



# FITTING INSTRUCTIONS

Part Number: **5423010**  
Product Description: **Under Vehicle Protection**  
Suited to vehicle/s: **Toyota Tacoma Gen II 04-15 & Gen III 16ON**

## WARNING

### REGARDING VEHICLES EQUIPPED WITH SRS AIRBAG:

When installed in accordance with these instructions, the vehicle protection panels do not affect operation of the SRS airbag.

### ALSO, NOTE THE FOLLOWING:

- ◆ This product must be installed exactly as per these instructions using only the hardware supplied.
- ◆ Do not use this product for any vehicle make or model, other than those specified by ARB.
- ◆ Do not remove labels (if any) from this product.
- ◆ This product or its fixing must not be modified in any way.
- ◆ The installation of this product may require the use of specialized tools and/or techniques
- ◆ These instructions are correct as at the publication date. ARB Corporation Ltd. cannot be held responsible for the impact of any changes subsequently made by the vehicle manufacturer
- ◆ During installation, it is the duty of the installer to check correct operation/clearances of all components
- ◆ Work safely at all times
- ◆ Unless otherwise instructed, tighten fasteners to specified torque

## **ARB 4x4 ACCESSORIES**

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# IMPORTANT INFORMATION.

## GENERAL CARE AND MAINTENANCE

By choosing ARB vehicle protection, you have bought a product that is one of the most sought after 4WD products in the world. Your under-vehicle protection panels are a properly engineered, reliable, quality accessory that represents excellent value.



- While these panels have been engineered for strength and functionality care and good judgment should be taken when traversing difficult off-road conditions to minimize damage to panels and vehicle.
- During servicing when panels are removed ensure fasteners are re-fitted to the correct torque values.
- Inspect panels visually on a regular basis. Dirt and foreign matter should be washed out to minimize build-up around hot components. **BE VERY CAREFUL** when removing foreign matter with hands while vehicle is hot or running. Replace any components as necessary. This service can be performed by your local authorized ARB Dealer.

### FITTING REQUIREMENTS

#### REQUIRED TOOLS FOR FITMENT OF PRODUCT:

|  |  |
|--|--|
| Basic Socket and Spanner Kit (Metric)          | Torque Wrench (22Nm – 44Nm)            |
| Trolley Jack or Axle Stands                    | Power Drill (if installing on Gen II)  |
| 8mm or 9mm Drill Bit (if installing on Gen II) | Center Punch (if installing on Gen II) |
| Engineers hammer                               |  |

#### HAVE AVAILABLE THESE SAFETY ITEMS WHEN FITTING PRODUCT:

|                    |   |
|--------------------|---|
| Protective eyewear |    |
| Hearing protection |  |

**NOTE:** ‘WARNING’ notes in the fitting procedure relate to OHS situations, where to avoid a potentially hazardous situation it is suggested that protective safety gear be worn or a safe work procedure be employed. If these notes and warnings are not heeded, injury may result.

#### FASTENER TORQUE SETTINGS:

| SIZE | Torque Nm | Torque lb-ft |
|------|-----------|--------------|
| M6   | 9 Nm      | 7 lb-ft      |
| M8   | 22 Nm     | 16 lb-ft     |
| M10  | 44 Nm     | 32 lb-ft     |
| M12  | 77 Nm     | 57 lb-ft     |

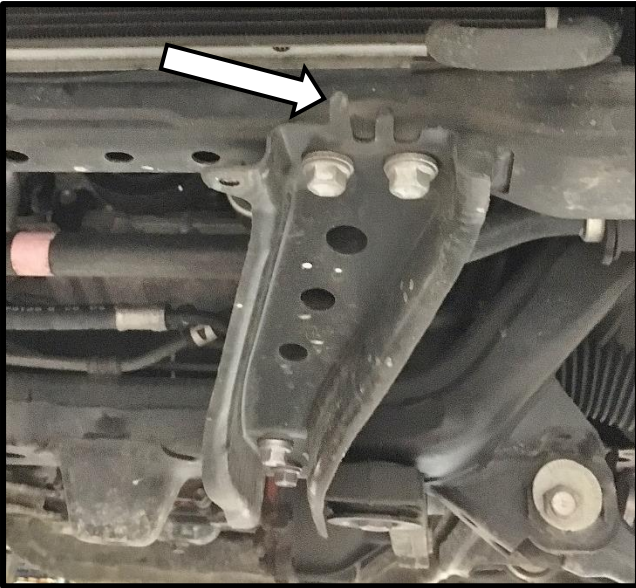
## PARTS LISTING (Fit Kit # 6174214)

