



INSTALLATION INSTRUCTIONS FOR MOUNTING

LUVERNE GRILL GUARDS WITH THE FOLLOWING MODEL NOS.:
330750/330753 & 340750/340753 ON:

2007 AND NEWER TOYOTA TUNDRA SERIES TRUCKS

1. READ THE INSTRUCTIONS COMPLETELY AND CHECK TO MAKE SURE THAT ALL OF THE REQUIRED PARTS ARE ON HAND BEFORE STARTING THE INSTALLATION. THE CARTON SHOULD CONTAIN:
 - (1) OUTER RING PACKAGE
 - (1) OUTER RING ASSEMBLY
 - (1) UPRIGHT PACKAGE
 - (1) UPRIGHT ASSEMBLY, RH
 - (1) UPRIGHT ASSEMBLY, LH
 - (1) MOUNTING BRACKET, RH
 - (1) MOUNTING BRACKET, LH
 - (1) MOUNTING BRACKET, RH, TOP
 - (1) MOUNTING BRACKET, LH, TOP
 - (1) HARDWARE PACKAGE
 - (1) CUSTOMER SERVICE PACKAGE

GUARD ASSEMBLY & INSTALLATION INSTRUCTIONS 2-11

2. LOOSEN AND REMOVE THE TWO BOLTS IN THE BOTTOM OF THE RIGHT HAND FRAME RAIL, THAT SECURE THE TOW HOOK TO THE FRAME.
3. SPIN A ½"-13 SERRATED FLANGE NUT (ITEM #13) ALL THE WAY ONTO THE THREADED END OF THE TOP RH MOUNTING BRACKET (ITEM #6), AS SHOWN IN *fig. 1*. INSERT THE BRACKET END OF THE BRACKET THROUGH THE OUTSIDE HOLE IN THE FACE OF BUMPER AND INSTALL TO THE TOP TWO BOLTS ON THE OUTSIDE OF THE FRAME, THAT ATTACH THE END FRAME HORN TO THE END OF THE MAIN FRAME, USING TWO M10 X 1.25 FLANGE NUTS (ITEM #22).
4. INSTALL THE RIGHT HAND MOUNTING BRACKET (ITEM #4), (NOTE: INSERT THE THREADED END OF THE TOP MOUNTING BRACKET THROUGH THE TOP HOLE IN THE BACK OF THE BOTTOM MOUNTING BRACKET AND INSTALL A ½"-13 SERRATED FLANGE NUT (ITEM #13) BEFORE ATTACHING THE BOTTOM BRACKET TO THE FRAME.) USING THE TWO M12 X 1.25 X 45mm BOLTS (ITEM #16), TWO ½" LOCK WASHERS (ITEM #18) AND TWO 7/16" FLAT WASHERS (ITEM #20) REINSTALL THE TOW HOOK AS SHOWN IN *fig. 1, 2 & 3*. HAND TIGHTEN ONLY AT THIS TIME.
5. REPEAT STEPS 2 & 3 FOR THE LEFT HAND SIDE.
6. CHECK THAT THE BRACKETS ARE PARALLEL AND THAT THE TOP CORNERS OF THE MOUNTING BRACKET CHANNELS ARE APPROX. 40-11/16" OUT TO OUT. SEE *fig. 1*. TIGHTEN THE M12 X 1.25 X 35mm BOLTS (ITEM #16) IN THE BOTTOM OF THE FRAME TO 54 FOOT-POUNDS OF TORQUE. TIGHTEN THE M10 X 1.25 NUTS (ITEM #22) ON THE TOP MOUNTING BRACKETS TO 31 FOOT-POUNDS OF TORQUE. RUN THE BACK NUT ON THE TOP BRACKET UP SNUG AGAINST THE BACK OF THE CHANNEL OF THE BOTTOM MOUNTING BRACKET. TIGHTEN THE FRONT NUT WHERE THE TOP BRACKET ATTACHES TO THE BOTTOM BRACKET TO 75 FOOT-POUNDS OF TORQUE.

