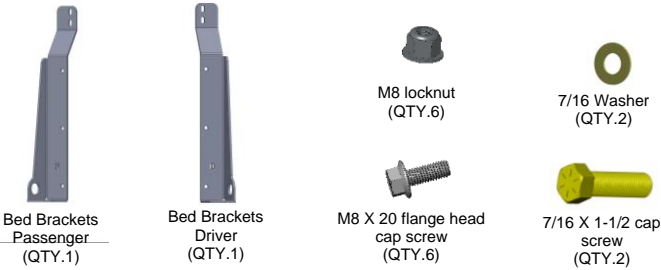


TACOMA BED STIFFENER INSTALLATION INSTRUCTION

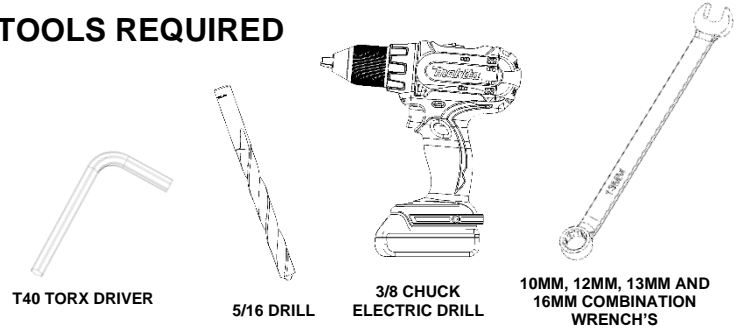
APPLICABLE MODELS:

2nd and 3rd Generation Tacoma Short and long bed models (2005-2021)

PACKAGE CONTENTS



TOOLS REQUIRED

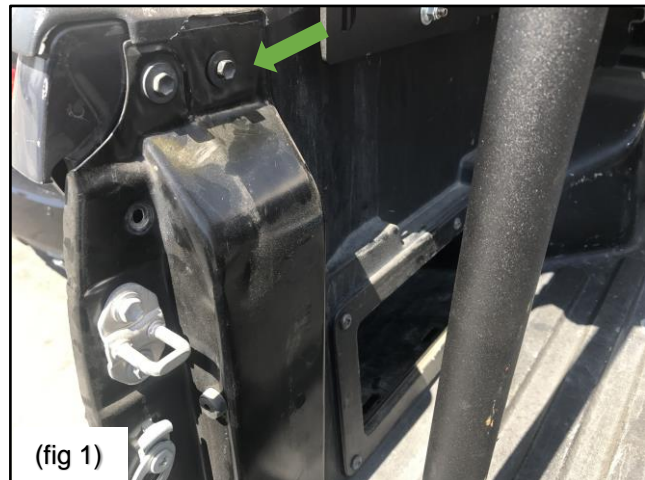


BEFORE INSTALLATION

THE ACS FORGED OR CLASSIC RACK MUST BE INSTALLED FIRST! DO NOT INSTALL THE BED STIFFENERS IF YOU DO NOT HAVE THE RACK INSTALLED!!

1 REMOVE BOLTS FROM TRUCK BED

- 1) USING A 10MM WRENCH OR SOCKET REMOVE THE BOLTS ON BOTH PASSENGER AND DRIVER SIDE D-PILLAR. (FIG 1)
- 2) REMOVE THE TIE DOWN BRACKET ON BOTH DRIVER AND PASSENGER SIDE USING A T40 TORX WRENCH. (FIG 2)



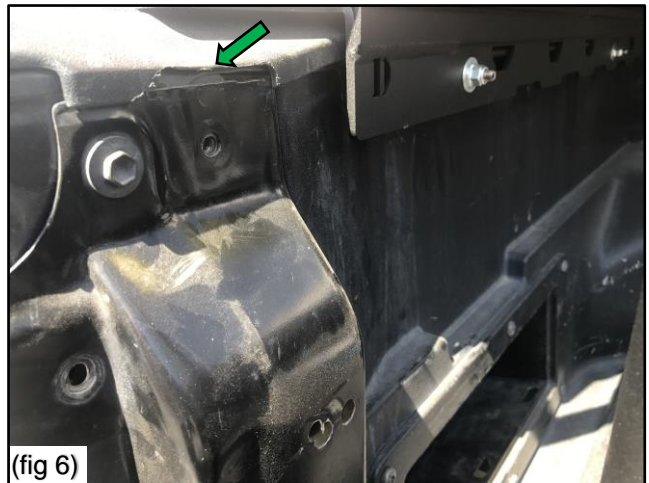
REMOVE TAILLIGHTS AND INSTALL BED STIFFENER BRACKETS

- 1) USING A 10MM WRENCH OR SOCKET REMOVE THE 2 BOLTS THAT HOLD THE TAILLIGHT ASSEMBLY'S TO THE TRUCK. (FIG 3)
- 2) PULL BACKWARD ON THE TAILLIGHTS (TOWARD REAR OF TRUCK) TO UNSEAT THE TAILLIGHT. LET THEM DANGLE BY THE WIRING HARNESS. (FIG 4)
- 3) ALIGN THE BRACKET AS SHOWN. USING THE SUPPLIED 7/16 BOLT AND WASHER LOOSELY TIGHTEN THE BOLT SO IT CAN STILL BE MOVED BY HAND. (FIG 5)
- 4) INSERT THE BOLT IN THE D-PILLAR REMOVED IN STEP 1. (FIG 5)



