

INSTALLATION INSTRUCTIONS

HIDDEN WINCH MOUNT

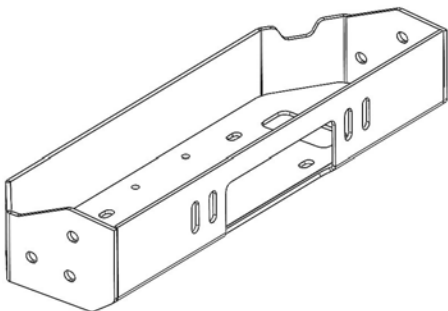


APPLICATION: 2024 TOYOTA TACOMA

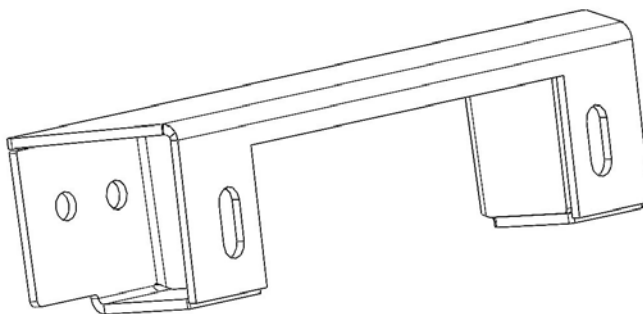
PART NUMBER: 2402785

| CONTENT | | | |
|---|----------|--|--------------|
| ITEM | QUANTITY | DESCRIPTION | TOOLS NEEDED |
| 1 | 1 | WINCH TRAY | 13MM SOCKET |
| 2 | 1 | FAIRLEAD MOUNT BRACKET | 16MM SOCKET |
| 3 | 1 | DRIVER MOUNTING BRACKET | 18MM SOCKET |
| 4 | 1 | PASSENGER MOUNTING BRACKET | RATCHET |
| 5 | 1 | SUPPORT BRACKET A | |
| 6 | 1 | SUPPORT BRACKET B | |
| 7 | 1 | SUPPORT BRACKET C | |
| 8 | 2 | SPACER | |
| 9 | 2 | M12 LONG HEX HEAD BOLT (YELLOW ZINC) | |
| 10 | 20 | M12 SHORT HEX HEAD BOLT (YELLOW ZINC) | |
| 11 | 20 | M12 SMALL FLAT WASHER (YELLOW ZINC) | |
| 12 | 2 | M12 LARGE FLAT WASHER (YELLOW ZINC) | |
| 13 | 22 | M12 SPLIT LOCK WASHER (YELLOW ZINC) | |
| 14 | 20 | M12 SERRATED FLANGED HEX NUT (YELLOW ZINC) | |
| 15 | 12 | M8 HEX HEAD BOLT (YELLOW ZINC) | |
| 16 | 12 | M8 SPLIT LOCK WASHER (YELLOW ZINC) | |
| 17 | 12 | M8 FLAT WASHER (YELLOW ZINC) | |
| 18 | 10 | M8 SERRATED FLANGED HEX NUT (YELLOW ZINC) | |
| 19 | 2 | M10 SOCKET HEAD BOLT (BLACK ZINC) | |
| 20 | 2 | M10 FLAT WASHER (BLACK ZINC) | |
| 21 | 2 | M10 SPLIT LOCK WASHER (BLACK ZINC) | |
| 22 | 2 | M10 SERRATED FLANGED HEX NUT (BLACK ZINC) | |
| ANTI-SEIZE LUBRICANT MUST BE USED ON ALL STAINLESS STEEL FASTENERS TO PREVENT THREAD DAMAGE AND GALLING | | | |

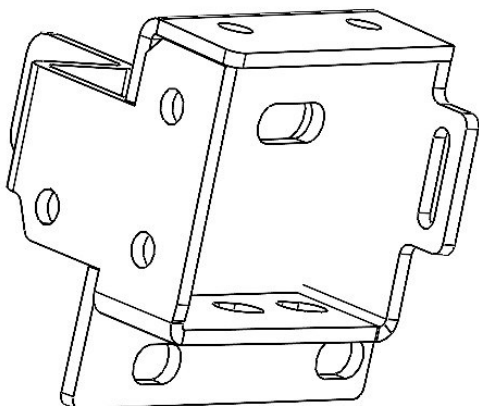
ITEM 1



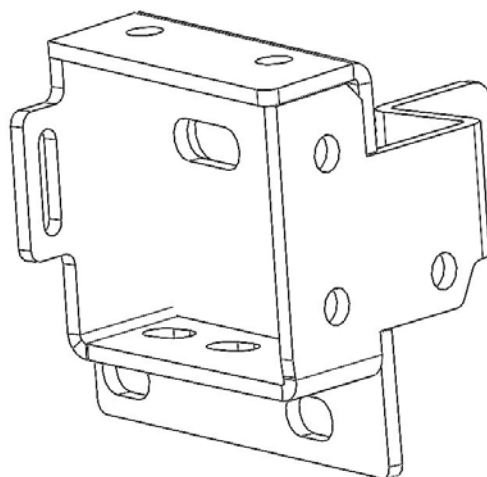
ITEM 2



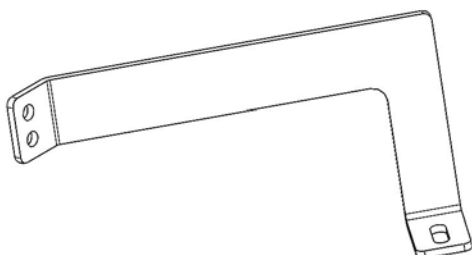
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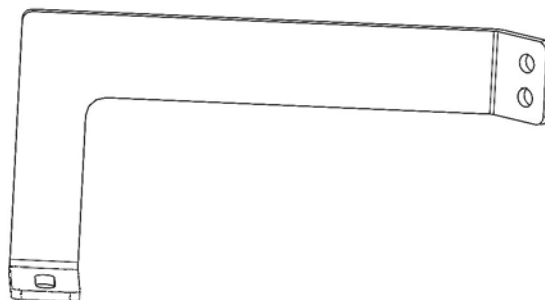
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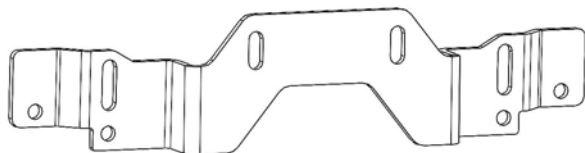
ITEM 5



