



# INSTALLATION INSTRUCTIONS

## Trans4mer Grille Guard/Winch Mount For Toyota Tundra Kit 68505

This WARN Trans4mer system can be customized to give your Toyota Tundra 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 to handle up to a 9500 lb. winch. It is durable and good looking 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. An accent cover is available to dress up the winch carrier. 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 can be easily added to any of the options above.

### **▲WARNING**

***ALWAYS 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**

***ALWAYS COMPLETE EVERY STEP OF THE INSTRUCTIONS AS SPECIFIED. NOT DOING SO MAY RESULT IN VEHICLE DAMAGE, PERSONAL INJURY, OR DEATH.***

### **▲WARNING**

***ALWAYS WEAR SAFETY GLASSES WHEN INSTALLING THIS KIT.***

### PARTS LIST

<u>PART NO.</u>	<u>QUANTITY</u>	<u>DESCRIPTION</u>
70552	2	Side Member, Black
29366	1	Grille Guard Tube, 2-1/2", Black
29365	1	Grille Guard Tube, 1-1/2", Black
68363	1	Frame Extension, RH
68364	1	Frame Extension, LH
68365	2	Clamp
68507	1	Strap Assembly, RH
68508	1	Strap Assembly, LH
68504	2	Strap Extension
39202	2	Nut w/Handle
29146	2	Plastic Washer, 1-1/2"
29147	2	Plastic Washer, 2-1/2"

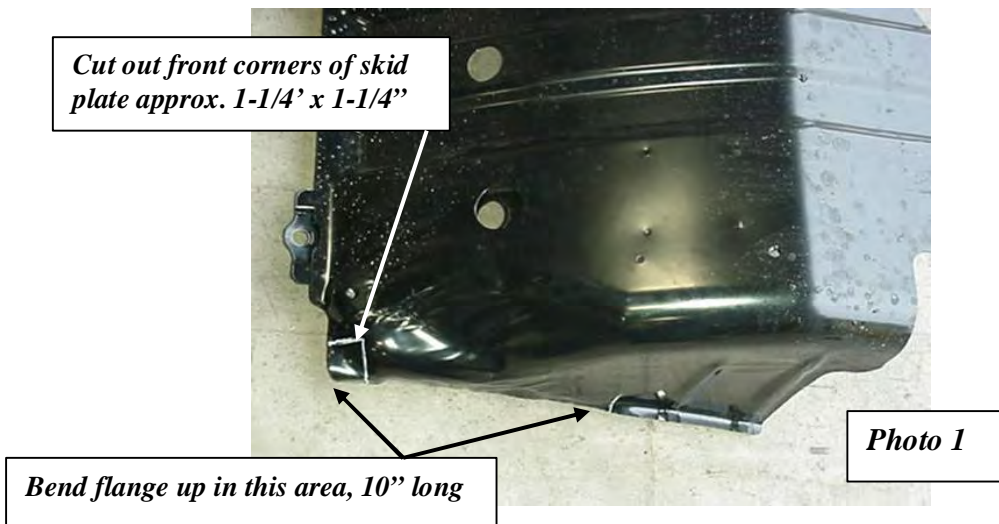
## TORQUE SPECIFICATIONS

BOLT SIZE	TORQUE
3/8 inch	30 lb. ft (40.7 N-m)
7/16 inch	50 lb. ft. (67.8 N-m)
M12	58 lb. ft. (78.7 N-m)

