



# INSTALLATION INSTRUCTIONS TRANS4MER KIT

Part Number: 71250

Application: Toyota Tacoma 4wd

Your safety, and the safety of others, is very important. To help you make informed decisions about safety, we have provided installation and operating instructions and other information on labels and in this guide. This information alerts you to potential hazards that could hurt you or others. It is not possible to warn you about all potential hazards associated with this product, you must use your own good judgment.

**CARELESS INSTALLATION AND OPERATION CAN RESULT IN SERIOUS INJURY OR EQUIPMENT DAMAGE. READ AND UNDERSTAND ALL SAFETY PRECAUTIONS AND OPERATING INSTRUCTIONS BEFORE INSTALLING AND OPERATING THIS PRODUCT.**

This guide identifies potential hazards and has important safety messages that help you and others avoid personal injury or death. **WARNING** and **CAUTION** are signal words that identify the level of hazard. These signal words mean:

**WARNING** signals a hazard that could cause serious injury or death, if you do not follow recommendations.

**CAUTION** signals a hazard that may cause minor to moderate injury, if you do not follow recommendations.

This guide uses **NOTICE** to call attention to important mechanical information, and **Note**: to emphasize general information worthy of special attention.

## **WARNING**

### **INJURY HAZARD**

**Failure to observe these instructions could lead to severe injury or death.**

- Always** remove jewelry and wear eye protection.
- Never** lean over battery while making connections.
- Always** insure components will remain secure during installation and operation.
- Always** tighten all nuts and bolts securely, per the installation instructions.
- Always** replace all worn or damaged parts before operating.
- Never** operate this WARN product with damaged or missing parts.

## **Caution**

### **Moving Parts Entanglement Hazard**

**Failure to observe these instructions could lead to minor or moderate injury.**

- Always** take time to fully read and understand the installation and Operations Guide included with this product.

**Read installation and operating instructions thoroughly.**

## **Notice**

### **Equipment Damage**

- Always** refer to the Installation and Specification Guide, supplied in the winch kit, for all wiring schematics and specific details on how to wire this WARN product to your vehicle.

**Read installation and operating instructions thoroughly.**

This **WARN Trans4mer system** can be customized to give your vehicle 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 9500 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. 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. Finally, Brush Guards that protect the headlights and front corners of the truck that can be easily added to any of the options above.

### I. BEFORE YOU BEGIN

- Read and understand these Installation Instructions.
- Refer to **Figure 1** to become familiar with the components and hardware in this kit.

