



INSTALLATION MANUAL
ROOF RACK
PRODUCT NUMBER: RR68
APPLICATION: 2025 TOYOTA 4RUNNER



IMPORTANT SAFETY GUIDE | Your safety and the safety of others is very important.

In order to help you make informed decisions about safety, we have provided the following warnings, safety precautions, installation instructions, and other important information to alert you to potential hazards that could hurt you or others.

Please do a job safety analysis before each task to identify potential hazards for your situation and remove/protect against them. Use own good judgment and take your time.

Check packaged materials immediately upon arrival to ensure that all listed parts are included and undamaged.

Read and understand all warnings, safety precautions, and instructions before installing this product.

SENSORS FIELD OF VIEW MAY BE ALTERED WITH USE OF THE REPLACEMENT BUMPER.

WARNINGS

- Failure to observe the following warnings and instructions provided in this manual could lead to severe injury and/or death.
- For professional installation only. Careless installation and/or operation can result in serious injury, death, and/or equipment damage. All liability for installation and use rests with the user or consumer.
- Fab Fours, Inc. only approves installing this product according to these written instructions with the hardware provided. Failure to install according to these instructions will invalidate the warranty. This includes, but is not limited to, using alternative installation methods, hardware, or materials.
- This product is for off road use only.

SAFETY PRECAUTIONS

- Always remove jewelry and wear eye protection.
- Always use extreme caution when jacking up a vehicle for work. Set emergency brake and use tire blocks. Locate and use the vehicle manufacturers designated lifting points. Use jack stands.
- Always use appropriate and adequate care in lifting components into place.
- Always ensure components will remain secure during installation and operation.
- Always wear safety glasses when installing this kit. A drilling operation will cause flying metal chips. Flying chips can cause serious eye injury.
- Always use extreme caution when drilling a vehicle. Always disconnect power before welding. Thoroughly inspect the area to be drilled (on both sides of material when possible) prior to drilling, and relocate any objects that may be damaged.
- Always use extreme caution when welding a vehicle. Thoroughly inspect the area to be welded (on both sides of material when possible) prior to welding, and relocate any objects that may be a fire hazard. When welding in a cab, make sure the interior surfaces are covered (e.g., welding blanket) and a fire extinguisher is at hand.
- Always use extreme caution when cutting and trimming during fitting.
- Always tighten all nuts and bolts securely per installation instructions.
- Always route electrical cables carefully. Avoid moving parts, components that become hot, and rough or sharp edges.
- Always insulate and protect all exposed wiring and electrical terminals.
- Perform regular inspections and maintenance on mounts and hardware.

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A MESSAGE FROM THE OWNER



Fab Fours' was born out of a passion for customizing vehicles and a love of the outdoors. Our engineering team uses the latest 3D design software to turn new product ideas into reality. In our factory, designs come to life with the combination of cutting edge technology for metal cutting and forming and an American workforce that puts its' heart and pride into every product.

From design and manufacturing, to quality and delivery, Fab Fours' mission is to be the market leader for steel truck and jeep accessories. We make sure a quality product is delivered on time, more than expected, better than expected to our customers.

Enjoy your new Fab Fours product. Welcome to the family!

Greg Higgs

FOUNDER, FAB FOURS

GETTING STARTED

Before you begin the installation process of your new Fab Fours product, we suggest laying out all materials and parts on a pad or protective surface.

Failure to fully account for all components before beginning installation may leave vehicle immobile until part is acquired. Refer to the next pages as an inventory check.