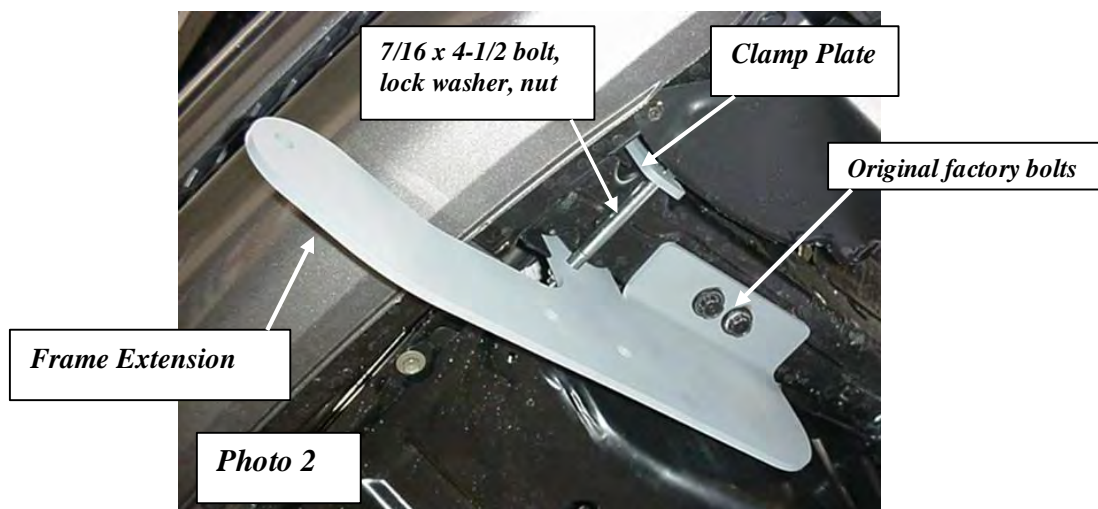
**NOTE:** This installation requires hole drilling. Make sure you have a drill motor and a sharp 7/16" drill bit available. Wear safety goggles.

**NOTE:** Follow the instructions step by step for fastest installation. Do not securely tighten fasteners until directed to do so.

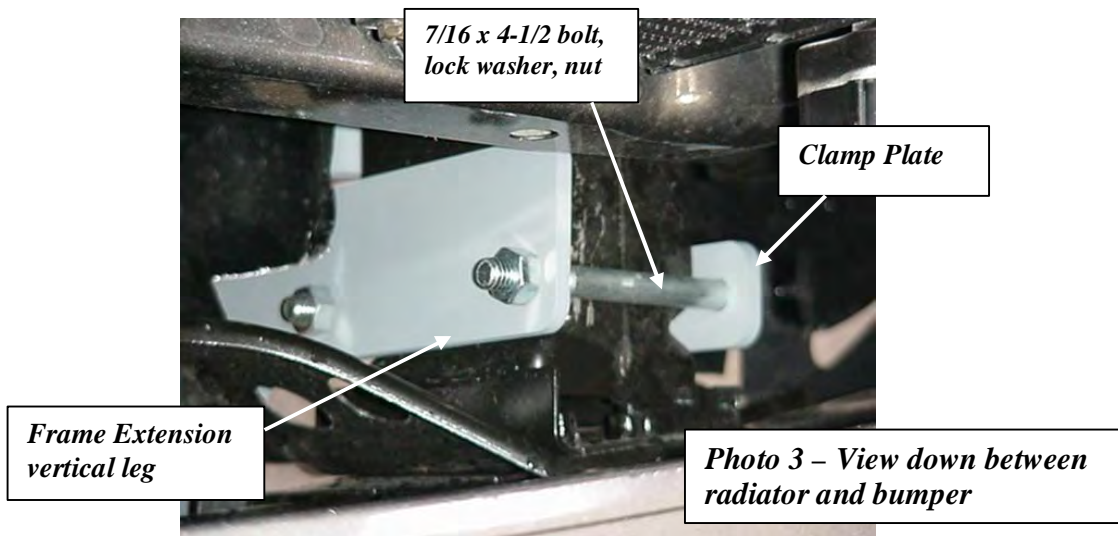
1. Remove the tow hook and the tie down loops from the bottom of the frame. Also remove the sheet metal skid pan. Remove the front license plate if one is mounted.
2. On the skid pan, bend up the side flanges as shown in **Photo 1**. Also cut out the front corners as shown. The cut out area should measure approximately 1-1/4" x 1-1/4". Reinstall the skid pan.