### II. PARTS LIST

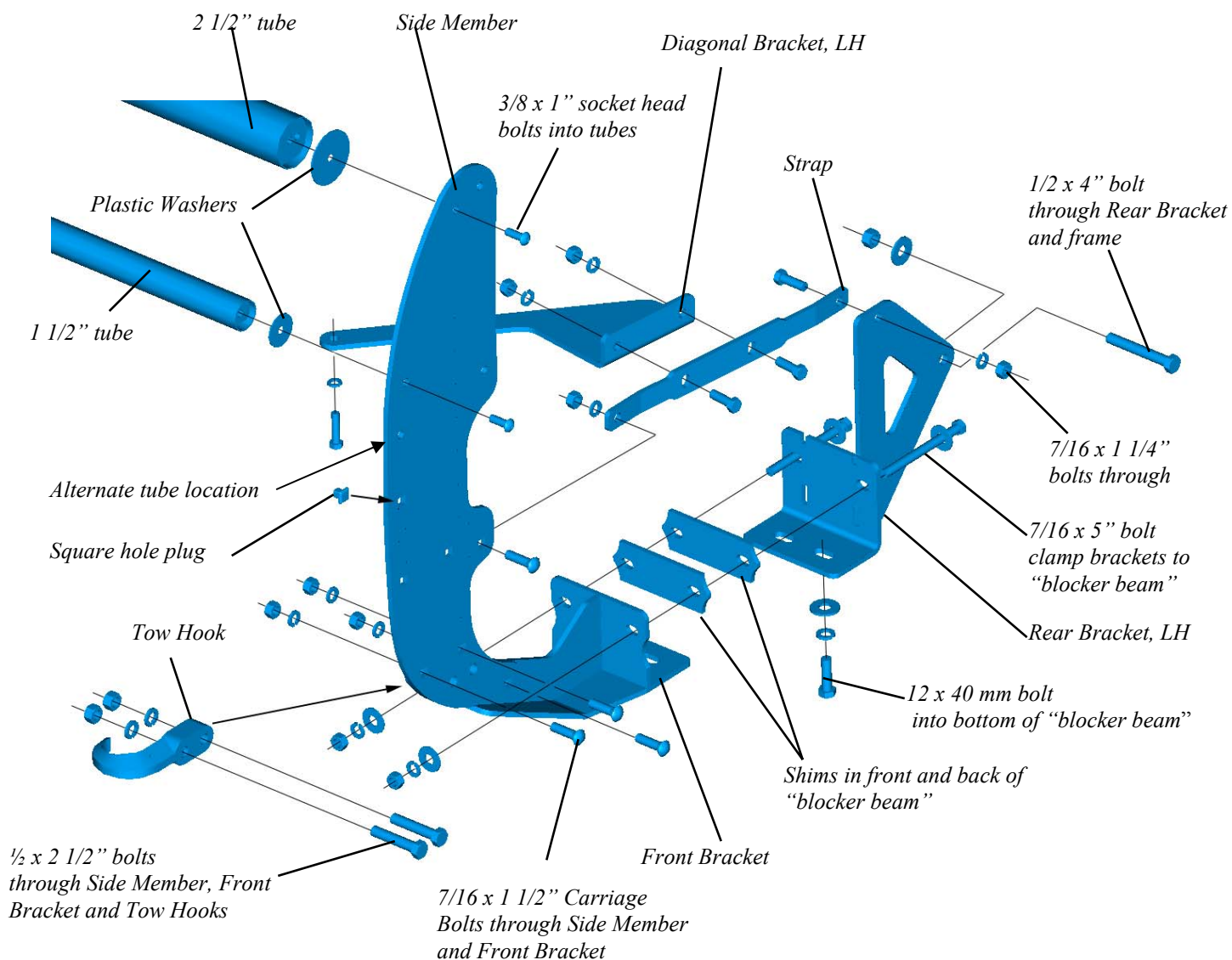
<u>Part Number</u>	<u>Qty</u>	<u>Description</u>
71249	2	Bracket, Front
71251	1	Bracket, LH Rear
71252	1	Bracket, RH Rear
71259	4	Shim
71260	2	Strap
71263	2	Side Member
71264	1	Bracket, LH Diagonal
71265	1	Bracket, RH Diagonal
29366	1	Tube Assembly, 2.5"
29365	1	Tube Assembly, 1.5"

### III. TOOLS REQUIRED

12mm socket wrench	5/8" socket and end wrenches
17mm socket wrench	11/16" socket and end wrenches
18mm socket wrench	3/4" socket and end wrenches
7/32" hex socket (Allen) wrench	

### IV. TORQUE SPECIFICATIONS

- 3/8 30 lb. ft. (40.7 N-m)  
 7/16 50lb. ft. (67.8 N-m)



**Figure 1 Left (driver side) shown**

## V. INSTALLATION

1. Remove the skid plate if so equipped. It will be re-installed later. Unbolt the tow loop or tow hook from the bottom of the frame, passenger side and discard. Remove the bolts securing the blocker beam extensions to each side of the frame. Do not remove the extensions. **Figure 2**  
 NOTE: Leave the tie-down loop in place on the driver's side of the blocker beam.

