

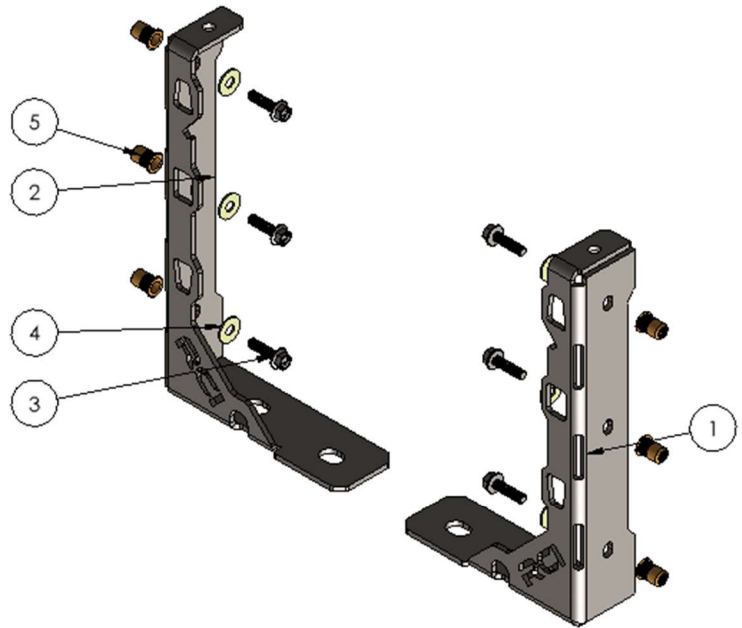
## 2024 Tacoma RCI Bed Stiffener Installation Guide

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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	SM-00742 (Passenger)	24 Tacoma Bed Stiffener Passenger	1
2	SM-00741 (Driver)	24 Tacoma Bed Stiffener Driver	1
3	HW-00025	M8-1.25 X 30MM HEX FLANGE BOLT	6
4	HW-00037	5/16 USS FLAT WASHER ZINC	6
5	HW-00148	M8-1.25 RIVET NUT	6
6	HW-00047	7/16-14 FIN HEX NUT GR-5 ZINC	1



B

A

RCI OFFROAD			
TITLE:			
2024 Tacoma Bed Stiffeners Install Guide			
Item Number	Sku	REV	1
DO NOT SCALE DRAWING		SCALE: 1:4	WEIGHT: SHEET 1 OF 1

A

2

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Figure 1: BOM

## INSTALLATION STEPS:

**\*\*Use hand tools, impact wrenches may cause damage if over torqued\*\***

- 1) Begin by unpacking and removing all components and hardware. Please verify that all hardware and mounting components are present. Reference your original order invoice and verify all items are accounted for.

a. **NOTE: The 2024 Tacoma Bed Stiffeners require drilling for installation.**

- 2) Remove the two torx bolts on both sides of the bed using a T40 for the smaller tie down bolt and a T55 torx bit for the large bed bolt. These will be reused later.



*Figure 2: OEM bolts to remove.*

- 3) Roughly install the bed stiffener using the two OEM bolts as depicted below.



*Figure 3: Correct install.*

- 4) Use a center punch or something similar to mark the three locations to be drilled.



*Figure 4: Example of marking hole locations.*

- 5) Remove the bed stiffener and drill out the three mounting locations finishing with a drill bit size of 13.5mm or 17/32".
  - a. The hole diameter should be snug around the rivet nut.



*Figure 5: Correct hole drilled.*

- 6) Use black paint to cover the bare metal to prevent future rusting.

- 7) Collect one M8 bolt, one M8 Rivet nut, one 7/16" nut, and two 5/16" washers. Assemble the hardware as depicted below.

