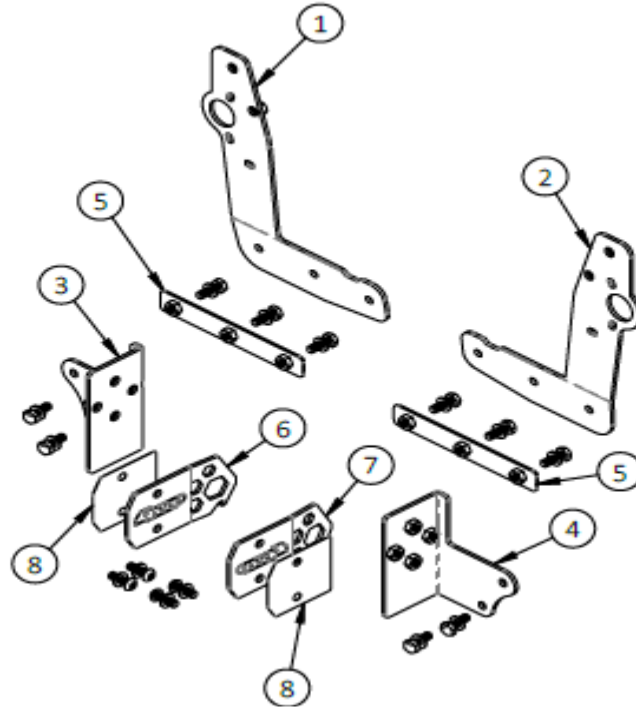




Installation Instructions:

(Part # 4WP61748W)
'05-2020 Tacoma Bed Stiffener

NOTE: Carefully read entire instructions thoroughly before attempting to install this part. After drilling holes, be sure to coat all bare metal with a zinc rich primer to prevent rust.



Parts Included	Qty	ID
84-12219 BED STIFFENER DRV.	1	1
84-12221 BED STIFFENER PASS.	1	2
84-12223 CORNER BRKT DRV.	1	3
84-12225 CORNER BRKT PASS.	1	4
84-12227 NUT PLATE	2	5
84-12229 TIE DOWN BRKT DRV.	1	6
84-12230 TIE DOWN BRKT PASS.	1	7
102-12231 BACKING PLATE	2	8

Hardware Pack 90-60794	Qty
M10x1.5x30 BUTTON HEAD SST 18-8	4
M10x1.5x30 HEX BOLT, CLASS 10.9	10
M10 FLAT WASHER ZINC	14

SUGGESTED TOOLS:

- General mechanic tool set
- Power drill
- Torque wrench
- Allen & Torx head drivers
- (Y) or 13/32" & a 1/8" or similar drill bits

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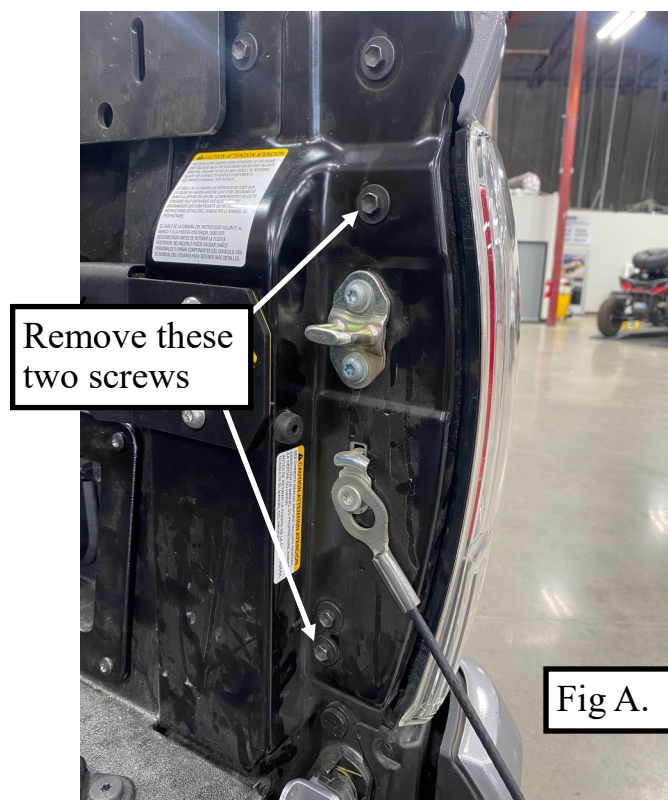
Installation Instructions: (Part # 4WP61748W) '05-2020 Tacoma Bed Stiffener

INSTALLATION:

Step 1: Read through these instructions thoroughly prior to starting the install. Use masking tape to protect painted surfaces.

