

# **ARB** **BED RACK**

Part Number: **17923020**  
Suits Vehicle: **TOYOTA TACOMA 160N**  
Product Description: **BED RACK MOUNT KIT**

Optional kits: **1780790 BED RACK CROSS BARS PR 1265MM**  
**1780780 BED RACK SIDE CHANNEL**  
**SEE BED RACK OPTIONS LIST FOR ALL OTHER ACCESSORIES**

## **WARNING**

### **NOTE THE FOLLOWING:**

- ◆ Vehicle accessories which are not properly fitted can be dangerous.
- ◆ Please read these instructions carefully prior to fitting, and comply with the instructions at all times.
- ◆ If in any doubt please contact your nearest ARB state office or the stockist from whom it was purchased.
- ◆ Do not use this product for any vehicle make or model, other than those specified by ARB.
- ◆ This product or its fixing must not be modified in any way.
- ◆ The installation of this product may require the use of specialized tools and/or techniques.
- ◆ It is recommended that this product is only installed by trained personnel.
- ◆ These instructions are correct as at the publication date. ARB Corporation Ltd. cannot be held responsible for the impact of any changes subsequently made by the vehicle manufacturer.
- ◆ During installation, it is the duty of the installer to check correct operation/clearances of all components.
- ◆ Work safely at all times.
- ◆ Unless otherwise instructed, tighten fasteners to specified torque.
- ◆ Check bolt torque after 500km & at regular service intervals.

## **ARB 4x4 ACCESSORIES**

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# SAFETY

## NET PAYLOAD FOR YOUR BED RACK

- ◆ Load must be evenly distributed and adequately secured.
- ◆ Any weight carried on the BED RACK will adversely affect its handling, particularly in cornering or in a cross-wind, the vehicle should therefore be driven with increased discretion.
- ◆ Regularly check the tightness of the securing clamps and the security of the load.
- ◆ Attention is directed to statutory requirements regarding maximum permissible projections from vehicles.
- ◆ If accessories are attached to the bed rack, one cross bar must be fitted at all times.
- ◆ All bolts should be checked prior to touring to ensure the BED RACK and accessories are fastened correctly.

## GENERAL CARE AND MAINTENANCE

By choosing an ARB BED RACK, you have bought a product that is one of the most sought after 4WD products in the world. Your BED RACK is a properly engineered, reliable, quality accessory that represents excellent value. To keep your BED RACK in original condition it is important to care and maintain it following these recommendations:

- As part of any pre-trip preparation, or on an annual basis, it is recommended that a thorough visual inspection of the BED RACK is carried out, making sure that all bolts and other components are torqued to the correct specification. Replace any components as necessary.



Please contact local Authorised ARB Stockist if you would like to have this service carried out on your behalf.

## FITTING REQUIREMENTS

### REQUIRED TOOLS FOR FITMENT OF PRODUCT:

METRIC SOCKET SET	ELECTRIC DRILL
TORQUE WRENCH MINIMUM 9Nm	10.5mm (13/32 INCH) DRILL BIT
TOUCH UP PAINT	9mm (11/32 INCH) DRILL BIT
MASKING TAPE	PEN OR THIN MARKER
TORX KEYS	PPE