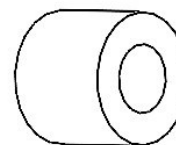
ITEM 6



ITEM 7



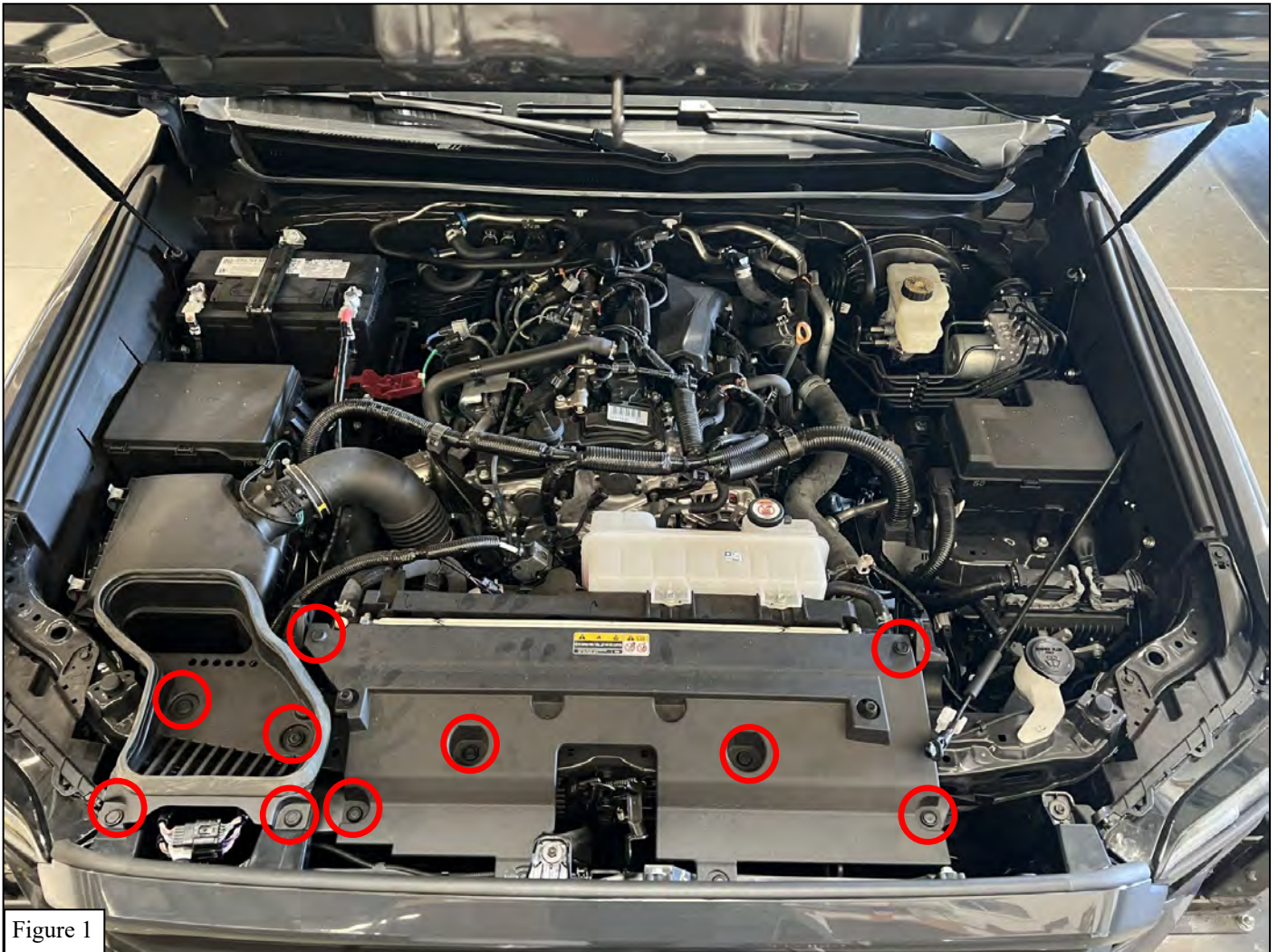
ITEM 8


WESTIN

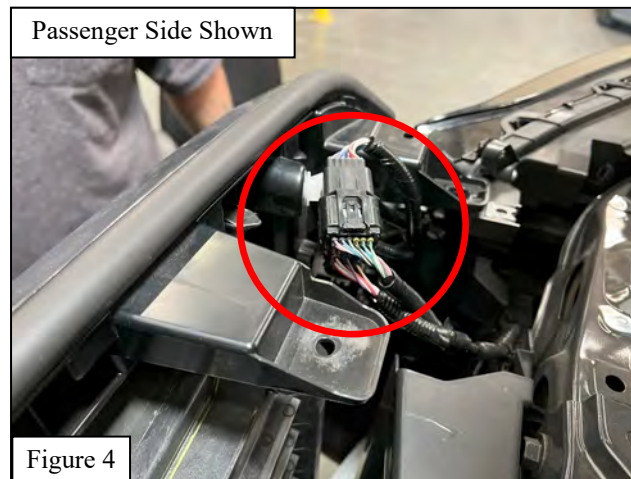
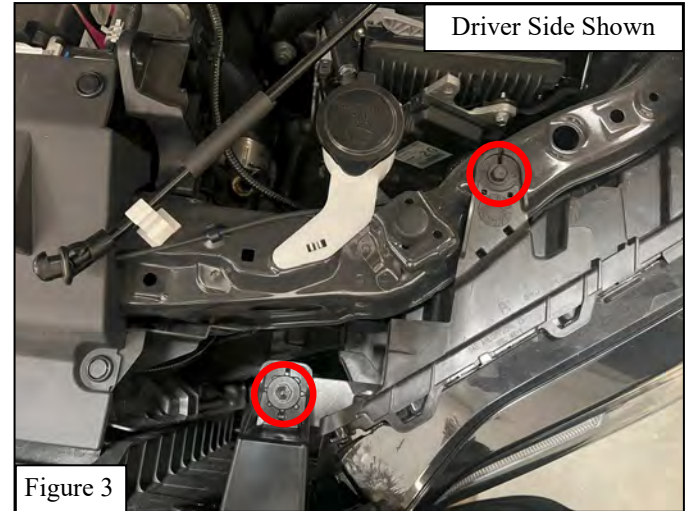
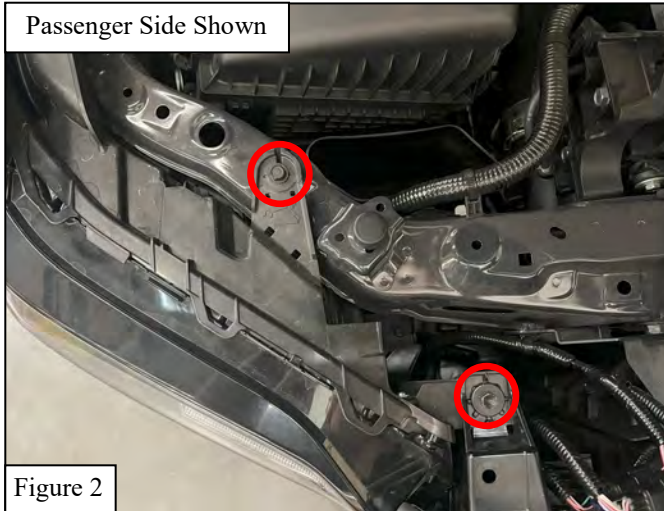
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PROCEDURE

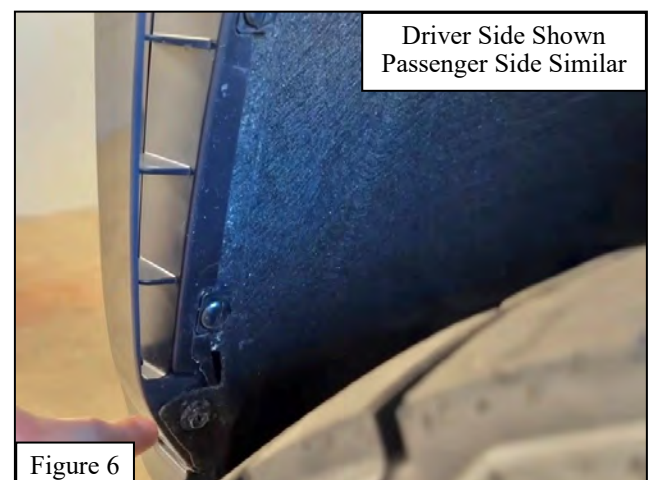
1. Remove contents from box, verify if all parts listed are present and free from damage.
Carefully read and understand all instructions before attempting installation.
Failure to identify damage before installation could lead to a rejection of any claim.
2. Open the hood of the vehicle. Locate and remove the plastic pins from the air intake duct and plastic cover as indicated below, (**Figure 1**). Remove and place aside the air intake duct and plastic cover.



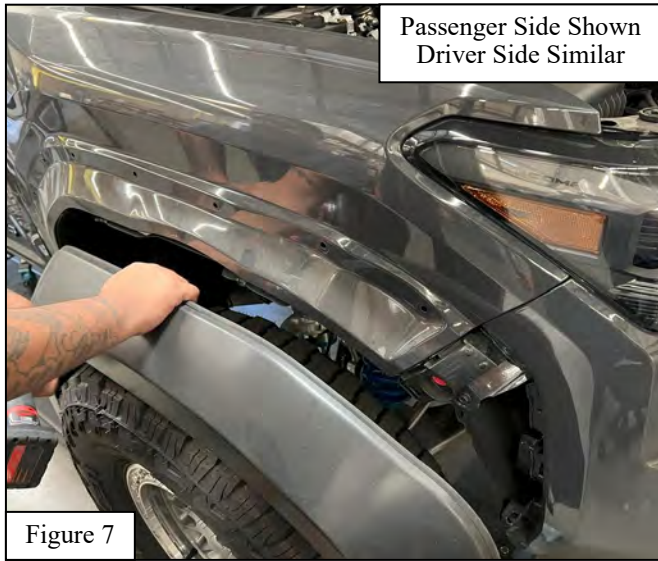
3. Next, remove (4) hex bolts indicated below using a 10MM socket (**Figure 2 & 3**). Disconnect any wiring harnesses found behind the front grille/bumper, (**Figure 4**).