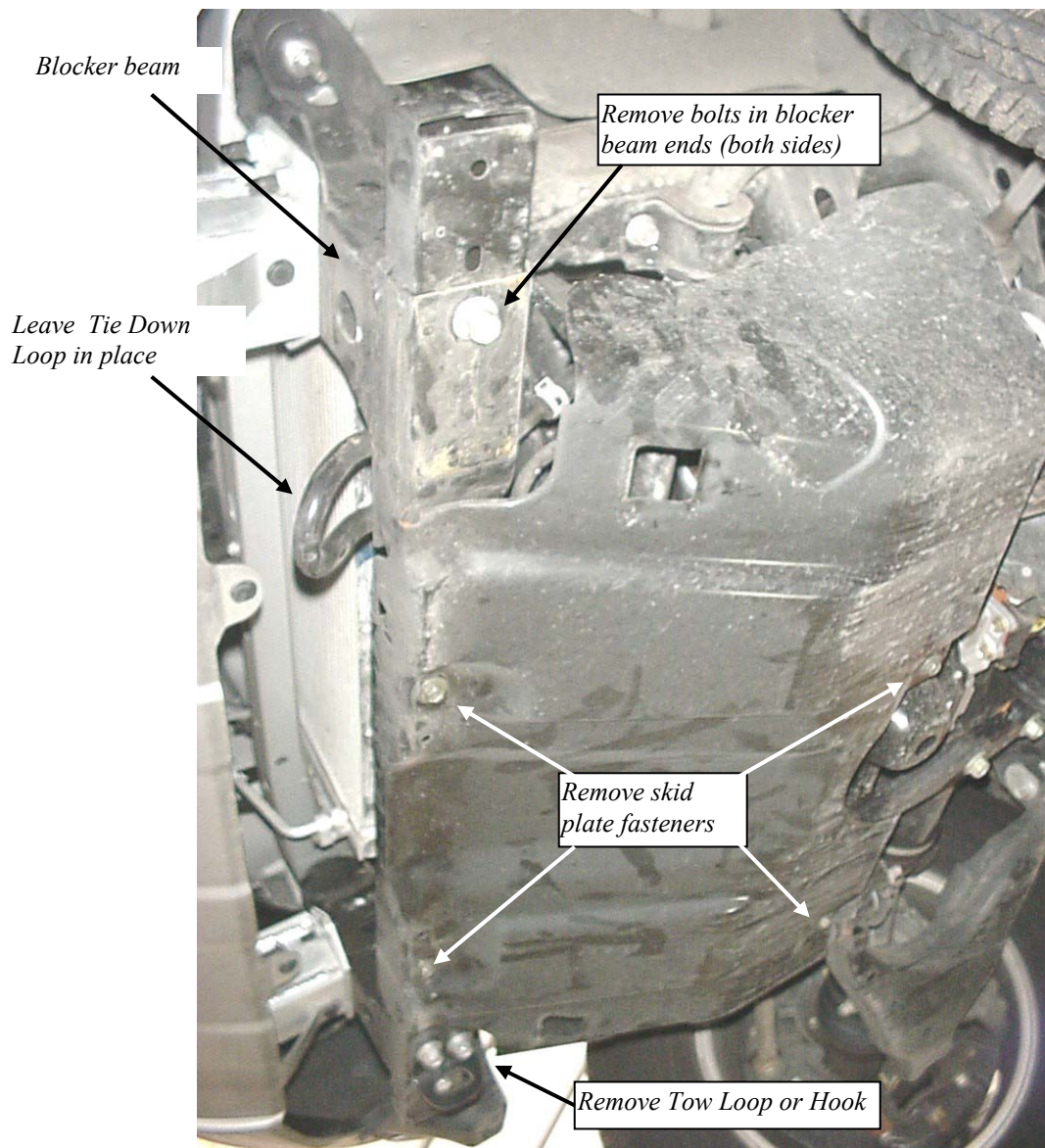


Figure 2

2. Position the Rear Brackets against the outside of the frame rails. See **Figure 3** to identify left and right Rear Brackets.