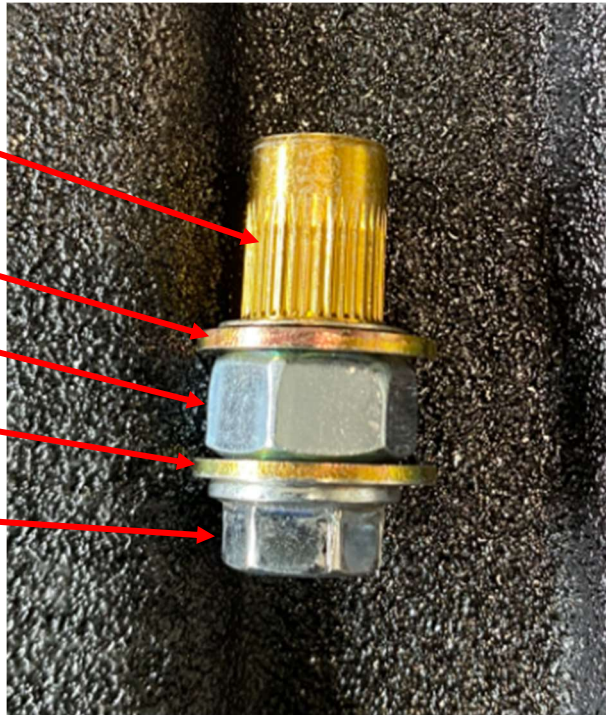
**M8 Rivet Nut**

**5/16" Washer**

**7/16" Nut**

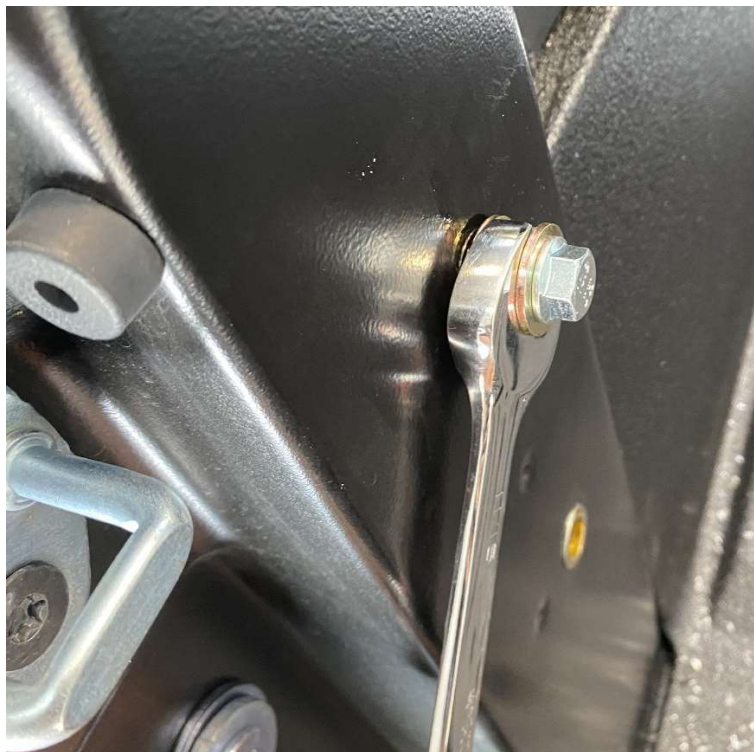
**5/16" Washer**

**M8 Bolt**



*Figure 6: Correctly oriented hardware.*

- 8) Install the rivet nut into one of the drilled holes. Press the nut into the side of the bed while holding the 7/16" nut with a 11/16" wrench.



*Figure 7: Correct orientation of hardware.*

- 9) While holding the hardware in place, use an impact driver with a 13mm socket to set the rivet nut.
  - a. Tighten until the rivet nut is fully installed.
  - b. Check occasionally while tightening that the rivet nut is seating properly.



*Figure 8: Correct orientation of hardware.*



*Figure 9: Correct rivet nut installation.*

- 10) Back out the M8 bolt and repeat for the remaining two holes.

11) With all three rivet nuts installed, reinstall the RCI bed stiffener with the two OEM torx bolts and M8 bolts with 5/16" washers.



*Figure 10: Correct installation of bed stiffener.*

12) Repeat the install process for the opposite side bed stiffener.

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