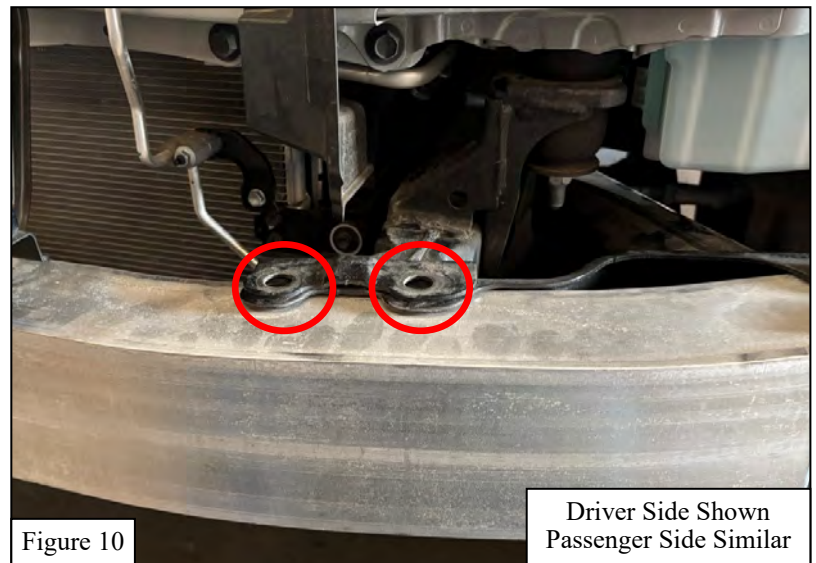
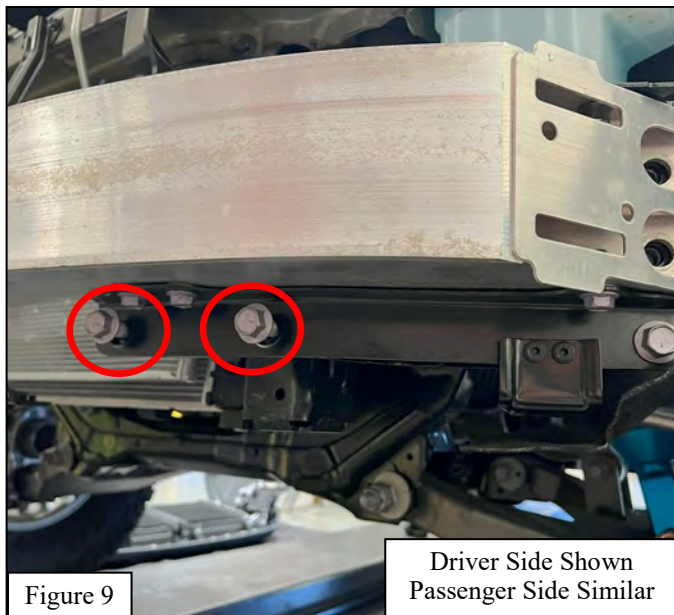
4. Remove the (3) 10mm hex bolts found in the front of the wheel well, as well as the two pins (**Figure 5 & 6**). Note: There is a hex bolt located on the bottom of the vehicle. Repeat this process for the other side of the vehicle.



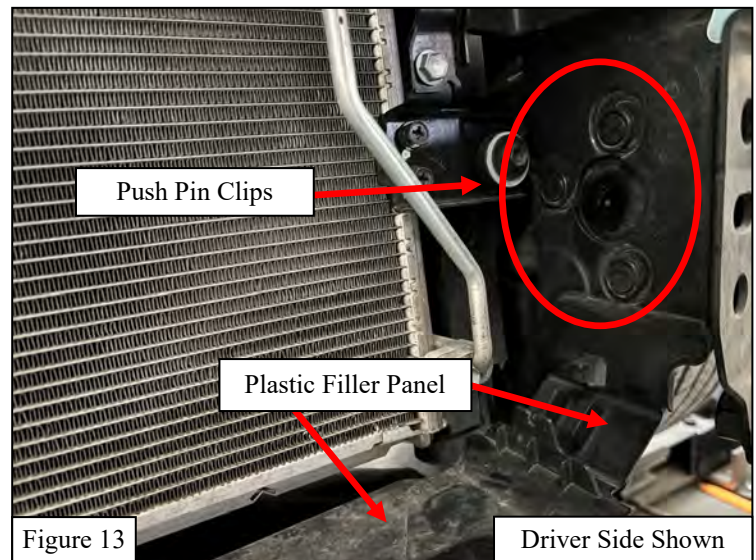
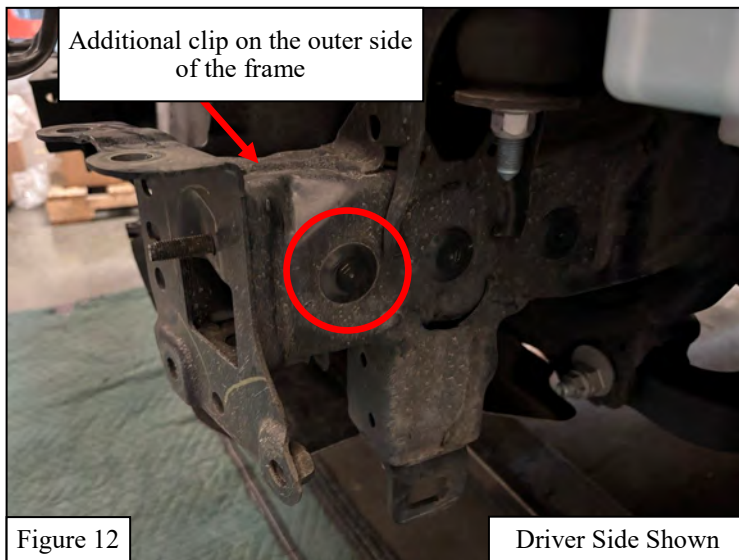
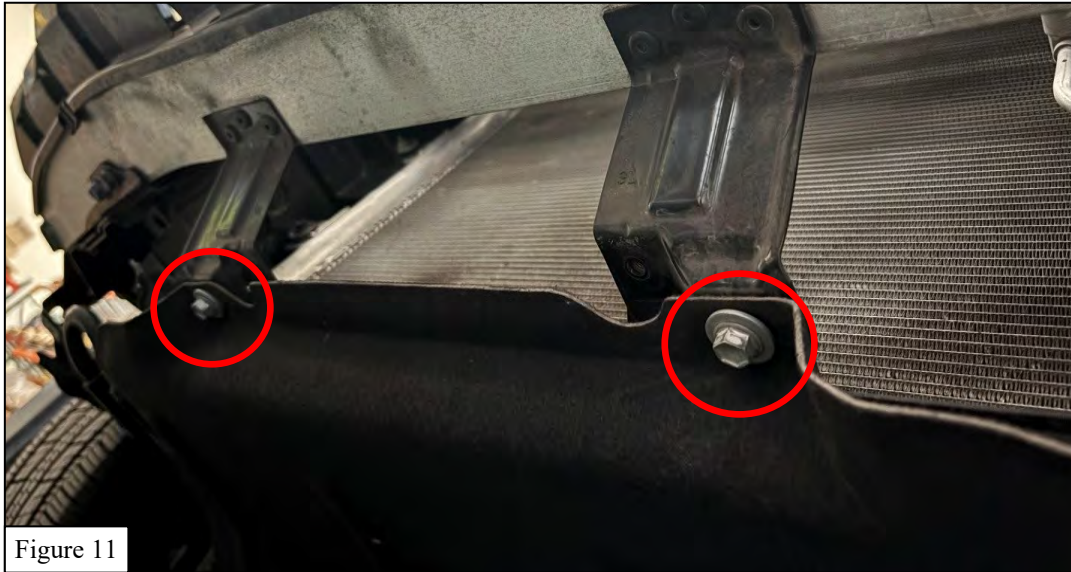
5. If equipped, carefully pry off the fender flares from both driver and passenger side by releasing the two clips found within the wheel well, and set them aside safely, (**Figure 7**). Locate and remove the Phillips head screw found behind the fender flare. Repeat for both sides, (**Figure 8**).



