



INSTALLATION INSTRUCTIONS

Trans4mer Mounting System Toyota Tacoma Kit No. 63065 (black) or 63066 (stainless steel)

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!**

PARTS LIST

PART NO.	QUANTITY	DESCRIPTION
35267	1	FRAME EXTENSION, R.H.
35265	1	FRAME EXTENSION, L.H.
63061	2 (black kit only)	SIDE MEMBER, BLACK
63655	2 (stainless kit only)	SIDE MEMBER, STAINLESS
63067	2	BRACE
63688	1 (stainless kit only)	1-1/2" TUBE, STAINLESS
29365	1 (black kit only)	1-1/2" TUBE, BLACK
60326	1 (stainless kit only)	2-1/2" TUBE, STAINLESS
29366	1 (black kit only)	2-1/2" TUBE, BLACK

TORQUE SPECIFICATIONS

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)
12mm	75 lb. ft. (101.7 N-M)

Note: Do not securely tighten any fasteners until directed later.

This **WARN Trans4mer system** can be customized to give your Toyota Tacoma 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, 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

Light Bar Kit, (Black)	29395
Light Bar Kit, (Stainless)	63325
Winch Carrier Kit (argent color matches winch)	29394
Receiver Kit (Black only)	29397
Brush Guard Kit (Black)	63062
Brush Guard Kit (Stainless)	63064
Accent Cover Kit	63130

NOTES: PLEASE READ THESE INSTRUCTIONS THOROUGHLY BEFORE STARTING THE INSTALLATION OF THIS KIT. MINOR MODIFICATIONS MAY BE REQUIRED DUE TO VARIATIONS BETWEEN VEHICLES. STAINLESS STEEL KITS WILL BE SLIGHTLY DIFFERENT AND MAY CONTAIN DIFFERENT HARDWARE.

