Winch Carrier Kit
29397	Receiver Kit (black only)
29781	Brush Guard Kit (black)
65873	Brush Guard Kit (stainless)

**TORQUE SPECIFICATIONS**

<b><u>BOLT SIZE</u></b>	<b><u>TORQUE TO</u></b>
3/8 inch	30 lb. ft. (40.7 N-M)
7/16 inch	50 lb. ft. (67.8 N-M)
1/2 inch	75 lb. ft. (101.7 N-M)

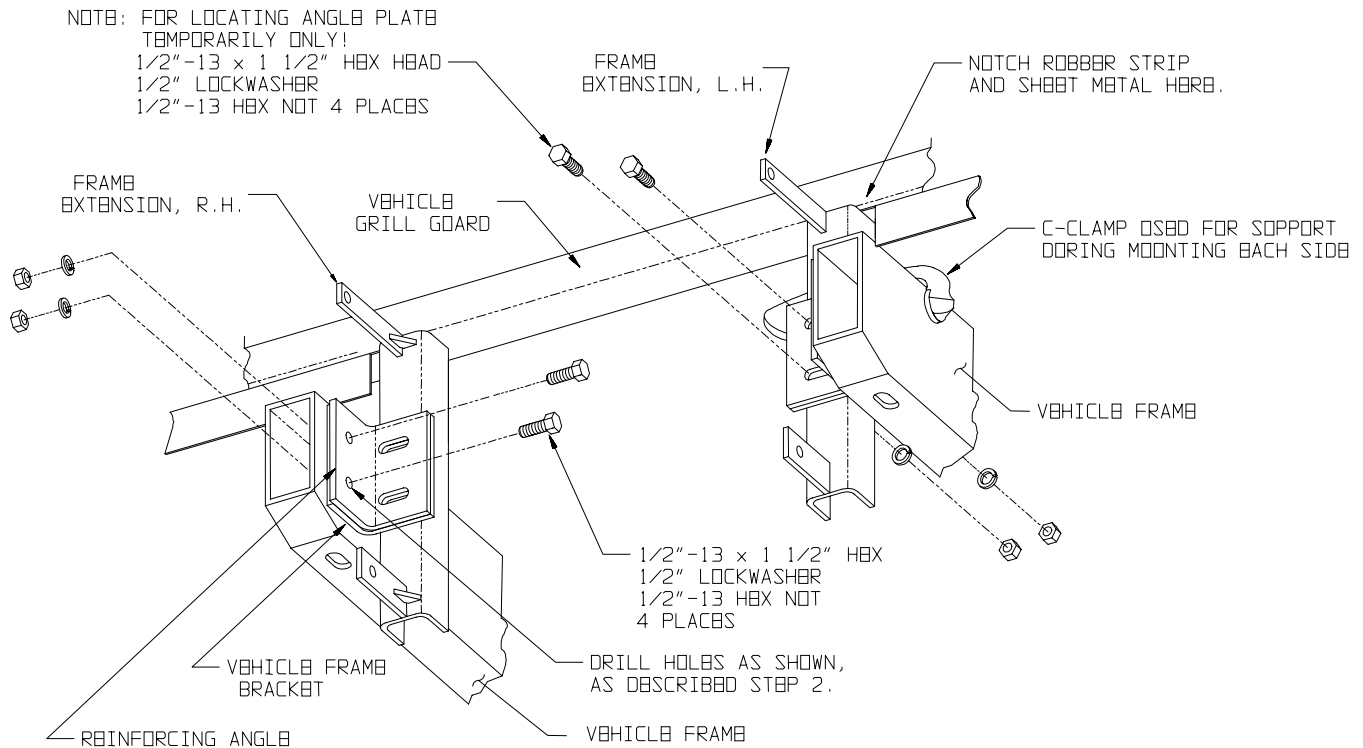
**▲WARNING** Never fasten parts to this kit in a position that will interfere with or damage brake lines, electrical wires, fuel tank or other objects. Damage to vehicle brakes, electrical system, or other systems may occur if brackets are installed improperly, resulting in serious injury. Tighten all fasteners securely.

1. Remove the factory bumper. Remove the retaining clips from the factory bolts. These will be replaced by fasteners supplied with the Trans4mer.
2. Align the slots in the reinforcing angles with the slots in the vehicle frame brackets where the bumper attaches. Bolt the reinforcing angle to the frame. Drill two 1/2" holes in each frame using the round hole in the reinforcing angles as guides. Install the 1/2" x 1-1/2" bolts through the drilled holes and torque to the specifications shown on the chart, Remove the bolts used to hold the reinforcing angle in place. As shown in **Figure 1**.

	<b><u>WARNING</u></b>
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Drilling operations can cause flying chips. **WEAR SAFETY GOGGLES.** Flying chips can cause eye injury.