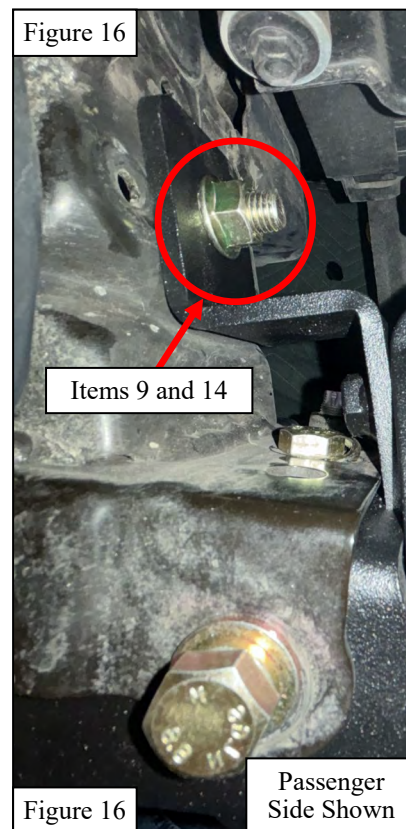
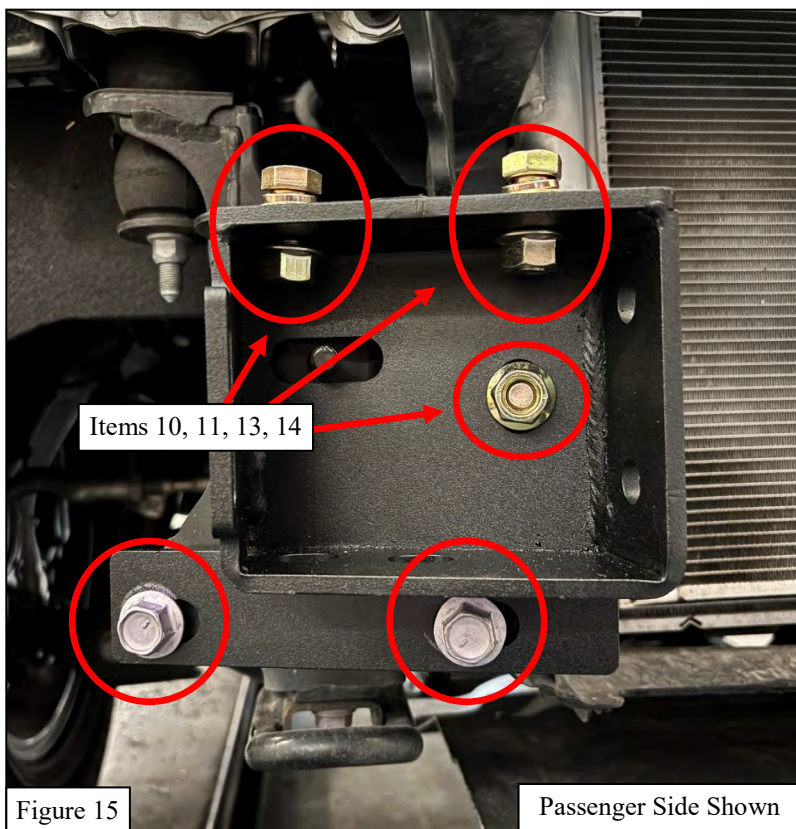
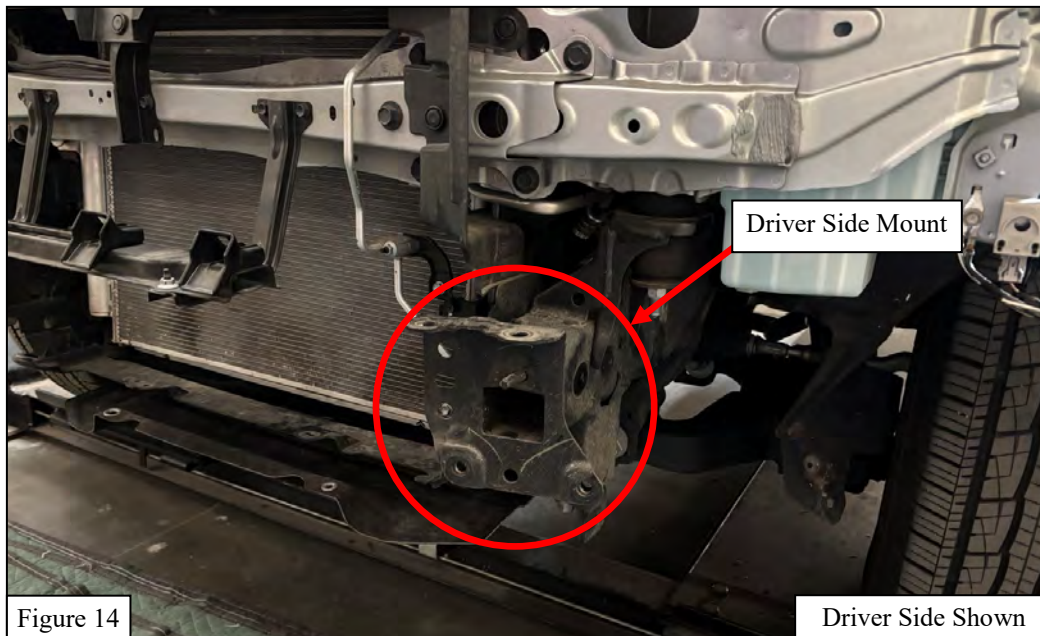
6. Remove the (8) 10mm bolts located on the bottom side of the front grille. There are (3) bolts on either corner of the bottom bumper, and (2) bolts located in the center, on the back edge of the plastic skid plate. Carefully pry the front grille off the upper clips and remove the grille and bumper.
7. Remove (8) 10mm bolts from the crash bar. On each side, (2) bolts are located on the bottom and (2) bolts are located on the top. See **Figures 9 and 10**.



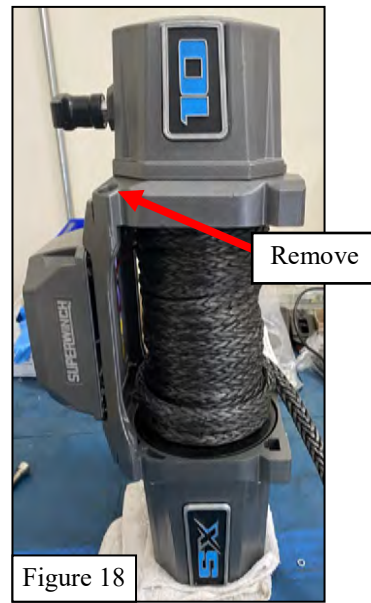
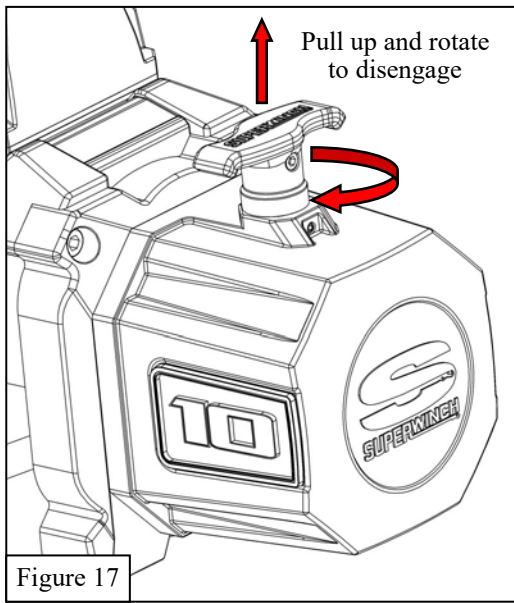
8. Remove the two bolts holding splash shield under the crash bar. See **Figure 11**.
9. Using a prying tool, remove (4) clips from the front of the frame. On each side, remove the round clips closest to the front. Two clips are located on the inner side of the frame and two clips are located on the outer side of the frame. See **Figure 12**.
10. Remove the plastic filler panel located at the bottom of the radiator. On each side, the filler panel is attached to the inner side of the frame using (3) push pin clips. See **Figure 13**.



