



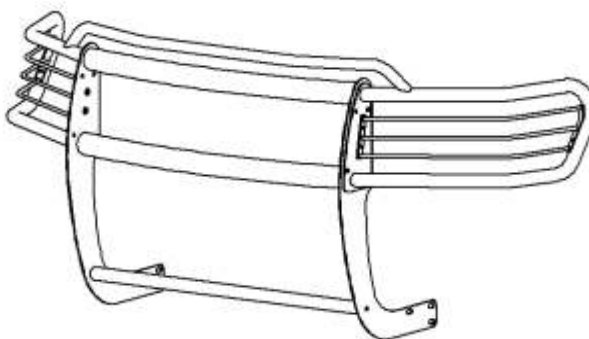
# INSTALLATION INSTRUCTIONS

APPLICATION: 1999-UP TOYOTA TUNDRA

**AUTOMOTIVE PRODUCTS, INC.**

SPORTSMAN  
ASSEMBLY

41-1365  
44-1360



## PARTS KIT CONTENTS

QTY	DESCRIPTION	QTY	DESCRIPTION
2	WING ASSEMBLIES	2	3/8-16 X 1.25" BUTTON HEAD CAP SCREW SS
2	UPRIGHT	2	3/8-16 X 1.25" BUTTON HEAD CAP SCREW
1	HOOD BAR	10	3/8-16 x 1.00" BUTTON HEAD CAP SCREW SS
1	TOP TUBE	2	3/8-16 x 1.00" THREAD CUTTING SCREW
1	CENTER TUBE	2	3/8-16 X .50" BUTTON HEAD CAP SCREW
1	BOTTOM TUBE	16	3/8" FLAT WASHER SS
2	HOOD BAR GASKET	4	3/8" FLAT WASHER
2	HOOD BAR GROMMET	2	3/8" NYLON WASHER
2	LIGHT MOUNT	2	3/8" INTERNAL TOOTH LOCK WASHER SS
2	BRACKET, PASSENGER/DRIVER	2	3/8-16 FLANGE LOCK NUT
2	BRACE, PASSENGER/DRIVER	8	3/8-16 NYLON INSERT LOCK NUT SS
4	1/2-13 X 1.50" FLAT HEAD BOLT SS	2	3/8-16 NYLON INSERT LOCK NUT
6	1/2-13 X 1.25" HEX HEAD BOLT SS	2	1/4" FLAT WASHER
12	1/2" FLAT WASHER SS	4	2 3/4" OD PLASTIC WASHER
2	1/2" NYLON FLAT WASHER	2	1.5/8" OD PLASTIC WASHER
6	1/2" LOCK WASHER SS	8	1.00" OD PLASTIC WASHER
6	1/2-13 HEX NUT SS		

