




INSTALLATION INSTRUCTIONS FOR MOUNTING

LUVERNE GRILL GUARDS WITH THE FOLLOWING MODEL NOs.:
331450/331453 & 341450/341453 ON:

2014 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, LH
 - (1) UPRIGHT ASSEMBLY, RH
 - (1) MOUNTING BRACKET, LH
 - (1) MOUNTING BRACKET, RH
 - (1) TOP MOUNTING BRACE
 - (2) UPRIGHT COVERS (**CHROME GUARDS ONLY**)
 - (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 FRAME RAIL, THAT SECURE THE TOW HOOK TO THE FRAME. REMOVE THE TOW HOOKS AND SET ASIDE.
3. REMOVE THE TOP TWO NUTS OF THE BOLTS THAT ATTACH THE END FRAME HORN TO THE END OF THE MAIN FRAME. INSERT THE FRAME END OF THE BRACES (ITEM #6) THROUGH THE OUTSIDE HOLE IN THE FACE OF BUMPER AND INSTALL THE M10 X 1.25 FLANGE NUTS (ITEM #24). LEAVE LOOSE AT THIS TIME. (**SEE NOTE BELOW**)
4. **NOTE:** AT THIS POINT IT WILL BE NECESSARY TO NOTCH OUT THE TOP END SECTION OF THE PLASTIC FILLER PANEL TO ALLOW THE TOP MOUNTING BRACE TO COME THROUGH. 
5. INSTALL THE BOTTOM MOUNTING BRACKETS (ITEM #4 & 5), ALONG WITH THE TOW HOOKS REMOVED IN STEP #2 USING THE FOUR M12 X 1.25 X 45mm BOLTS (ITEM #16), FOUR 1/2" LOCK WASHERS (ITEM #17) AND FOUR 7/16" FLAT WASHERS (ITEM #20). LEAVE LOOSE AT THIS TIME.
6. INSTALL THE UPRIGHTS (ITEM #2 & #3) ONTO THE MOUNTING BRACKETS USING THE 1/2"-13 X 3" ROUND HEAD BOLTS (ITEM #11), 1/2" SAE FLAT WASHERS (ITEM #19) AND 1/2"-13 ACORN NUTS (ITEM #14).
7. FASTEN THE THE TOP MOUNTING BRACES (ITEM #6) TO THE UPRIGHTS USING THE 1/2"-13 X 1-1/2" HEX HEAD BOLTS (ITEM #12), 1/2" FLAT WASHERS (ITEM #18) AND 1/2" LOCK WASHERS (ITEM #17) INTO THE 1/2"-13 CAPTIVE NUTS (ITEM #22).

LUVERNE
TRUCK EQUIPMENT

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 THE UPRIGHT COVERS (ITEM #26) (**CHROME GUARDS ONLY**), 7/16"-14 X 1-1/4" HEX BOLTS (ITEM #15) AND 7/16" FLAT WASHERS (ITEM #21) INTO THE 7/16"-14 CAPTIVE NUTS (ITEM #23) 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 M12 X 1.25 X 45mm BOLTS (ITEM #16), SECURING THE BRACKETS TO THE FRAME.
11. MAKE SURE THE UPRIGHTS ARE STRAIGHT UP AND DOWN AND TIGHTEN THE FOUR 1/2" ACORN NUTS (ITEM #14), SECURING THE UPRIGHTS TO THE MOUNTING BRACKETS.
12. TIGHTEN THE M10 X 1.25 HEX FLANGE NUTS (ITEM #24) ATTACHING THE TOP MOUNTING BRACES (ITEM #6) TO THE FRAME.
13. TIGHTEN THE 1/2"-13 X 1-1/2" BOLTS (ITEM #12) SECURING THE TOP MOUNTING BRACES TO THE UPRIGHTS.

