



INSTALLATION INSTRUCTIONS

SEMI HIDDEN KIT

Part Number: 103209

Application: 2014+ Toyota Tundra

GENERAL SAFETY PRECAUTIONS

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

IMPACT AND MOVING PARTS ENTANGLEMENT HAZARD

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

- **Always** take time to fully read the Instructions and/or Operations Guide, and/or Basic Guide to Winching Techniques, in order to understand your winch and its operations.
- **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 (on both sides of material) 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.
- **Always** wear safety glasses when installing this kit. A drilling operation will cause flying metal chips. Flying chips can cause eye injury.
- **Always** use extreme caution when cutting and trimming during fitting.
- **Always** remove jewelry and wear eye protection.
- **Never** lean over battery while making connections.
- **Never** route electrical cables:
 - o Across any sharp edges.
 - o Through or near moving parts.
 - o Near parts that become hot.
- **Always** insulate and protect all exposed wiring and electrical terminals.
- **Always** install terminal boots as directed in installation instructions.
- **Always** use appropriate and adequate care in lifting components into place.
- **Always** insure components will remain secure during installation and operation.
- **Always** tighten all nuts and bolts securely, per the installation instructions.
- **Always** perform regular inspections and maintenance on the plow mechanism, fasteners, cable and related hardware.
- **Always** replace all worn or damaged parts before operating.
- **Never** operate this WARN product with damaged or missing parts.

Read installation and operating instructions thoroughly.

WARN INDUSTRIES, INC. 12900 S.E. Capps Road,
Clackamas, OR USA 97015-8903, 1-503-722-1200, FAX: 1-503-722-3000
Customer Service: 1-800-543-9276
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⚠ 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.
- **Never** operate this product if you are under 16 years of age.
- **Never** operate this product when under the influence of drugs, alcohol or medications.

Read installation and operating instructions thoroughly.

NOTICE

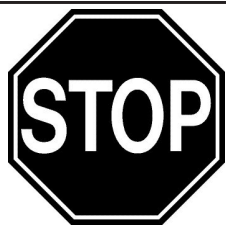
EQUIPMENT DAMAGE

- **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.

BEFORE YOU BEGIN

NOTICE



This product may interfere with driver assist systems such as adaptive cruise control and parking assist systems that have sensors or cameras installed in the bumpers or front grill area. If your vehicle is equipped with any of these systems or features, consult your vehicle owner's manual before installing this product. These systems may need to be disabled as a result of installing this product.