NOTE: Product in illustrations is shown in contrasting colors for clarity.

Step 2: Open the tailgate. Starting on either side, use a 10mm socket to remove the two bolts shown, that retain the taillight housing (**Fig A.**)



Step 3: Remove the taillight housing by pulling straight back, Newer vehicles may require some extra encouragement to release the locating pins, (**Fig B.**)

Step 4: To prevent damage to the taillight or wiring harness, remove the light sockets from the housing with a 1/4 twist (**Fig C.**), Set the housing aside in safe place, lens side up to prevent scratches, until reassembly. Repeat this process on the opposite side.

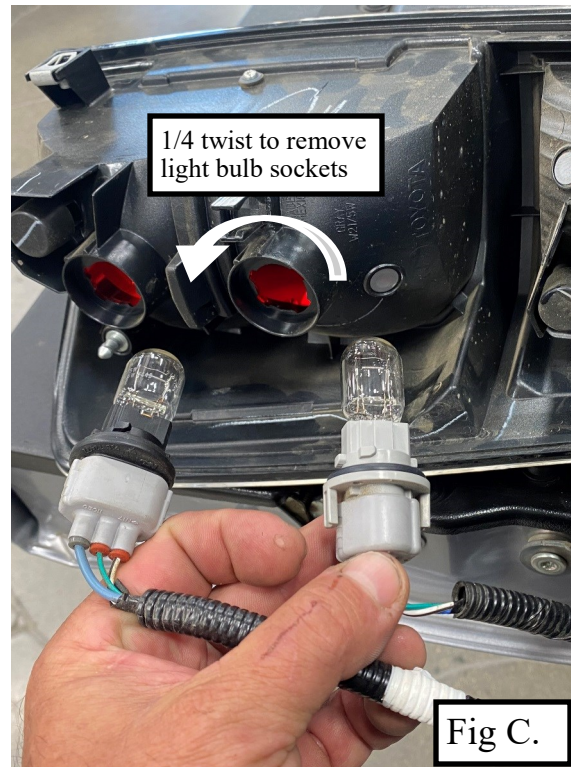
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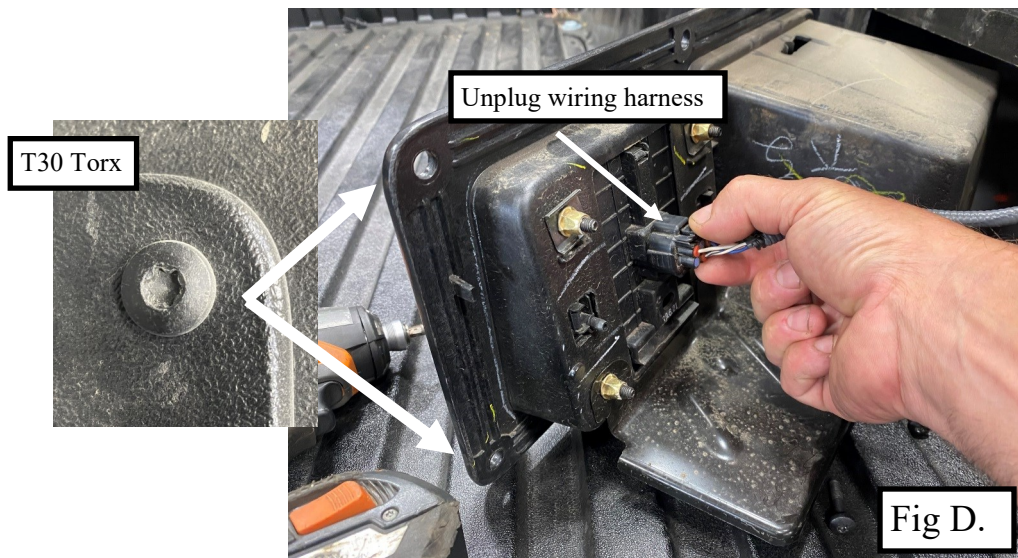


Installation Instructions:

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Step 5: If your vehicle is equipped with the optional Cubby hole/110v power inverter in the bed, remove the (6qty) T30 Torx screws that secure the panel the bed. Carefully remove the panel and unplug the power wire from the back side (**Fig D**).

