



FITTING INSTRUCTIONS

Part Number: **3423020 F/KIT 6173071**
Product **WINCH BULL BAR**
Description:
Suited to **TOYOTA TACOMA 1995-2004**
vehicle/s:

WARNING

REGARDING VEHICLES EQUIPPED WITH SRS AIRBAG:

When installed in accordance with these instructions, the front protection bar does not affect operation of the SRS airbag.

ALSO, NOTE THE FOLLOWING:

- ◆ This product must be installed exactly as per these instructions using only the hardware supplied.
- ◆ In the event of damage to any bull bar component, contact your nearest authorised ARB stockist. Repairs or modifications to the impact absorption system must not be attempted.
- ◆ Do not use this product for any vehicle make or model, other than those specified by ARB.
- ◆ Do not remove labels from this bull bar.
- ◆ This product or its fixing must not be modified in any way.
- ◆ The installation of this product may require the use of specialized tools and/or techniques
- ◆ It is recommended that this product is only installed by trained personnel
- ◆ These instructions are correct as at the publication date. ARB Corporation Ltd. cannot be held responsible for the impact of any changes subsequently made by the vehicle manufacturer
- ◆ During installation, it is the duty of the installer to check correct operation/clearances of all components
- ◆ Work safely at all times
- ◆ Unless otherwise instructed, tighten fasteners to specified torque

ARB 4x4 ACCESSORIES

Corporate Head Office

42-44 Garden St
Kilsyth, Victoria
AUSTRALIA 3137

Tel: +61 (3) 9761 6622
Fax: +61 (3) 9761 6807

Australian enquiries
North & South American enquiries
Other international enquiries

sales@arb.com.au
sales@arb.com.au
exports@arb.com.au

www.arb.com.au

GENERAL CARE AND MAINTENANCE

By choosing an ARB Bar, you have bought a product that is one of the most sought after 4WD products in the world. Your bar is a properly engineered, reliable, quality accessory that represents excellent value. To keep your bar in original condition it is important to care and maintain it following these recommendations:

- Prior to exposure to the weather your bar should be treated to a Canuba based polish on all exposed surfaces. It is recommended that this is performed on a six monthly basis or following exposure to salt, mud, sand or other contaminants.
- As part of any Pre Trip Preparation, or on an annual basis, it is recommended that a thorough visual inspection of the bar is carried out, making sure that all bolts and other components are torqued to the correct specification. Also check that all wiring sheaths, connectors, and fittings are free of damage. Replace any components as necessary. This service can be performed by your local authorized ARB Stockist.

FITTING REQUIREMENTS

REQUIRED TOOLS FOR FITMENT OF PRODUCT:

BASIC METRIC SOCKET AND WRENCH SET	DRILL MOTOR ½" CAPACITY
DRILL BITS, DIAMETERS 10.5 AND 13.0	TEST LAMP

HAVE AVAILABLE THESE SAFETY ITEMS WHEN FITTING PRODUCT:

Protective eyewear		Hearing protection	
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NOTE: 'WARNING' notes in the fitting procedure relate to OHS situations, where to avoid a potentially hazardous situation it is suggested that protective safety gear be worn or a safe work procedure be employed. If these notes and warnings are not heeded, injury may result.

FASTENER TORQUE SETTINGS:

SIZE	Torque Nm	Torque lbft
M6	9Nm	7lbft
M8	22Nm	16lbft
M10	44Nm	32lbft
M12	77Nm	57lbft