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TRUCK EQUIPMENT

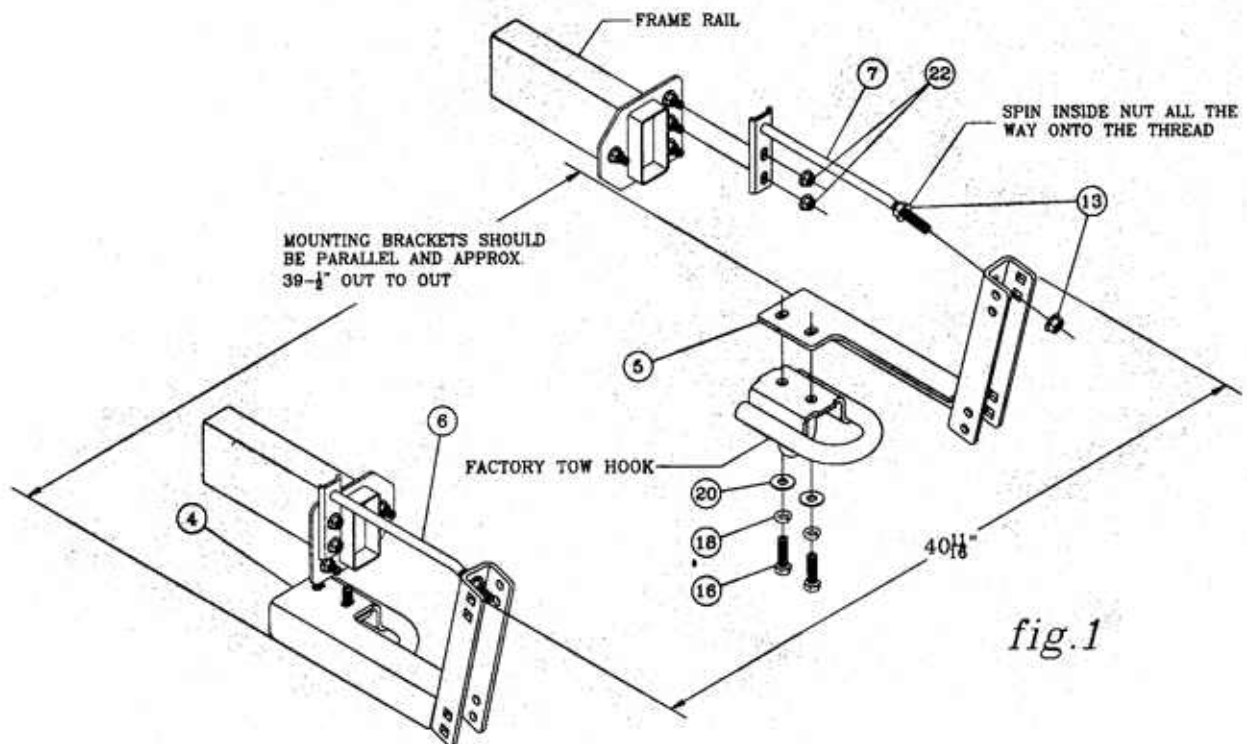
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7. INSTALL THE RIGHT HAND UPRIGHT (ITEM #2) ONTO THE MOUNTING BRACKET USING THE 1/2"-13 X 3" ROUND HEAD BOLTS (ITEM #11), 1/2" SAE FLAT WASHERS (ITEM #19) AND 1/2"-13 CAP NUTS (ITEM #14).
8. REPEAT STEPS 5 FOR THE LEFT HAND SIDE.
9. INSTALL THE RING (ITEM #1) BY LOWERING IT DOWN FROM THE TOP AND BEHIND THE UPRIGHTS, (TAKING CARE NOT TO SCRAPE THE ENDS OF THE RING AGAINST THE SIDE OF THE VEHICLE.) AND SLIDE THE RING INTO THE NOTCHES OF THE UPRIGHTS. FASTEN WITH 7/16"-14 X 1-1/2" HEX BOLTS (ITEM #15), 7/16" FLAT WASHERS (ITEM #20) AND 7/16" LOCK WASHERS (ITEM #17) INTO THE 7/16"-14 CAPTIVE NUTS (ITEM #21) IN THE UPRIGHT MOUNTING PLATES.
10. CHECK THAT THE GRILL GUARD IS CENTERED AND VERTICAL ON THE BUMPER AND THE UPRIGHTS ARE STRAIGHT UP AND DOWN. THEN TIGHTEN THE FOUR 7/16" BOLTS (ITEM #15) SECURING THE RING TO THE UPRIGHTS. TIGHTEN TO 54 FOOT-POUNDS OF TORQUE..
11. TIGHTEN THE FOUR 1/2" CAP NUTS (ITEM #14), SECURING THE UPRIGHTS TO THE MOUNTING BRACKETS, TO 75 FOOT-POUNDS OF TORQUE.