### HAVE AVAILABLE THESE SAFETY ITEMS WHEN FITTING PRODUCT:

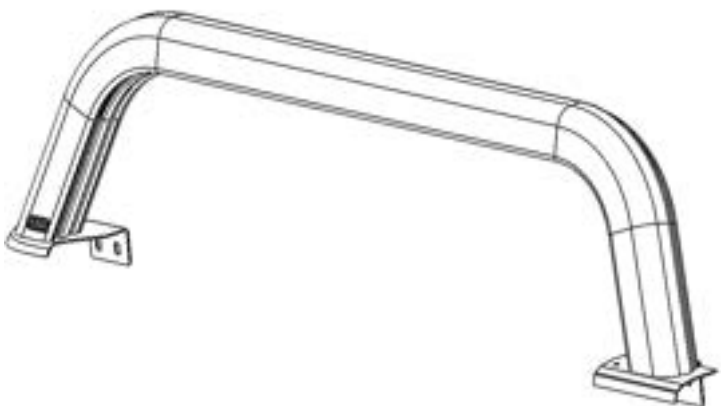

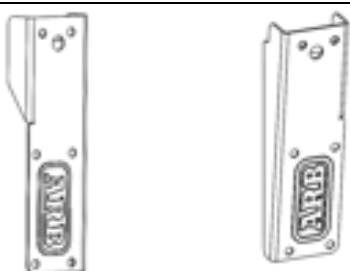
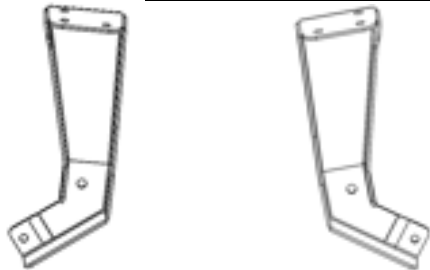
Protective eyewear 	Hearing protection 
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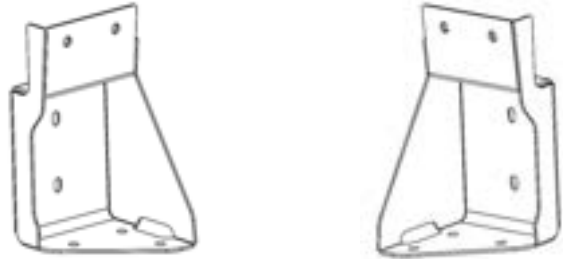
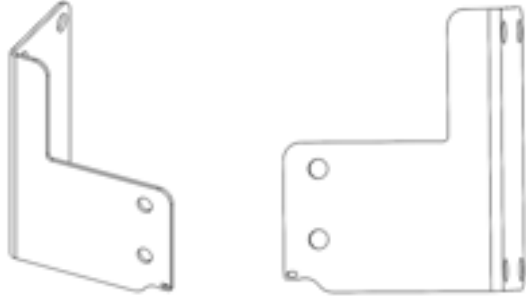
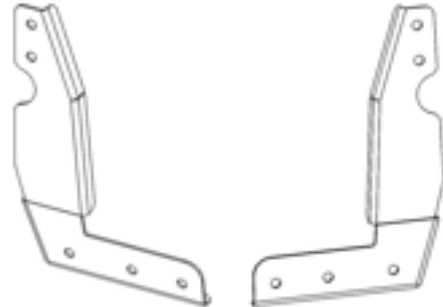









**NOTE: 'WARNING' notes in the fitting procedure relate to OHS situations, where to avoid a potentially hazardous situation it is suggested that protective safety gear be worn or a safe work procedure be employed. If these notes and warnings are not heeded, injury may result.**


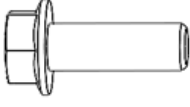
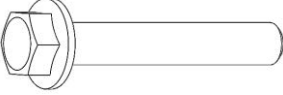
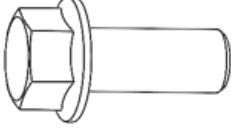

**FASTENER  TORQUE SETTINGS:**

SIZE	Torque Nm	Torque lbft
M6	9Nm	7lbft
M8	22Nm	16lbft
M10	44Nm	32lbft
M12	77Nm	57lbft

**PARTS LISTING**

PART NUMBER	DESCRIPTION	QTY	DIAGRAM
6136699R	BED RACK FRAME WELDMENT RH   SUITS TACOMA	1	
6136699L	BED RACK FRAME WELDMENT LH   SUITS TACOMA	1	
4655428L&R	TACOMA REAR CORNER SUPPORT	1L & 1R	
4681832L&R	TACOMA FRNT MAIN BRACE	1L & 1R	

