



FITTING INSTRUCTIONS

ARB WINCH/NONWINCH BUMPER TO SUIT TOYOTA TUNDRA 2003 on

PRODUCT No. 3915020

FITTING KIT No's: 6171419, 6171838, 6171839

WARNING

FOR VEHICLES EQUIPPED WITH SRS AIRBAG

WHEN INSTALLED IN ACCORDANCE WITH THESE INSTRUCTIONS, THE FRONT PROTECTION BAR DOES NOT AFFECT OPERATION OF THE SRS AIRBAG.

TAKE NOTE OF 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.**

Tools Required

8,10, 12,13, 14, 18, 19mm Spanners and Sockets. Phillips head screwdriver , Sharp Knife. Drill and 8mm or 5/16" Bit. Black silicone based rubber adhesive.

IMPORTANT

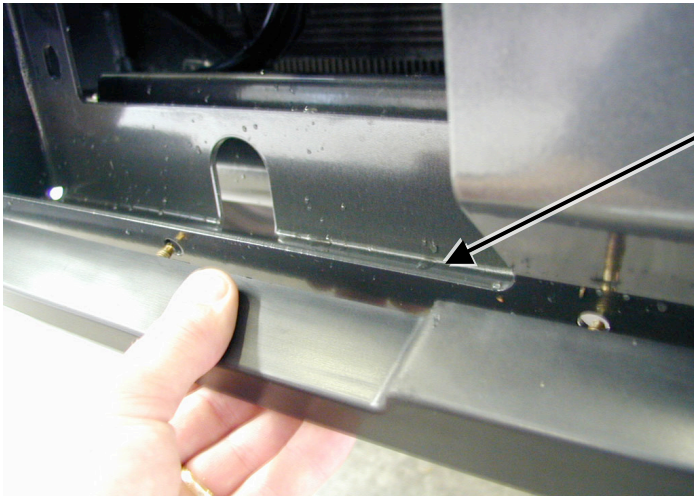
- **This winch bumper is suitable only for Warn 10,000lb, 12,000lb winches only.**

Optional Extras suited for this bar includes a range of IPF driving lights. Contact your nearest ARB stockiest for further information.

USE	PART No	QTY	DESCRIPTION
BUFFER FITTMENT	6151128	16	NUT FLANGE M6
	3162174	1	BUFFER LOWER
	3162153	1	BUFFER LHS
	3162154	1	BUFFER RHS
LIGHT SURROUNDS TO BAR	3162456	1	LIGHT SURROUND LHS
	3162457	1	LIGHT SURROUND RHS
CHROME TUBE FITTMENT	6151255	2	BOLT M12 X 40mm
	4581049	2	WASHER FLAT M12
	4581050	2	WASHER SPRING M12
	6131189	1	CHROME TUBE
MOUNT ASSY TO VEHICLE	3756254L	1	BRACKET IMPACT ABSORBER LHS
	3756254R	1	BRACKET IMPACT ABSORBER RHS
	4581010	4	WASHER FLAT 35 x 14 x 3mm
WINCH	4581041	4	WASHER FLAT 25 X 11.5 X 1.6
ROLLER FAIRLEAD FITMENT	4581049	4	WASHER FLAT M12
CONTROL BOX FITMENT	3756250	1	CONTROL BOX BRACKET
	BLR560	1	BATTERY LEAD RED
	BLB560	2	BATTERY LEAD BLACK
	6151017	3	BOLT M6 X 16MM
	6151128	3	NUT FLANGE M6
	3756260	1	BKT INSULATOR COVER
	3756248	1	BKT INSULATOR BASE
	180302	6	CABLE TIES
WINCH COVER FITTMENT	6151128	2	NUT FLANGE M6
	6151256	2	SCREW M6 S/STEEL BUTTON HEAD
	6191001	1	WINCH COVER EXTRUSION
	6522009	1	WINCH COVER
	6151046	2	WASHER M6
NUMBER PLATE FITTMENT	6151017	2	BOLT M6 x 16mm
	6151128	2	NUT FLANGE M6
	6781408	1	TAPE DOUBLE SIDED
RUBBER EXTRUSION FITMENT	6821116	16	SQUARE PLASTIC PLUG
	6151176	16	SCREW SELF TAPPING 12mm 8G
	6191002	2	EXTRUSION
	3193686	2	MOUNT STRIPS
BAR TO MOUNT ASSEMBLY	6151255	6	BOLT M12 X 40mm
	4581050	6	WASHER SPRING M12
	4581007	6	WASHER FLAT M12 LARGE
	6151020	2	BOLT M8 X 16mm
	6151132	2	NUT FLANGE M8
CB	3162152	2	PLASTIC PLUG DIA16
SPLASH PAN FITTMENT	3314419	1	PAN
	6151020	3	BOLT M8 X 16mm
	6151132	3	NUT M8 FLANGE