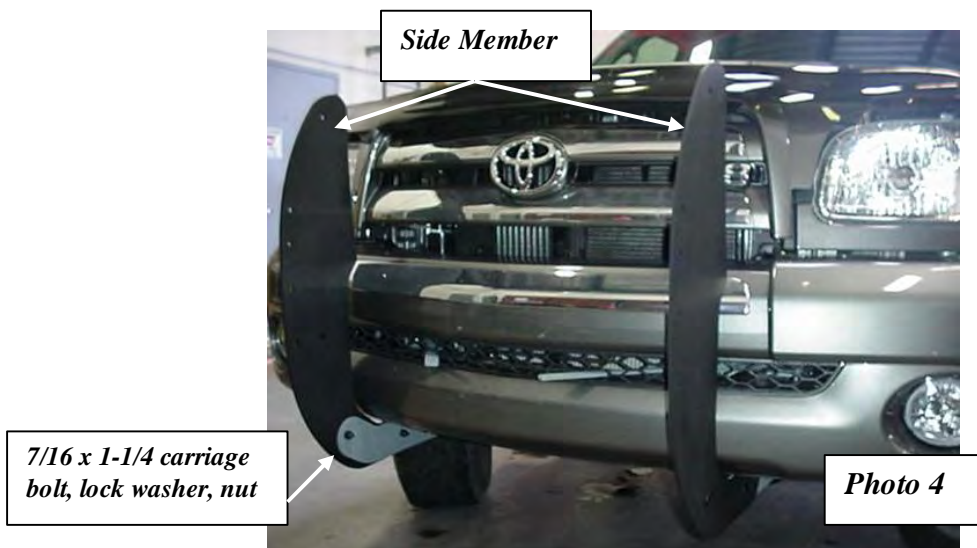
3. Install the Frame Extensions to the bottom of the frame as shown in **Photo 2**. Use the original factory bolts and reinstall the tow hook on the passenger side. Do not reinstall the tie down loops. Be sure that the vertical tab is tight against the inside surface of the frame and adjust the forward ends to be 32" apart over their outside surfaces. Tighten the bolts securely.



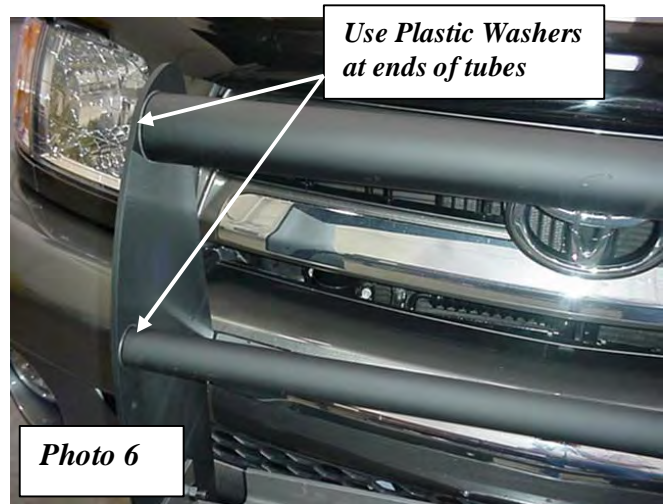
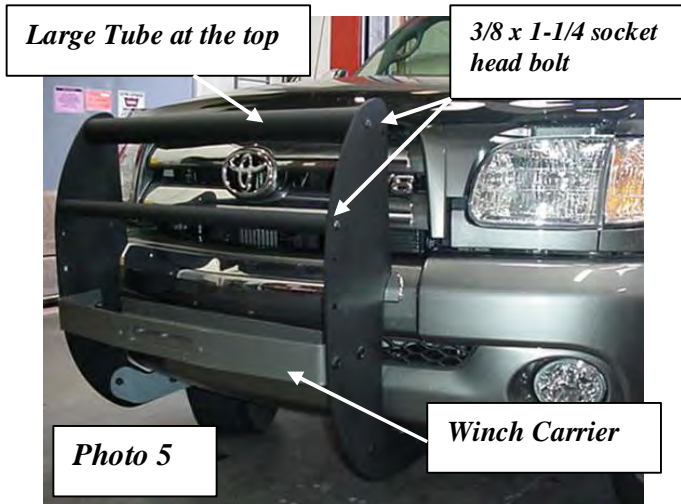
4. Install the Clamp Plates to the outsides of the frame using the 7/16 x 4-1/2" bolts, one over the top of the frame and one under the frame. Tighten securely. See **Photo 3**.