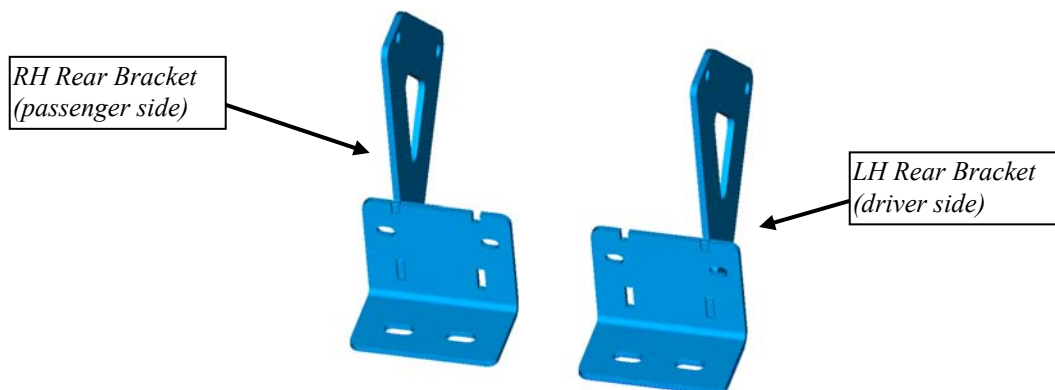
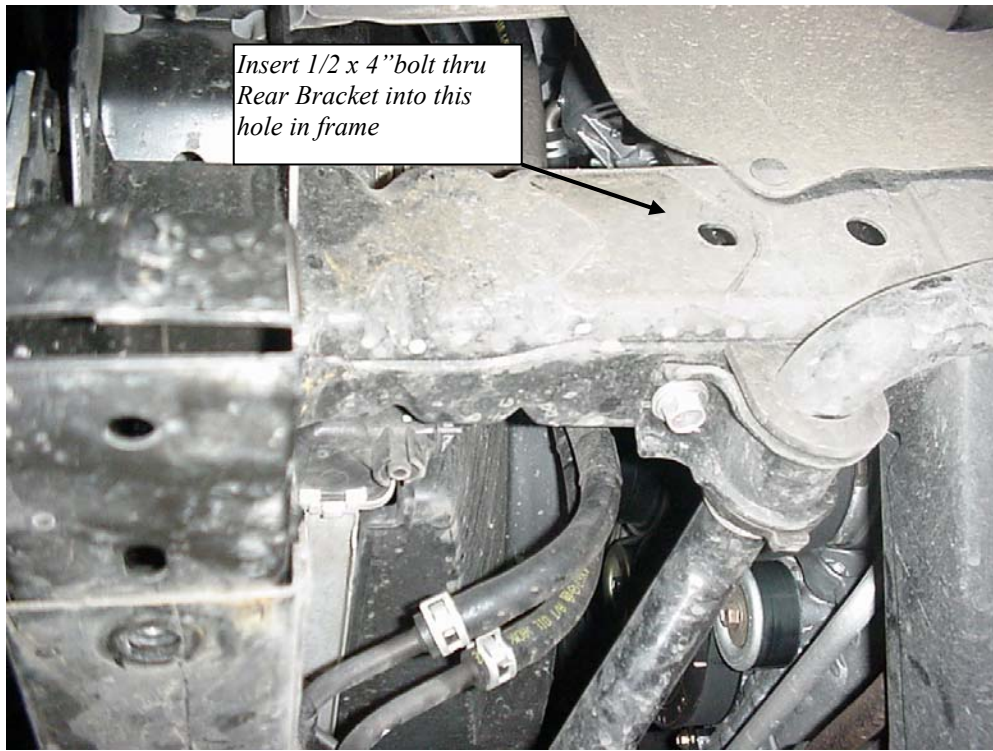
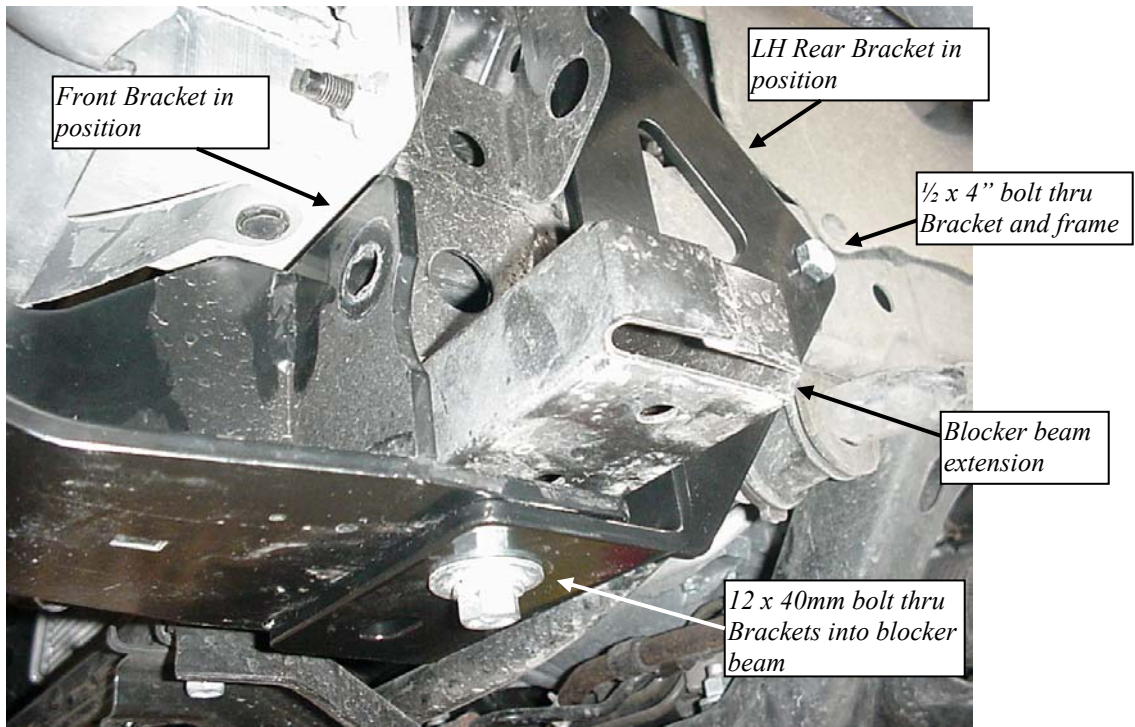