ASSEMBLY SEQUENCE FOR WINCH BUMPER.

1.



1. Remove the bumper bar from the vehicle.
2. Position the lower buffer on the winch bumper and assemble using the M6 flange nuts. (do not overtighten)

2.



3. Insert the side buffers through the holes and fix using the M6 flange nuts. (do not overtighten)

5.



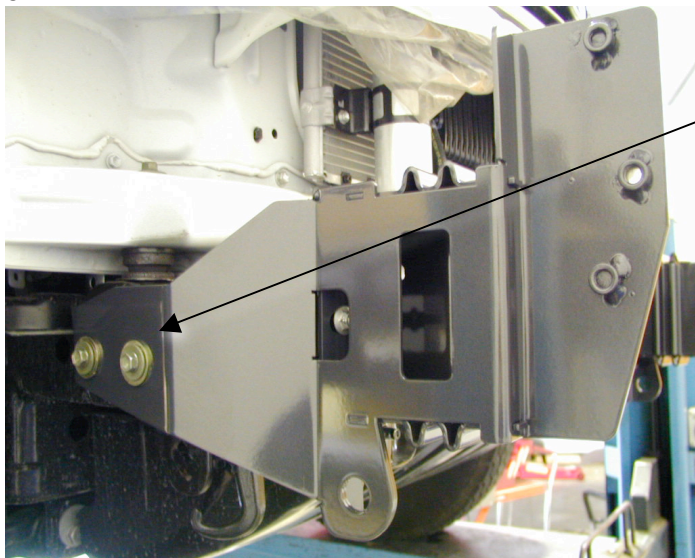
4. Glue the light surrounds to the bar using a silicone based rubber adhesive. Run the bead along the cavity on the rear side of the part. Position the surround to align the inside edge with the buffer and concentric to the light.
5. Wipe off any adhesive on the front face of the bar. Allow adhesive to cure before continuing.
6. **If fitting optional fog lights, do so at this stage.**

7.



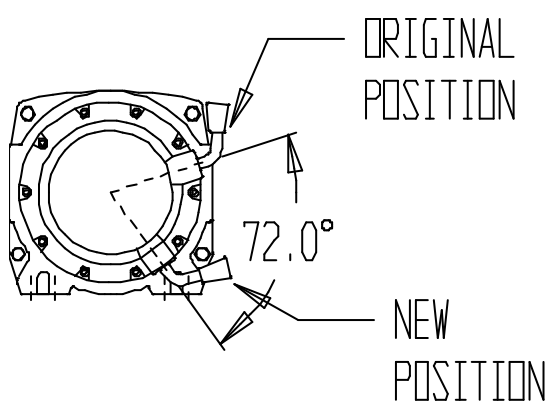
7. Push the top chrome tube through the hole in the buffer and fasten using the M12 x 40mm bolts, washers and spring washers.

8.



8. Mount the Impact Absorber brackets to each side of the chassis using original fasteners.
9. Fit flat washer 35 x 12 x 2.5mm to side hole of bracket and fasten.

9.

