



INSTALLATION INSTRUCTIONS



48675 (05-15 TACOMA)



48676 (2016+ TACOMA)

COMPONENT: BOLT-ON TACOMA BED STIFFENERS

PART #: 48675 (05-15 TACOMA)

48676 (2016+ TACOMA)

PART #	ITEM DESCRIPTION	QTY
48672L / 48673L	TACOMA BED STIFFENER: LEFT	1
48672R / 48673R	TACOMA BED STIFFENER: RIGHT	1
10819	BOLT: 5/16" - 18 X 1.00" GRADE 8	6
12516	WASHER: 5/16" SAE	12
11515	NUT: 5/16" - 18 NYLOCK	6
10512	BOLT: 7/16" - 20 X 1.25" GRADE 8	2
12504	WASHER: 7/16" SAE	2

REQUIRED TOOLS

- T-55 Torx
- T-40 Torx
- 10mm Wrench or socket
- 1/2" Wrench or socket
- 5/8" Wrench
- 5/16" Drill bit

IMPORTANT

- This product is designed to reinforce the weak bed characteristics of the 2005 and newer Tacoma as well as provide an additional place to secure bed cargo.
- No load ratings are implied. Bed stiffeners are NOT intended to be used as a lifting point or tow hook.
- When installing bed stiffeners, start **ALL** hardware by hand (3-5 threads screwed in) **BEFORE** snugging or tightening any of the other bolts. If you tighten any bolts before they are all started, its possible that some holes will not line up. This is most likely due to a warped or bent bed. Once all bolts are started, tighten them from bottom to top.

STEP 1

Using a 10mm wrench or socket, remove the top bolt above the 'Attention' sticker.

Note: If the vehicle is equipped with a camper shell, it may be necessary to use a barrel sander to sand the shell and make room to remove the top bolt.



STEP 2

Using a 10mm wrench or socket, remove the bolt above the tailgate latch, which is one of two bolts that hold the taillight in. Next remove the lower taillight bolt.

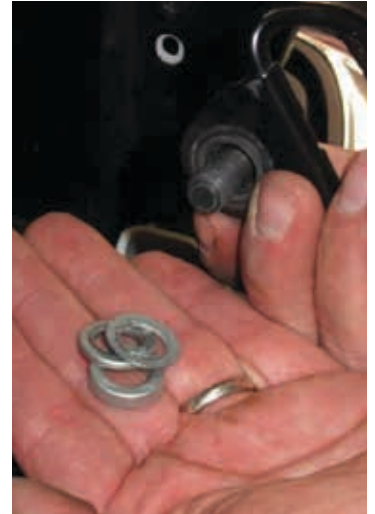
**STEP 3**

Remove the taillight and let it hang by the wires.



STEP 4

Using the T-40 Torx bit, remove the factory tie down mount, making sure to keep all the washers and spacers that were underneath the mount. Once the mount is off, put the washers and spacers back in the hole, in the same orientation shown in the picture.

**STEP 5**

Using the T-55 bit, remove the bed mount bolt.

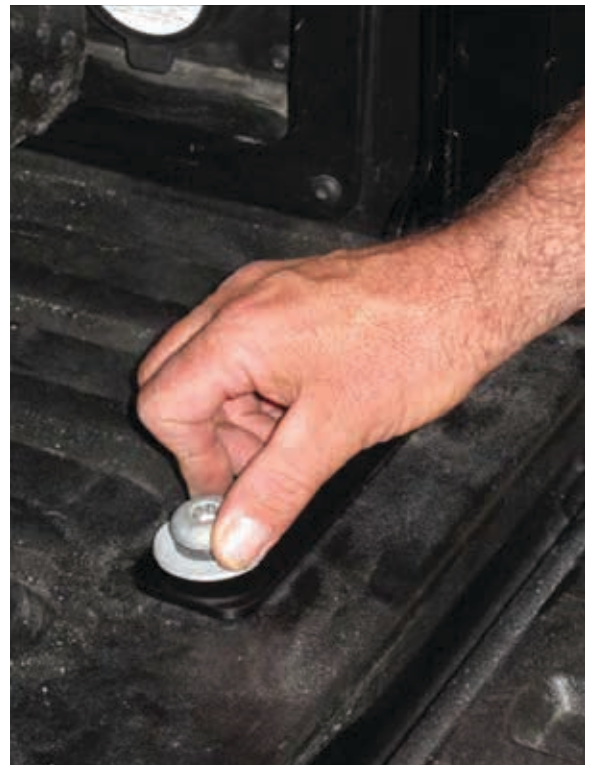


STEP 6

Set the new bed stiffener in place and install the provided 7/16" bolt with the supplied washer on the top of the bed stiffener and the factory washers underneath where the stock tie down mount was (from Step 4).

**STEP 7**

Install the T-55 bed bolt.



STEP 8

Install the stock top bolt into the bed.

Note: If there is a gap between the bed stiffener and the bed it means your bed is slightly bent. In this situation, DO NOT tighten this bolt all the way because it may break. Get a few threads started before proceeding to Step 9.



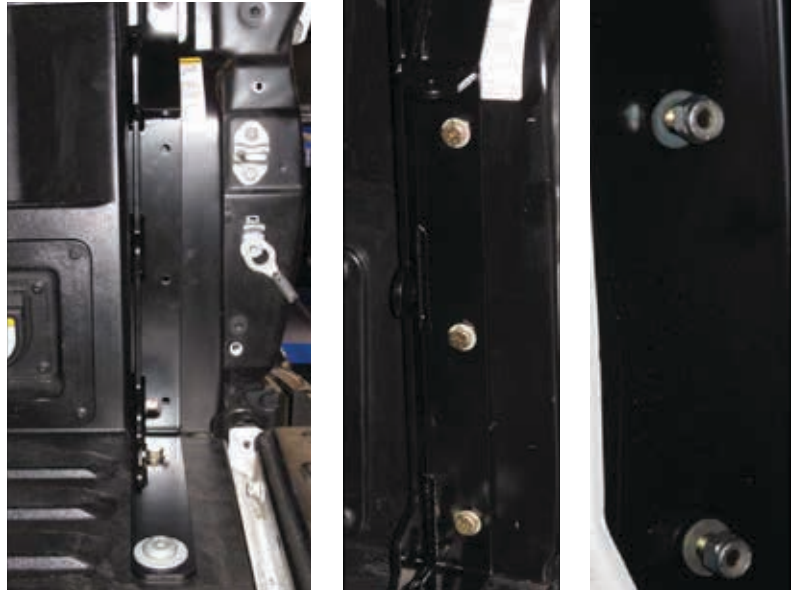
STEP 9

Using a 5/16" drill bit, use the holes in the bed stiffener as a guide to drill through the bed.



STEP 10

Once the holes are drilled, install the provided 5/16" bolts into the three holes and loosely secure them with the provided nuts making sure to include a washer on both sides.



STEP 11

Working from bottom to top, tighten down each bolt. Once complete, reinstall the taillight.

Bolt Torque Specs:

T-55 Bed Bolt: 60 ft/lbs

7/16" Bolt: 50 ft/lbs

5/16" Bolt: 18 ft/lb

Stock 6mm Bed Bolt: 10 ft/lbs



CONGRATS! YOUR BED STIFFENERS ARE READY TO GO!



FOR INSTALL QUESTIONS OR CUSTOMER SERVICE INQUIRIES:

Call 951.737.9682 or email info@chaosfab.com