1. Review **Figure 1** to become familiar with the kit components.

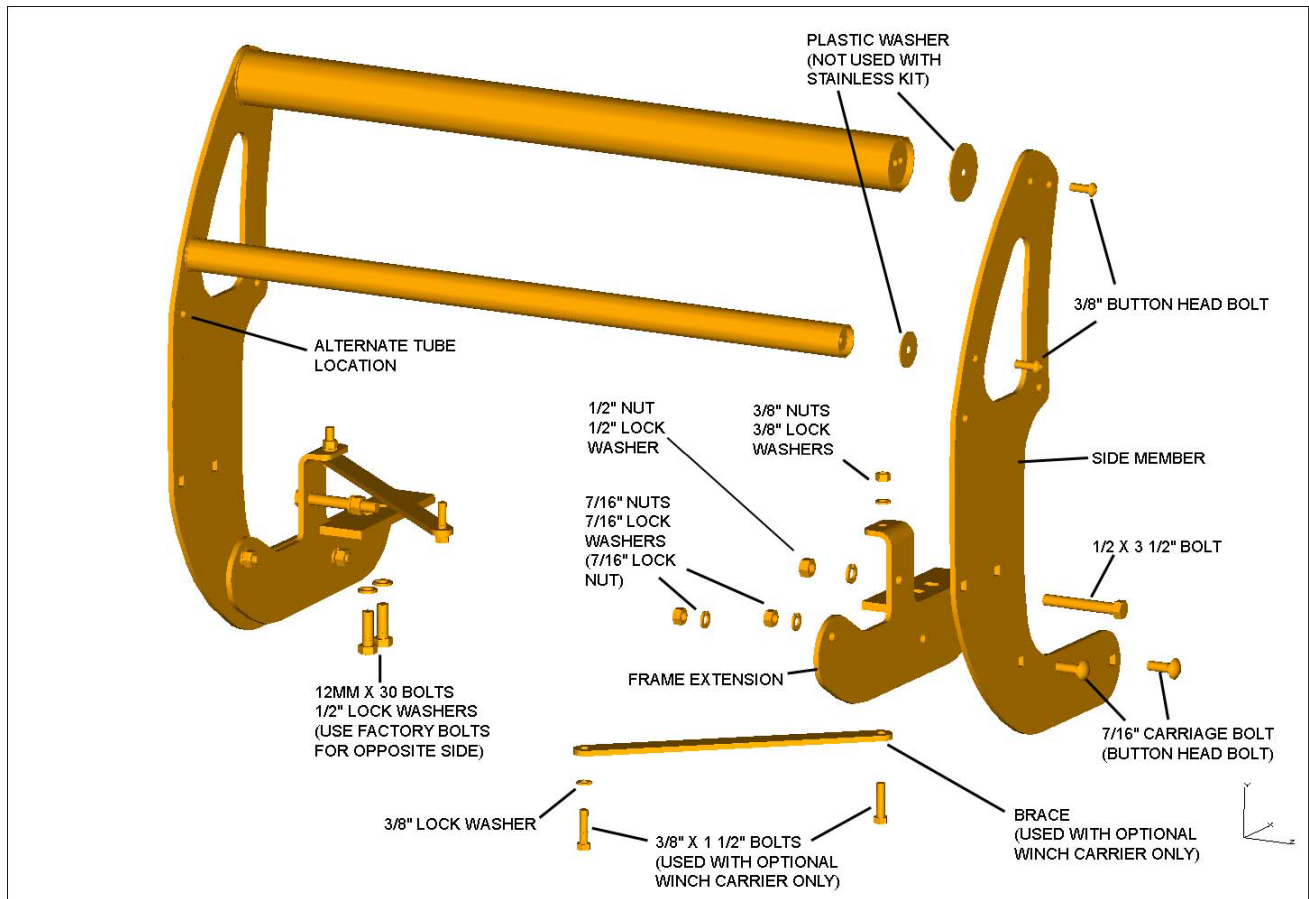


Figure 1. Toyota Tacoma Grille Guard Kit Components

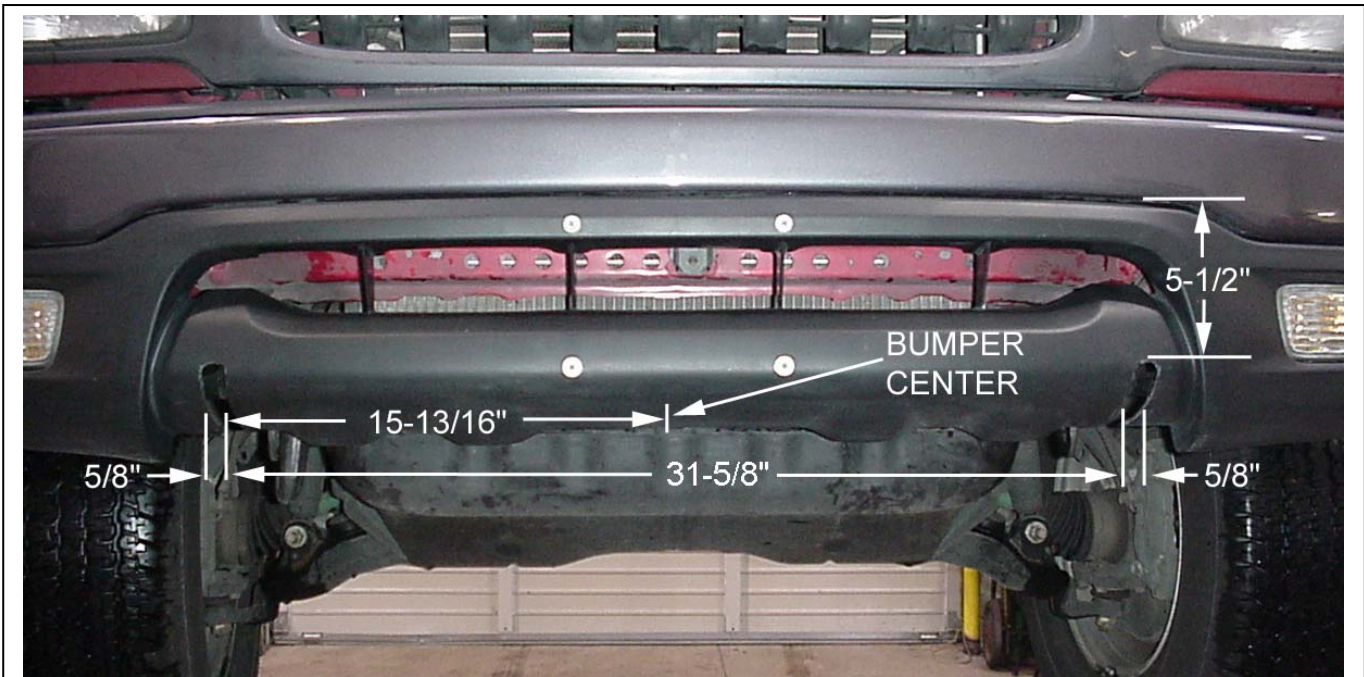


Figure 2. Front Bumper Trim

2. Refer to **Figures 2** and **3**. Measure across the bumper. Mark and cut slots into the plastic at the locations shown. The plastic can easily be drilled, sawed or cut with any sharp cutting tool. The corners at the end of the slots should be rounded.



Figure 3. Slot Detail



Figure 4. Right Side Tie-Down and Tow Hook



Figure 5. Left Side Tie-Down

3. Remove the factory tow hook and tie downs from the bottom of the vehicle frame. See **Figures 4 and 5**. Save the left side bolts for attaching the frame extension. Shorter 12mm bolts to replace the right side bolts are supplied.

4. If installing a winch, insert a 3/8 x 1 1/2" bolt through one end of a brace and the upper hole of a frame extension. The brace should be below the frame extension tab with the bolt installed from the bottom. Secure finger tight with a 3/8 lock washer and nut on top of the frame extension tab. **Figure 6**. Repeat this step for the opposite side.

NOTE: The two long braces are used only when mounting a winch. Be sure to save them if a winch is not being installed now, but may be in the future.