**FIGURE 1**

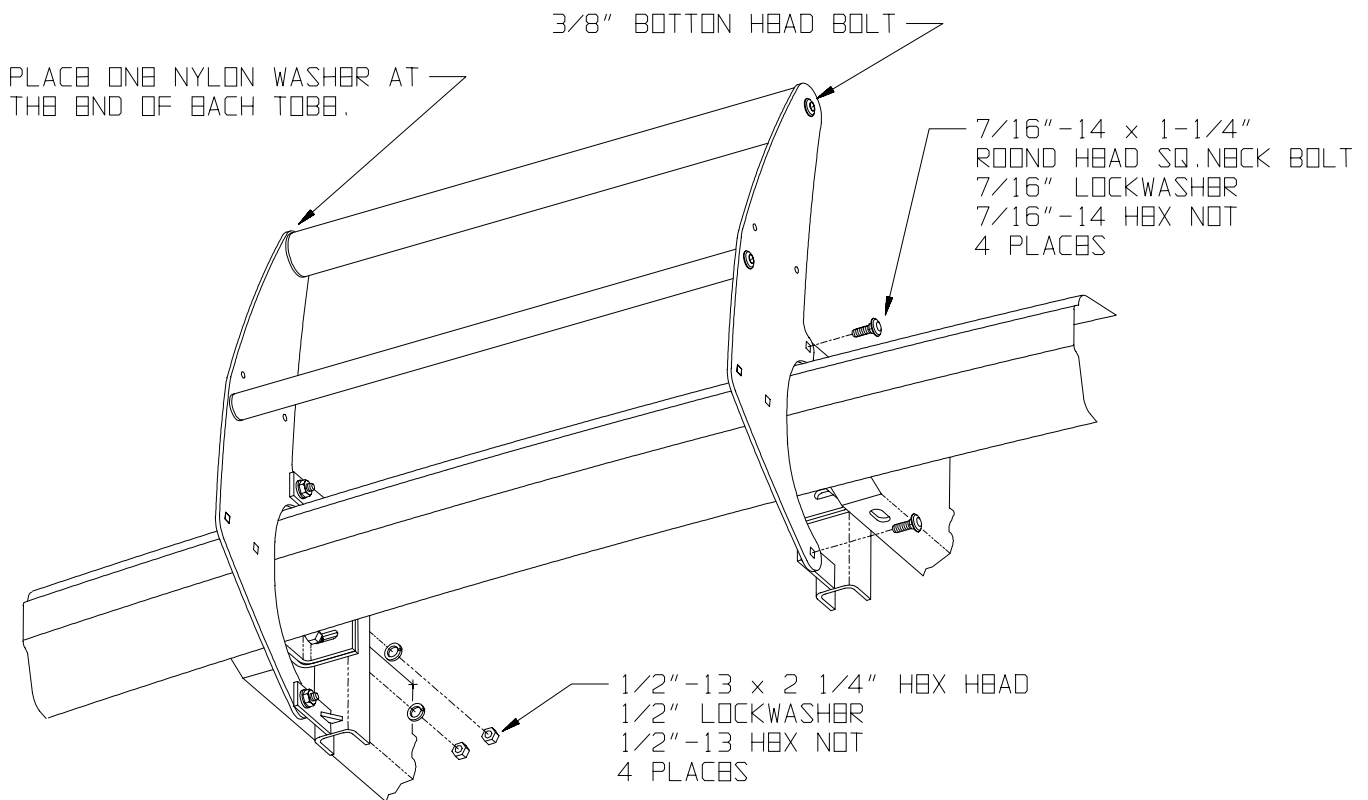
6. Identify the right and left hand frame extension, Note: that the reinforcing gussets are to the inside of the frame extensions, and the shorter wider tab is on the bottom of the frame extensions. As shown in **Figure 1**. Hold the frame extension behind the vehicle frame brackets and against the frame. Mark the rubber strip below the grille at the outside of the frame extension. Notch the rubber strip and the sheet metal to allow the top of the frame extension to be raised to the lower horizontal surface of the grille. As shown in **Figure 1**.
4. Measure the distance between the slots in the left and right hand brackets attached to the back side of the bumper. It should be approximately 30-3/4". Clamp the frame extensions to the vehicle frame as shown in **Figure 1**. Shims may be required to match the distance between vertical slots in the frame extensions and the slots in the bumper.