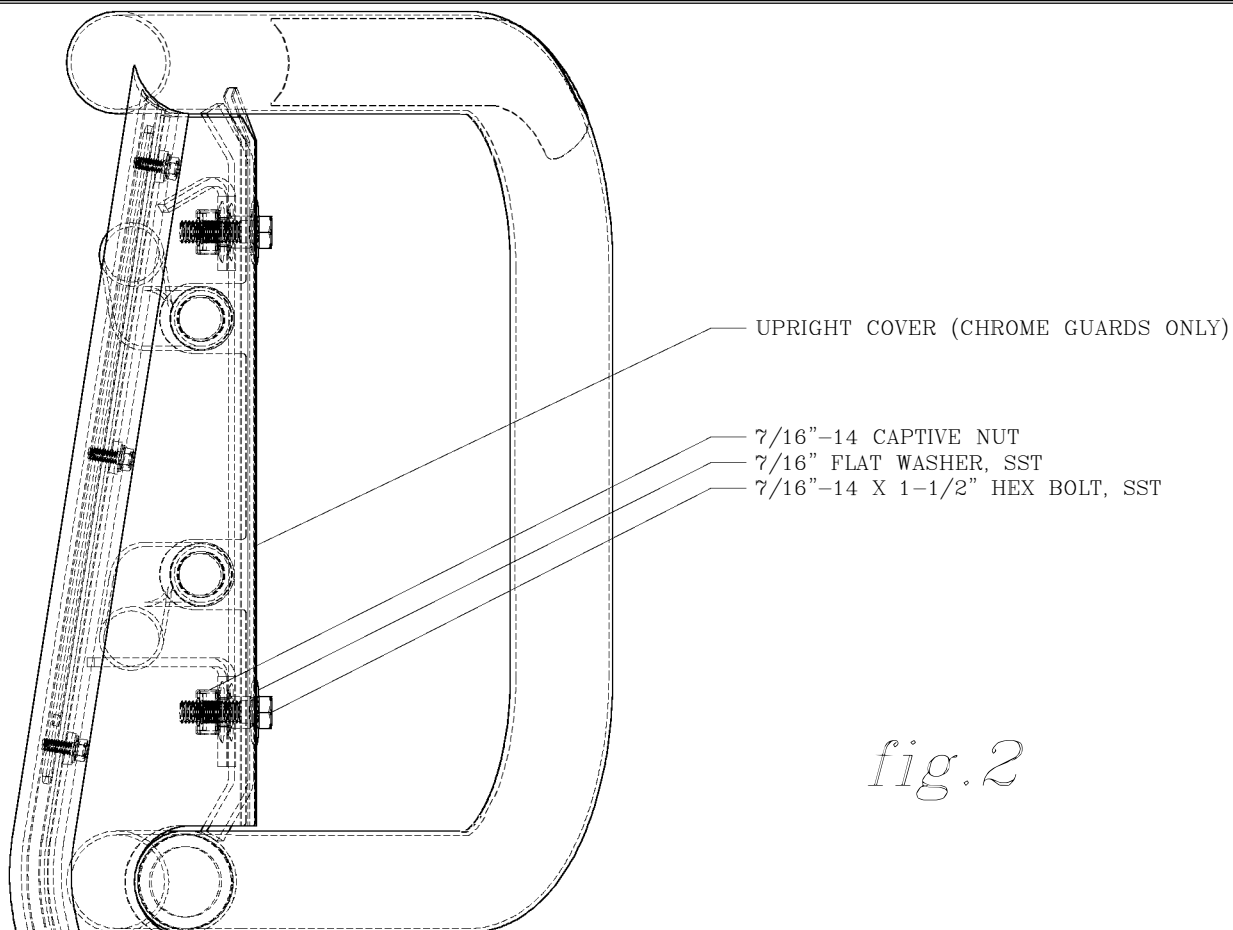
NOTE: IF ONE SIDE OF THE GRILLE GUARD SITS HIGHER THAN THE OTHER (LEFT SIDE?) USE THE REQUIRED NUMBER OF SPACERS (ITEM #7) BETWEEN THE BOTTOM OF THE FRAME AND THE TOP OF THE MOUNTING BRACKET TO HELP LEVEL IT OUT.