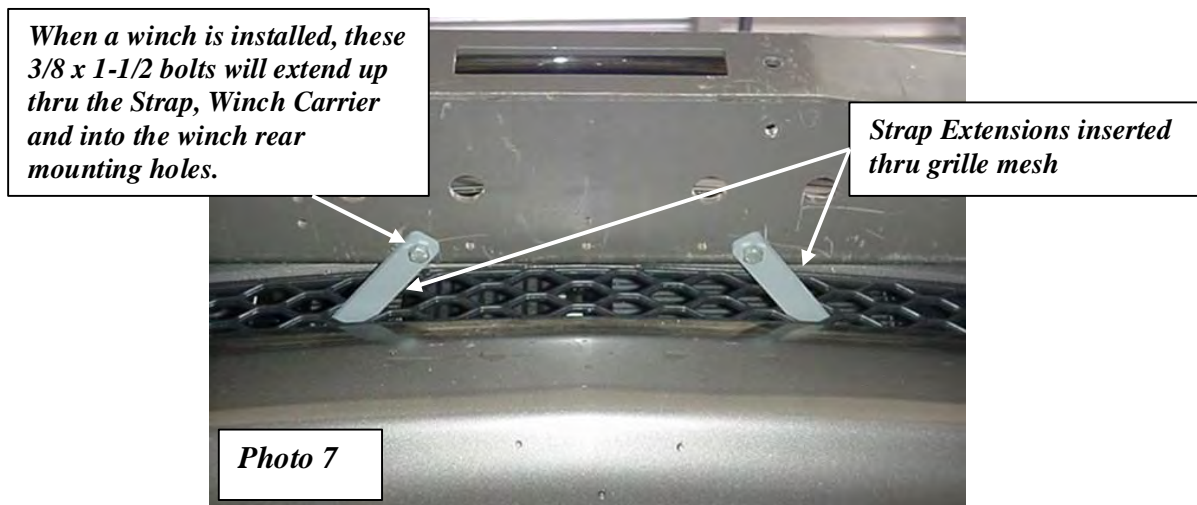
5. Install Side Members on outsides of Frame Extensions as shown in **Photo 4**. Leave bolts slightly loose.



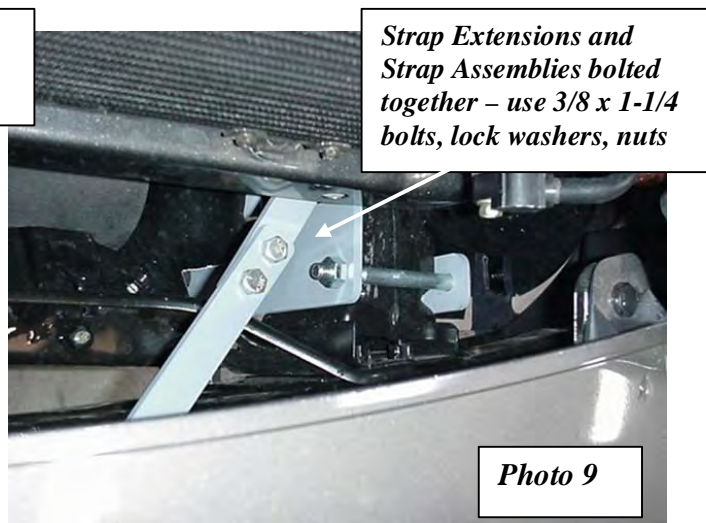
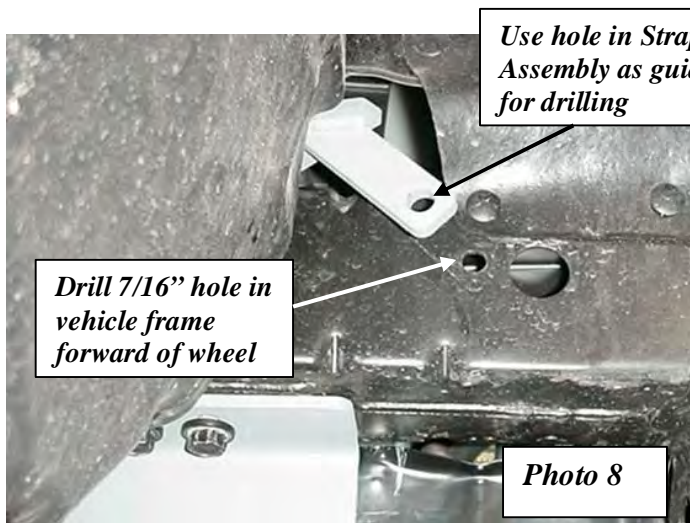
6. Install Upper Tube and the Winch Carrier (if being used). **Photos 5 & 6.** Do not install the Lower Tube until after the winch is installed (step 11 & 12).



