



3841 Quest Court #13
Shingle Springs, CA 95682

ph: 530 677-8111 web: www.inchwormgear.com

P/N: 300-0054

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Rev. Date: 07/09/2011

2WD 4-RUNNER AUTO 4-SPEED TRANSMISSION W/ SLIP to '79-'95 4cyl. 23 SPLINE GEAR DRIVEN T-CASE

KIT INCLUDES:

No.	Part No.	Qty.	Ck. Box	Description
1.	240-0050	1		Adapter Plate - PreRunner Adapter
2.	240-0051	1		Adapter Casting - PreRunner Adapter - W/ Speed Sensor Hole
3.	160-0006	1		Oil Seal - 34 x 53 x 8
4.	160-0008	1		Oil Seal Adapter - PreRunner Casting x 23 Spline Seal
5.	160-0408	1		Coupler - 23 x 23 Spline - 3" Long
6.	120-0052	1		Hardware Kit - PreRunner Adapter
7.	100-1204	2		Nut - 10m x1.5 - JIS Hex
8.	100-0416	4		Bolt - Socket - Cap - 10m x 1.5 x 55mm
9.	100-0201	2		Stud - 10m x 1.5 x 45mm
10.	100-0409	8		Bolt - 14m Hex - 10m x 1.25 x 40mm
11.	100-0801	10		Washer - Flat - 10m
12.	100-0802	12		Washer - Lock - 10m
13.	100-0401	2		Bolt - Socket - Cap - 10m x 1.25 x 40mm
14.	100-0402	4		Bolt - Socket - Button - 8m x 1.25 x 20mm
15.	100-2003	1		Cover Plate - Speed Sensor Hole - PreRunner Adapter Plate
16.	100-0415	1		Bolt - Hex - 6m x 1.0 x 15mm
17.	100-0805	1		Washer - Lock - 6m
18.	100-0803	4		Washer - Flat - 8m
19.	100-0804	4		Washer - Lock - 8m
20.	260-0054	1		Instruction Sheet - PreRunner Adapter - 2wd 4Runner Automatic Trans x 23 Spline Gear Driven Tcase (also available on-line)

Note on this Kit:

The Prerunner Adapter Kit utilizes the combination of 2 adapters. The adapters need to be installed in the correct order with the transercase. Incorrect order of installation can result in leakage, cracking and non functioning adapter kits. New hole(s) in the floor will be necessary in order to shift the transercase(s). The location of the hole will depend on single/dual cases, forward shift or top shift. Your application might be different so it is best to measure for yourself to get the correct location of the hole(s). Crossmember mounts and driveline modifications will be necessary to make your setup work.

PLEASE READ: The components of this kit have been machined for specific applications. Double check you have the correct application for this adapter kit. Any modifications to this kit or the parts in it will void any warranty or return privileges. The instructions are designed to provide information about this adapter. Information about torque specifications, vehicle stabilization, disassembly, fluid recommendations and other related data is best found in repair manuals or factory service manuals available at auto parts stores or dealerships.



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Note on Clocking Adapters:

This Adapter Kit is Clockable. The major benefit to clocking your transference is ground clearance. It is important to note that clocking can cause clearance issues with the floor, e-brakes, shift levers etc. and mounting issues with the crossmember. Before final assembly test fit the transference in your truck to see if you would like to clock your cases or not. If so make the necessary adjustments before final assembly and install of transfer cases.

TRANSMISSION PREPARATION:

Remove slip yoke, Speed Sensor and Tailhousing from the back of the transmission. Do not remove speed sensor rotor from shaft. Your Transmission will not shift without it! Once Tailhousing is removed from the Transmission measure 3.4 inches from the slip yoke end of the output shaft and mark the shaft with a marker. Cover back of transmission to seal off any holes from the grinder dust, debris etc. With a cutoff wheel shorten the shaft to your mark. Clean up any burrs on the splines with a metal file and clean area free of grinder dust and debris.

ADAPTER INSTALLATION:

Ensure stock speedometer gear and sensor rotor are in place (see diagram). Install Transmission to Transference Coupler on output shaft of transmission, light tapping with a brass hammer may be necessary to fully seat the coupler.

The first adapter to be bolted up is the PreRunner Adapter.

Clean mounting surface of adapter and transmission. Evenly spread silicone on back of transmission and install Inchworm Prerunner adapter with the Logo facing the back of the truck. Use 2 Socket Head Bolts (no.8) for the upper 2 holes in the Adapter and 4 Socket Head Bolts (no.7) for the lower 4 holes. Lock Washers are not necessary for these bolts. Torque to factory tailhousing specifications.

The Adapter Casting is Bolted to the PreRunner Adapter Next. If you are using a top shift transference install Cover Plate (no.13) on Adapter Casting with silicone using Bolts (no. 14) and Washers (no. 19 and 20). Clean mounting surface of PreRunner Adapter and the round side of the Adapter Casting. Evenly coat mounting surface of Adapter Casting with silicone and install behind the Inchworm Prerunner Adapter in the desired clocking holes with the remainder of the Socket Head Bolts (no.8) and Lock Washers (no.11). Coat the Billet Nuts (no. 6) with silicone and slide through the Inchworm Adapter to accept the upper 2 bolts going through the Adapter Casting.