4681831L&R	TACOMA FRNT BRACE	1L&1R	
4681830L&R	TACOMA REAR INTERNAL BRC	1L&1R	
4518333L&R	TACOMA LOWER REAR GUSSET	1L&1R	
3194330	CAGE PLATE D40 SIDE RAIL (400mm)	2	
3199848	PAJERO CAGED NUT PLATE	2	
3195759	M8 X 300 NUT STICK	2	
4581288	WASHER FLAT M10x35x3   ZP	6	
4584399	WASHER FLAT M10x25x3   ZNB480	6	
4584410	WASHER FLAT M12x31.75x2.5   BTZP480	4	
6151303	NUT CAGED M8 1.8-3.2   1238-B	2	
6151305	NUT CAGED M12 3.3-4.7   1412-C	4	
6151752	NUT FLANGE M10x1.5   PC8.8 BTZP480	24	

6152008	BOLT HXHD FL M6x1.0x25   PC8.8 ZNB480	2	
6151965	BOLT HXHD FL M10x1.5x30   PC8.8 ZNB480	36	
6152042	BOLT HXHD FL M8x1.25x50   FT PC8.8 ZNB480	2	
6152127	BOLT HXHD FL M12x1.75x30   PC8.8 ZNS480	4	
4584361	WASHER FLAT M10x25x4   HV300 TZP480	6	

## **BEFORE STARTING, READ ALL STEPS OF THE INSTRUCTIONS**



1. Remove the bed rack carton lid, remove the large staples and place into the tub. The carton lid will protect the tub or tub liner from scratches.
2. Remove all brackets from fit kit and lay them out in the tub



3. Remove all hardware from bag and sort into piles of associated hardware

**M8 Nut Stick**



**M12 Nut Sticks**



4. Insert M8 cage nuts into black powder-coated nut sticks
5. Insert the M12 cage nuts into the other two styles of sticks as shown to the left.