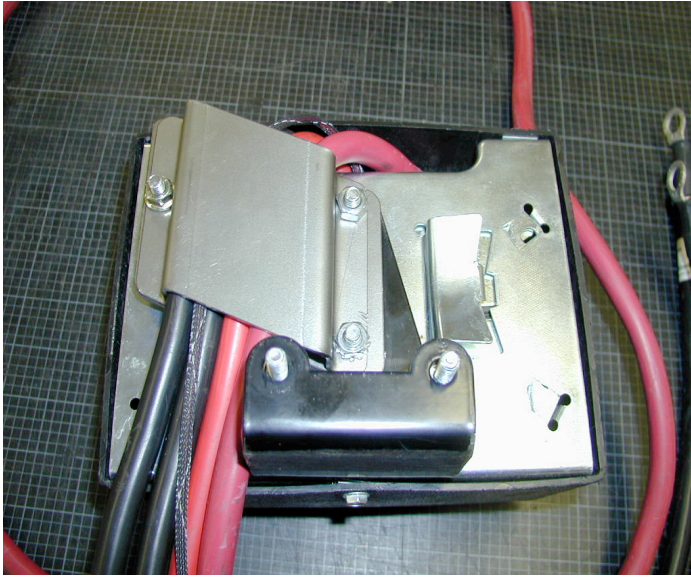


(If fitting the winch.)

10. To place the winch clutch handle in a convenient location the winch gearbox must be rotated 2 hole spacings, 72 degrees, in an clockwise direction when viewed from the gearbox end. Place the winch on its end and remove all gearbox bolts. Gently raise the gearbox just enough to rotate it. Do not completely remove the gearbox and avoid damaging the gasket. Refit all bolts and tighten.

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

10.



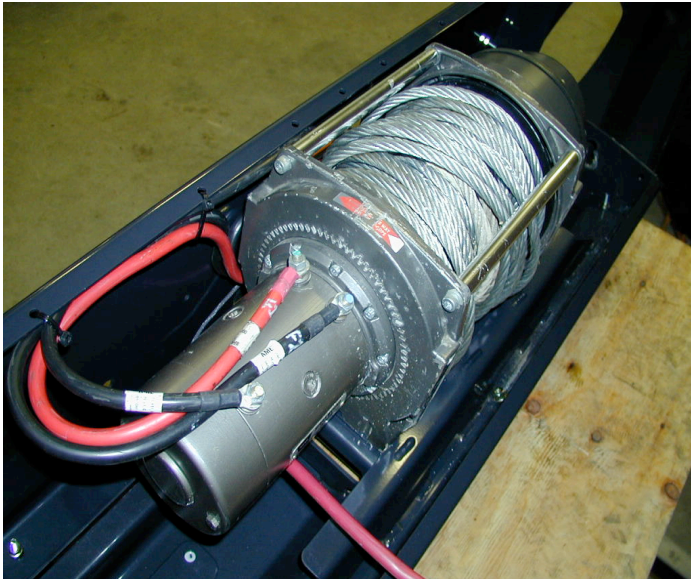
11. By undoing the screws on the side of the control box, remove the top cover and replace the three short leads with the longer ones supplied in the fitting kit.
12. Position the control box bracket, then the lead insulator bracket to the back of the control box.
13. Ensuring the leads are neatly on top of the bkt place the cover bkt on and fasten with the control box nuts and the M6 x 16mm bolt and flange nut.

11.



14. Fasten control box assembly to the bar using the M6 x 16mm bolts and flange nuts.

12.



15. Install the winch and roller fairlead using bolts, nuts and spring washers supplied by Warn, and the 25 x 11.5 x 1.6mm flat washers supplied in the bolt kit. Refer to Warn installation instructions for correct procedure. Adjust winch in slots until the winch is centralised in the bull bar.
16. Connect Control box leads to winch. Refer to the Warn winch handbook for additional information.

13.



(If not fitting winch)

17. Wrap rubber extrusion around the winch cover and trim excess.
18. Place spacer washers over the winch cover fixing holes, located on the top face of the winch bumper.
19. Place the winch cover on top of the winch bumper inline with the mount holes.
Bolt together using the M6 button head stainless steel screws and M6 nuts.