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TOOLS REQUIRED

- Standard wrenches
- Standard sockets
- Reciprocal saw or other cutting tool

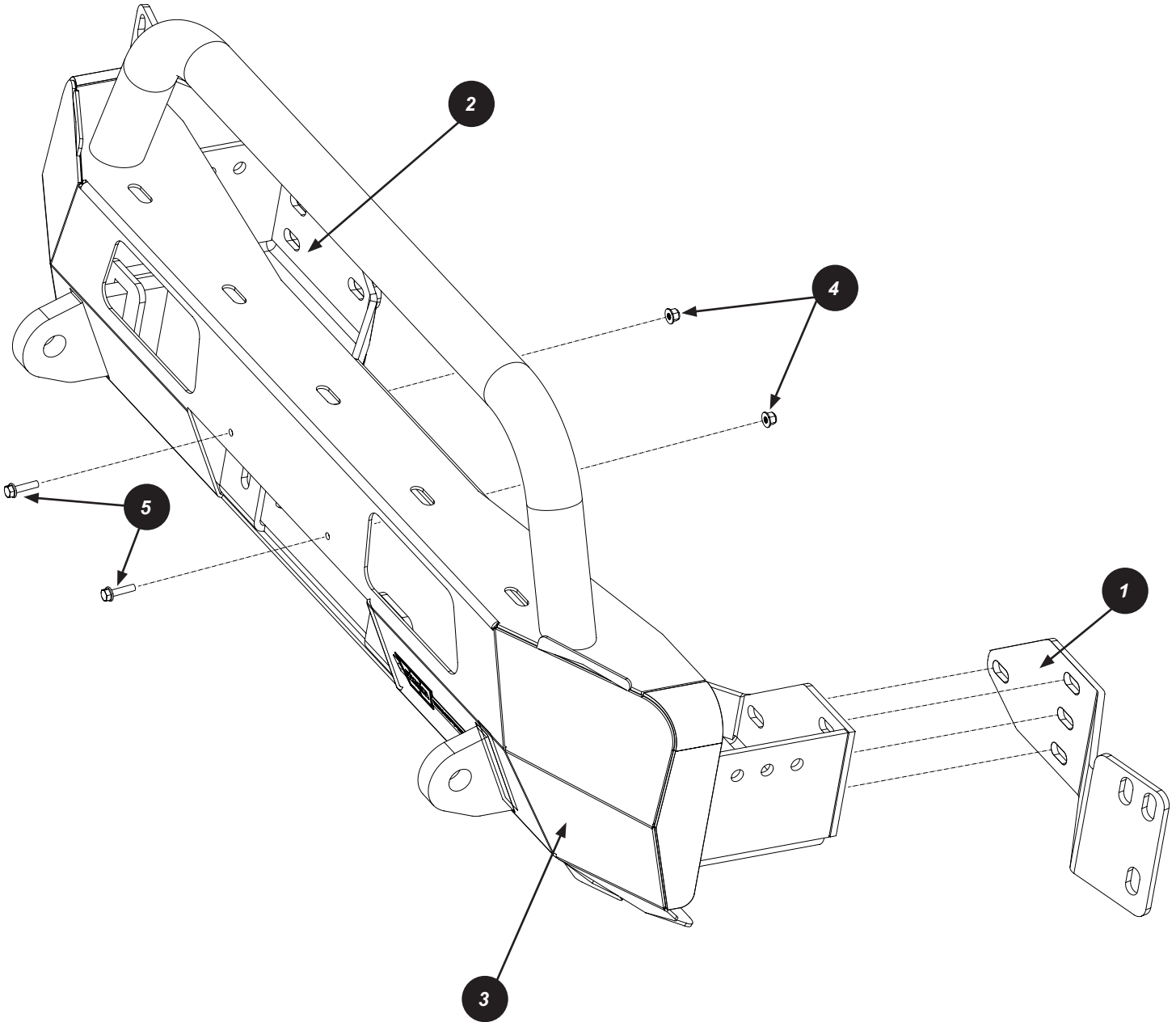
TORQUE SPECIFICATIONS

Please use the recommended torque specifications when assembling this product unless otherwise specified in the instructions.

FASTENER SIZE			FASTENER TORQUE		
	lb-ft	(N.m)		lb-ft	(N.m)
1/4"	8	(11)	M4	(2)	3
5/16"	17	(23)	M5	(4.5)	6
3/8"	30	(40)	M6	(7.5)	10
7/16"	48	(66)	M8	(18)	25
1/2"	74	(100)	M10	(37)	50
9/16"	106	(144)			
5/8"	148	(200)			
3/4"	269	(364)			

PARTS LIST

ITEM	PART NO.	DESCRIPTION	QTY	ITEM	PART NO.	DESCRIPTION	QTY
1	103206	LH BUMPER BRACKET	1	4	83125	M6 X 1.0 NUT	2
2	103195	RH BUMPER BRACKET	1	5	64108	M6-1.0 x 25 BOLT	2
3	102846	SEMI HIDDEN WELDMNT	1	6	102248	BLACK PLASTIC PLUG (not shown)	2



INSTALLATION INSTRUCTIONS

1. Using a 10mm socket, remove grille by removing the four front center screws, as well as the two outer push pins.

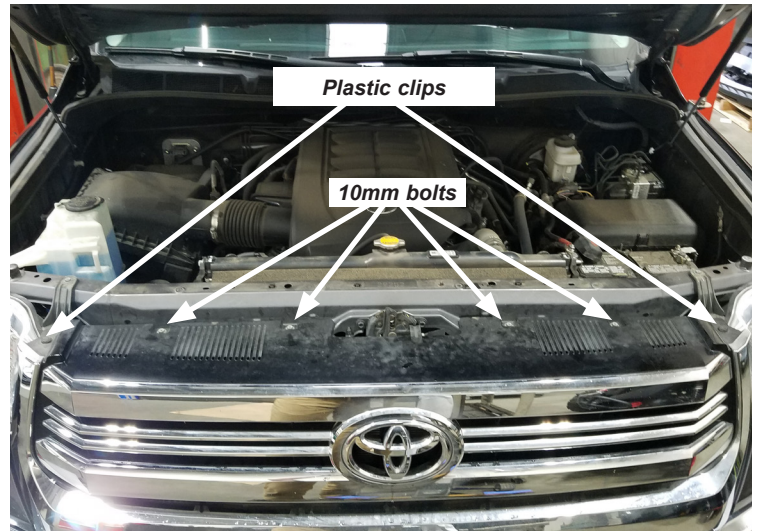


Figure 1

2. Remove one plastic clip from fender liner (both sides).



Figure 2

3. Using a 17mm socket, remove the two bolts securing the tow hook (each side). Remove tow hook and set aside. **Save tow hook and bolts for reuse.**



Figure 3

4. Remove three screws holding bumper to skid pan.
Optional: Remove skid pan to increase access for upcoming installation.