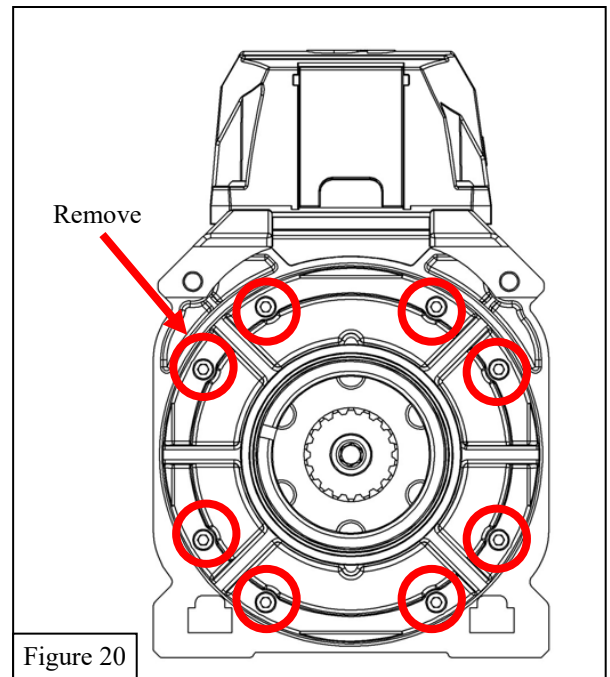
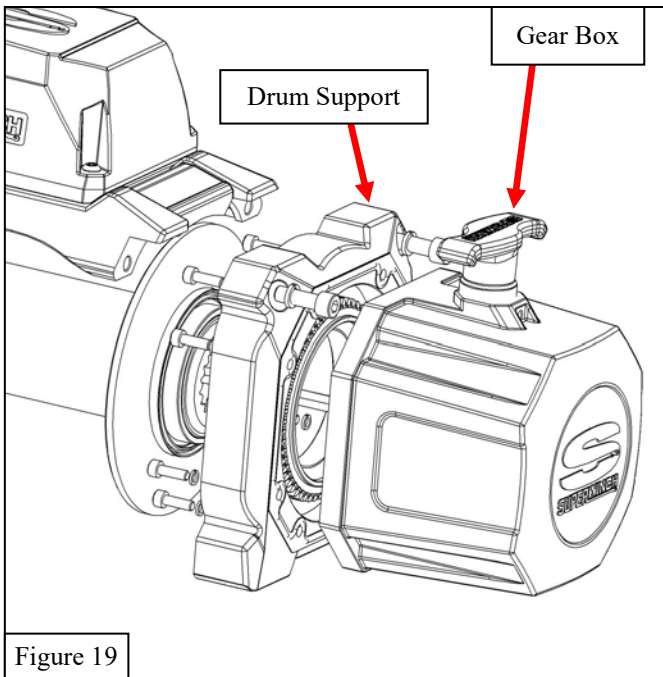
11. Starting on the driver's side, loosely install the Driver Mounting Bracket (**item 3**) onto the mount using the provided M12 hardware (**items 9-14**). Use (3) short M12 hex head bolts (**item 10**) on the front side of the bracket and (1) long M12 hex head bolt (**item 9**) on the back of the bracket. Slide the long M12 bolt through the frame from the outer side. Place a split lock washer and a large M12 flat washer on the outer side of the frame. Tighten the M12 hardware to 50-55 ft-lbs. See **Figures 14 - 16**.
12. Reinstall the lower hardware removed in **step 7**, attaching the bottom of the Mounting Brackets to the vehicle frame. See **Figure 15**.
13. Repeat steps 10 and 11 on the passenger side.



14. Pull and twist the SX winch clutch handle so that the clutch is in the free spool position. See **Figure 17**.
15. Stand the winch up onto the motor cover. See **Figure 18**.



16. Remove the (4) M8 bolts attaching the tie bar to the gear box and motor end of the winch. See **Figure 19**.
17. Remove the gearbox assembly and tie bar from the winch. See **Figure 19**.
18. Remove the eight bolts that attach the gear box to the drum support. Do not completely separate the gearbox from the drum support. Separate the two parts just enough to rotate the gearbox. See **Figure 20**.



19. Rotate the gear box to the position shown in **Figure 21**.
20. Replace the (8) bolts that attach the gear box to the drum support in.
21. Torque M5 bolts in a star pattern to 50-55 in-lb. See **Figure 22**.
22. Place the gearbox assembly onto the winch. Ensure the drive shaft and drum properly engage the gearbox. Rotate the gearbox assembly as necessary to engage the gearbox.
23. Reinstall the tie bar. Torque the M8 tie bar bolts to 18 ft-lbs.