14.



20. Using sharp scissors or a cutting blade, cut the plastic inner guard as per line shown in the photo.

15.



With winch

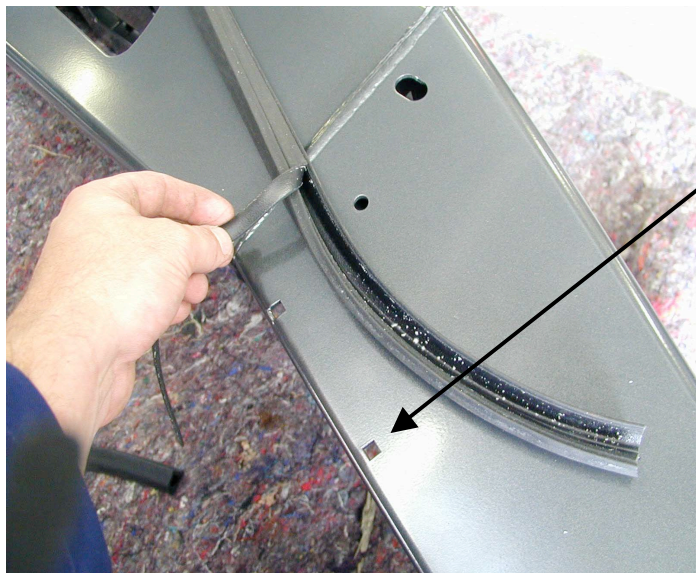


Without winch

(If fitting with winch.)

21. Peel off one side of the double sided tape and adhere to the top rear side of the number plate.
Note: Clean the adhering surfaces before applying tape with an alcohol solvent.
22. Peel off the other side of the tape and bolt to the winch bumper with the M6 X 16mm bolts and M6 flange nuts through the lower holes of the number plate.
23. Press firmly to the top of the number plate so the tape can properly adhere.
(If not fitting with winch.)Bolt the number plate through the top holes using M6 X 16mm bolts and M6 flange nuts. If desired the double sided tape can be used down the sides of the number plate.

16.



24. The rubber extrusion contains a support section to assist in the moulding. Remove this section by tearing at one end. Discard this section.

25. Insert the square plastic plugs into the square holes on the top face of the wing.

17.



26. Insert the mount strips inside the channel section of the rubber extrusion. Make sure the flap section is on the outer side. Allow generous even amounts of excess at either end of the strip so that it can be trimmed later.

18



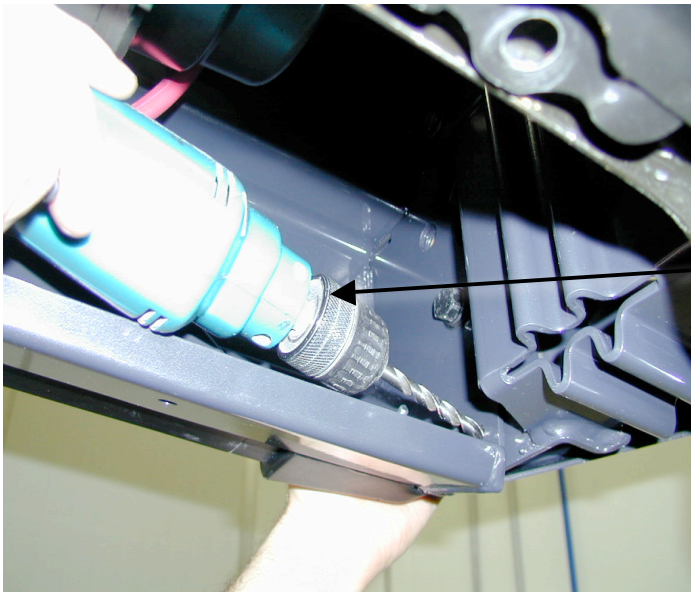
27. Using a phillips head screw driver or cordless drill with a phillips head tip fix the extrusions to the top of the wings using the self taper screws.

