



# MARKS4WD

## Fitting Instructions for MFK40440 Crossmember Mounting - LS V8 60 Series



### Important Information

This instruction booklet can be used standalone for the above stated conversion but we would also recommend having a workshop manual for your vehicle and for the engine/transmission you are installing to cover any factory torque / installation settings to complete the installation.

The instruction booklet describes the required modifications (if any) and installation process in order for our kit to fit and work properly. These instructions **make no assumption** on whether additional changes need to be considered or made. It is highly possible that other aspects of your vehicle and/or third party products, eg. Engine, transmission etc. will have an impact on all that is required for you to achieve your desired outcome.

Marks 4WD Adaptors do not and cannot take responsibility for knowing everything that may impact on your conversion. Before beginning any work, thoroughly work through the sequence of changes, work and potential impact of your conversion. You must ensure you completely understand all the factors that may impact on achieving your desired results.

**NOTE:** We have fitted this conversion into the Toyota LandCruiser FJ60 with a three-piece cross member. If fitting to different models or configurations, modifications may be required.

### **Step 1 Remove Factory Crossmember Chassis Brackets**

Unbolt the original Toyota cross member brackets from the chassis and ensure the bolts at both ends of the cross member are loose.

### **Step 2 Install Engine, Transmission & Transfer Case**

Install the engine, transmission, and transfer case to the vehicle.

Doing this will be a test fit installation to find the new location of the cross member mounts that will require welding to the chassis.

If you use a 6L80 automatic transmission, the new location for the cross member mounting brackets is rearward of the original Toyota location.

Check and measure the cross member is in the correct place. Ensure your engine mount location is correct on the chassis for clearance around the firewall and distance to the radiator. See image 1.1



**Image 1.1 Check Location**

### **Step 3 Tack Weld in Place**

When you have completed all checks and measurements, proceed to check your vehicle's electrical system and fully disconnect the battery and check your surrounding area for highly flammable items. These include fuel and brake lines located on the chassis rail. The model or variant of vehicle you have, adjust accordingly depending on the original engine & transmission that was factory installed. These could be too close to your welding area. You may require surface preparation for welding. The condition and cleanliness of the metal surfaces can affect weldability. The chassis should be free from rust, scale, paint, dirt, and other materials. These can cause variability in weld quality. Loose contamination may be wiped from the surface, whereas paint may need to be removed by solvent or wire brushing. When you have completed the surface preparation, continue to tack weld cross member mounts to the chassis. See image 3.1



**Image 3.1 Tack Weld Bracket**



### **Step 4 Complete Welding**

If required, remove the complete assembly of the engine, transmission, and transfer case from the vehicle to give more access for welding. Then fully weld both sides of the cross member mounts to the chassis. Doing this gives you two complete welds per cross member mount. Carry out the same for both sides of the chassis. Clean any welding splatter if required, then paint. See image 4.1 & image 4.2



**Image 4.1 LHS Cross member Mount**

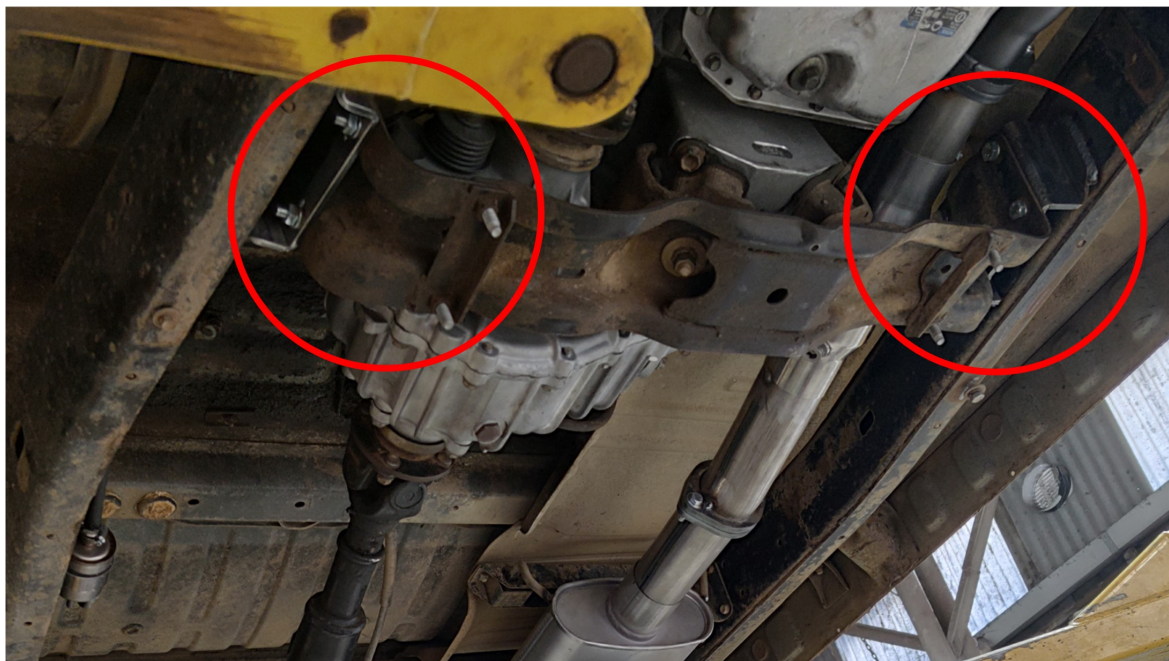


**Image 4.2 RHS Cross member Mount**

### **Step 5 Install Cross Member**

Install the engine, transmission, and transfer case to the vehicle. You may have removed it in the previous step. Install all supplied bolts & washers, then torque to specs from the Toyota workshop manual.

See image 5.1



**Image 5.1 Cross Member Mounts Completed**

## **Terms and Conditions**

Thank you for purchasing this product manufactured by Marks 4WD Adaptors. Components supplied in this kit are designed and machined for a specific conversion only as outlined in this guide. Modifications to or substitution for any of the components without the written consent of Marks 4WD Adaptors will void any possible warranty or return privileges.

The following instructions are intended as a guide and only for Marks 4WD Adaptors kits. If you do not fully understand the steps, modifications or changes required to complete the conversion, contact our sales department for more information. We recommend that you purchase a service manual pertaining to your vehicle for specific torque values, wiring diagrams and other related information.

## **Contact Information**

Web: <http://www.marks4wd.com/>  
Email: [sales@marks4wd.com](mailto:sales@marks4wd.com)  
Phone: +61 3 9552 6555  
Address: 385-393 Lower Dandenong Rd  
Dingley, Victoria, 3172  
Australia