| APPLICATION.  | PART NO. | QTY                       | DESCRIPTION                    |
|---|----------|---------------------------|--------------------------------|
| <b>Front Panel</b>                                    | 6523131  | 1                         | Front Panel Weldment           |
|   | 6151022  | 2                         | Hex Bolt M8 X 1.25 X 25mm      |
|   | 6151083  | 2                         | Hex Bolt M8 X 1.25 X 35mm      |
|   | 4581046  | 4                         | M8 Spring Washer               |
|   | 4581044  | 4                         | M8 Flat Washer                 |
| <b>2<sup>nd</sup> Panel<br/>(Differential Panel)</b>  | 6523132  | 1                         | 2 <sup>nd</sup> Panel Weldment |
|   | 6151022  | 3                         | Hex Bolt M8 X 1.25 X 25mm      |
|   | 6151083  | 2                         | Hex Bolt M8 X 1.25 X 35mm      |
|   | 4581046  | 5                         | M8 Spring Washer               |
|   | 4581044  | 5                         | M8 Flat Washer                 |
| <b>3<sup>rd</sup> Panel<br/>(Transmission Panel)</b>  | 6523133  | 1                         | 3 <sup>rd</sup> Panel Weldment |
|   | 3750015  | 1                         | Crossmember Bracket            |
|   | 6151022  | 3                         | Hex Bolt M8 X 1.25 X 25mm      |
|   | 6151040  | 2                         | Hex Bolt M10 X 1.25 X 30mm     |
|   | 4581046  | 3                         | M8 Spring Washer               |
|   | 4581044  | 3                         | M8 Flat Washer                 |
|   | 4581048  | 2                         | M10 Spring Washer              |
|   | 4581040  | 6                         | M10 Flat Washer                |
| 6151478   | 2        | Hex Flange Nut M10 X 1.25 |                                |
| <b>4<sup>th</sup> Panel<br/>(Transfer Case Panel)</b> | 6523134  | 1                         | 4 <sup>th</sup> Panel Weldment |
|   | 6151022  | 7                         | Hex Bolt M8 X 1.25 X 25mm      |
|   | 4581046  | 7                         | M8 Spring Washer               |
|   | 4581044  | 7                         | M8 Flat Washer                 |
|   | 6151132  | 4                         | Hex Flange Nut M8 X 1.25       |

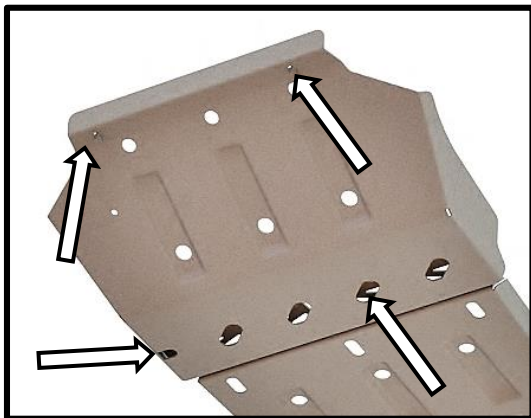
## FITTING PROCEDURE



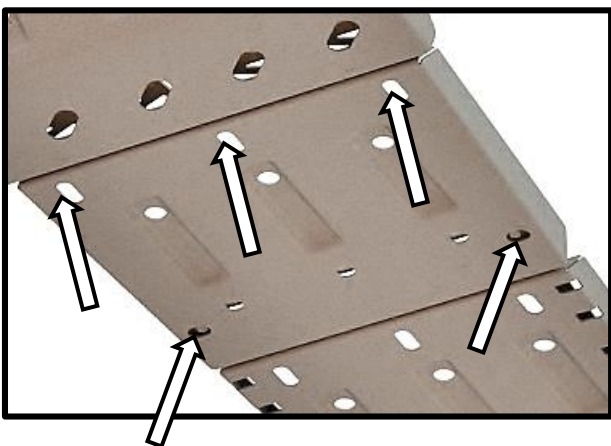
1. Remove all factory under vehicle protection panels from vehicle. These panels will not be re-installed.



2. Hammer the front right protection panel hook up and out of the way as shown.



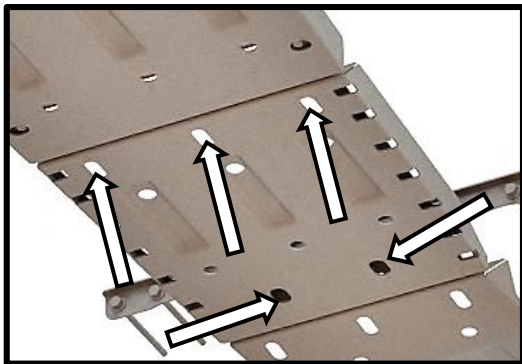
3. With the help of another person, hold the front panel to the vehicle and fasten (2) M8 x 25mm hex bolts, spring washer, and flat washer sets into the factory weld nut locations as shown in the front. Fasten the (2) M8 x 35mm hex bolts, spring washer, and flat washer sets into the factory weld nut locations towards the rear. Do not tighten these fasteners at this step.