Figure 3



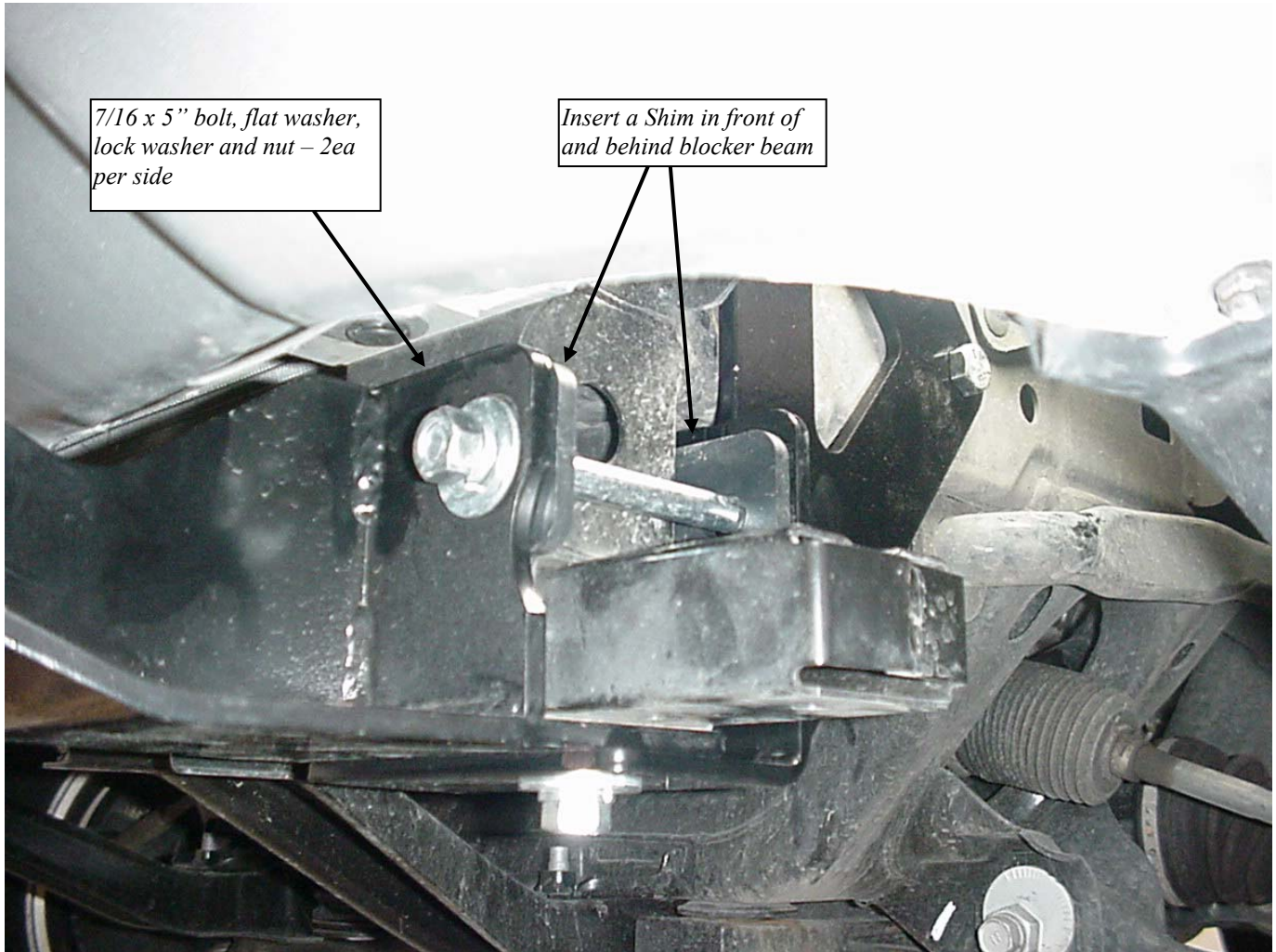
**Figure 4 Left frame rail shown**

3. Use the 1/2 x 4" hardware shown in **Figure 1** to attach the Rear Bracket to the hole in the frame. Do not tighten yet. **Figure 4**
4. Hold a Front Bracket between the bottom of the blocker beam and the lower leg of the Rear Bracket. Install a 12 x 40mm bolt through each bracket into the threaded hole in the blocker beam extension. Do not tighten yet. **Figure 5**