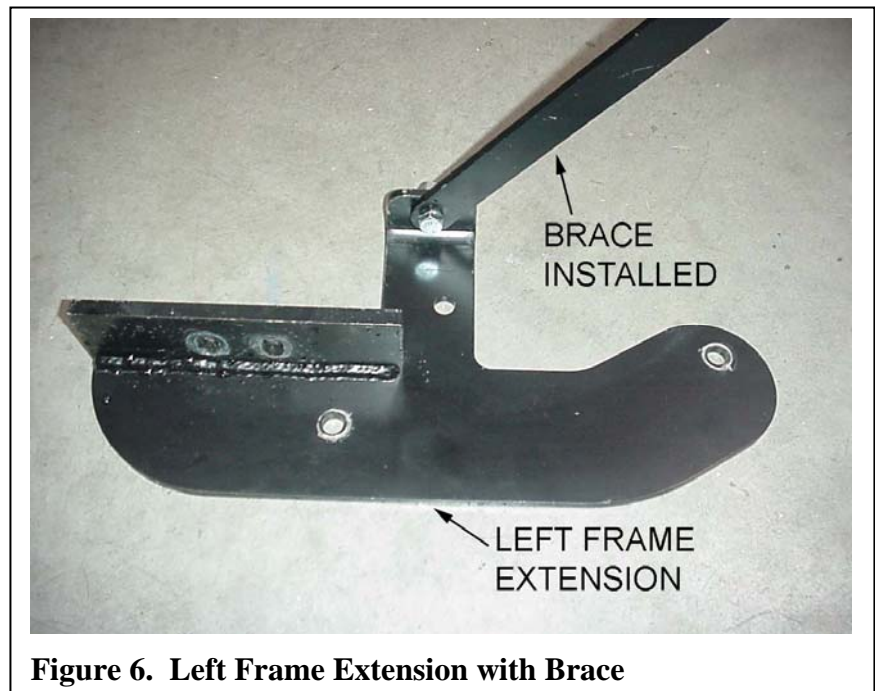


Figure 6. Left Frame Extension with Brace

5. Install the frame extensions onto the bottom of the frame as shown in **Figure 7**. The braces (if installed) should pass through the openings in the lower bumper at a diagonal, behind the vertical bars. **Figure 9**. Leave the bolts slightly loose.
6. Use the factory tie-down bolts on the left (driver's) side and the 12mm bolts and 1/2" lock washers on the right side.

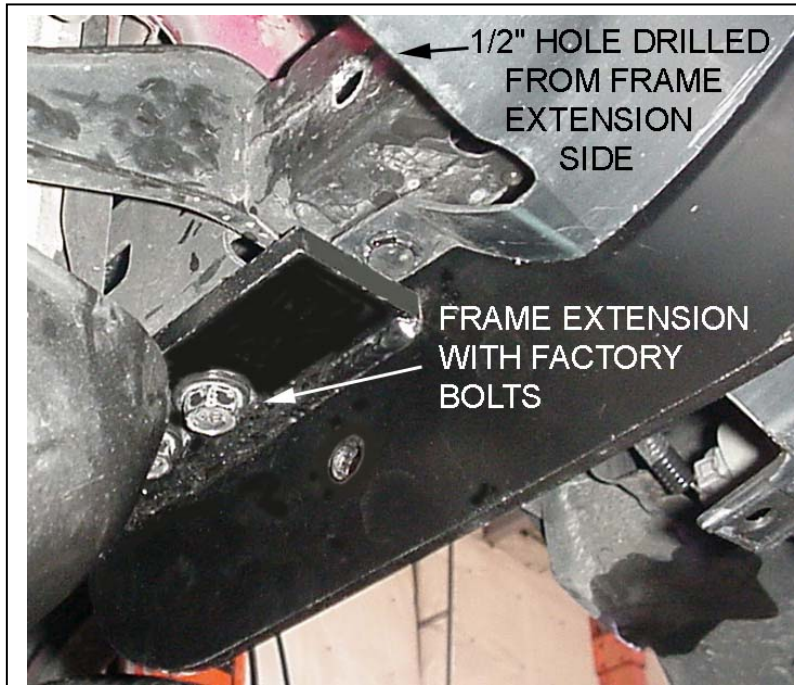


Figure 7. Left Frame Extension with Factory Bolts Installed



WARNING



Drilling operations can cause flying metal chips. **WEAR SAFETY GOGGLES.** Flying metal chips can cause eye injury.

7. Use the hole in the frame extension and frame as a guide and drill a 1/2" hole through the inside of the box frame. It may be necessary to loosen or remove the plastic lower bumper for adequate drilling room. Secure the frame extension with a 1/2 x 3-1/2" bolt, lock washer and nut. **Figure 8**.
8. Install the side members onto the outsides of the frame extensions. Use 7/16" carriage bolts, lock washers and nuts. The stainless kit substitutes 7/16" button head bolts in place of carriage