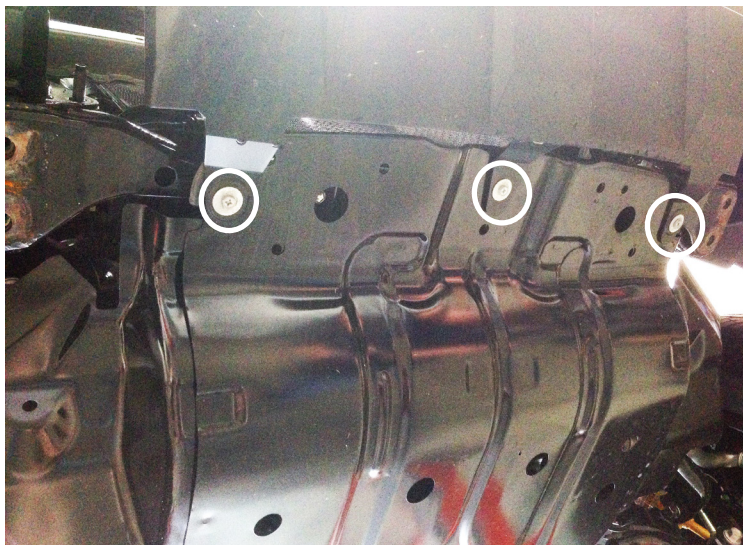


Figure 4

5. From underneath the bumper, use a 14mm socket to remove the four nuts (each side) holding the bumper structure to the frame rails. Save nuts for reuse.

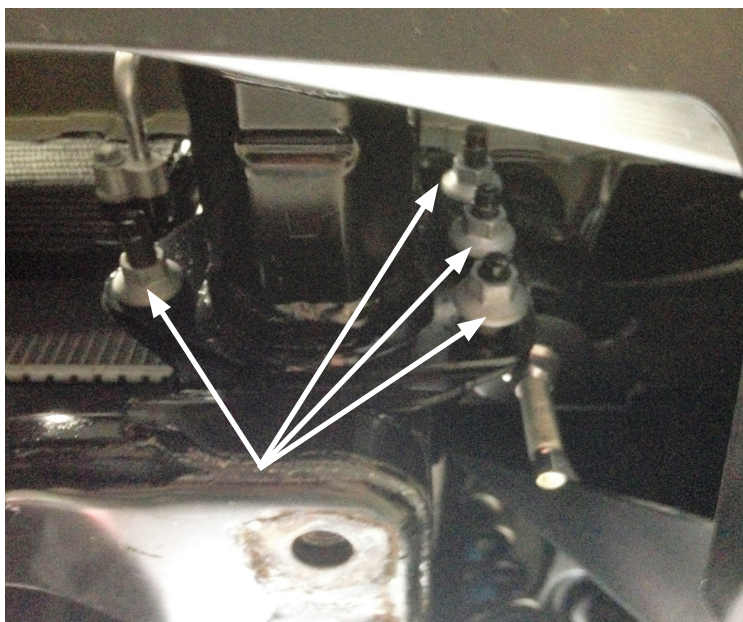


Figure 5

6. *If equipped*, disconnect harness from rear of fog lamps and disconnect park sensor harness (both sides).

⚠ WARNING Always use assistance when moving or lifting heavy parts.