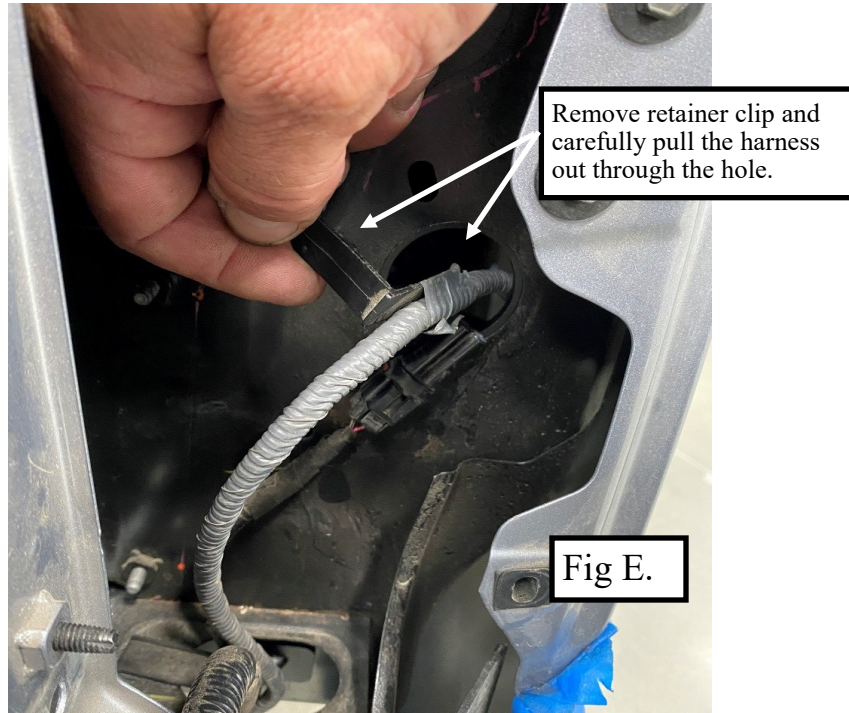


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Installation Instructions: (Part # 4WP61748W) '05-2020 Tacoma Bed Stiffener

Step 6: Carefully unclip the retainer and fish the inverter harness out through the hole behind the taillight (**Fig. E**).



NOTE: The Tie Down Brackets can be mounted vertically or horizontal depending on your needs. (See Fig N.)
If you have bed storage boxes, install the tie down brackets vertically to clear the slide out drawers. Step 8
If there aren't any clearance concerns, mount the brackets horizontally. Step 7

Step 7: Starting on either support pillar. With a thin ruler or tape measure, measure up from the center of the metal crossmember (not the plastic bed) and place marks 2' in from the leading edge of the pillar at 9 11/16" (246mm) and 11 15/16" (303mm) (**Fig. F**).

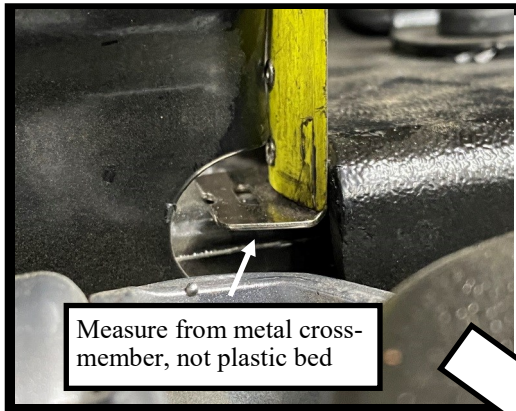
Step 8: Starting on either support pillar. With a thin ruler or tape measure, measure up from the center of the metal crossmember (not the plastic bed), mark a horizontal line at 10 13/16" (275mm). From the leading edge of the pillar measure back and place marks at 7/8" (22mm) & 3 1/8" (79mm) (**Fig G**)