7. Insert Strap Extensions thru the mesh in the lower grille and line up the single hole end with the rear winch mounting holes in the Carrier as shown in **Photo 7**.



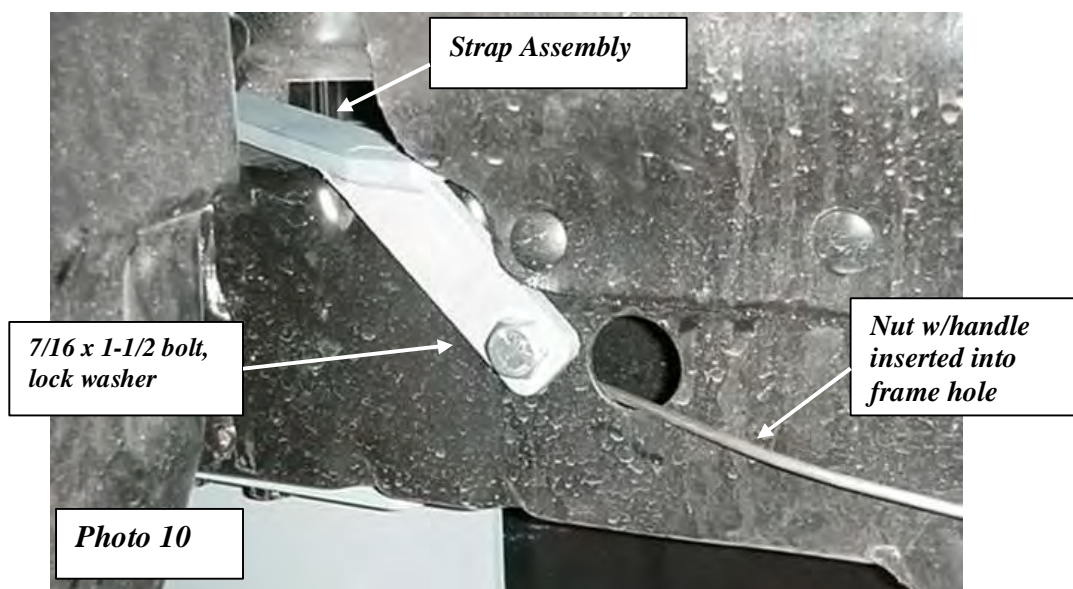
8. Working in the engine compartment, insert the Strap Assemblies thru the small space on either side of the radiator just above the frame rail. Rotate the tail piece down so that it lies against the outside of the frame just forward of the large hole in the frame. This is inside the wheel well, see **Photo 8**. In the space between the radiator and the bumper, bolt the Strap sections together. The forward section should lie on top of the rear section. See **Photo 9**.



9. After the Strap sections are bolted together and to the Carrier, pull them back and position the tail section down tight against the frame. Mark the frame for drilling and drill a 7/16" hole.

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

10. Install the Nut With Handle thru the large hole in the frame. Bend the wire into a gentle "s" shape to help make the nut lie flat against the inside of the frame. Secure the tail section of the Strap Assembly to the frame with the 7/16" x 1-1/2" bolt and lock washer as shown in **Photo 10**. Cut off the excess length from the wire handle.



11. Install the winch (if applicable) referring to the instructions packaged with the winch.
12. Install the lower Grille Guard Tube as shown in **Photos 5 & 6**. Tighten all fasteners securely.