PROVIDED MATERIALS



23486 - FRONT VISOR



23489 - VISOR FILL PLATE



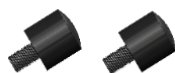
23488 - CROSS BAR QTY: 4



23487 - REAR CROSS BAR



61723 - RUBBER
EDGE TRIM



61720 - RUBBER BUMP
STOP QTY: 2



23429 - MOUNTING BRACKET
QTY: 4



23436 - NUT
PLATE QTY: 4



23484 - PS RUNNER



23485 - DS RUNNER

REQUIRED TOOLS

- PRY TOOL
- ALLEN SOCKET SET
- 10MM SOCKET
- 12MM SOCKET
- 13MM SOCKET
- 9/16 SOCKET

ASSISTANCE

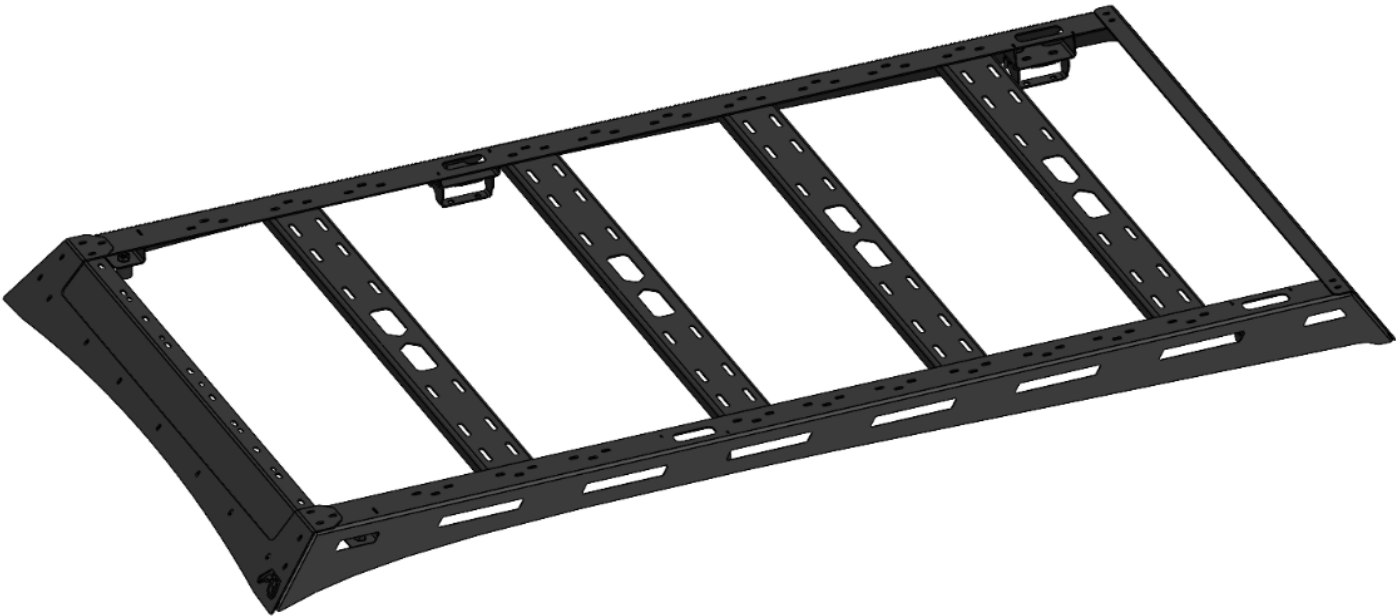
We recommend two people perform the installation as items are heavy and may need to be held in place while installing.

ORGANIZATION

Disassemble the vehicle where you can catalog and store everything. We suggest labeling and bagging all the OEM bolts when removing from the vehicle. Failure to keep track of parts could lead to an inability to properly reinstall components.

HARDWARE KIT | 50527-HW

ID #	COMPONENT DESCRIPTION	QTY
50527-HW	M8-1.25 X 20MM YELLOW ZINC HHCS	8
50527-HW	M8 WEATHER-RESISTANT RUBBER SEALING WASHER	16
50527-HW	M6-1.0 X 25MM BHCS	50
50527-HW	M6-1.0 SERRATED HEX FLANGE NUT	50
50527-HW	3/8"-16 X 1" YELLOW ZINC HHCS	8
50527-HW	3/8" YELLOW ZINC FLAT WASHER	8
50527-HW	242 THREAD LOCTITE	1



DISASSEMBLY & INSTALLATION

1. If your 4Runner is equipped with a factory roof rack, start by removing the rack using the recommended tooling by the manufacturer. If there is no rack on your 4Runner, start by removing the 4x small weather-stripping patches on the weather lining rails to expose the rack mounting locations. (Figure 1)
2. Place 8x of the provided rubber sealing washers over the OE rack mounting hole locations. (Figure 1)