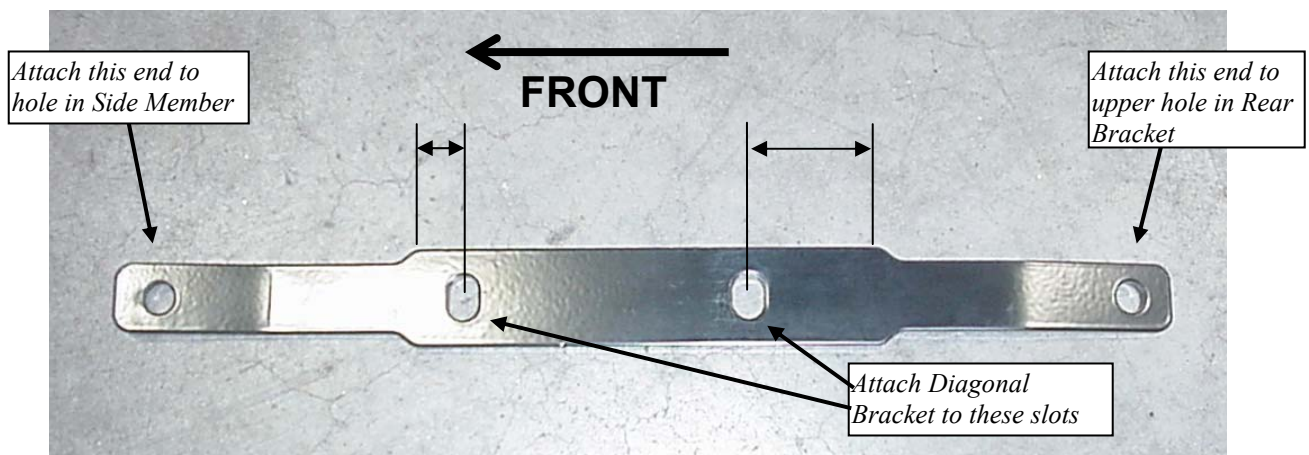
**Figure 5 Left frame rail shown - note Bracket overlap direction**

5. Insert a Shim between each Front and Rear Bracket and the blocker beam. Insert a 7/16 x 5" bolt and flat washer from the rear through all hardware on both sides of the blocker beam. Install flat washer, lock washer and nut on each. Do not tighten yet. **Figure 6**