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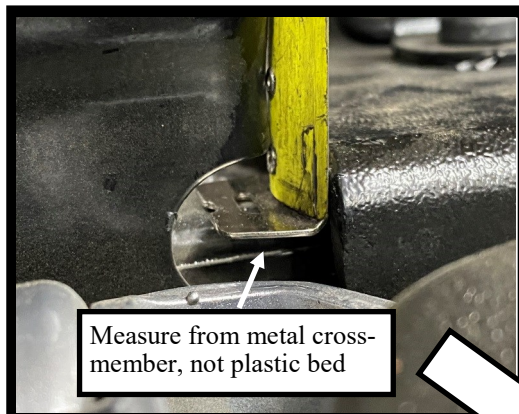
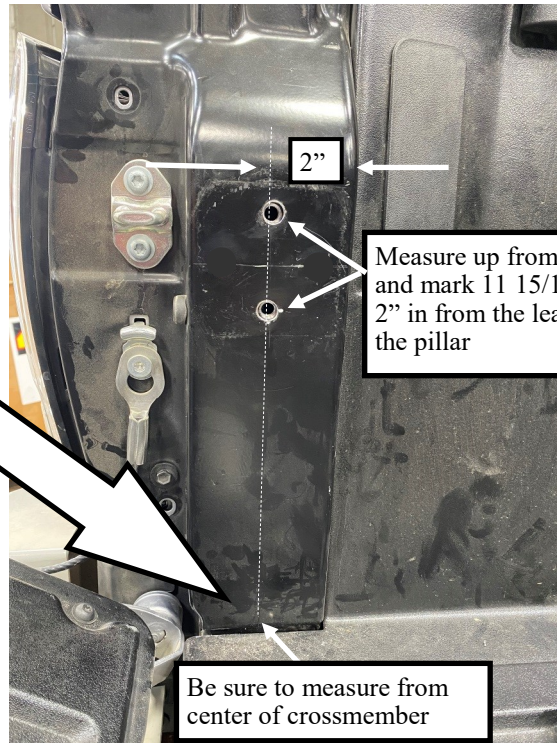


Installation Instructions:

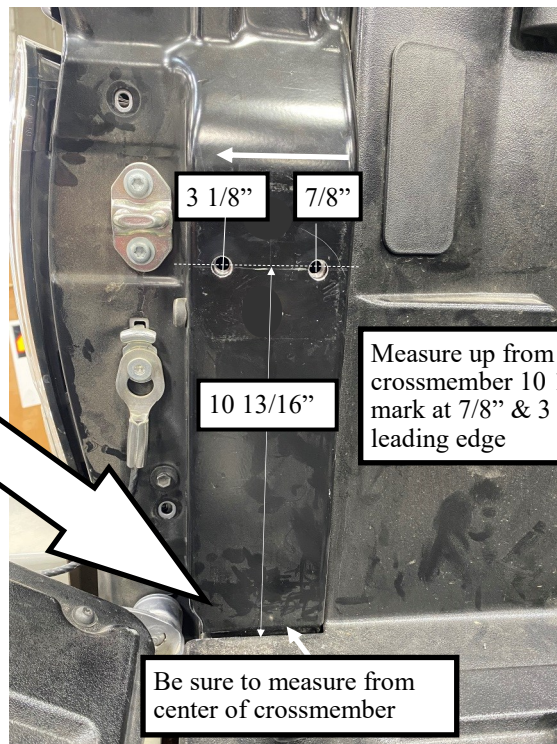
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Horizontal install Fig . F



