Step 1 80 Series Roof Rack Install Instructions



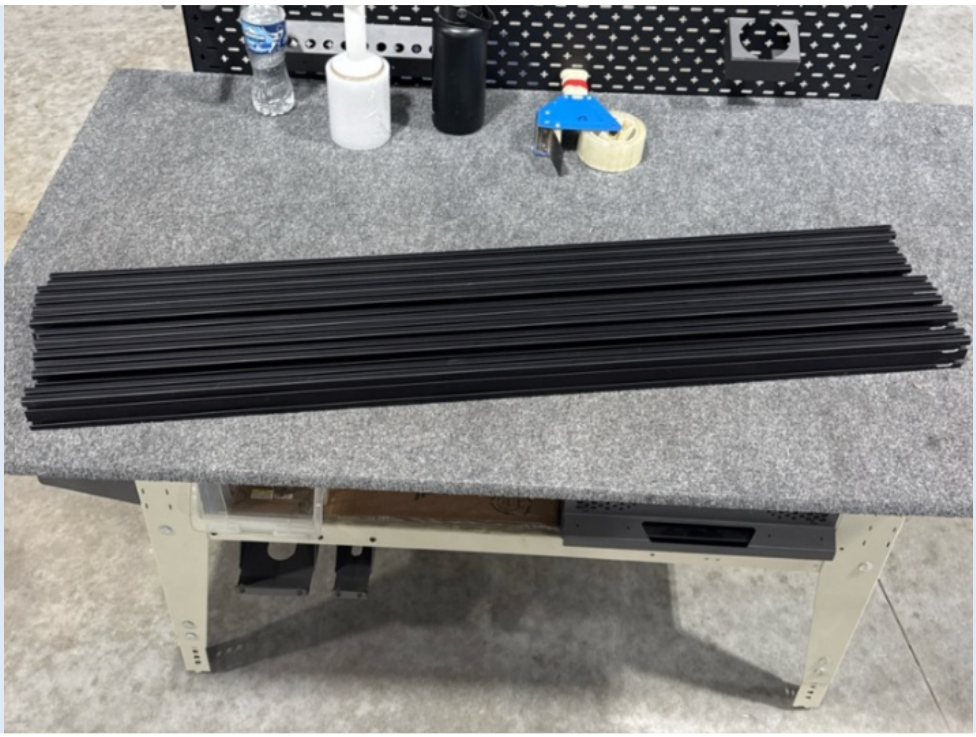


Step by step on how to install the 80 Series Roof Rack. Please read all steps carefully before starting the install.

Installation Video: https://www.youtube.com/watch?v=5eF9VghjaQQ

Questions or Support:
Phone: 269-353-1184
Email: info@victory4x4.com

Step 2 Included Parts



Check that you have all of the parts shown before starting.

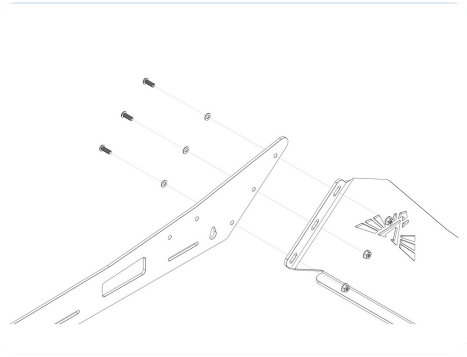
Step 3 Included Hardware

Check that you have all of the hardware below before starting:

- 1/4-20 x 3/4 in button head bolts
- 1/4 in washers
- 1/4-20 serrated flange nuts
- 5/16-18 x 5/8 in button head bolts
- 1/4 in USS washers
- M5 flanged button heads (to seal factory rail holes)
- T-nuts (light bar option)

Step 4 Remove Factory Rack

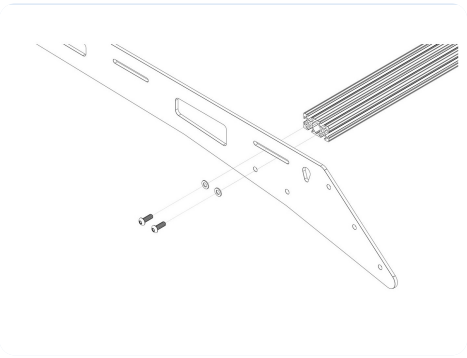




80 Series Land Cruiser roof rack. If you have the factory rack or rails, remove them using the install video. Seal each exposed roof hole with a bead of RTV, then bolt an M5 flanged button head into each.

Step 5 Mount Crossbars

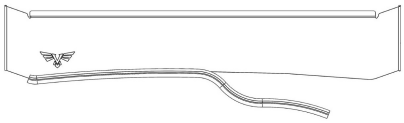




Assemble the rack on the ground. Mount the crossbars between the 2 side rails with 1/4-20 x 3/4 button heads and 1/4 washers, 2 per bar per side. Keep the machined slot in each crossbar facing up so you can add t-nuts for gear.

Step 6 Install Fairing Trim





Mount the trim strip along the bottom edge of the front fairing, starting just outside the peak and running to the matching point on the other side. Cut off the extra, split it in half, and mount both pieces on the rear fairing wherever it touches the roof.