PARTS LISTING			
APPLICATION.	PART NO.	QTY	DESCRIPTION
IMPACT ABSORBER TO CHASSIS	6151096	4	BOLT M12 x 1.25P X 40
	4581050	6	WASHER SPRING M12
	4581049	4	WASHER FLAT M12
	4581007	2	WASHER FLAT M12 LARGE
	6151509	2	BOLT M10 X 110
	4581040	4	WASHER M10 FLAT
	6151322	2	NUT M10 NYLOC
	3758081L	1	IMPACT ABSORBERS
	3758081R	1	IMPACT ABSORBERS
	4721551	2	TUBE OD 13 X ID 10.3 X 80
	3194189	2	PACKER TOW HOOK
SPLASH PAN TO BULL BAR	6151021	3	BOLT M8 x 20
	4581044	3	WASHER FLAT M8
	4581046	3	WASHER SPRING M8
	3314401	1	SPLASH PAN
	6151303	3	NUT CAGE M8
BULL BAR TO IMPACT ABSORBERS MOUNT BRACKETS	6151045	6	BOLT M10 SEMS
	6151304	6	NUT CAGED M10
BUFFERS TO BULL BAR	6151132	4	NUT FLANGE M8
	4581044	2	WASHER FLAT M8
	6151021	2	BOLT M8 x 20
CONTROL BOX BRACKET	4581044	2	WASHER FLAT M8
	6151021	2	BOLT M8 X 20
	3751564	1	CONTROL BOX BRACKET
	6151132	2	NUT FLANGE M8
NUMBER PLATE BRACKET	6151017	4	BOLT M6 x 16
	6151046	4	WASHER FLAT M6
	6151128	4	NUT FLANGE M6
	3751542	1	NUMBER PLATE BRACKET
BUFFERS AND INDICATORS	3500200	1	BUFFERS KIT
	3500080	1	ARB INDICATORS
8-9000lb WINCH TO PAN	4581040	4	WASHER FLAT 3/8"x 1"
	180302	6	CABLE TIES
	6151074	2	BOLT 3/8 X 1 3/4"
	6151073	2	BOLT 3/8 X 1 1/2"
BRACKET SUMP GUARD	3756407	1	BRACKET SUMP GUARD SUPPORT
	6151303	3	NUT CAGE M8
	6151021	3	BOLT M8 X 20MM
	4581044	3	WASHER M8
	4581046	3	WASHER SPRING M8

NOTE:

- ◆ UP TO 900 SERIES ROUND OR 800 RECTANGULAR DRIVING OR FOG LAMPS SUIT THIS PRODUCT
- ◆ WINCHES: WARNE 9.5 XP, HS9500, XD9000, M8000

FITTING PROCEDURE

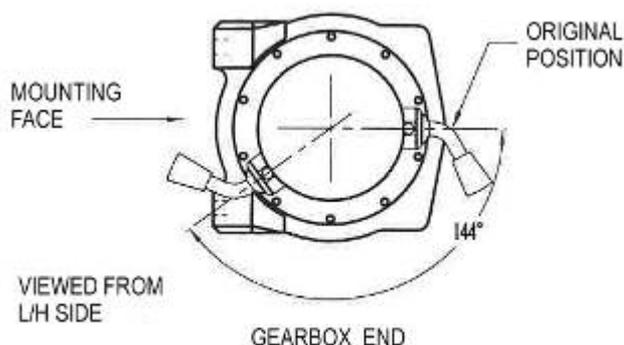


1. Remove bumper bar, tie down rings, and tow hook from the vehicle.
2. Undo front of sump guard at to cross member, running between chassis ends.
3. **Unbolt to remove the crush cans as shown. Do not cut off the end of the chassis if it is extended on some models.** The cross member can also be removed from the front of the vehicle.



4. Fit the indicators into bar.
5. Fit number plate bracket to bull bar using 6mm hardware.
6. Fit control box bracket to bull bar using M8 hardware.
7. Fit buffers to bull bar using M8 flange nuts and M8 x 20 bolts supplied in buffer kit.

NOTE: DO NOT OVER TIGHTEN BUFFER FASTENERS. o



8. To place the clutch handle in the correct position, the winch gearbox must be rotated 144 degrees (4 hole spacings), in anti-clockwise direction when viewed from gearbox end. Place the winch on its end and remove all gearbox bolts. Gently raise the gearbox just enough to rotate it. When the correct position is located, refit all bolts and tighten.

NOTE: Take care not to lift the assembly more than a couple of millimetres while rotating to correct position to avoid unmeshing the gears.

See diagram opposite.