Vertical install Fig . G



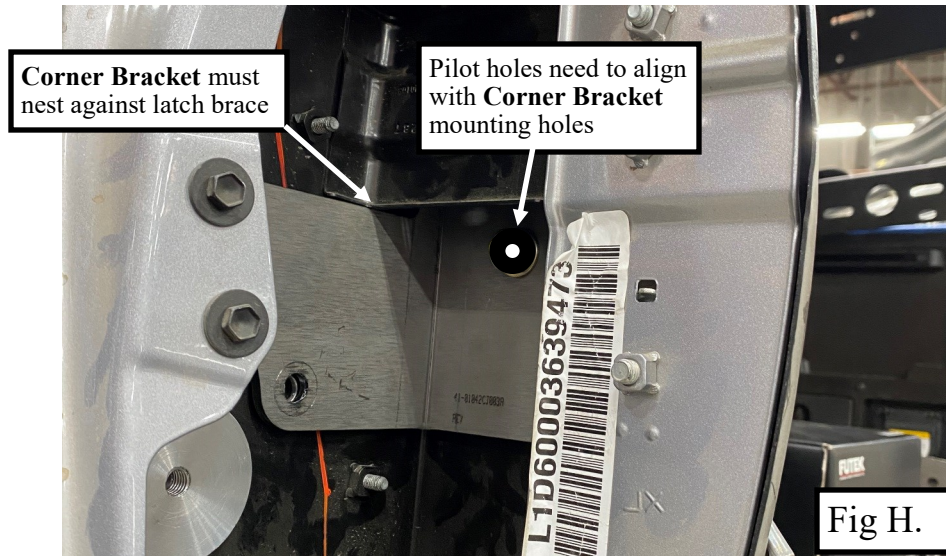
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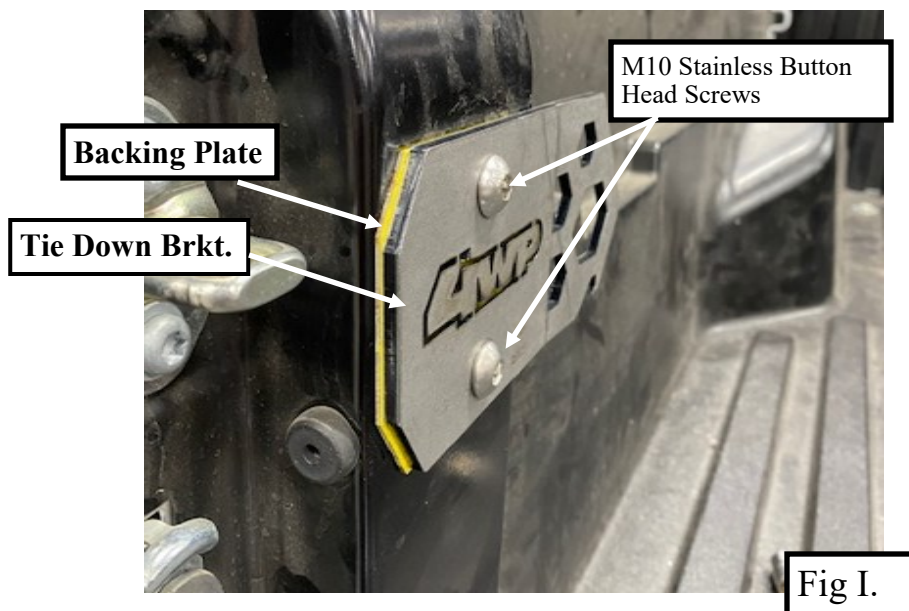
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Step 9: Drill the (2) marks on each pillar with a small (1/8"-3/16") drill bit. Install the corresponding **Corner Bracket** behind the pillar and against the latch brace, as shown in **(Fig H.)**. Make sure the holes align, if not, carefully clearance the holes as necessary.



Step 10: When satisfied with alignment of the pilot holes, drill them out to 13/32". Locate a **Backing Plate** and the corresponding **Tie Down Bracket**. Install using **(2qty) M10x1.5x30 SST Button Head Screws, Washers**. Adjust as needed and tighten just until snug **(Fig. I)**. Repeat on opposite side.