6. Remove and set aside bumper.

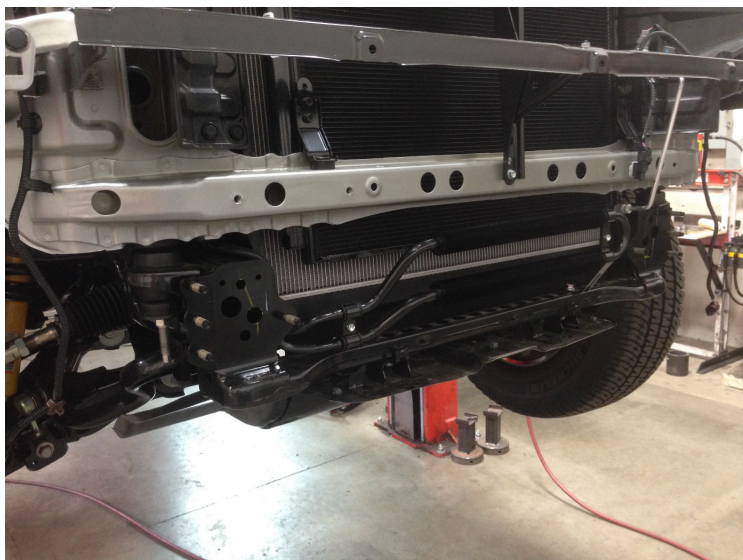


Figure 6

7. From inside of the stock bumper, remove the plastic fender liners by removing the 10 fasteners (five on each side) using a 10mm socket.



Figure 7

8. Using a 12mm socket, remove the remaining hardware securing the bumper structure and front bumper reinforcement bar to the bumper. Retain hardware for later use.

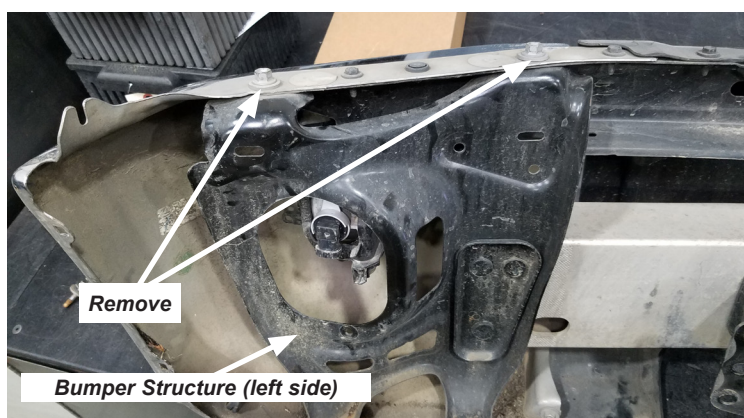


Figure 8

9. Using a 14mm socket, remove the 6 nuts securing the bumper structure to the reinforcement bar. Retain hardware for later reinstall.

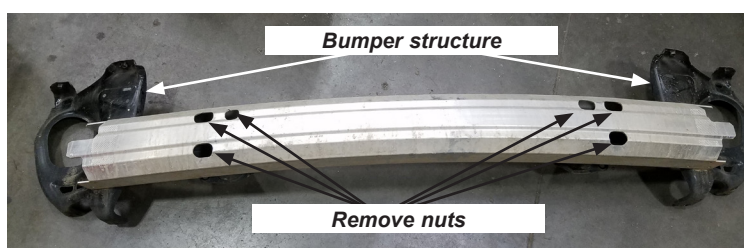


Figure 9

10. Reinstall bumper structure using the original hardware. Do not completely tighten to leave room for adjustment.

11. Install new the left (1) and right (2) bumper brackets to the stock bumper, using the six reinforcement bar nuts.

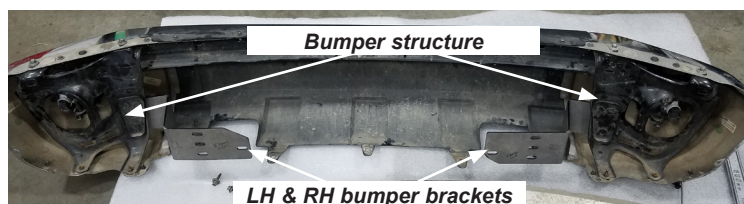


Figure 10

12. From the outside of the bumper, use a reciprocating saw or similar tool to carefully cut out the center plastic (following styling lines). *Tip: Mask cut lines to prevent unnecessary damage.*

NOTE: Relocating the control pack can be done to avoid next step.

For winches with top mounted control pack only:

13. From the inside of the bumper, carefully cut a 10 x 2 inch section out of the center of the bumper support rib. **NOTE: Be sure to cut only on the support rib. Do not cut through the outside of the bumper.**

NOTE: For winches with a remote plug on the side of the contactor, extend the cutout and additional four inches, making the cut out 14 x 2 inches.