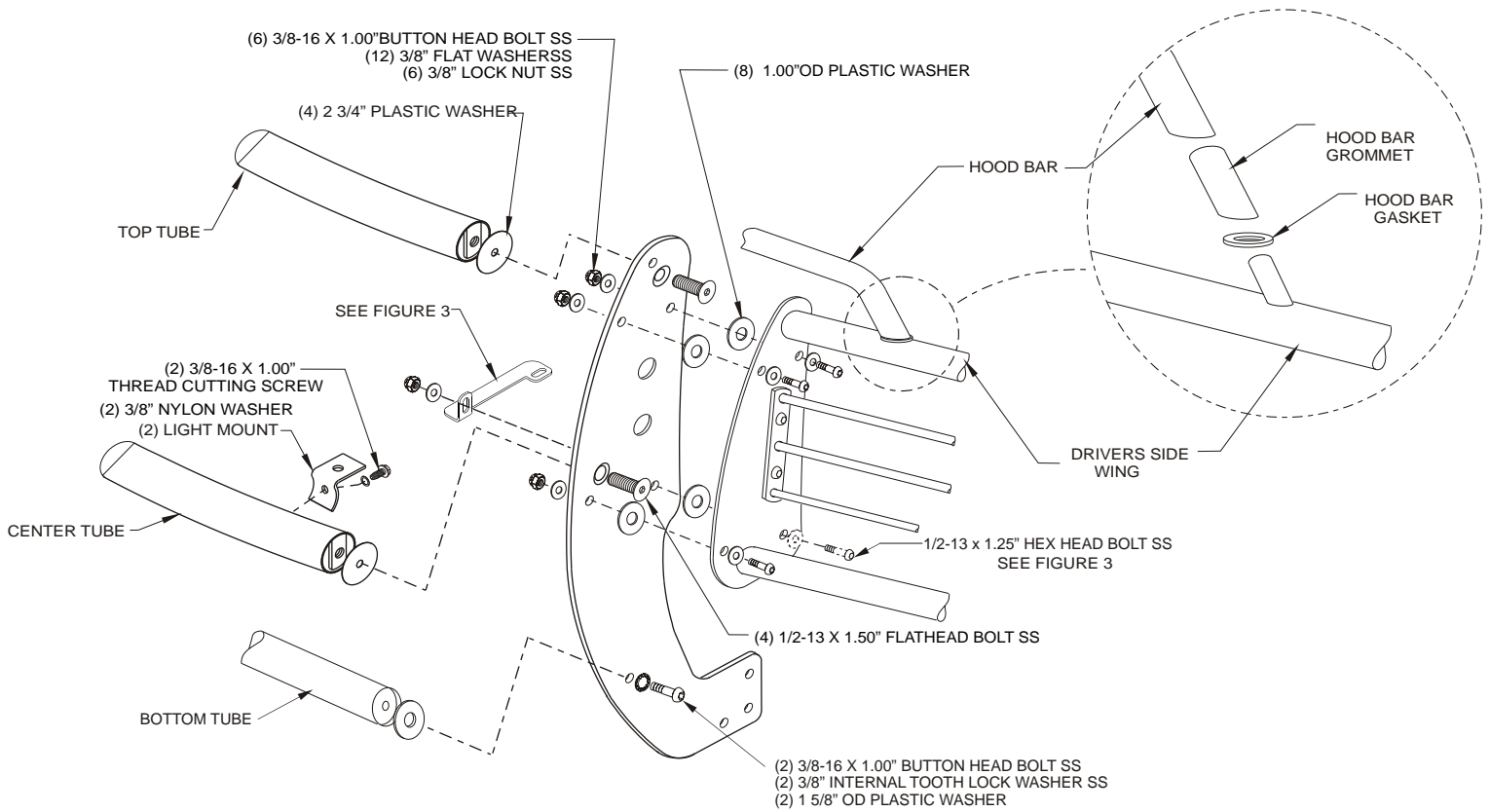
## TOOLS REQUIRED

3/4" SOCKET	3/4" WRENCH	9/16" SOCKET	9/16" WRENCH
5/16" HEX WRENCH	7/32" HEX WRENCH	17MM SOCKET	10MM SOCKET
RATCHET	SOCKET EXTENSION	TORQUE WRENCH	

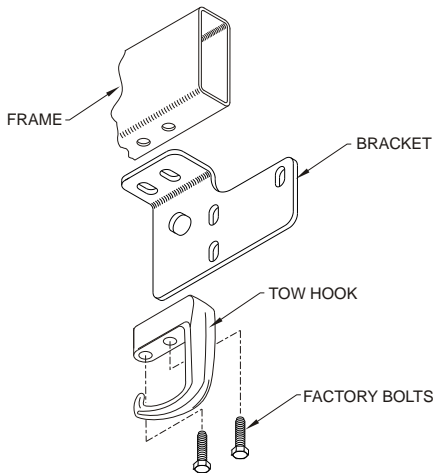
- STEP 1. Remove the contents from the box and check for any damage. Verify all parts against the parts list.
- STEP 2. Read and understand instructions completely before beginning installation.
- STEP 3. Determine passenger and driver uprights, top, center and bottom tubes. (Uprights are positioned so raised side of bolt holes are facing each other).
- STEP 4. Fasten uprights to top, center and bottom tubes using (4) 1/2-13 x 1.50" stainless flathead bolts, (4) 2.75" OD plastic washers, (2) 1.625" OD plastic washer, (2) 3/8" stainless internal tooth lock washers and (2) 3/8-16 x

1.00" button head cap screws. Level tubes and torque 1/2" fasteners to 60 FT. LBS and 3/8" fasteners to 30 FT. LBS.