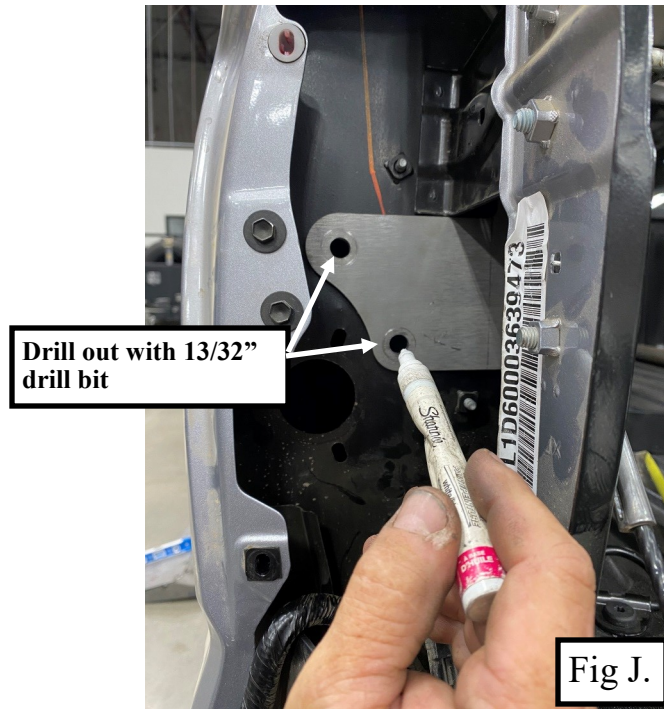
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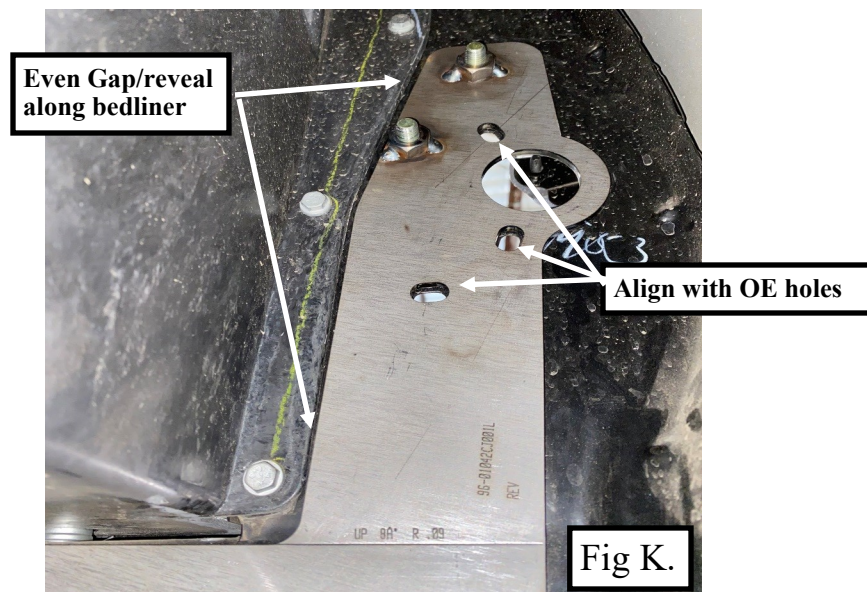
Installation Instructions:

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Step 11: Mark the remaining (2) holes in the **Corner Plate** and drill out with the 13/32" drill bit (**Fig J.**) Repeat on opposite side.



Step 12: Locate the corresponding **Bed Stiffener**, install underneath the bed and behind the support pillar so that it aligns with the OE holes in the support pillar (**Fig K.**) Secure using (2qty) **M10 Hex Bolts and Washers** through the holes you just drilled. Tighten the bolts snug, adjust the **Bed Stiffener** so it has an even reveal with the bedliner.