SERVICE PARTS LIST

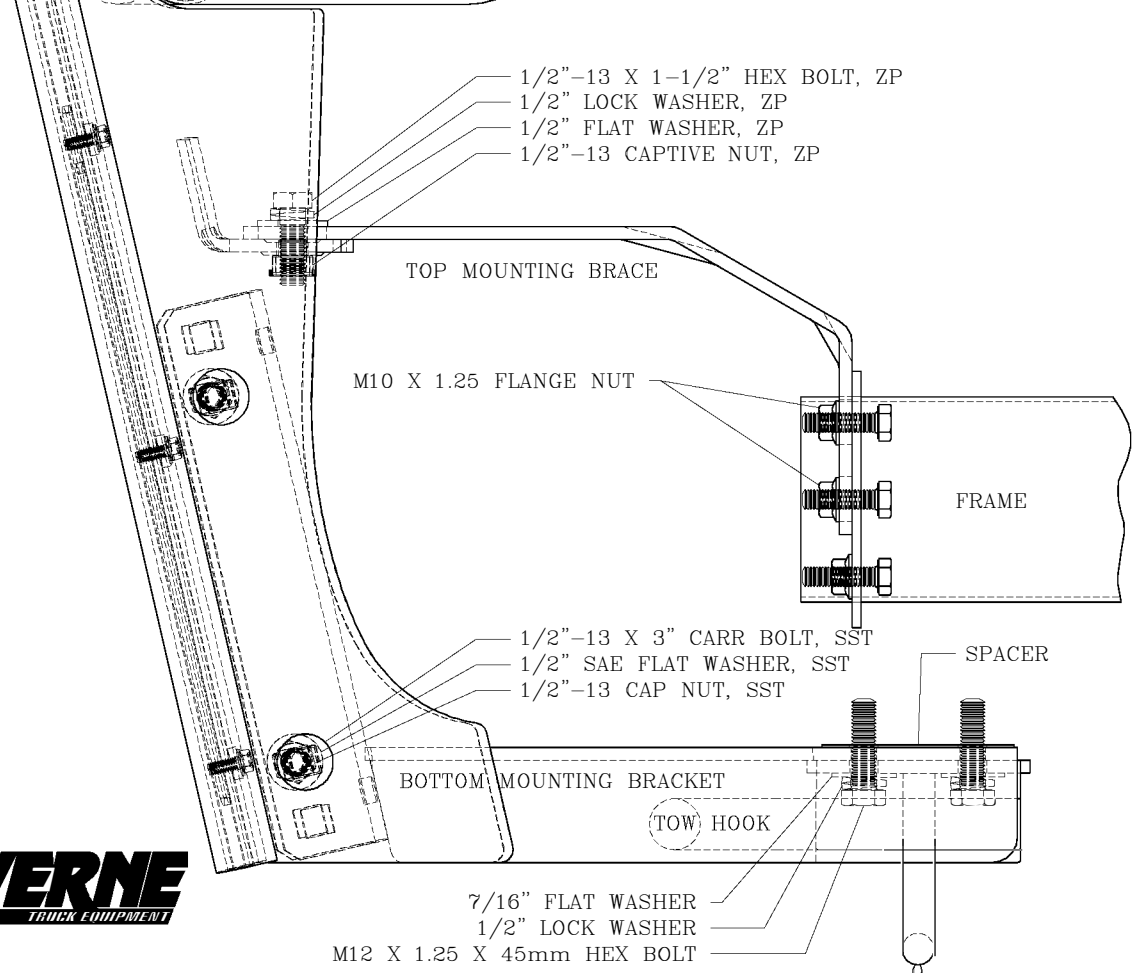
ITEM	PART NO.	QTY	DESCRIPTION
1	202726	1	RING WELDMENT – CHROME
1	202732	1	RING WELDMENT – BLACK
2	202710	1	UPRIGHT WELDMENT – CHROME, LH
2	202726	1	UPRIGHT WELDMENT – BLACK, LH
3	202711	1	UPRIGHT WELDMENT – CHROME, RH
3	202727	1	UPRIGHT WELDMENT – BLACK, RH
4	202717	1	MOUNTING BRACKET – LH
5	202718	1	MOUNTING BRACKET – RH
6	202722	2	MOUNTING BRACE – TOP
7	202697	5	SPACER, ZP
8	201122	2	TAPPING BAR – 13.000”
9	202243	2	TAPPING BAR – 14.000”
10	121168	2	RUBBER EXTRUSION – MACHINED,34.00”
11	107231	4	ROUND HEAD BOLT – 1/2”-13 X 3”, SST
12	100088	2	HEX HEAD BOLT – 1/2”-13 X 1-1/2”, ZP
13	103715	12	SELF TAPPING SCREW – 1/4”-20 X 5/8”
14	104994	4	ACORN NUT – 1/2”-13, SST
15	105939	4	HEX HEAD SCREW – 7/16”-14 X 1-1/4”,SST
16	107789	4	HEX HEAD SCREW – M12 X 1.25 X 45mm, ZP
17	100121	6	LOCK WASHER – 1/2”, ZP
18	100118	2	FLAT WASHER – 1/2”, ZP
19	104995	4	FLAT WASHER – SAE, 1/2”, SST
20	100081	4	FLAT WASHER – 7/16”, ZP
21	103286	4	FLAT WASHER – 7/16”, SST
22	107383	2	CAPTIVE NUT – 1/2”-13
23	100083	4	CAPTIVE NUT – 7/16”-14
24	107795	4	HEX FLANGE NUT – M10 X 1.25, ZP
25	105293	4	TUBE PLUG – Ø1-1/4”
26	202549	2	UPRIGHT COVERS (CHROME GUARDS ONLY)
27	106902	1	DECAL-MATTE, BLACK, LH
28	106901	1	DECAL-MATTE, BLACK, RH
29	100252	1	DECAL – LOGO, 1 X 3





- UPRIGHT COVER (CHROME GUARDS ONLY)
- 7/16" -14 CAPTIVE NUT
- 7/16" FLAT WASHER, SST
- 7/16" -14 X 1-1/2" HEX BOLT, SST

fig. 2



- 1/2" -13 X 1-1/2" HEX BOLT, ZP
- 1/2" LOCK WASHER, ZP
- 1/2" FLAT WASHER, ZP
- 1/2" -13 CAPTIVE NUT, ZP
- TOP MOUNTING BRACE
- M10 X 1.25 FLANGE NUT
- FRAME
- 1/2" -13 X 3" CARR BOLT, SST
- 1/2" SAE FLAT WASHER, SST
- 1/2" -13 CAP NUT, SST
- BOTTOM MOUNTING BRACKET
- TOW HOOK
- SPACER
- 7/16" FLAT WASHER
- 1/2" LOCK WASHER
- M12 X 1.25 X 45mm HEX BOLT



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fig. 3