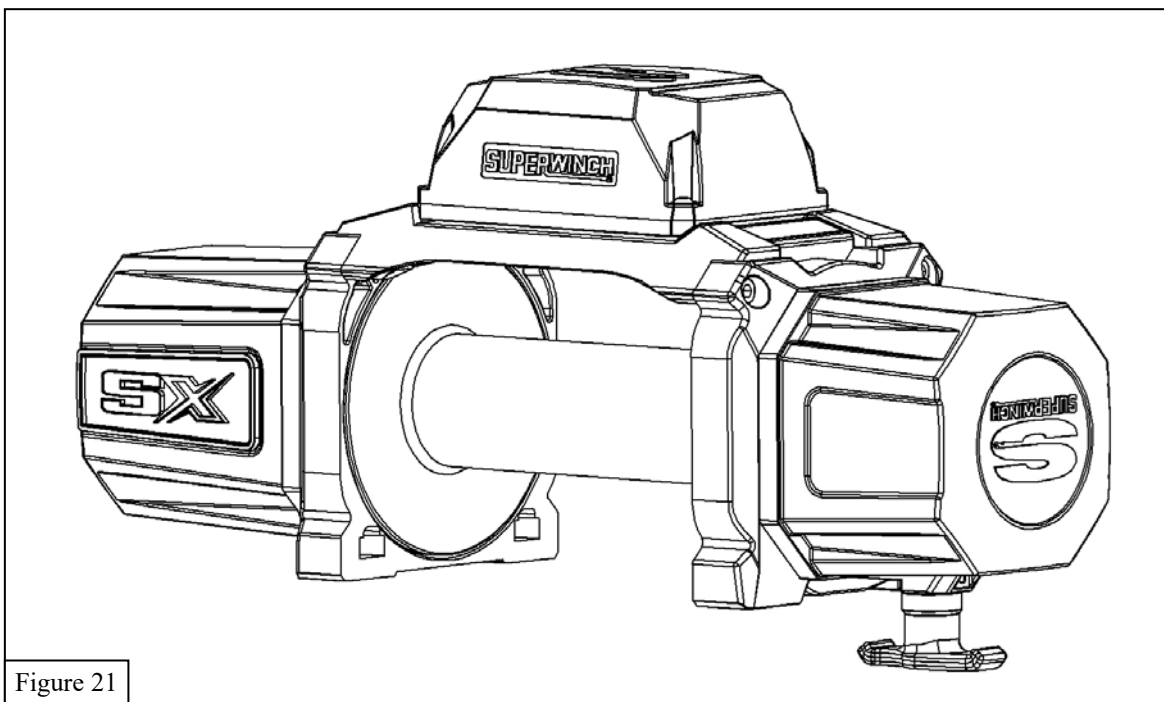


Figure 21

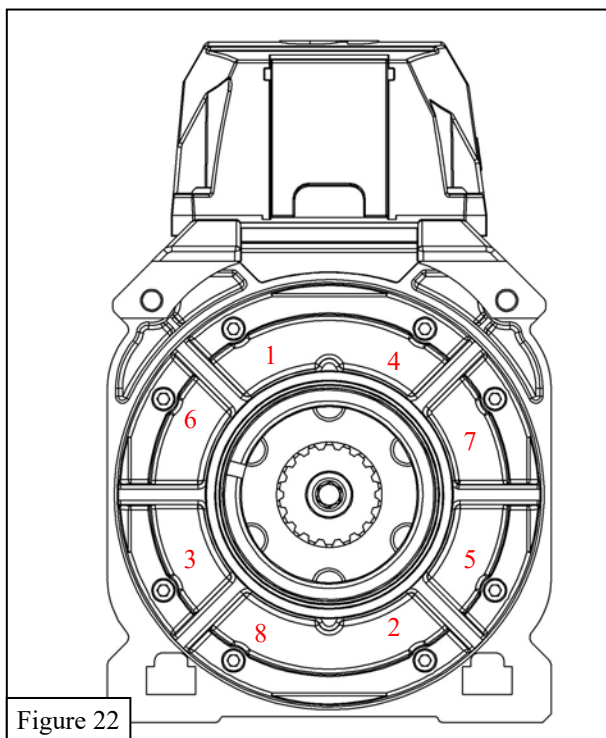
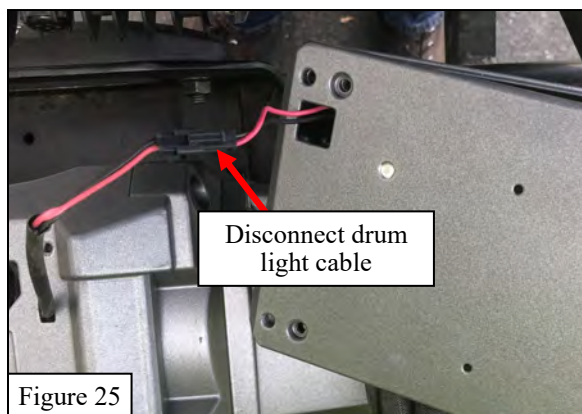
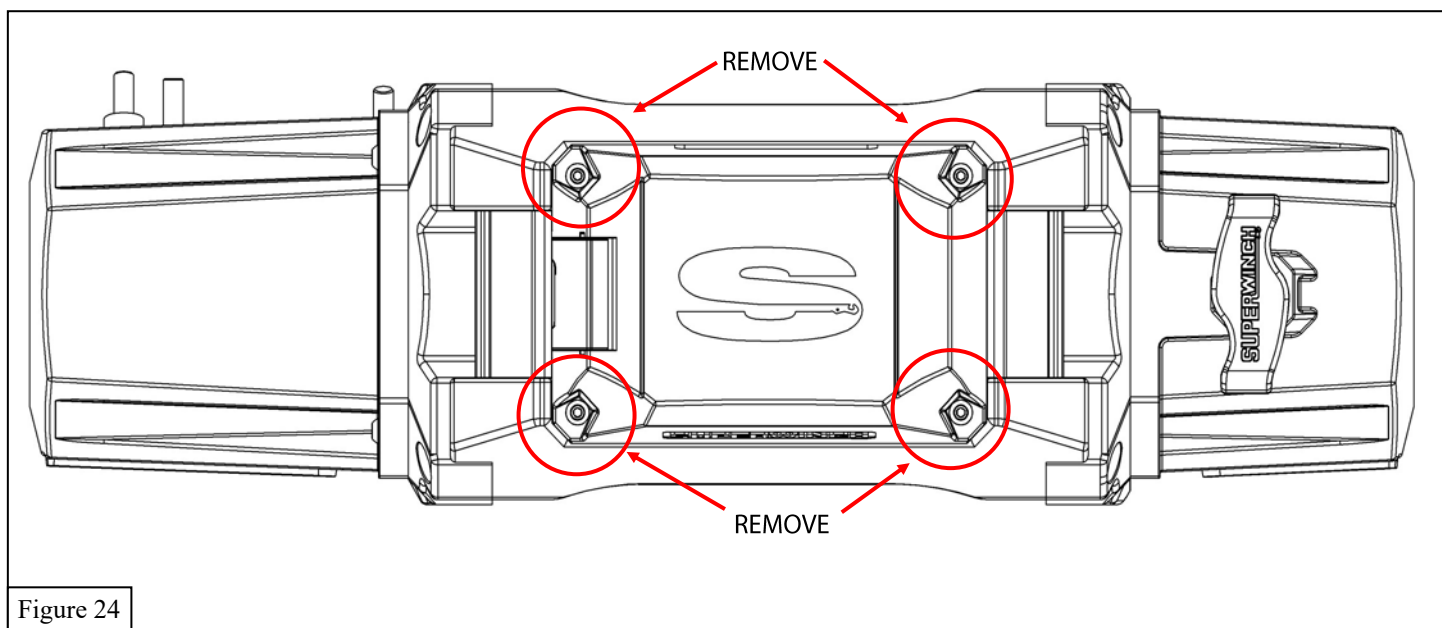
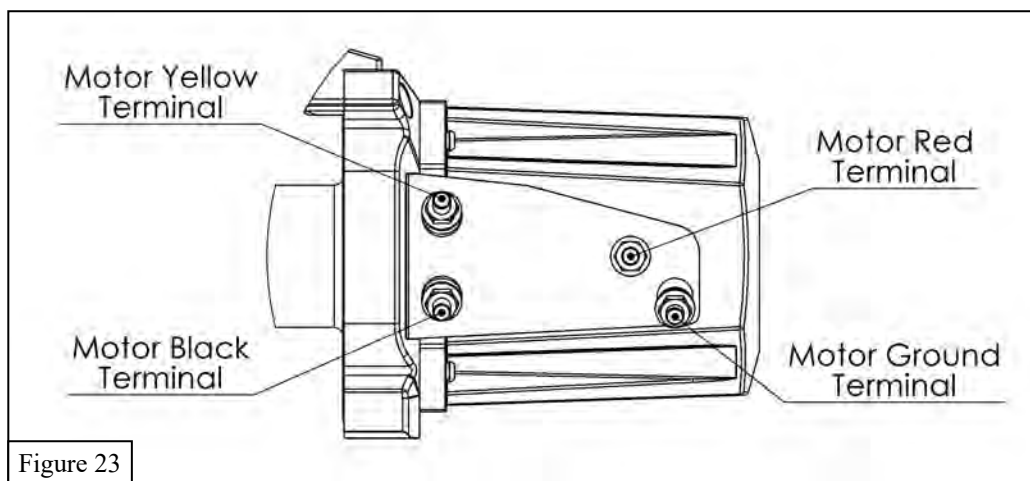


Figure 22

24. Disconnect the cables attached to the winch motor. See **Figure 23**.
25. Remove the winch control box by removing the (4) bolts attaching it to the tie bar. See **Figure 24**.
26. Disconnect the drum light cable. See **Figure 25**.



27. Loosely attach the Fairlead Mount Bracket (**item 2**) onto the Winch Tray (**item 1**) using the M12 hardware (**items 10-11 & 13-14**). On each side, slide two short hex head bolts through the fairlead mount bracket and the front of the winch tray. The serrated flanged hex nuts will be on the inside of the winch tray. See **Figure 26**.