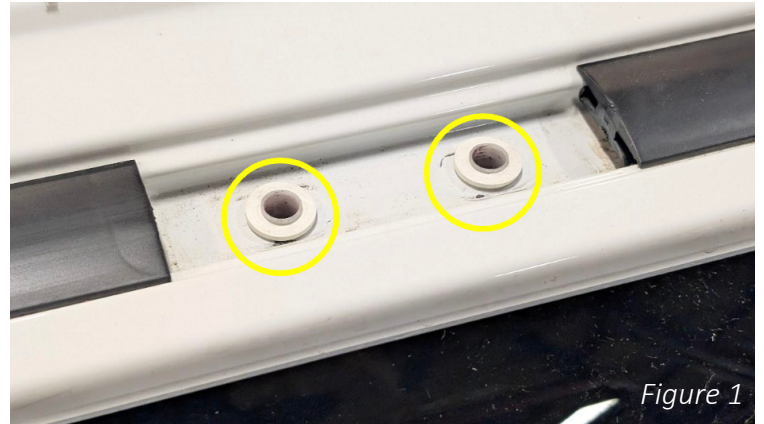


Figure 1

3. Install the 4x provided [23429] mounting brackets in the front and rear OE mounting locations. Use 2x of the provided M8 flange bolts with 2x rubber sealing washers to fasten them in place. Place a small amount of the provided [242 Loctite] on each bolt before installation. (Figure 2)



Figure 2

4. Place the provided rubber edge trim [61723] along the base of the visor weldment [23486]. Cut the rubber trim to length once installed. (Figure 3)



Figure 3

5. If installing lights: install the provided visor fill plate [23489] onto the visor [23486] using 7x of the provided M6 BHCS and nuts orienting the fill plate to provide a mounting surface for the lights. Layout and drill mounting holes for your lights before installing the visor onto the rack assembly. (Figure 4).

If no lights are to be installed, flip the orientation of the fill plate and use an additional 2x BHCS and nuts to fasten the fill plate to the visor. (Figure 5)

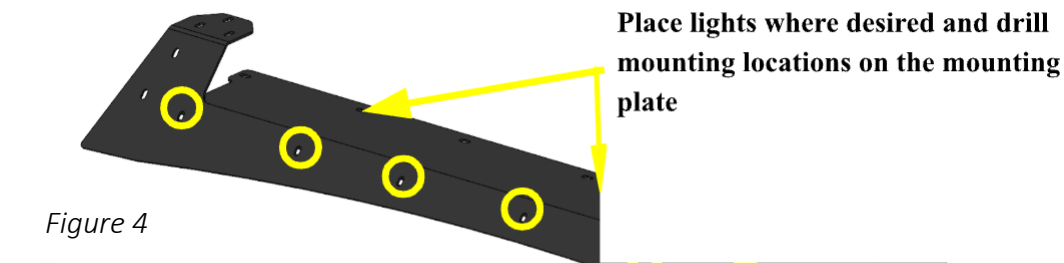


Figure 4



Figure 5

6. Attach the two runner assemblies [23484 and 23485], the front visor [23486] assembled in Step 4 and rear crossbar [23487] using 8x M6 BHCS and 8x M6 flange nuts for both front and rear. Place a small amount of the provided 242 Loctite on each bolt before installation. (Figure 6-7)



Figure 6



Figure 7

7. Place the 4x crossbars [23488] where desired along the runners and use the 6x M6 BHCS and 6x M6 flange nuts per crossbar to attach them. Place a small amount of the provided 242 Loctite on each bolt before installation. (Figure 8)

