



# MARLIN CRAWLER MARRACK

## HEAVY DUTY CENTER MOUNT INSTALLATION

### OVERVIEW

Thank you for purchasing our Heavy Duty Center Mount Kit. This installer shows how to install a Heavy Duty (solid) Center Mount for all Heavy Duty MarRack Steering Rack Installations. The MarRack Steering System features a full-size Heavy Duty steering rack with provisions for an additional center frame mount which this kit takes advantage of for additional steering rack-to-frame connection strength.

This Kit is specifically designed to be compatible with a 200-series steering rack installed using RCLT HD MarRack installation procedure and equipment for proper alignment with frame.

### HOW TO USE THIS INSTALLER

Before beginning, please read entire install guide and ensure all parts are present. The procedures are presented in a step-by-step format:

- The photo or illustration shows *what* to do and *where* to do it.
- The task heading tells *what* to do.

The detailed text tells *how* to perform the task and gives other information such as specifications and warnings.

### INSTALLATION OVERVIEW

**Estimated Installation Time:** 1-2 hours

### GENERAL REPAIR INSTRUCTIONS

1. Use fender, seat, and floor covers to keep the vehicle clean and prevent damage.
2. During disassembly, keep parts in order to facilitate reassembly.
3. Carefully observe all specifications for bolt tightening torques. Always use a torque wrench.
4. Care must be taken when jacking up and supporting the vehicle.
  - a. If the vehicle is to be jacked up only at the front end, be sure to block the rear wheels to ensure safety.
  - b. After the vehicle is jacked up, be sure to support it on stands.

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**Kit Part Number MCST-2221**

**Installer version: 1.01** (12/7/2022)



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# CENTER MOUNT INSTALLATION



Fig 1

## 1. REMOVE SKID PLATE

If applicable, remove vehicle skid plate to expose front IFS sub frame crossmember and MarRack



Fig 2

## 2. [TACOMA ONLY] REMOVE CENTER JACK-POINT BRACKET

**NOTE:** This step is **ONLY** for 2005+ Tacoma

Using a grinder, plasma, torch, or equivalent cutting device, cut-off and remove factory center jack-point bracket from front IFS sub frame crossmember. Figure 2 shows center jack-point bracket removed and factory welds ground down smooth



Fig 3

## 3. INSTALL UPPER PLATE

Remove both M14 main MarRack mount bolts, tilt and wiggle the rack rearward about an inch. Steering hardware does not need to be disconnected

Slide Upper Plate under the rack with welded spacers facing upright

Tilt and insert both 1/2" Grade 8 Carriage Bolts down through both square holes and into the sub frame assembly crossmember



Fig 4

## 4. INSTALL LOWER PLATE

Install Lower Plate through either of the large holes indicated by arrows

Pass plate up through both bolts, capturing it with both 1/2" Grade 8 Crimp Nuts

**IMPORTANT: LEAVE NUTS FINGER TIGHT ONLY**

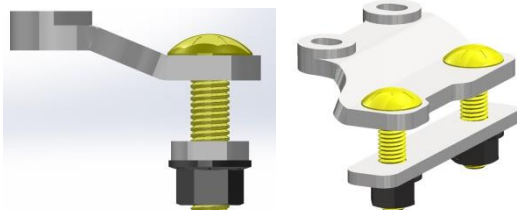


Fig 5

Figure 5 shows proper installation orientation



Fig 6

### 5. TIGHTEN UPPER PLATE TO MARRACK

Reinsert M14 MarRack hardware and loosely install both nuts

Ensure Upper & Lower Plates are not in a bind

Use provided M10x1.50x35 Class 10.9 Flanged Bolts to attach Upper Plate to MarRack

Torque to 40 lb-ft lubricated or 50 lb-ft dry



Fig 7

### 6. TIGHTEN MARRACK TO SUB FRAME CROSSMEMBER

Ensure Lower Plate and hardware are not in a bind

Tighten M14 MarRack hardware

Torque to 111 lb-ft lubricated or 148 lb-ft dry



Fig 8

### 7. TIGHTEN CENTER MOUNT ASSEMBLY TO SUB FRAME CROSSMEMBER

Torque 1/2" Crimp Nuts to 80 lb-ft lubricated or 100 lb-ft dry

**TIP:** Use a thin-wall chrome socket to access hardware

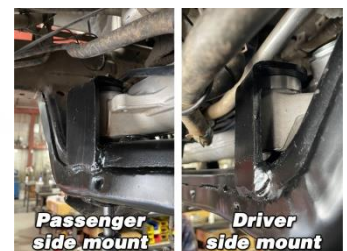
**TACOMA APPLICATIONS:** Tape surrounding area and spray paint former center jack-point location to prevent corrosion

Reinstall Vehicle Skid plate (if applicable)

Installation is now complete

This Setup pairs *great* with our Heavy Duty Double-Shear MarRack Mount Upgrade Kit and is how we prefer to install RCLT HD setups, especially for applications running 37" or larger tires

Scan the QR code for details



Passenger side mount

Driver side mount