FITTING PROCEDURE



9. Once winch is rotated, positioned winch on bench face up.

10. Lower bull bar on top of winch and align holes with each other. Using 1 1/4" x 3/8" bolts and flat washers from bolt kit, secure the two most upper holes first and finger tighten. Remove top circlips from vertical rollers of fairlead and remove pins and rollers, this is done so there is easy access to lower bolts.

11. Place roller fairlead in bar cutout over lower holes and fasten using 1 1/2" x 3/8" bolts and 3/8" flat washers supplied in bolt kit.

12. When all is positioned, tighten all bolts firmly and replace rollers, pins and circlips back to roller fairlead.



13. Fit control box to control box bracket and tighten firmly.

14. Pull wires through viewer cutout under control box and wire up as per Warn instruction manual.

15. Tie back cables clear of all moving parts with cable tie supplied.

16. Place ground earth lead under bolt of winch tension bar.



17. Fit 3 x M10 cage nuts to inner face of both impact absorbers.

18. Fit impact absorbers to both sides of the vehicle using M12 x 1.25P x 35 bolts, spring washers and large panel washers, with the bracket for sump guard sandwiched between the mounts and the chassis ends, lower folded flange at the bottom and facing rearward. **Only snug up bolts do not fully tighten**

19. Centralise brackets to vehicle and check width across inside of mount faces is 725-727mm, adjust if required.

20. **Tighten bolts to full torque**

FITTING PROCEDURE



Warning: Drilling operations can result in flying metal debris, safety glasses should be

PINNING HOLES IN CHASSIS

21. From underneath each mount bracket, using the Dia 10.0 hole in the lower flange as a guide, drill vertically right up through chassis and top flange of mount bracket using Dia10.5mm drill bit.
22. **Using Dia 13.0mm drill bit, drill only the lower flange of the mount bracket and lower section of the chassis. DO NOT DRILL ALL THE WAY THROUGH THE TOP SECTION OF THE CHASSIS AND MOUNT BRACKET FLANGE**



23. Fit M10 x 110 bolts, with M10 flat washers and Dia 13 OD spacer tubes up through pinning holes and secure with 2 x M10 flat washers and M10 nyloc nuts. ***Tighten fully to specified torque***
24. On LH Side of vehicle, if refitting tow hook, use original long M12 bolts, packing hook down to clear M10 pinning bolt head using packing spacers provided.

FITTING PROCEDURE



FIT BULL BAR TO VEHICLE

25. Lift bar into position between impact absorbers and bolt up using M10 SEMS bolts. Snug up only. (Bolts fit from inside of bar.)
26. Adjust bar so that there is a 20mm gap around the periphery of the vehicle and **securely tighten all remaining bolts throughout to specified torque**
27. Wire main power leads to battery as per Warn instructions and cable tie leads securely from all moving parts with cable ties supplied.
28. Fit licence plate using M6 bolts.
29. Pull winch cable through roller fairlead, and fit tow hook.



30. Check polarity of vehicle indicator wiring use test light, determine '+' & '-' wires.
31. Connect the indicator looms to the existing indicator loom with the Scotchloks supplied. Test to ensure the indicators function correctly.
32. Fit M8 cage nuts to 3 x holes in lower pan and 3 x holes in bracket sump guard support to fasten splash pan
33. Fasten vehicle sump guard and supplied splash pan to bracket sump guard support using 3 x M8 bolt and washer sets.
34. Front of splash pan is bolted to bull bar using 3 x 8mm hardware sets supplied.



35. If driving lights are to be fitted, use extension bar with ratchet, $\frac{3}{4}$ " long reach socket to tighten from cutout in centre pan

FITTING PROCEDURE



36. Winch handle is operated from this cutout.

ONCE BAR IS FITTED:

- ◆ Ensure all bolts are tensioned correctly
- ◆ All wiring is clear of sharp edges or moving surfaces and secured properly
- ◆ Piping is secured well away from sharp or moving components
- ◆ Check operation of winch if fitted
- ◆ Check all wiring and connections to turn signal lamps, sensors, headlamp washers etc. are functioning correctly

FITTED PRODUCT