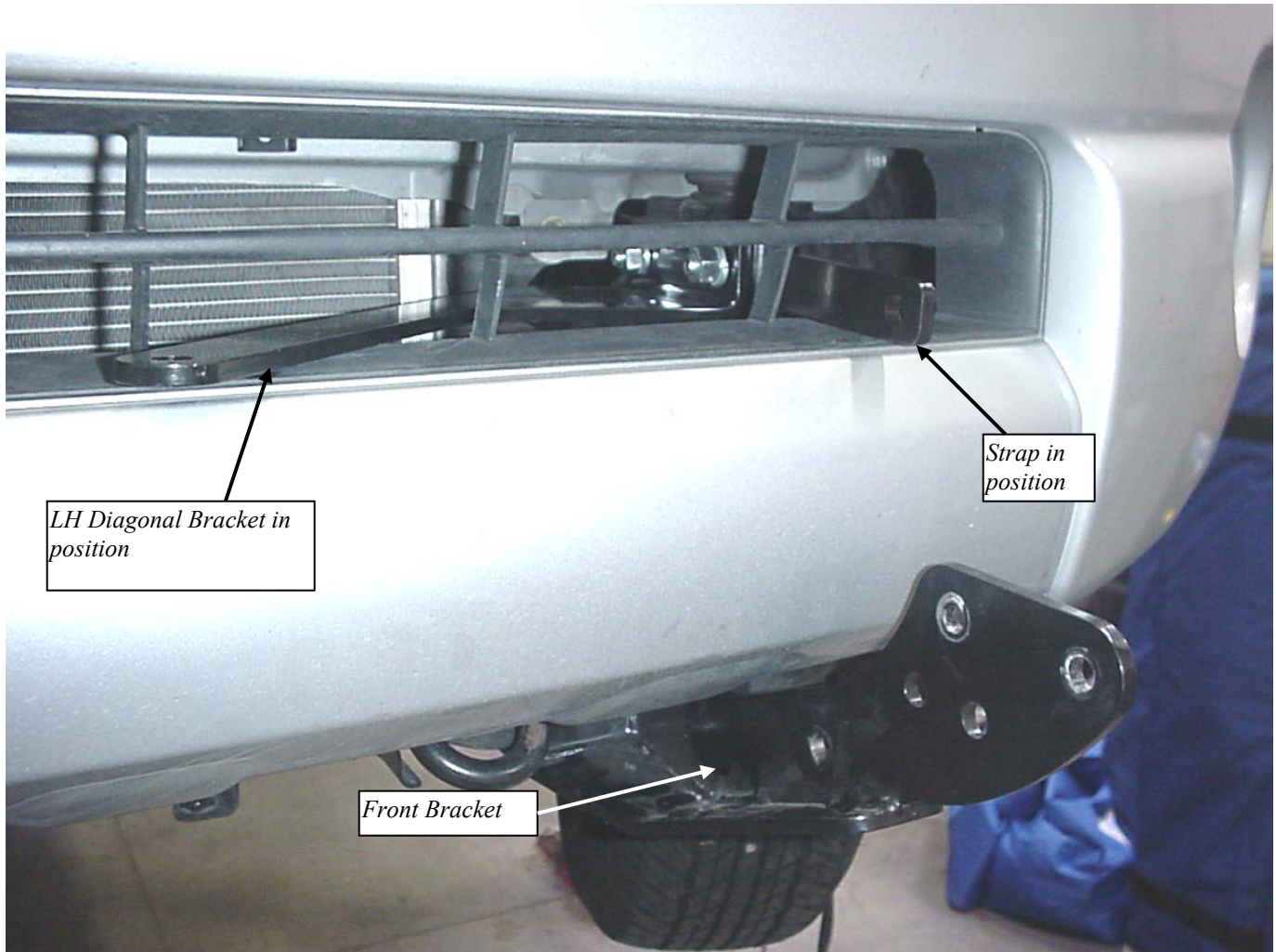
**Figure 6**

6. Attach a Strap to the upper hole of each Rear Bracket, above the frame. Use a 7/16 x 1 1/4" bolt inserted through the "long leg". **Figure 7** Position the other end of the Strap forward through the bumper grille. Do not tighten yet.