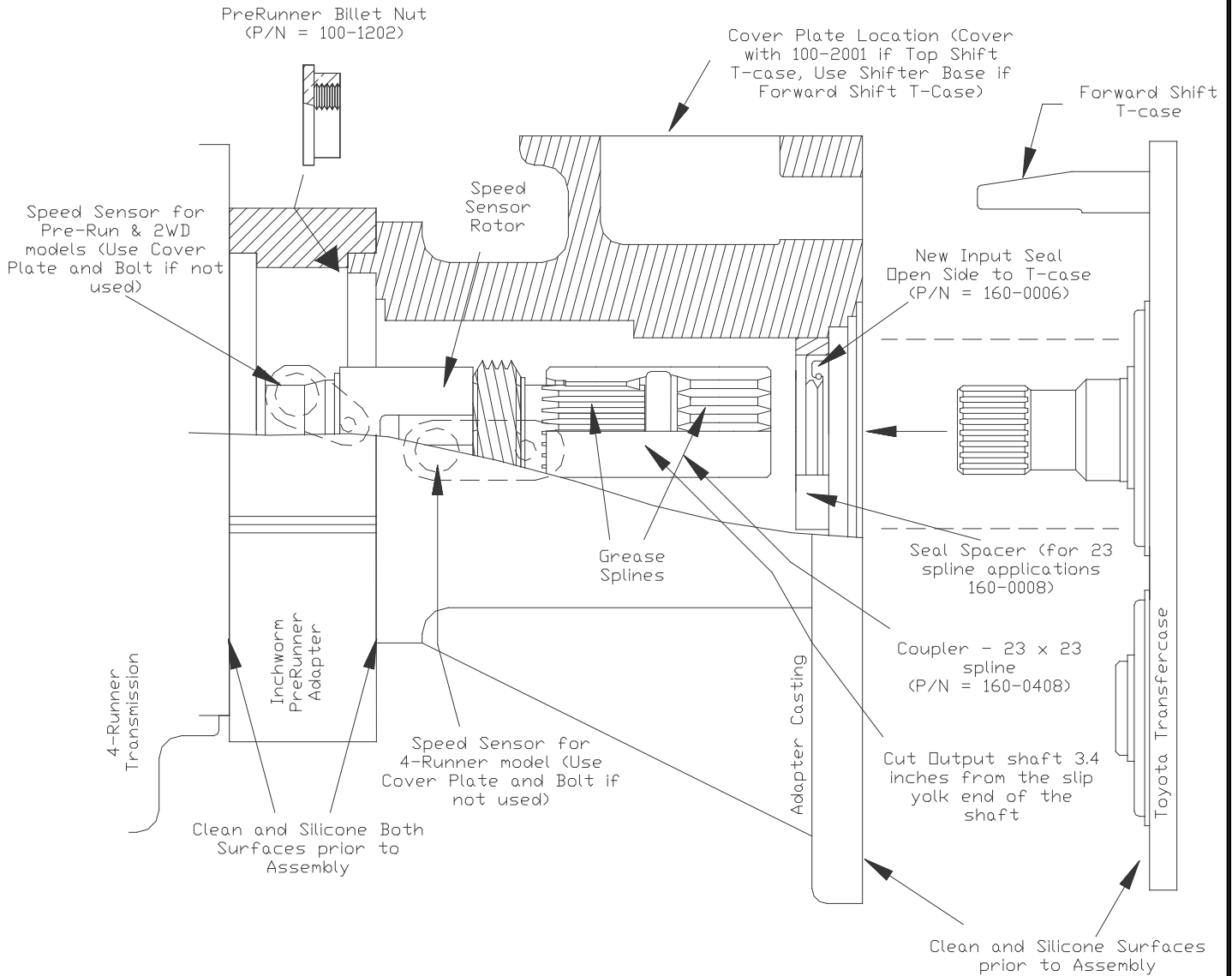
Install Speed Sensor into Adapter Casting, note: coat threads of speed sensor bolt with silicone prior to installation to prevent leaks. Install Speedometer Cover Plate (no.16) with silicone and Bolt (no.17) to cover the unused speedo holes. Cover Plate (no. 15) can be discarded.

TRANSFERCASE(S) INSTALLATION:

The Cases are installed last. Clean mounting surface of Adapter Casting and Transference free of oil, debris, etc. Apply hi pressure grease to splines on input shaft of t-case. Evenly coat the mounting surface of the transference with silicone. Install Transference(s) onto Casting in the truck using Hex Head Bolt (no.9) with Flat and Lock Washers (no. 10 and 11) for the lower four holes and Socket Head Bolt (no. 12) with Lock washers (no.11) for the upper two holes **Support weight of transference(s) with a transmission jack. Adapter may be damaged if the weight of the transference(s) is not supported.** The crossmember will support the weight once the case(s) are installed.

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