**NOTE: Stainless Steel Kits**

Nylon washers are **not** used between the Side Members and Grille Guard Tubes shown in **Figure 2** Stainless 7/16" button socket head bolts are used in place of round head square neck (carriage) bolts shown in **Figure 2**

7/16" lock nuts are used instead of 7/16" hex nuts and lock washers listed in **Figures 2 and 3**

Stainless 7/16" hardware is provided to replace the winch carrier carriage bolts and hardware listed in **Figures 3 and 4**



**FIGURE 2**

5. Reinstall the factory bumper. (NOTE: Your vehicle may be equipped with a factory air dam that must be slotted so the lower tabs of the frame extensions can extend through it.) Hold the bumper up to the vehicle to determine where to make slots, mark both locations on back of the air dam, then remove bumper and slot the air dam.) Then attach bumper to the vehicle using the four 1/2" x 2-1/2" bolts provided. These bolts must pass through the bumper brackets, reinforcing angle, vehicle frame brackets and the frame extensions as shown in **Figure 2**. **Do not torque the fasteners at this time.**

**NOTE:** this process may require assistance from another individual or a lift device to stabilize parts during installation.

6. Assemble the side members to the upper and lower grille guard tubes using the 3/8" button head bolts and the nylon washer (which are placed between the tubes and side members on Black Kits only – nylon washers are not used on Stainless Kits) as shown in **Figure 2**. **Do not torque the fasteners at this time.**

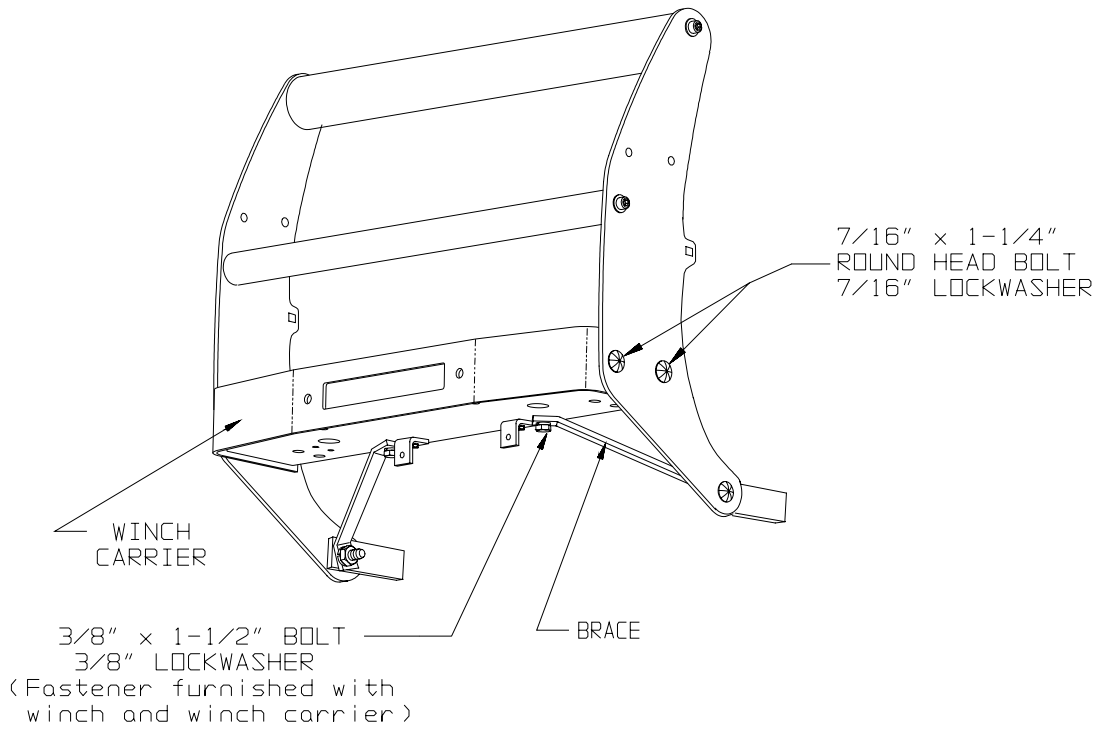
**NOTE: IF YOUR APPLICATION INCLUDES WINCH OR BRUSH GUARDS, REFER TO THE INSTRUCTIONS FOR THOSE KITS NOW! IF NOT CONTINUE WITH #7.**