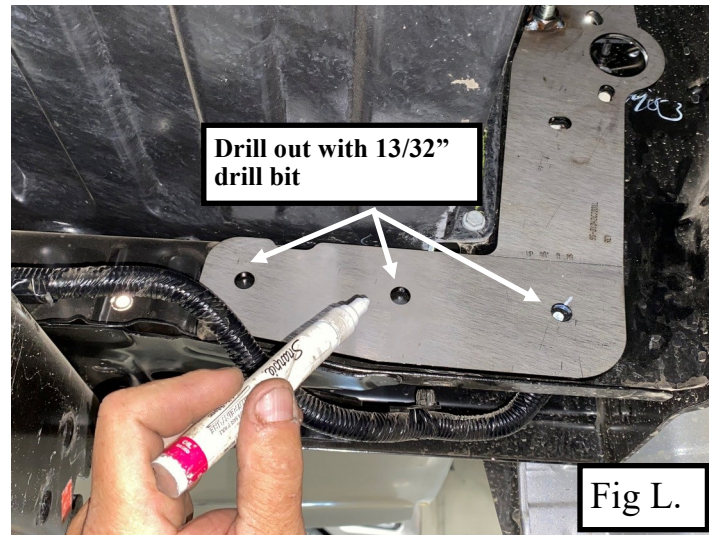
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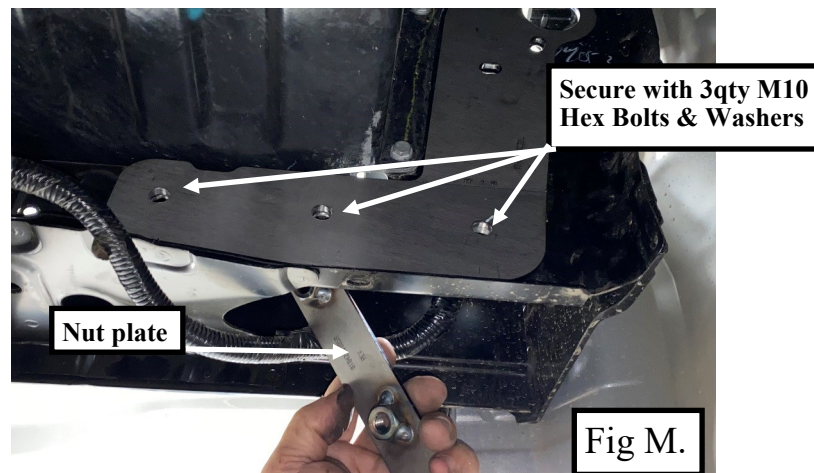
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Step 13: Mark the (3) holes along the bottom of the **Bed Stiffener** and drill out with the 13/32" drill bit (**Fig L.**) Repeat on opposite side.



Step 14: Locate the **Nut plate**, install behind the **Bed Stiffener** and secure with (3qty) **M10 Hex Bolts and Washers** (**Fig M.**) Snug all bolts, Double check alignment, then torque to **45ft-lbs**. Repeat this process on other side.



Step 15: Double check alignment of the **Tie Down Brackets** (**Fig I.**), then torque all remaining hardware to **45ft-lbs**. Reconnect and reinstall wiring harnesses and tail lights. Tighten the T 30 torx screws for the Cubby hole/110v inverter panel (**Fig D.**) and tail light mounting screws (**Fig A.**) to **5 ft-lbs**. Your install is complete.

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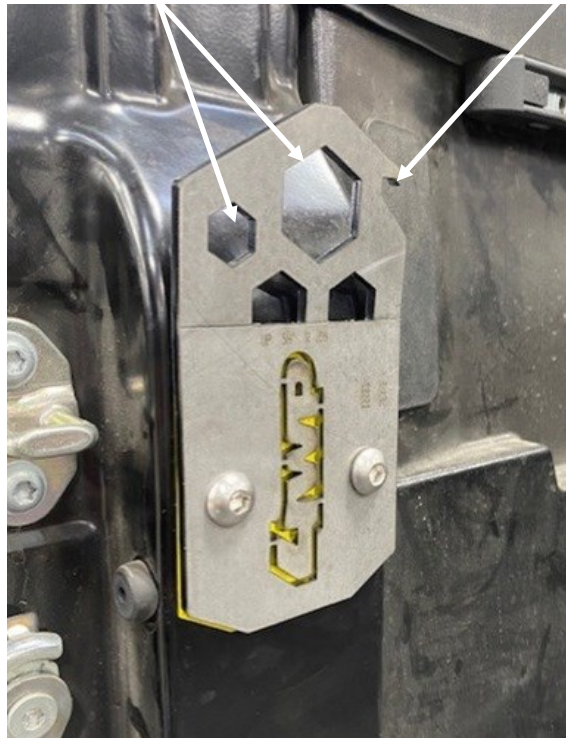
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Fig N.



Tie down locations

Bottle opener



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Use this only as a guide for hardware without a called out torque specification in the instruction manual.