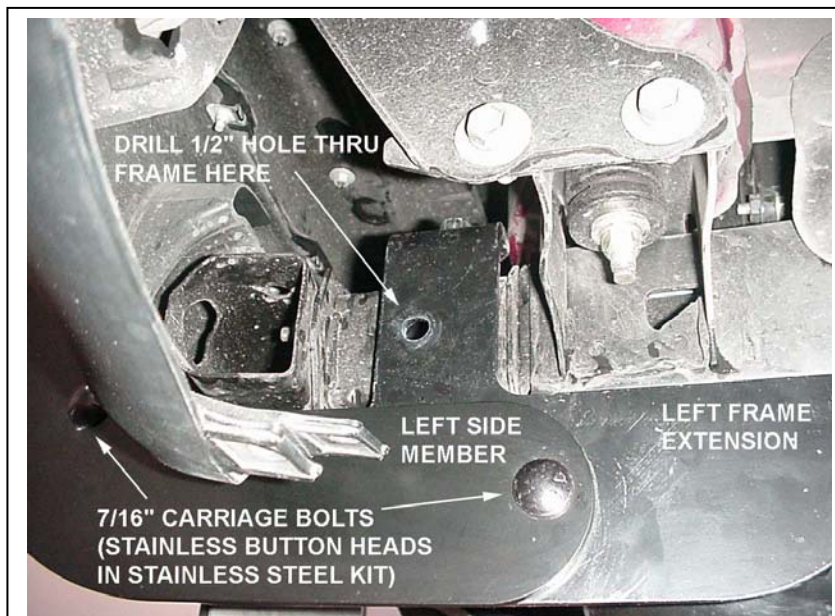


Figure 8. Left Side Member

bolts and lock nuts in place of lock washers. **Figure 8.**

9. If the Trans4mer is being installed as a grille guard and a winch is not being mounted at this time, install the tubes in any desired position as shown in **Figure 1**. If the Winch Carrier or Receiver Kit is being added, install a tube only in the top position and then refer to the specific instructions packaged with those items.

NOTE: The plastic washers are not used when installing the stainless steel tubes.

If a Winch Carrier is being mounted, install the braces as previously described. Line up the brace end with the rear winch mounting holes underneath the winch carrier (it may be necessary to trim a vertical piece of one of the air slots). With the winch in place, use 3/8 x 1-1/2" bolts with lock washers through the braces, carrier and into the winch.

Figure 9.

NOTE: If a winch carrier is being installed in a stainless kit, use the 7/16" button head bolts from this hardware kit to secure it (in place of the carriage bolts supplied in the carrier kit.)

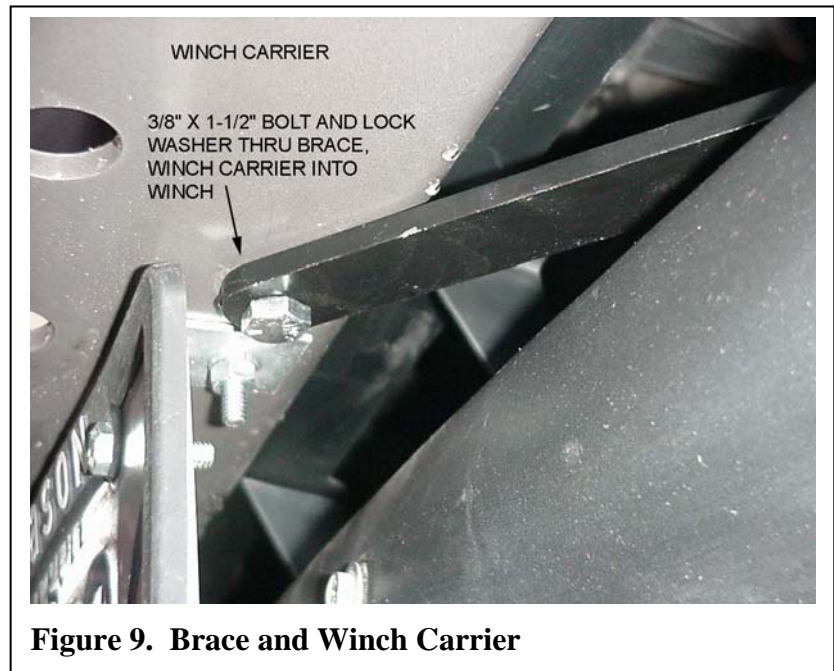


Figure 9. Brace and Winch Carrier

10. Align the entire assembly with the vehicle and tighten all fasteners securely. The side member fit to the bumper can be improved, if necessary, by loosening the factory bumper brackets at the frame, adjusting the bumper and then tightening.

Warn Industries 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.