7. Attach Trans4mer system to frame extension as shown in **Figure 2**.

8. All fasteners may now be tightened to the torque specifications on page 1.

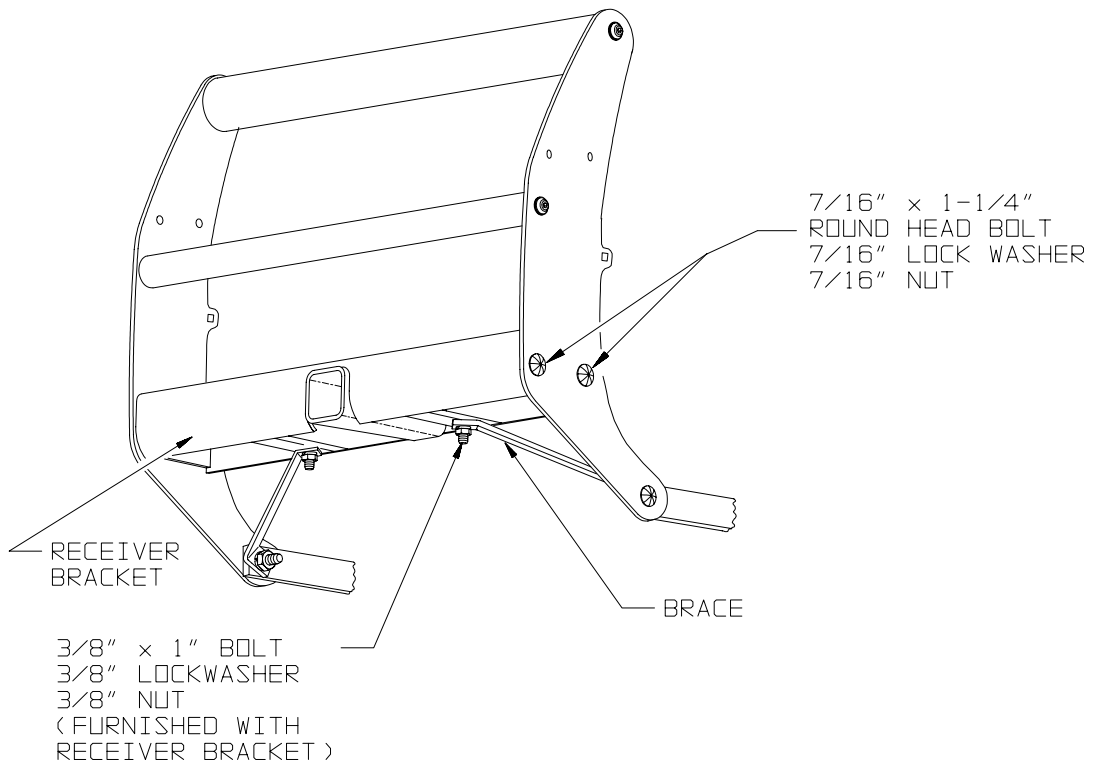
**NOTE:** The two braces (bent parts approximately 14 inches long) are to be used only when mounting a winch. Be sure to save them if a winch is not being installed now, but will be installed in the future.

9. If a winch carrier is being mounted, install the braces as shown in **Figure 6**.



**Figure 6**

10. If the Receiver Kit is being mounted, install the braces as shown in **Figure 7**.



**Figure 7**

## **Stainless Steel Truck Accessories**

### **What to expect:**

Polished stainless steel combines the beauty of a chrome-like appearance with extreme durability and corrosion resistance. With a minimum amount of care, the appearance will last almost indefinitely. Unlike platings or coatings, there is nothing to peel off or wear away that would allow corrosion underneath.

The actual appearance may not be exactly like new chrome in either the degree of luster or color. There may be fine polishing lines visible up close and small differences between mating parts of an assembly. A grille guard, for instance, may have small differences between the round tubing and the flat plate. The backside of a part may not be as highly polished as the front. However, part of the beauty and appeal of stainless actually lies in the smooth “hand-worked” appearance.

There also is a possibility that small rust spots can appear on stainless products. They are usually due to minor iron contamination on the surface as a result of normal manufacturing and handling processes. This minor rust, if it occurs at all, is easy to remove and will not tend to spread.

### **Recommended care:**

Regular washing with fresh water and mild car wash detergents followed by rinsing and drying with a soft towel is the best minimum care. Beyond that, any cleaner/wax recommended for automotive finishes will work well to remove minor stains and scuffs, enhance the shine and provide protection. Always use clean soft cotton cloths. In most cases, this will be all that is required for many years. For more serious blemishes or a rust spot, use a cream metal polish recommended for stainless, aluminum, etc. Try to rub in the direction of the original polishing lines. Ultimately, any stainless part can be restored to a brilliant shine with power buffing processes.

### **Caution:**

Do not use steel wool or any type of metal scraper. Do not use “Scotch Brite” pads or abrasive powdered cleaners. Do not try to clean with muriatic acid or any other acid.

### **Stainless Fasteners**

Stainless steel fasteners are included in many of the stainless kits. These fasteners provide similar corrosion resistance and appearance as the rest of the kit. However, stainless fasteners are prone to galling when installed in similar stainless material. It is a good idea to apply a small amount of anti-seize compound to the threads when installing them. Care should also be taken when tightening the fasteners to prevent rounding or deforming the corners of the bolts. Make sure the wrenches are the correct size and fit properly. In the case of socket heads, the wrench should have sharp, un-worn edges. With a few precautions during assembly the products should provide years of service.