Step 7 Mount Fairings

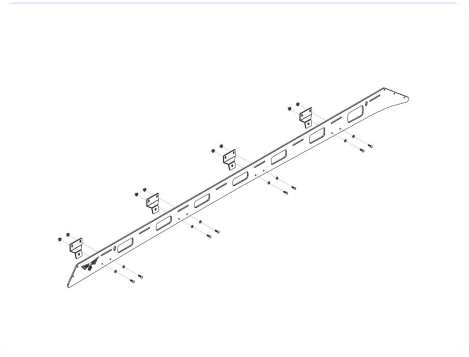




Mount the front and rear fairings with 1/4-20 x 3/4 button heads, washers and serrated flange nuts: 3 each per side on the front and 2 each per side on the rear. Set the front fairing all the way up and leave the bolts loose for adjusting on the roof.

Step 8 Attach Inner Mounts

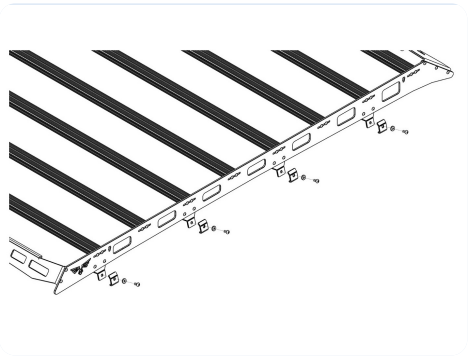




Attach the inner mounts to the inside of the side rails with the same 1/4-20 button heads, washers and flange nuts. All mounts are identical. Face the side with the PEM nut in toward the center of the rack.

Step 9 Set Rack on Roof

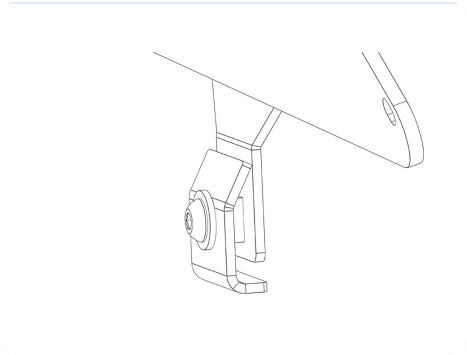




Set the rack on the roof with the mounts inside the rain gutters, and position it for an even gap between the bottom edge of the side rails and the roof. Place each outer mount over its inner mount with the rain gutter between them.

Step 10 Clamp Gutter Mounts





Clamp the rain gutter between the mounts by tightening the outer mount to the inner mount with 5/16-18 x 5/8 button heads and 1/4 USS washers.

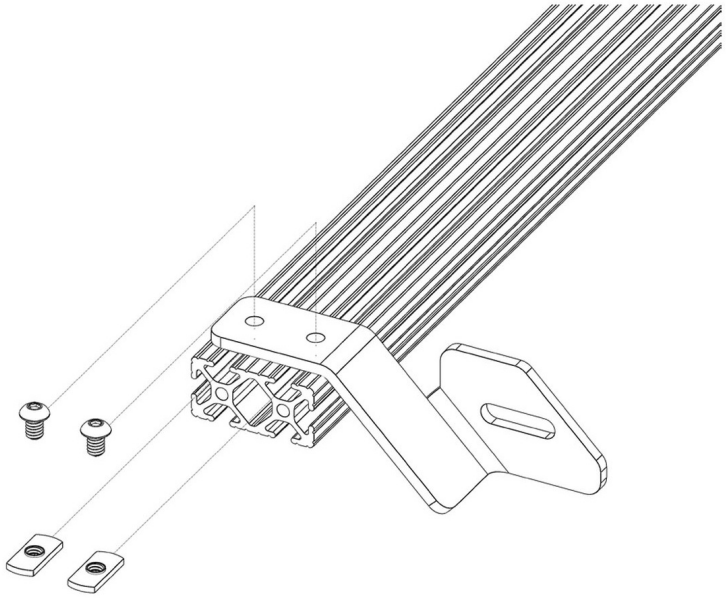
Step 11 Adjust and Tighten





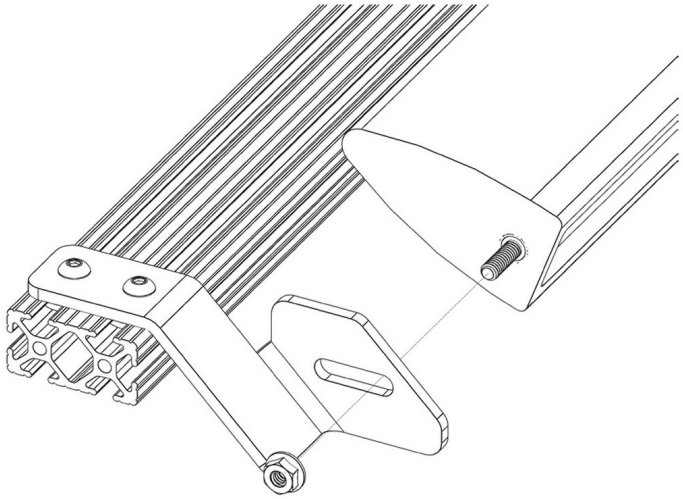
Make final adjustments for an equal gap along the length of the roof. Push the front and rear fairings down tight to the roof and tighten everything. Clear 3M paint protection film where the trim touches the roof protects the paint.

Step 12 Optional Light Bar



Optional 40 inch light bar: slide 2 t-nuts into each channel on the top of the front-most crossbar. Set each light bar mount over a pair of t-nuts and loosely bolt it with the 1/4-20 x 3/8 button heads.

Step 13 Mount Light Bar



Place your light bar between the mounts and secure it in the slots with the hardware that came with the light bar. Center it on the rack, adjusting the crossbar in its slot if needed, then tighten.

Step 14 Installation Complete



Confirm all hardware is tightened. Congrats! Your installation of the 80 Series Roof Rack is now complete. Enjoy!