

3rd Gen Tundra Double Cab
PRINSU RACK



Applications installation instructions

These installation instructions apply to the following Prinsu products

– *3rd gen Toyota Tundra Double Cab* Prinsu Rack | 2022- Present SKU:400-000-012-010

IMPORTANT!

THANK YOU for purchasing this Prinsu product. Please read through this entire document before proceeding with installation. If you are not confident in your mechanical skills, please seek the help of a professional to perform the installation. Check your packages immediately upon arrival to ensure that everything listed is included, and to check for damage during shipping. ***If anything is missing or damaged, or if you need technical assistance with any aspect of this installation, call Prinsu at (208) 528-0664 as soon as possible.***

IMPORTANT!

If your Prinsu product comes as unpainted, bare steel or aluminum. You will want to either powder coat or paint prior to final installation, however it is very important to PRE-INSTALL the unpainted product first, following these instructions, BEFORE painting or powder coating any of the components! This will ensure that all parts are correct and any incidental trimming or drilling will have been done prior to coating. Also, it will give you a practice run to familiarize yourself with the process, to lessen the likelihood of damaging the finish during final installation. Prinsu is NOT RESPONSIBLE for paint or powder coating costs, damage to paint or powder coating, or costs associated with inadvertently painting or powder coating components that are defective or were shipped or assembled in error. It is the customer's responsibility to pre-install and verify that all parts are correct prior to paint or powder coat

Hardware

DESCRIPTION	QTY
0.319"ID-3/4"OD x 5/8" Long Aluminum Spacer	8
1/4"-20 0.020"- 0.280" Grip Range Yellow Zinc Flat 1"Length Steel Sherex™ CPB Rivet Nut	9
1/4"-20 x 2" Steel Hex Cap Screw Zinc	8
1/4" x .734" x .062" Steel Flat Washer	8
5/16"-18 x 1-1/8" Steel Coupling Nut Zinc	1
1/4"-20 x 2-1/2" Steel Hex Cap Screw Zinc	1
Crossbar Hardware (For 8 Cross Bars) 51"	
DESCRIPTION	QTY
1/4"-20 x 1" Steel 6-Lobe Pan Machine Screw Black Zinc	34
Vibra-Tite 111 Low Strength Threadlocker Pack of 3 Tubes	1
1/4" x .557" - .567" x .044" - .052" Steel Flat Washer	34
	69
Wind Deflector Hardware	
DESCRIPTION	QTY
1/4"-20 Steel T-nut Plain	12
1/4"-20 x 1/2" Steel Pan Head Phillips Black Zinc	12
1/4" x .557" - .567" x .044" - .052" Steel Flat Washer	12
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Tools Required

- Phillips head screwdriver
- T-30 Torque driver
- Tape Measure
- Sharp metal drill bits
- 7/8" Hole Saw (optional)
- Razor knife
- RTV Black Silicone
- 1/2" wrench
- 7/16" socket or wrench

Note for Dealers and Installers:

It is your responsibility to ensure instructions are given to the end user or client.

Sequence of Steps

Sequence of Steps

1. Lay your rack out and a blanket to reduce damage to the powder coated pieces.
Confirm you have every piece required to mount the rack.
2. Start prepping your T-30 bolts with washers and Vibra-tight.
3. Install three cross bars (front, middle, back) to the side rails, using the t30 Torx Bolts-they are the longer black hardware (Only installing a few will avoid extra weight when putting the rack on the vehicle to make the layout for drilling).
4. Start bolts by hand. Be careful not to overtighten the bolts if using a drill or impact.
5. The crossbars will attach to the smaller slots on the side rails
6. At the vehicle, starting at the black trim at the back of the cab, measure forward 2 inches. Mark with marker. Repeat on the other side.
7. **Drilling for the Plus Nuts.** Starting at the 2 inch mark, drill an 1/8 inch hole just as a pilot hole (don't go too deep, just deep enough to pierce through the first layer of steel)
- **8. Using a 7/8 hole saw drill just deep enough so that the hole saw takes out the foam - This will allow the spacer to sit flat against the metal surface. If you do not feel comfortable with the hole saw, you can use a utility knife to cut out the foam for the spacer. Be EXTREMELY careful with the hole saw.
9. Final drill bite size of 3/8 inch

10. **Plus Nuts** Taking the 2 1/2 inch bolt, add a washer and hex coupler, a washer and plus nut. Making sure you run the plus nut all the way to where it is snug against the last washer. Apply silicone around the base of the plus nut Using a 1/2 wrench, hold the hex coupler then using a 7/16 socket, turn the top of the socket until the plus nut is snug and compressed (75 inch Lbs.)

11. Bring the roof rack over to the vehicle Start a bolt in each of the installed plus nuts. Stand back making sure the rack looks straight.

12: Mark remaining bolt holes.

13: Remove roof rack, and drill remaining bolt holes, inserting plus nuts in the same fashion as before.

14 Move rack back to roof

15: **Spacers** Fill the entire hole with silicone before pushing the spacers into the holes. Hand tighten bolt into the center of the hole.

16: Step back make sure everything is still in alignment and then tighten all the bolts, making sure not to over tighten.

17: Install remaining crossbars

18: Preparing and installing Wind deflector

19. Slide T-nuts into the gray colored Cross bar with the higher side facing down.

20. Align T-nuts with Wind Deflector holes.

21. Prep Phillips head bolts in the same fashion as the T-30 bolts (washer and Vibra-tight)

22. Start Phillips head bolts by hand first then tighten down once all the bolts are started and the Wind deflector is flush with the gray cross bar.

23. Apply Noise Reducing trim and cut off the excess.

Spacers

NOTE:

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Use extreme caution not to drill through the foam into the roof.

Plus Nuts



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