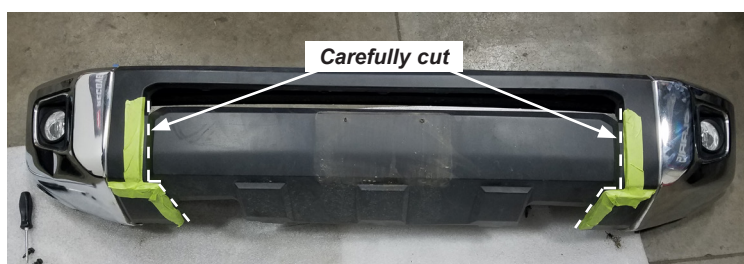


Figure 11

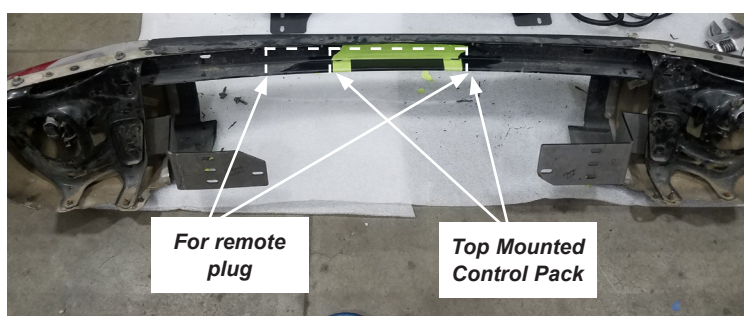


Figure 12

14. Reinstall the plastic fender liners using original hardware.



Figure 13

15. Mount the fairlead to the semi hidden weldment (3), according to your winch mounting instructions.



Figure 14

16. Mount the winch to the semi hidden weldment according to your winch mounting instructions

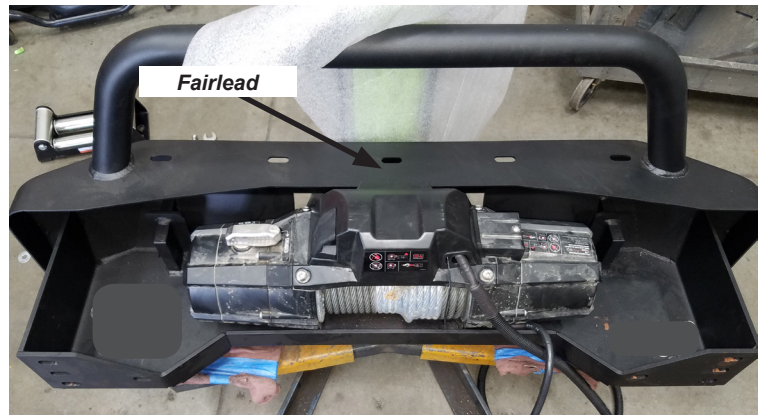


Figure 15

⚠ WARNING Always use assistance when moving or lifting heavy parts.

17. With assistance, place bumper in position on vehicle. **Do not install nuts yet.**

18. Before installing the semi hidden weldment/winch assembly, route the winch power cables through the cutout in the bumper and in front of the radiator.



Figure 16

⚠ WARNING Always use assistance when moving or lifting heavy parts.

19. With assistance, line up the semi hidden weldment/winch assembly.
20. Slide it underneath the bumper and then up into position (lining up mounting studs).
21. The winch control pack is the part that must pass underneath and into the space you trimmed out. **NOTE:** More trimming may be necessary to obtain accurate fit.

NOTE: Be sure to keep winch power cables clear of weldment assembly.



Figure 17

22. Once accurate fit is achieved, install the four factory mounting nuts (4 per side). **Do not tighten to allow for adjustment.**
23. Adjust and center the bumper and semi hidden assembly horizontally. **NOTE: Horizontal adjustment is at the frame pad studs.**
23. Align the stock bumper vertically. **NOTE: Vertical alignment of the stock bumper is adjusted at the bumper bracket vertical slots.** **TIP:** We recommend using a floor jack to help with this.
24. Now that all the hardware is installed:
 - a) Check to make sure that there isn't too much space between the frame brackets and the bumper.
 - b) Confirm bumper is centered and aligned vertically and horizontally.
 - c) Once satisfied with alignment, torque all hardware to suggested values on page 2. **NOTE: Always make adjustments with assistance.**
25. Installation is now complete. Use the two bolts (5) and nuts (4) to install license plate to the front of the weldment. **NOTE: Plastic plugs (6) are included for the two lower front winch access holes.**



Figure 18



Figure 19

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.