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SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	202394	1	RING WELDMENT - CHROME
1	202413	1	RING WELDMENT - BLACK
2	202398	1	UPRIGHT WELDMENT - CHROME, RH
2	202414	1	UPRIGHT WELDMENT - BLACK, RH
3	202399	1	UPRIGHT WELDMENT - CHROME, LH
3	202415	1	UPRIGHT WELDMENT - BLACK, LH
4	202405	1	MOUNTING BRACKET - RH
5	202406	1	MOUNTING BRACKET - LH
6	202416	1	MOUNTING BRACKET - RH, TOP
7	202417	1	MOUNTING BRACKET - LH, TOP
8	201122	2	TAPPING BAR - 13.000"
9	202243	2	TAPPING BAR - 14.000"
10	202404	2	RUBBER EXTRUSION - MACHINED, 33.50"
11	107231	4	ROUND HEAD BOLT - 1/2"-13 X 3", SST
12	103715	12	SELF TAPPING SCREW - 1/4"-20 X 5/8"
13	100123	4	SERRATED FLANGE NUT - 1/2"-13
14	104994	4	HEX CAP NUT - 1/2"-13, SST
15	100070	4	HEX HEAD SCREW - 7/16"-14 X 1-1/2", ZP
16	107789	4	HEX HEAD SCREW - M12 X 1.25 X 45mm, ZP
17	100078	4	LOCK WASHER - 7/16", ZP
18	100121	4	LOCK WASHER - 1/2", ZP
19	104995	4	FLAT WASHER - SAE, 1/2", SST
20	100081	8	FLAT WASHER - 7/16", ZP
21	100083	4	CAPTIVE NUT - 7/16"-14
22	107795	4	HEX FLANGE NUT - M10 X 1.25, ZP
23	105293	4	TUBE PLUG - Ø1-1/4"
24	106901	1	DECAL-MATTE, BLACK, RH
25	106902	1	DECAL-MATTE, BLACK, LH
26	100252	1	DECAL - LOGO, 1 X 3