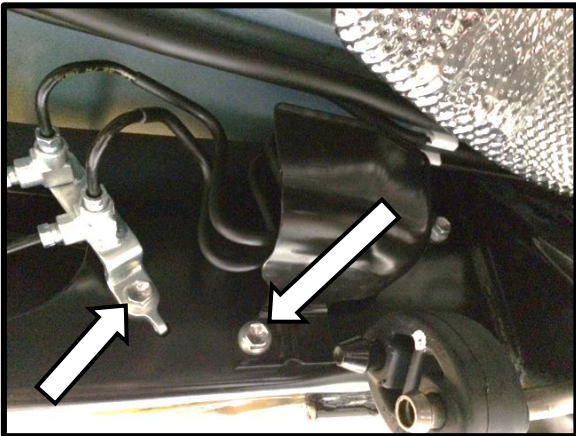
4. Hold the 2<sup>nd</sup> panel from the front up to the vehicle and fasten the (3) M8 x 25mm hex bolts, spring washer, and flat washer sets connecting this panel to the 1<sup>st</sup> panel. Fasten the (2) M8 x 35mm hex bolts, spring washer, and flat washer sets into the factory weld nut locations as shown. Do not tighten these fasteners at this step.



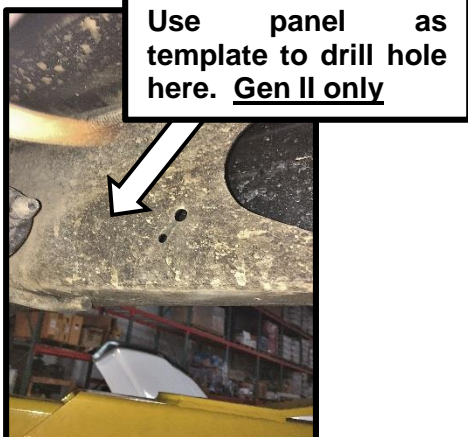
5. With a trolley jack or axle stand, support the center crossmember as shown. Remove the (2) bolts from both the right and left sides.
6. Install the 3<sup>rd</sup> panel crossmember brace on the **front** side of this crossmember, by using the factory bolt and nut sets. Place (1) M10 flat washer between the brace and the crossmember, at each bolt, to take up the space in the crossmember indentation. Do not tighten these fasteners at this step.



7. Hold the 3<sup>rd</sup> panel from the front up to the vehicle and fasten the (3) M8 x 25mm hex bolts, spring washer, and flat washer sets connecting this panel to the 2<sup>nd</sup> panel. Fasten the (2) M10 x 30mm hex bolts, spring washer, flat washer, and serrated nut sets connecting the 3<sup>rd</sup> panel to the crossmember brace installed in the previous step. Do not tighten these fasteners at this step.



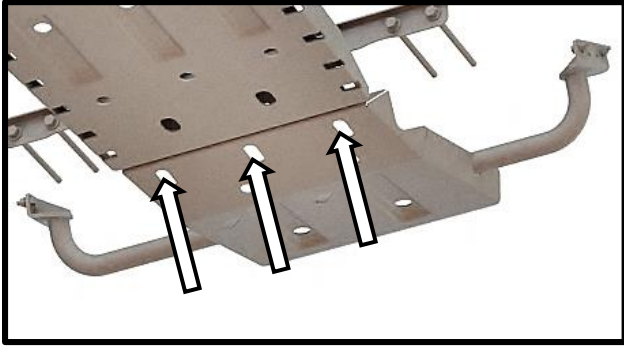
8. Remove the (2) hex bolts securing the fuel line bracket and cover shroud to the frame as shown in the picture (**note:** some variants of this truck do not have the fuel line shroud). Discard these fasteners, pull the fuel lines away from the frame to allow space for the 4<sup>th</sup> panel.



9. For Gen II Tacomas, the forward most hole is not predrilled into the frame of the vehicle. Using the 4th UVP panel as a template, match drill the frame to include these holes at Ø9.0mm.



**Warning:** Drilling operations can result in flying metal debris, safety glasses should be worn.



10. Hold the 4<sup>th</sup> panel from the front up to the vehicle and fasten the (3) M8 x 25mm hex bolts, spring washer, and flat washer sets connecting this panel to the 3<sup>rd</sup> panel. Do not tighten these fasteners at this step



11. Place the fuel line bracket over the 4<sup>th</sup> panel support plate as shown. Replace the fuel line shroud if equipped. For all holes with factory weld nuts in the frame, fasten with supplied M8 x 25mm hex bolts, spring washer, and flat washer sets. For the holes without factory weld nuts, use a M8 serrated flange nut to secure. Do not tighten these fasteners at this step.

12. Starting at the front of the vehicle moving rearwards, tighten each fastener to the specified torque values.



**M8 22Nm 16 lb-ft**



**M10 44Nm 32 lb-ft**

## FITTED PRODUCT

