

07+ TUNDRA BED STIFFENER KIT

	<p>NOTICE</p> <p>Read instructions completely before installing this product. Refer back to the instructions frequently during installation.</p>		<p>CAUTION</p> <p>Flying Object Hazard. Fluid Splash Hazard. Wear safety glasses at all times when working on vehicle.</p>
<p> WARNING: Cancer and Reproductive Harm - www.P65Warnings.ca.gov</p>			

1. Remove the upper and lower taillight mounting bolts using a T30 Torx bit.



2. Remove the taillight and let it hang by the wires. Use care to remove the tail light straight out from the body to avoid damaging the snaps that hold the front of the tail light in place.



AP-308736

3. Remove the bed mount bolt as shown using a T55 Torx bit.



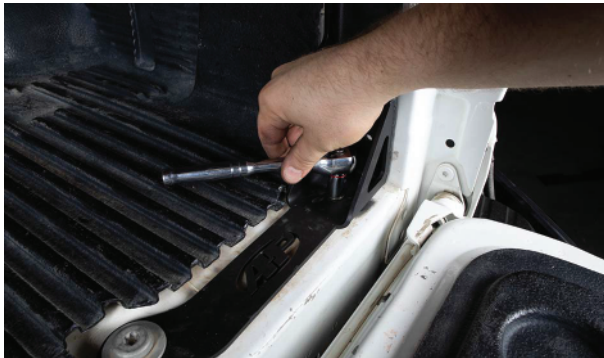
4. Set the new bracket in place and align the large bottom mounting hole in the bracket with the bed mount hole in the bottom of the bed. Note the brackets are side specific, with the bracket's bottom curved section oriented toward the front of the vehicle.



5. Reinstall the bed mount bolt. Once the bed mount bolt is installed push the bottom of the bracket against the side of the bed to take up any space between the two. Snug the bed mount bolt but do not fully tighten it yet. At this point it would be a good idea to raise and lower your tailgate to ensure that the bracket will not interfere with your tailgate. If the bracket prevents your tailgate from closing rotate the bed side of the bracket toward the cab of the truck and retest.



6. Using the small hole in the bottom of the bracket as a guide and a 5/16" drill bit, drill through the bottom of the bed. After drilling through the bed install a provided short 5/16 bolt, flat washers, lock washer, and nut through the hole. Tighten the 5/16 bolt and the bed bolt to the torque specifications given in these instructions.



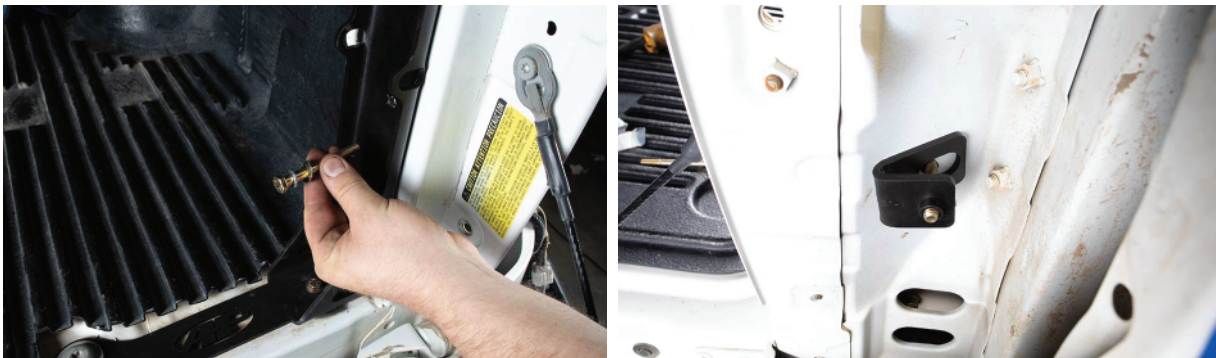
7. Using the three holes in the side of the bracket as a guide and a 5/16" drill bit, drill through the side of the bed. Start with the bottom hole and work your way up towards the top of the bracket. Before drilling the next hole make sure that the previous holes in the bed are still aligned with the holes in the bracket.



8. Install the provided short 5/16 bolts with a washer between the head of the bolt and the bracket, and with a washer between the nut and the bed for the two locations shown. Tighten both bolts to the torque specifications given in these instructions. If you had a gap between the side of the bed and the bracket tighten the bolts from bottom to top to take up the gap.



9. Install the provided longer 5/16 bolt with a lock washer between the head of the bolt and the flat washer in the location shown. Align the bent bracket on the other side of the bed with the longer 5/16 bolt and tighten the 5/16 bolt. Torque the longer 5/16 bolt to 12 ft/lb MAX.





10. Check all bolts to make sure they are tight and reinstall the tail light.

11. Repeat the procedure to install the bracket on the other side of the bed.

Bolt Torque:

Short 5/16 bolt: 18 ft/lb

Long 5/16 bolt: 12 ft/lb MAX

T55 bed bolt: 60 ft/lb