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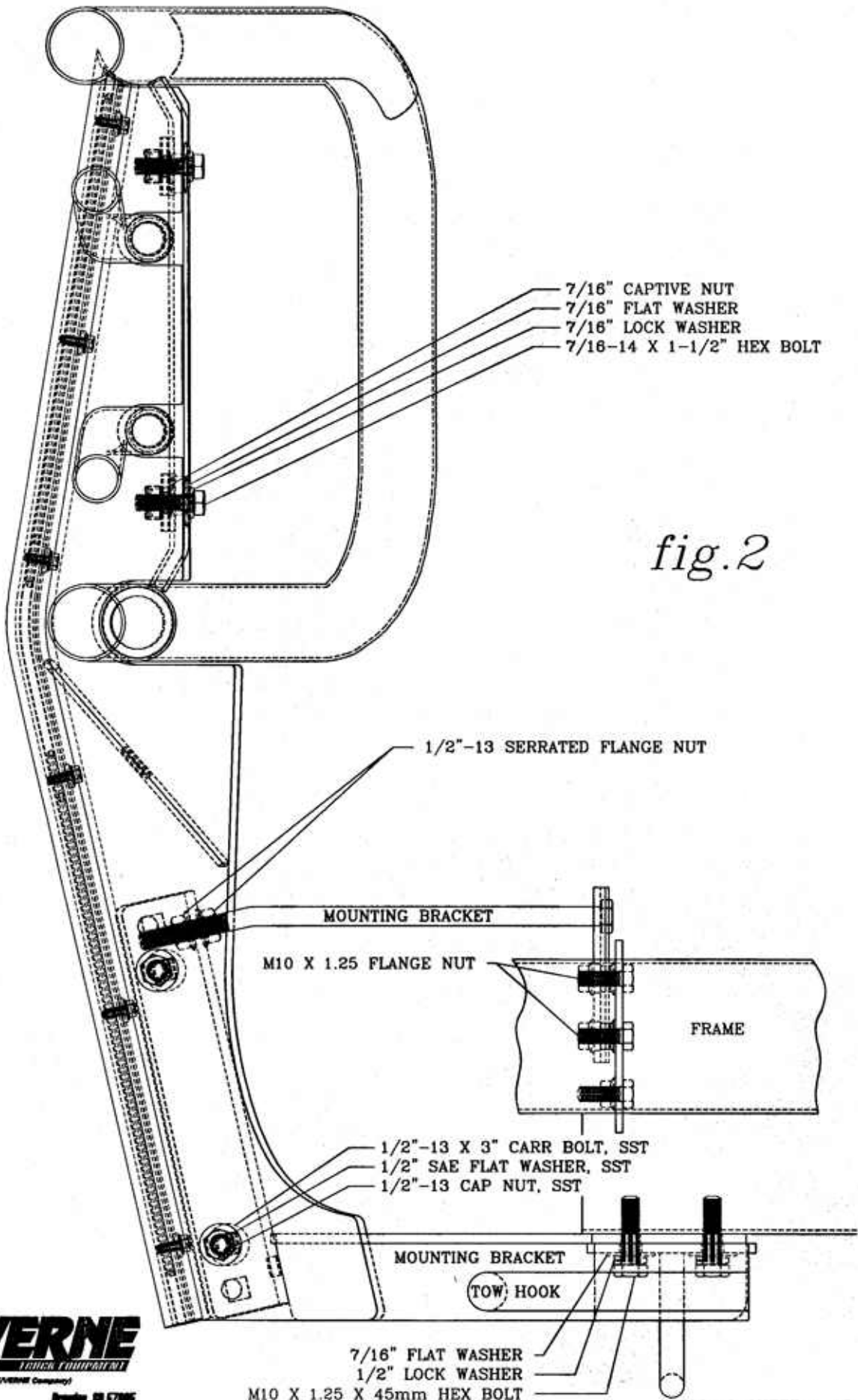
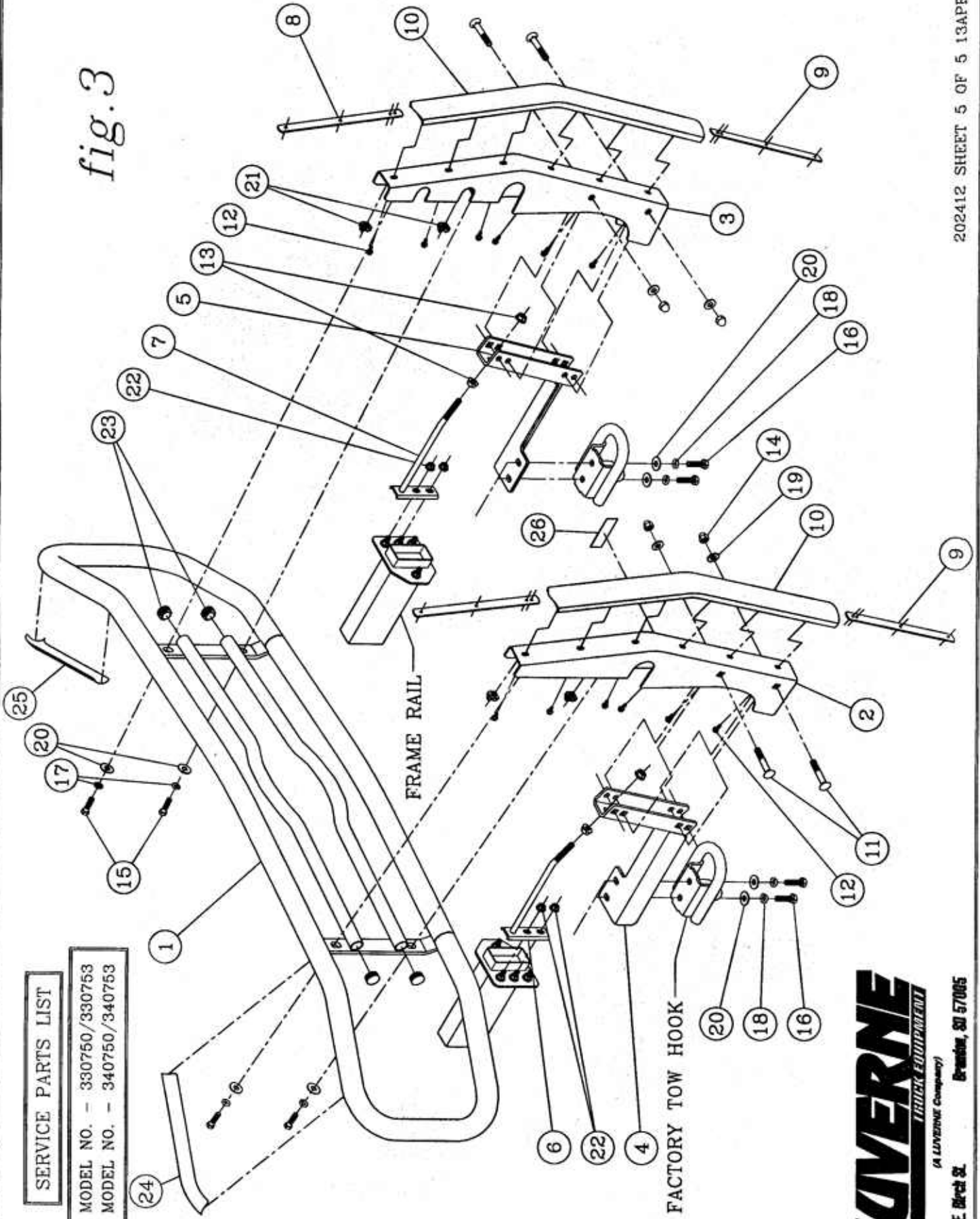


fig.2

fig. 3



SERVICE PARTS LIST

MODEL NO. - 330750/330753
 MODEL NO. - 340750/340753

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