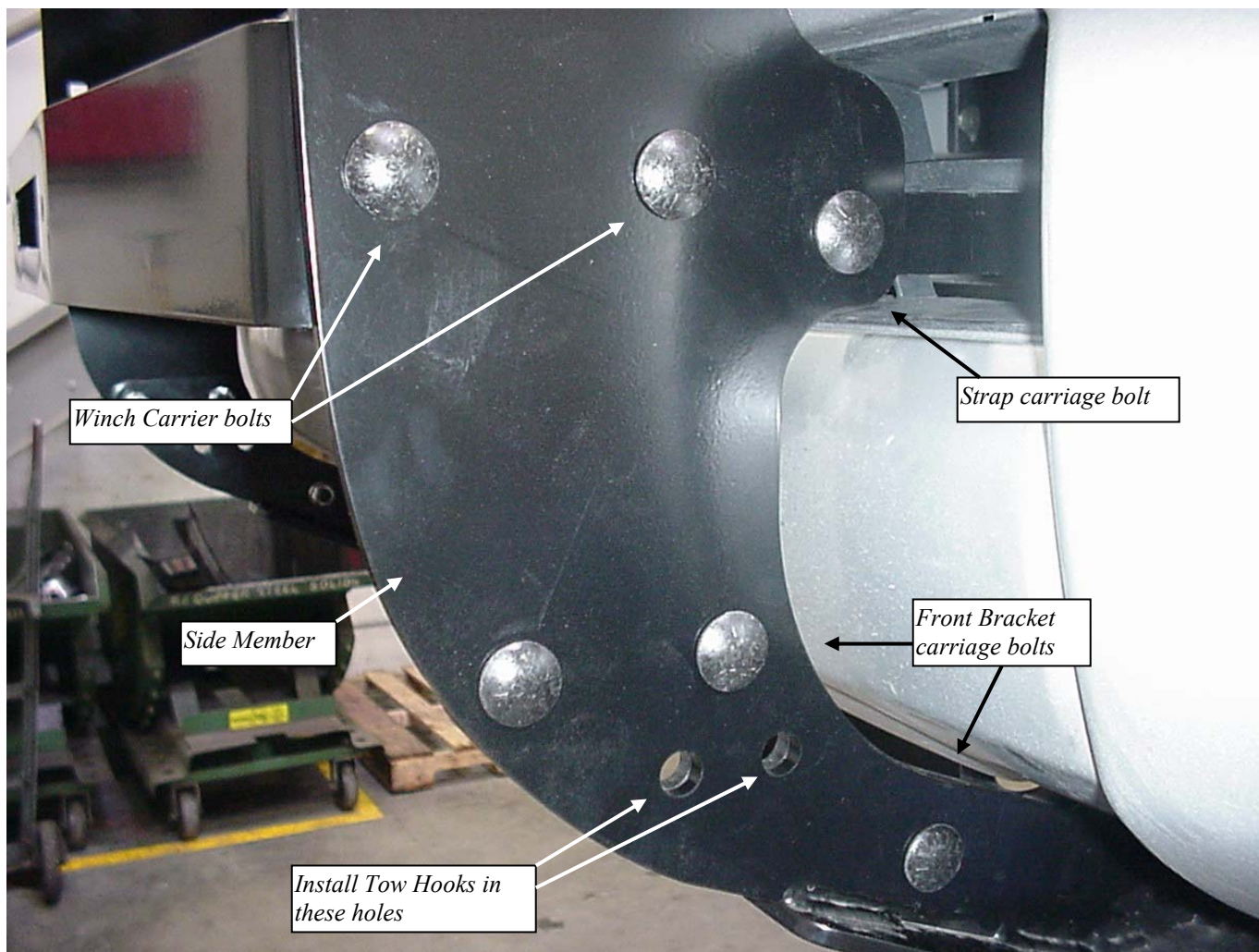
**Figure 7 Strap**

7. Attach the Left and Right Diagonal Brackets to the inside of the Straps. The Diagonal Brackets should be positioned so they “drop” and angle inward and forward through the bumper grille. Use 3/8 x 1 1/4” bolts, lock washers and nuts. Do not tighten yet. **Figure 8**



**Figure 8** Left side bumper shown

8. Install the Side Members to the outside of the Front Brackets and the Straps. Use the 7/16” carriage bolts, lock washers and nuts. Do not tighten yet.
9. If a winch is to be installed, install the Winch Carrier now. Use the 7/16” carriage bolts, lock washers and nuts provided with the Carrier Kit, through the holes indicated in **Figure 9**.  
Note: The Diagonal Brackets should be positioned below the Carrier and the holes should align with the rear winch mounting holes in the Carrier.
10. Install the winch per the Winch Installation Instructions. Use the longer 3/8 x 1 1/2” bolts provided in this kit to attach the Diagonal Brackets to the Carrier and the rear winch mounts.
11. Install the 2 1/2” diameter Grille Guard Tube. Use 3/8 x 1” hex socket bolts through the holes indicated in **Figure 1**. Insert a plastic washer between the end of the tube and the Side Member. Tighten the hardware.
12. Install the 1 1/2” diameter tube with plastic washers. The winch model installed may determine the position.



**Figure 9 Left Side Member**

13. Tighten the Carrier hardware.
14. Tighten the 1/2 x 4" Rear Bracket bolts through the frame to 20 lb.ft. maximum.  
Note: Do not over tighten. Over tightening can deform the frame.
15. Tighten the metric bolts in the bottom of the blocker beam. Tighten the Rear Bracket to Front Bracket bolts. Tighten the Strap to Side Member bolts.
16. Tighten the Diagonal Bracket to Strap bolts.
17. Install the Tow Hooks provided. Use 1/2 x 2 1/2" bolts with lock washers and nuts. See **Figure 9** for the proper location.
18. Install the skid plate removed in step 1.

**⚠ WARNING**

**READ THE VEHICLE'S OPERATOR MANUAL, WINCH OPERATOR MANUAL, AND ALL WARNING LABELS PRIOR TO OPERATION OF WINCH.**

**⚠ WARNING**

**FAILURE TO SECURELY TIGHTEN ALL BOLTS ON THE WINCH PLATE, WINCH, AND FAIRLEAD CAN RESULT IN PRODUCT FAILURE WHICH MAY RESULT IN VEHICLE DAMAGE AND OPERATOR INJURY OR DEATH. DOUBLE CHECK THAT ALL BOLTS ARE SECURELY TIGHTENED PRIOR TO USE.**



## VII. MAINTENANCE/CARE

1. Inspect all parts on the winch, winch mount, and related hardware prior to each use. Replace all hardware that appears rusted or deformed.
2. Inspect all nuts and bolts on the winch, winch mount, and related hardware prior to each use. Tighten all nuts that appear to be loose. Stripped, fractured, or bent bolts or nuts need to be replaced.
3. Check all cables prior to use. Replace cables that look worn or frayed.
4. Check all moving or rotating parts. Remove debris that may inhibit the part from moving freely.

### **WARNING**

**PERFORM REGULAR INSPECTIONS ON THE WINCH, WINCH MOUNT, AND RELATED HARDWARE. NEVER OPERATE THE WINCH OR WINCH MOUNT WITH DAMAGED OR MISSING PARTS. FAILURE TO FOLLOW THIS WARNING MAY CAUSE VEHICLE DAMAGE AND OPERATOR INJURY OR DEATH.**