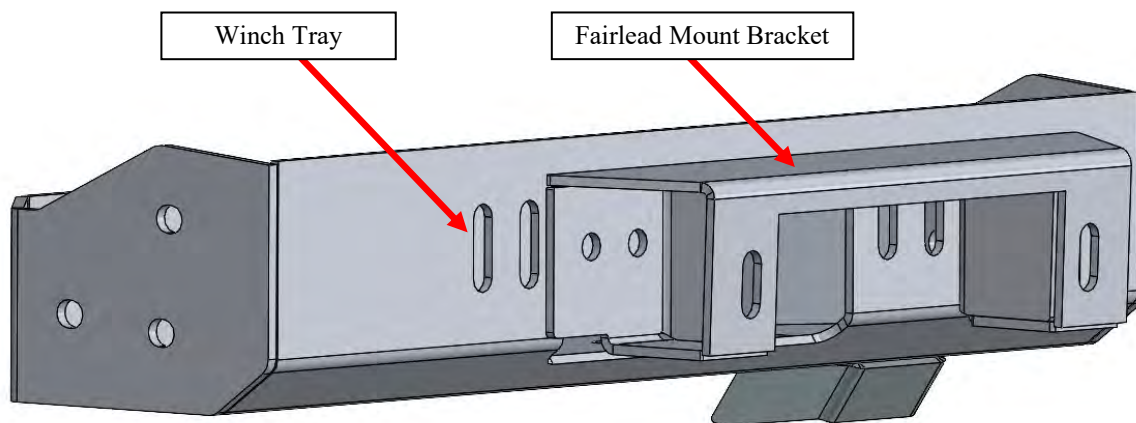


Figure 26

28. Loosely install the winch in the Winch Tray (**item 1**) using the hardware included with the winch. See **Figure 26**.
 29. Loosely install the Winch Tray between the mounting brackets using the M12 hardware (**items 10-11 & 13-14**). The front (4) bolts are installed from the outside placing the serrated flanged hex nuts inside the winch tray. The back (2) bolts are installed from the inside of the winch tray. See **Figures 27 and 28**.

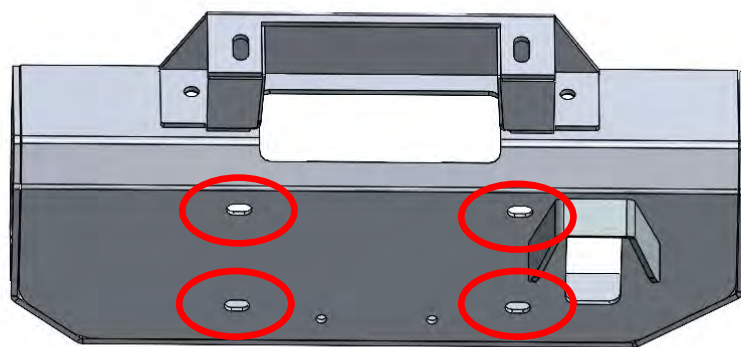


Figure 26



Figure 27

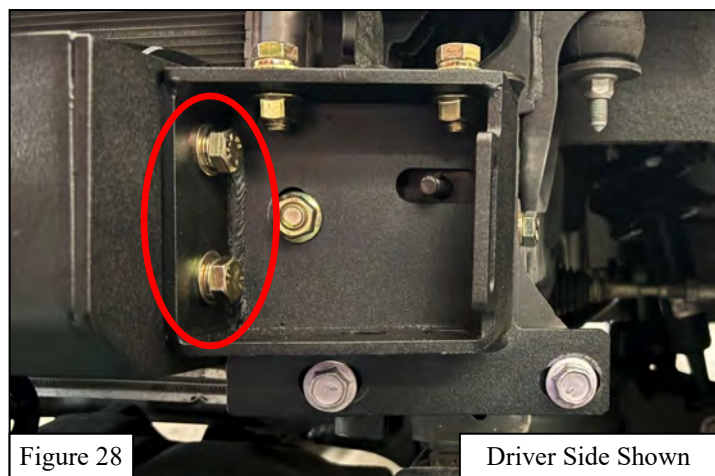


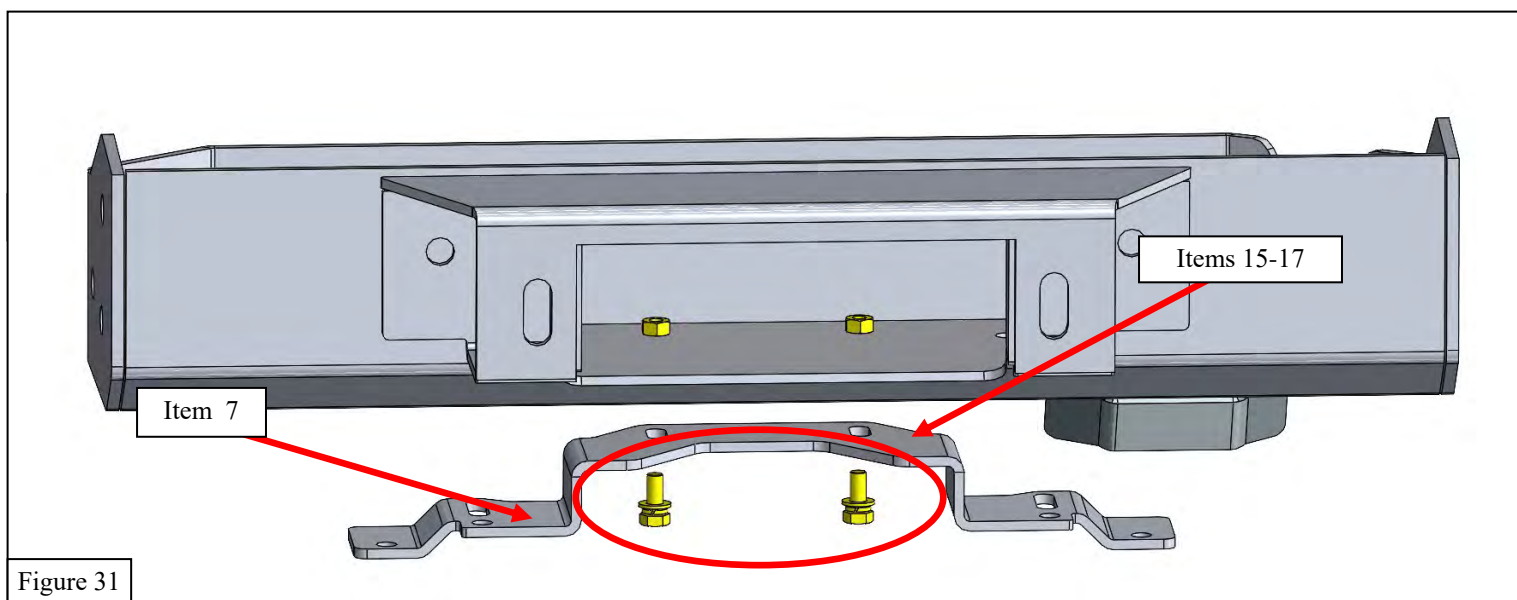
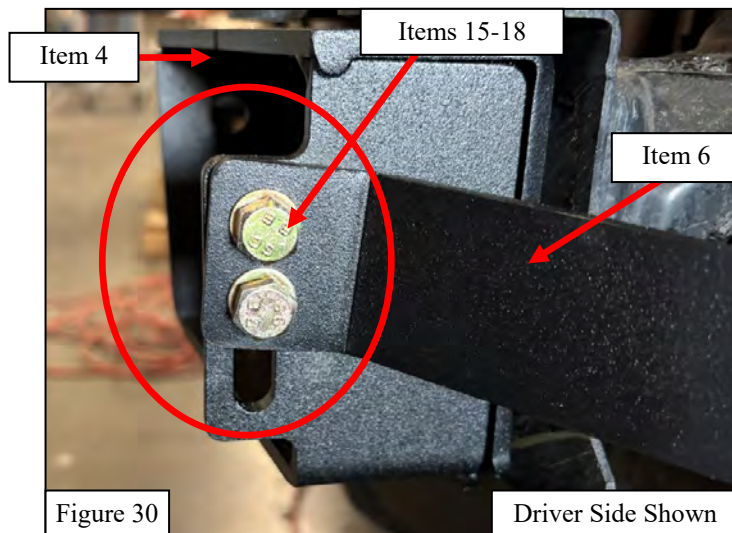
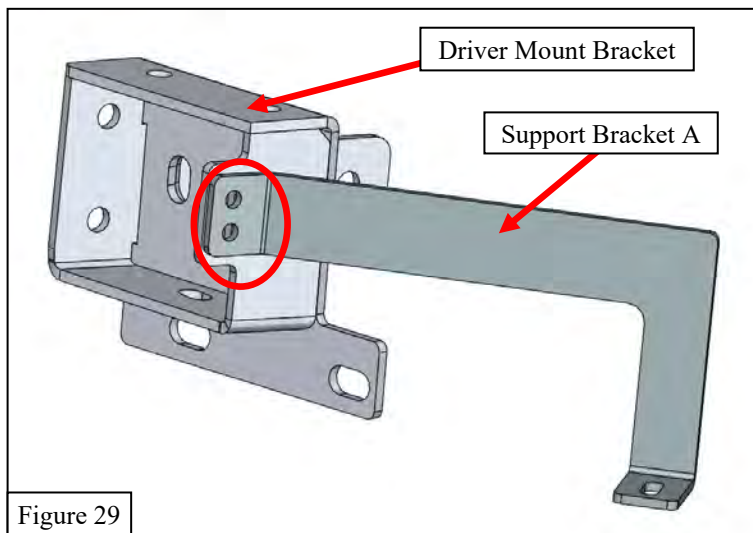
Figure 28

