



VICTORY
4X4

TUNDRA ROOF RACK INSTRUCTIONS

TOOLS NEEDED

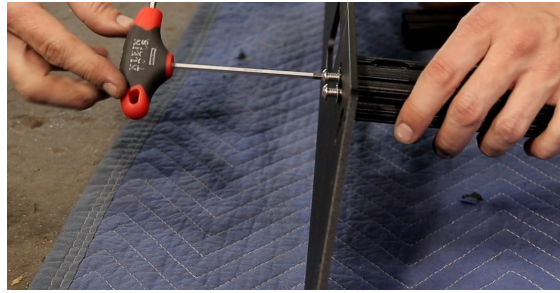
- 4mm Allen
- 3/16 Allen
- 5/32 Allen
- 1/2 Drill Bit
- 1/8 Drill Bit
- Center Punch
- Drill Stop
- 5/8 End Wrench
- 10mm Socket

HARDWARE

- 1/4-20 x 3/4" Stainless Button Head qty. 42
- 1/4" Stainless Washer qty. 42
- 1/4-20 Flange Nut qty. 20
- M6 x 25mm Stainless Button Head qty. 10
- M8 Stainless Flat Washer qty. 10
- 8mm-1.25 Button Head qty. 8
- External-Tooth Lock Washer qty. 1
- M6 x 1 mm x 40mm Hex Head qty. 1
- 5/16-18 Threaded Hex Coupler qty. 1
- 1/4 Flat Washer qty. 1
- M6 Nutsert qty. 10
- 23/64 Drill Bit qty. 1

Please read the instructions below carefully before attempting to install.

1. Assemble the rack on the ground. Start by assembling the crossbars to the side rails using the small button head bolts and small washers (2 per side). Make sure the hole on the side of the crossbar is facing upward so you can easily slide t-nuts into the rail for mounting. One side of the rail can also be removed to slide t-nuts in. Use a 5/32 allen to tighten the bolts.



2. Add weather strip along the bottom of the front and rear fairing. Use the majority of the weather strip on the front fairing and the remaining strip, cut in half, on the rear fairing. Assemble the front and rear fairing. Use the small button head bolts along with the small washers and a flange nut. Adjust the fairing upward to avoid contact with the paint, while setting it on the roof.

Front fairing - 3 bolts per side

Back fairing - 2 bolts per side



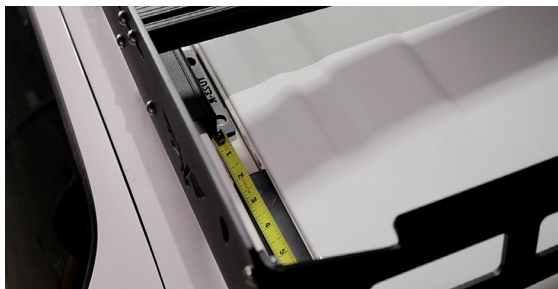
3. If you are installing a light bar, remove the bolts to one side of the cross bar and slide in 4 T nuts (2 per side). Then you can install the light bar brackets to the crossbar and install your light bar.



4. Next we will install the mounts to the rack. The mounts will have letters cut out on them to determine if they are front (F) or rear (R) mounts. The letter side of the mounts will attach to the roof of the truck. Make sure the arrow is facing toward the front fairing before bolting it on. Use 2 button head bolts with washers and flange nuts then secure the mounts on the inside of the rack. The access cab will only have front and rear mounts.



5. CREW MAX ONLY - Remove the rubber molding on the roof of the truck. Make sure the rear mount is 2 inches from the back edge trim.



DOUBLE CAB - Remove the rubber molding on the roof of the truck. Make sure the rear mount is sitting right next to the edge trim.



Once you position the rack on the roof, mark the mounting holes.

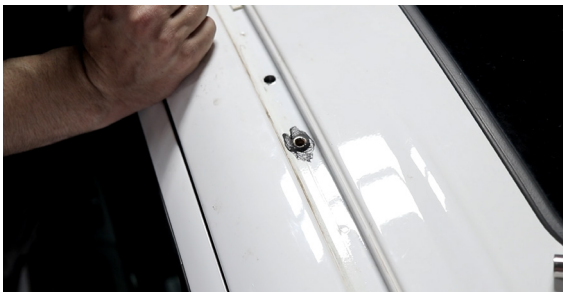
6. Before drilling, center punch the marks we made in the previous step. After you center punch the mark, use a 1/8" drill bit and drill through the mark. After you drill the pilot holes, use the drill bit we provide to open up the holes large enough for the nutserts. **You only need to drill .25"-.5" through the roof. We recommend using a drill stop on both bits so you do not drill too far down into your headliner, side curtain airbags, or into any wiring. In order to be completely sure there is nothing specific to your vehicle in the drilling area, drop the very edge of the headliner to see what is below.**



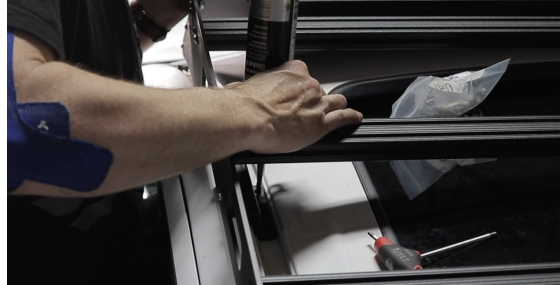
7. Vacuum the metal shavings before installing the nutserts.



8. Apply RTV on the nutsert before inserting it into the hole. Use the nutsert install kit to install the nutserts. Insert the nutsert into the drill hole and begin tightening using a 5/8 end wrench and a 10mm socket. Once its tight, remove the nutsert install kit. With all of the nutserts installed, apply RTV on all of the nutserts before mounting the rack on the roof.



9. Have a friend help you lift the rack onto the roof. Line to holes in the mount with the nutserts. If the holes don't line up you can loosen the button head bolts to adjust the mounts. Fill the nutserts with additional RTV.



10. Use the long M6 bolts with washers to secure the mounts to the roof. Hand thread the bolts and then use a 5/32 allen to loosely tighten the bolts. Be careful when tightening the mounting bolts into the nutserts. You do not want to cross thread the bolts.



11. Once all of the bolts are loosely installed, you can tighten them all down.



12. Reinstall the factory rubber molding. You will have to cut it since the mounts are in the way. Use 3M tape to secure it back into place. The last step is to add the edge trim to the fairings and adjust them. We recommend adjusting them down against the roof for added support, to eliminate any flex at high speeds.

We recommend using 3M Paint Protection Film (or similar) below the fairings. This will protect the clear coat and paint from dust, debris, and wear from the rubber.



You are now finished with the installation, enjoy your new roof rack!