19.



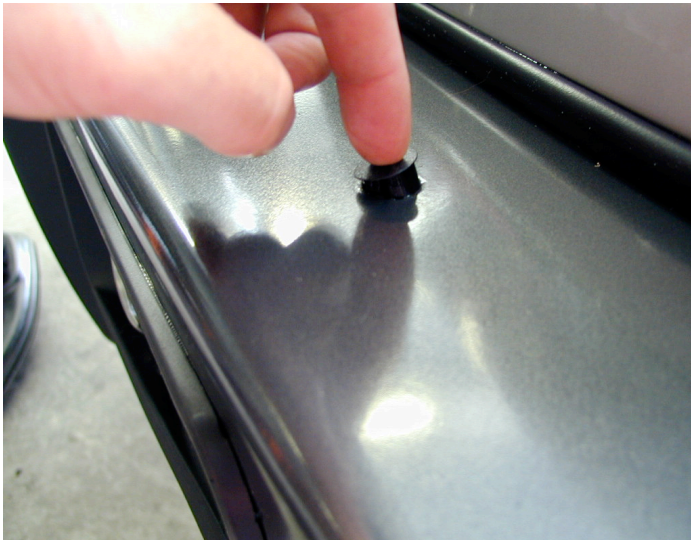
28. Using a sharp knife cut the excess rubber in line with the inside end of the wing. Only cut the inside excess, the other end will be cut when the winch bumper is fitted.

20.



29. With the aid of another person carefully place the bar on the mounting brackets.
30. Horizontally and vertically align the bar to the body and fasten using the six M12 x 40mm bolts, large washers and M12 spring washers. Tighten all bolts so as the large washer deforms inside the cutout.
31. Drill out the lower pin bolt hole on each side with a 8mm or 5/16" drill bit.
32. Fasten with 8mm x 16mm bolts and flange nuts.

21.



33. There are two 16 dia holes located on the top face of the bar. If no CB aerals are fitted the holes can be covered with the plastic plugs provided in the fitting kit.

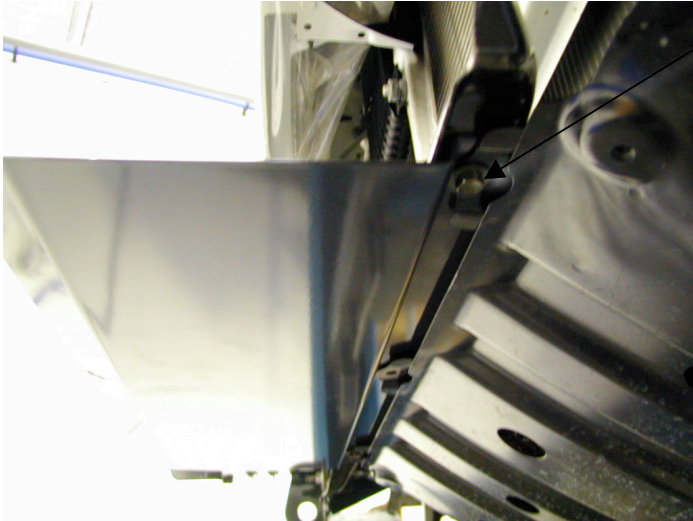
22.



(If fitting with winch)

34. Feed the winch cable through the roller fair lead. Mount the hook to the end of the cable.

23.



35. Undo the three front pan bolts and loosen the two rear ones.
36. Position splash pan between the body and the original pan and loosely fasten with original bolts.
37. Connect splash pan to underside of bar using the M8 x 16mm bolts and flange nuts.
38. Tighten all bolts

24. (If fitting with winch)

Connect the long winch + & - cables to the vehicle after the bar is installed.

Refer to the Warn winch manual for vehicle wiring instructions.

Ensure that these cables are installed well clear of sharp, hot or moving objects. Secure the winch cables to the vehicle and winch bumper with the supplied cable ties.