Driver Side Shown

30. Relocate the winch control box using the Control Box Relocation Cable Kit for SX10/12 Winches (90-42782) and the Winch Control Box Relocation Bracket (90-42793). Refer to the instructions included with the cable kit and relocation bracket. The 8 foot long power cable isn't needed but can be used if preferred.

Attach the cables to the winch motor before continuing to the next step

31. Tighten the winch mounting hardware.
32. Tighten all loose M12 hardware to 50-55 ft-lbs.
33. Loosely install Support Bracket A (**item 5**) onto the Driver Mounting Bracket (**item 3**) using the M8 hardware (**items 15-18**). See **Figures 29 and 30**.
34. Loosely install Support Bracket B (**item 6**) onto the Passenger Mounting Bracket (**item 4**).
35. Loosely install Support Bracket C (**item 7**) using the M8 hardware (**items 15-17**). See **Figure 31**.



36. Trim the bumper lower valence. Place the winch fairlead centered at the top of the lower valence. Mark the lower valence around the outside of the fairlead. Trim the lower valence along the marked lines. Additional trimming may be needed after the fairlead is installed. See **Figure 32**.
37. Loosely install the fairlead onto the Fairlead Mount Bracket (**item 2**) using the stainless M10 hardware (**items 19-22**) and the Spacers (**item 8**). See **Figure 33**.
38. Reattach the grille and bumper. Use the M8 hardware (**items 15-18**) to attach the bottom of the bumper to Support Brackets A, B, and C.
39. Tighten the fairlead hardware.
40. The Fairlead Mount Bracket and Support Brackets A, B, and C may need to be adjusted. If needed, remove the grille and bumper, adjust the brackets, tighten the hardware, reinstall the grille and bumper.
41. Trim the lower valence as needed to access the clutch handle on the bottom of the winch tray.
42. Tighten all hardware to the following specifications: M8 to 20-25 ft-lbs, M12 to 50-55 ft-lbs.

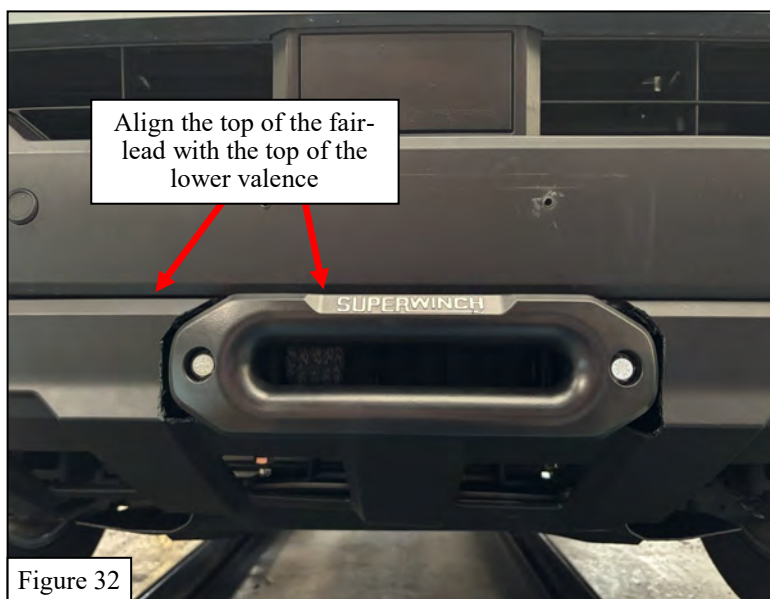


Figure 32

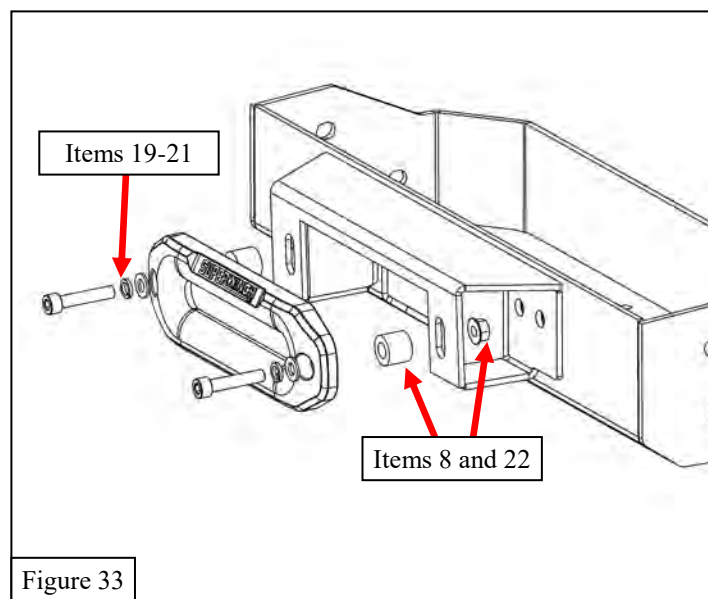


Figure 33

INSTALLATION COMPLETE



CARE INSTRUCTIONS

- REGULAR WAXING IS RECOMMENDED. DO NOT USE ANY TYPE OF POLISH OR WAX THAT MAY CONTAIN ABRASIVES.
- STAINLESS STEEL PRODUCTS CAN BE CLEANED WITH MILD SOAP AND WATER. STAINLESS STEEL POLISH SHOULD BE USED TO POLISH SMALL SCRATCHES.
- GLOSS BLACK FINISHES SHOULD BE CLEANED WITH MILD SOAP AND WATER.

WESTIN

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WARNING



Failure to follow these instructions could lead to death, personal injury, and / or property damage.

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FASTENERS:

All Westin supplied fasteners must be utilized and installed in accordance with the installation instructions and apply torque to the specifications as defined. **DOUBLE CHECK ALL FASTENERS BEFORE INITIAL USE, AND PERIODICALLY IN THE FUTURE TO ENSURE PROPER FUNCTION AND SAFETY.**

DRILLING:

Most Westin products do not require drilling for installation. If drilling is defined as required, use caution when drilling a vehicle. **FAILURE TO REVIEW AN AREA TO BE DRILLED MAY RESULT IN PERSONAL INJURY AND/OR INJURY TO OTHERS AS WELL AS VEHICLE DAMAGE.**

EYE PROTECTION:

ALWAYS WEAR SAFETY GLASSES OR GOGGLES DURING THE INSTALLATION PROCESS TO AVOID PERSONAL INJURY.

MAXIMUM TOWING/CARRYING CAPACITY: (if applicable)

The Westin Receiver Hitches will have a visible tow rating label affixed directly on the product. User should never exceed the vehicle manufacturers maximum tow and weight rating regardless of the capacity of the hitch. **FAILURE TO FOLLOW THESE GUIDELINES WILL VOID THE WESTIN WARRANTY AND MAY RESULT IN PERSONAL INJURY AND/OR INJURY TO OTHERS AS WELL AS VEHICLE DAMAGE.**

FOR CALIFORNIA RESIDENTS ONLY-PROP 65 WARNING:

Some products may contain chemicals such as DEHP, which can cause cancer, birth defects or other reproductive harm. For more info go to www.p65warnings.ca.gov



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