INSTALL BED STIFFENER BRACKETS

- 1) ON 2005-2015 2ND GEN TACOMA'S THE BED RAIL CAP WILL NEED TO BE SLIGHTLY MODIFIED TO MAKE CLEARANCE FOR THE BED STIFFENER. (USE A DREMEL OR RAZOR KNIFE FOR THIS. (FIG 6)
- 2) USING THE 3 HOLES IN THE BED STIFFENER BRACKET AS A GUIDE DRILL THE 3 HOLES WITH A 5/16 DRILL. (FIG 7)
- 3) INSERT THE 3 M8 X 20 SCREWS AND ATTACH A LOCK NUT ON THE BACK. (FIG 8)
- 4) TIGHTEN THE THREE M8 BOLTS USING A 12MM AND 13MM WRENCH RESPECTIVELY.
- 5) TIGHTEN THE 7/16 BOLT USING A 17MM WRENCH.
- 6) TIGHTEN THE TOP 6MM BOLT USING A 10MM WRENCH. MAKE SURE THIS IS THE LAST BOLT THAT IS TIGHTENED AS IF THE BRACKET IS TOO FAR AWAY FROM THE TRUCK BED IT CAN BE STRIPPED.
- 7) REPLACE THE LIGHT ASSEMBLY WITH THE SCREWS REMOVED IN STEP ONE ON PAGE TWO.
- 8) REPEAT FOR OTHER SIDE.



ACTIVE CARGO SYSTEM GUIDLINES

When using Leitner Designs carriers and accessories, the user must understand the precautions. The points listed below will assist you in using the rack system and will encourage safety.

- For quality fits and safety, use only the recommended rack or accessories. Do not assume a rack will fit, always check the current Fit Guide when obtaining a new vehicle.
- The maximum load is not to be exceeded. (250# off road – 500# on road). However, this limit is always subordinate to the maximum load recommended by the manufacturer of the vehicle itself. It is always the lower maximum recommended load that applies. Max truck load = load carrier weight + any fitted carrier accessories + the weight of the load itself.
- Make sure all knobs, bolts, screws, straps, and locks are firmly attached, tightened and locked before every trip. Knobs, bolts, screws, straps and locks must be periodically inspected for signs of wear, corrosion, and fatigue. Check your load at stops during the trip to ensure continued fastening security.
- Check local and state laws governing projection of objects beyond the perimeter of a vehicle. Be aware of the width and height of your cargo since low clearance branches, bridges, and parking garages can affect the load. All cargo will affect the vehicle's driving behavior. Never drive with any lock, knob or rack in an open or unlocked position. All long loads such as, but not limited to, sailboards, surfboards, kayaks, canoes, and lumber must be tied down front and rear to the bumpers or tow hooks of the vehicle.
- All locks must be turned and moved periodically to ensure smooth operation. Use graphite or dry lubricant to help this. Leitner designs locks are designed to deter vandalism and theft but should not be considered theft proof. Remove valuable gear if your vehicle is unattended for an extended period. Place at least one key in the glove compartment.
- For safety to your vehicle and rack system, obey all posted speed limits and traffic cautions. Adapt your speed to the conditions of the road and the load being carried.
- Do not use Leitner Designs load carriers and accessories for purposes other than those for which they were designed. Do not exceed their carrying capacity. Failure to follow these guidelines or the product's instructions will void the warranty.
- Consult with your Leitner Designs dealer if you have any questions regarding the operations and limits of Leitner Designs products. Review all instructions and warranty information carefully.

ACTIVE CARGO SYSTEM WARRANTY

Leitner Designs warrants product to be free from defects in material and workmanship, for terms specified below, provided there has been normal use and proper maintenance. All remedies under this warranty are limited to the repair or replacement of any item found by the factory to be defective within the time period specified. If you have a warranty claim, first you must call our factory at the number below for instructions. You must retain proof of purchase and submit a copy with any items returned for warranty work. Upon completion of warranty work, if any, we will return the repaired or replaced item or items to you freight prepaid. Damage to our products caused by accidents, Fire, vandalism, negligence, misinstallation, misuse, Acts of God, or by defective parts not manufactured by us, is not covered under this warranty.

THE WARRANTY TIME PERIOD IS AS FOLLOWS: (2) TWO YEARS FROM DATE OF PURCHASE.

ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND/OR FITNESS FOR A PARTICULAR PURPOSE CREATED HEREBY ARE LIMITED IN DURATION TO THE SAME DURATION AND SCOPE AS THE EXPRESS WRITTEN WARRANTY. OUR COMPANY SHALL NOT BE LIABLE FOR ANY INCIDENTAL OR CONSEQUENTIAL DAMAGE.

Some states do not allow limitations on how long an implied warranty lasts, or the exclusion or limitation of incidental or consequential damages, so the above limitations or exclusions may not apply to you. This warranty gives you specific legal rights, and you may also have other rights that vary from state to state.

**FOR WARRANTY ISSUES WITH THIS PRODUCT PLEASE CALL OR EMAIL LEITNER DESIGNS CUSTOMER SERVICE 949-395-3049
support@leitnerdesigns.com**

WARNING

Be sure to read and precisely follow the provided instructions when installing this product. Failure to do so could place the vehicle occupants in a potentially dangerous situation. After installing or reinstalling, re-check to ensure that the product is properly installed.