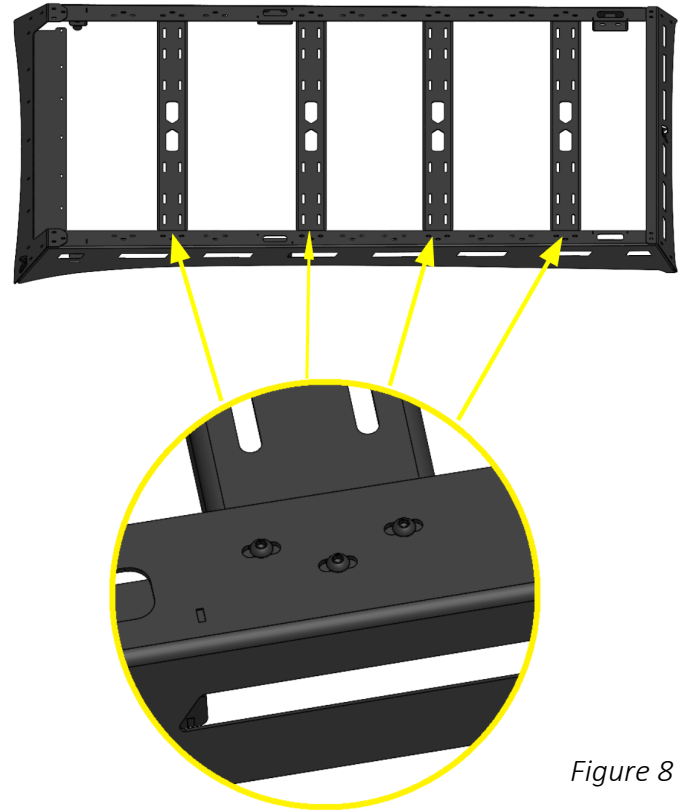


Figure 8

8. Place the 2x provided rubber bump stops [61720] into their mounts located at the front of each runner. Bump stop can be adjusted once on the truck. (Figure 9)

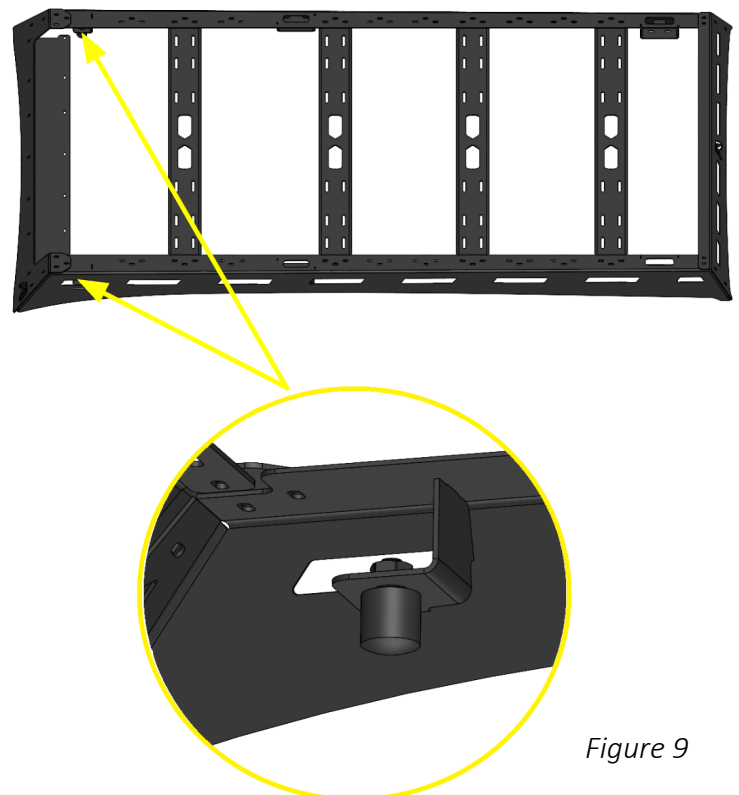


Figure 9

9. With assistance, lift the rack assembly onto the vehicle and on the mounts from Step 2. Use the provided 4x nut plates [23436] and 3/16" hardware to attach the rack to the four corner mounts. Place a small amount of the provided 242 Loctite on each bolt before installation. (Figure 10)



Figure 10

10. Position the rack and fasten all mounting hardware. Adjust the bump stops installed in Step 7 until they are supporting the front section of the rack. Enjoy the fit and Finish of your Fab Fours Roof Rack!

CONTACT INFORMATION

FAB FOURS INC.
2213 INDUSTRIAL PARK ROAD
LANCASTER, SC 29720

PHONE: (866) 385-1905
FAX: 970-385-1914
EMAIL: SUPPORT@FABFOURS.COM
FABFOURS.COM



**“IF YOU’RE LOOKING FOR MORE OF THE SAME,
THEN YOU’VE COME TO THE WRONG PLACE.”**

- GREG HIGGS