Bolt Torque and ID						
Decimal System			Metric System			
All Torques in Ft. Lbs. Maximums						
Bolt Size	Grade 5	Grade 8	Bolt Size	Class 9.8	Class 10.9	Class 12.9
5/16	15	20	M6	5	9	12
3/8	30	45	M8	18	23	27
7/16	45	60	M10	32	45	50
1/2	65	90	M12	55	75	90
9/16	95	130	M14	85	120	145
5/8	135	175	M16	130	165	210
3/4	185	280	M18	170	240	290

<p>1/2-13x1.75 HHCS</p> <p>D T L X</p>	<p>Grade 5 Grade 8</p> <p>(No. of Marks + 2)</p>
<p>G = Grade (Bolt Strength)</p> <p>D = Nominal Diameter (Inches)</p> <p>T = Thread Count (Threads per Inch)</p> <p>L = Length (Inches)</p> <p>X = Description (Hex Head Cap Screw)</p>	<p>M12-1.25x50 HHCS</p> <p>D T L X</p> <p>P = Property Class (Bolt Strength)</p> <p>D = Nominal Diameter (Millimeters)</p> <p>T = Thread Pitch (Thread Width, mm)</p> <p>L = Length (Millimeters)</p> <p>X = Description (Hex Head Cap Screw)</p>

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Installation Instructions:

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Product cleaning and maintenance instructions

Stainless Steel Finish – Aluminum polish may be used to polish small scratches and scuffs on the finish. Mild soap, window or glass cleaner may be used to clean the finish. Dual state powder coat finish – Mild soap, window or glass cleaner may be used to clean the finish. In order to protect the finish, you may wax your product on a regular basis with pure carnauba automotive wax. Do not use any types of soap, polish or was that contains abrasive that could damage the finish. Textured coated finishes should be cleaned with a mild soap on a damp sponge. Do not apply polish or was that requires to be removed by means of buffing. This type of wax is commonly used at car wash facilities. Chrome Finish – Mild soap, window or glass cleaner may be used to clean the finish. In order to protect the finish, you should wax your product on a regular basis with pure carnauba automotive wax. Do not use any types of soap, polish or was that contains abrasive that could damage the finish.

Limited Warranties

4WP's products are covered under the following limited warranties only. Note that the duration of the limited warranty differs according to the material and finish of the product purchased. Subject to the duration and conditions of the limited warranty stated below, 4WP warrants to the original retail purchaser that its products are free from defects in material and workmanship. All other warranties and representations express or implied, are hereby disclaimed, including fitness for merchantability and buyer's intended use or purpose. All parts are sold "AS IS" except for the limited warranties granted herein. Buyer assumes all risks as to the selection, suitability and performance of all goods and products selected. This limited warranty does not cover damage or impairment in any part due to misuse, improper installation, accident or contact with on-road or off-road hazards, product modification, improper or inadequate cleaning and/or maintenance. 4WP is not responsible for items damaged during shipping. This warranty is not transferable from the original buyer. For the original Buyer to be eligible for the limited warranty coverage, the Buyer must provide proof of purchase. 4WP strongly recommends returning the warranty registration card.

Customer's remedy hereunder shall be limited only to repair or replacement (at 4WP's option) of any defective part(s) returned to 4WP at customer's expense. The determination of whether or not a returned part is defective or subject to coverage under the limited warranties stated herein shall be made at 4WP's sole discretion.

To assure product quality, 4WP reserves the right to change product design, material, specification and finishes without prior notice to customers. This limited warranty gives you specific legal rights and you may also have other rights, which may vary from state to state. Some states do not allow limitations on how long an implied warranty lasts, so the above limitations may not apply as to you. Also, some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitations or exclusions may not apply to you. 4WP reserves the right to discontinue product lines and substitute products or provide other remedies than those listed in this limited warranty for those discontinued products.

Warning

Rollover and other types of vehicle accidents may result in serious injury or death to you, your passengers and others sharing the road. 4WP accessories are decorative and are not intended to reduce or avoid injury or damage in the event of an accident. The weight and location of 4WP accessories may affect your vehicles' handling, stability and performance, creating an increased risk of accident or rollover. Before installing any accessory, check state laws and assure that the accessory will not obscure any lights or interfere with proper operation on your vehicle's safety equipment. Consult your owner's manual and the 4WP instructions, or additional safety information. 4WP products, nor the warnings contained herein, are not a substitute for your safe driving. Don't drink and drive, always use seat belts and don't drive faster than conditions permit.

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