- STEP 5. Fasten light mounts to center tube using (2) 3/8-16 x 1.00" thread cutting screws and (2) 3/8" nylon washers. Tighten and torque to 20 FT. LBS. SEE FIGURE 1.
- STEP 6. Determine passenger and driver brackets.
- STEP 7. From underside of vehicle, remove tie down loop and tow hook. Discard tie down loops and move tow hook and factory bolts from passenger side to driver side and visa versa, if needed. Install brackets and tighten by hand. SEE FIGURE 2.
- STEP 8. Determine passenger and driver side braces. SEE FIGURE 3.  
NOTE: 1999-02 models use shorter braces. 2003-UP models use longer braces.
- STEP 9. Open vehicle hood. NOTE: 1999-02 models: Fasten braces to front hole on front end panel using (2) 3/8-16 x .50" stainless button head cap screws and (2) 3/8-16" flange lock nut. Leave loose. 2003-UP models: Remove 10mm nut from stud on front end panel and fasten brace using 1/4" flat washer and nylon washer. Leave loose. SEE FIGURE 3.
- STEP 10. Place cardboard under front of vehicle. Lay center section on cardboard with front side down.
- STEP 11. Slide center section back so that rearmost lower slots align with the rearmost lower slots on brackets. Fasten together at the lower rear slot on each side using 1/2" fasteners. Finger tighten.
- STEP 12. Rotate center section up toward vehicle until remaining slots are aligned. Insert remaining 1/2" fasteners.
- STEP 13. Level and adjust center section. Make sure braces line up with hole in uprights. Tighten and torque tow loop bolts to 75 FT. LBS. and 1/2" fasteners to 65 FT. LBS.
- STEP 14. Install hood bar gasket and grommet on each wing assembly. Place gasket over the small tube and slide grommet until flush with gasket. SEE FIGURE 1.
- STEP 15. Determine passenger and driver wing assemblies. SEE FIGURE 1. Install driver side wing assembly using (3) 3/8-16 x 1.00" stainless button head cap screws, (8) 3/8" stainless flat washers, (4) 3/8" stainless lock nuts, (4) 1.00" OD plastic washers and (1) 3/8-16 x 1.25" stainless button head cap screw where brace lines up.
- STEP 16. Install hood bar over grommet on driver wing.
- STEP 17. Install passenger side wing assembly using same fasteners as in Step 15. Place passenger side wing into hood bar as wing assembly is brought towards the center section. Center and level wings. Tighten and torque stainless 3/8" fasteners to 35 FT. LBS.  
NOTE: Hood bar will fit tight against gasket as wings assemblies are tightened.  
NOTE: Slowly close vehicle hood! Be sure there is proper clearance between the Sportsman Bar and hood. If not, readjust the Sportsman Bar.
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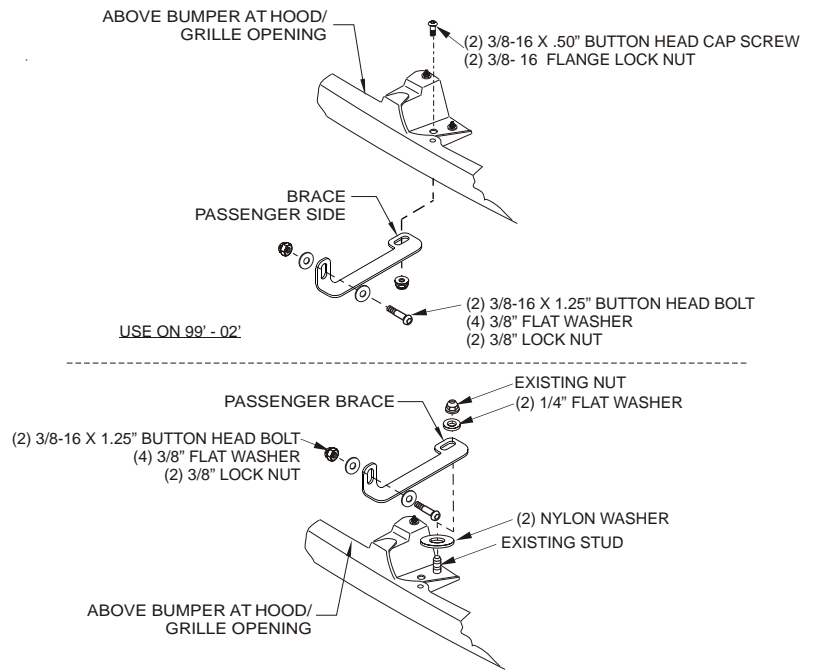


**FIGURE 1**



**FIGURE 2**

DRIVER SIDE INSTALLATION SHOWN



**FIGURE 3**

USE ON 03' - UP

Finish protection - Westin products have a high quality finish that must be cared for like any other exposed finish on the vehicle. Protect the finish with a non-abrasive automotive wax (pure carnauba, for example) on a regular basis. The use of cleaner wax or any compound which contains an abrasive is detrimental, as the compounds scratch the finish and open it to corrosion.



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Thank You for choosing Westin products  
For additional installation assistance please call  
Customer service (800) 793-7846 or (507) 375-3559