6. Remove 3x M6 bolts on the left side of the truck to release the tail lights



7. Pull rearwards to remove the tail lights





8. Disconnect plugs from the tail light housing and set the housing to the side along with the 3x bolts removed.

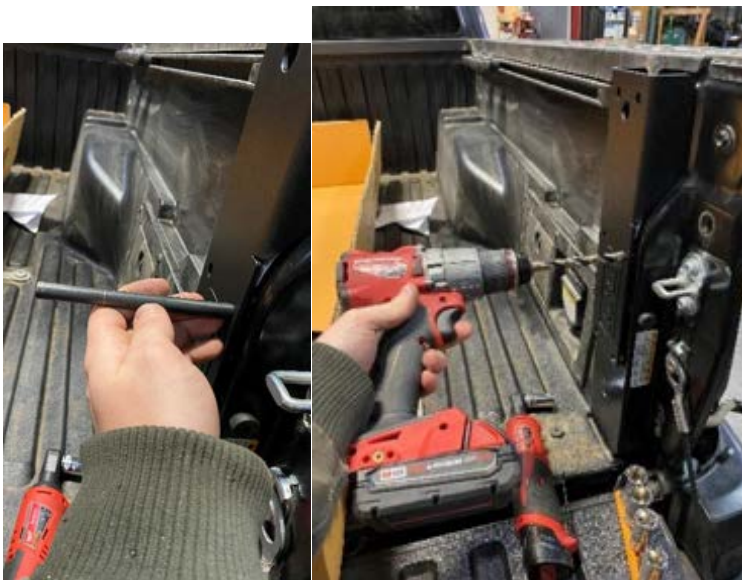


9. Identify the rear corner support bracket





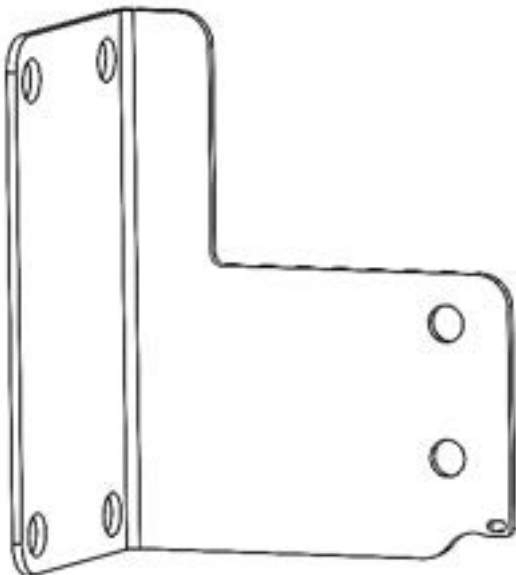
10. Using an M6x25mm flange bolt attach the rear corner support.



11. (Optional) Use a transfer punch to mark the center of each hole before drilling.
12. Drill each of the 4 holes in the rear corner support with a 10.5mm drill bit ( $\frac{13}{32}$  inch bit)
13. Paint raw edges to prevent corrosion.



**WARNING: Drilling & Cutting operations can result in flying debris. Eye and ear safety protection should be worn.**



14. Identify the rear internal brace

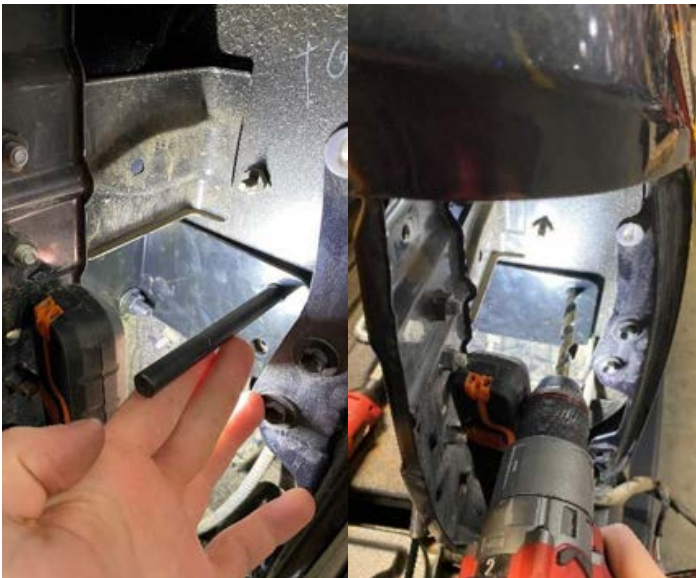


15. Insert the rear internal brace into the taillight area as shown.

**Tip:** The wiring harness inside may need to be moved for the brace to slip inside but can be reinstalled once it's in.



16. Loosely fasten four M10x30mm flange bolts and four M10 flange nuts to locate the rear internal brace.



17. (Optional) Use a transfer punch to mark the centre of the holes

18. Drill the two holes in the rear internal brace with Ø10.5mm drill bit ( $\frac{13}{32}$  inch bit)

19. Paint raw edges to prevent corrosion.



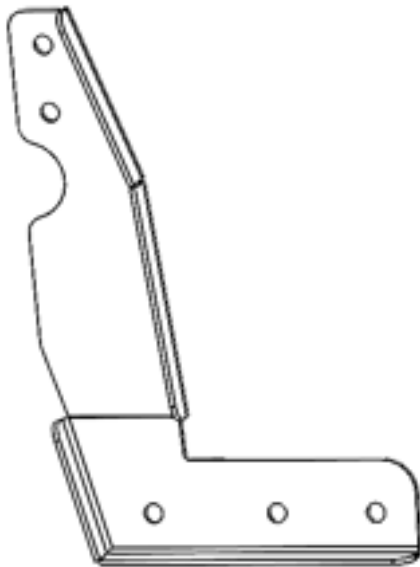
**WARNING:** Drilling & Cutting operations can result in flying debris. Eye and ear safety protection should be worn.



20. Insert 2x M10x30mm flange bolts to locate the rear internal brace.



21. (Optional) If the bed has a removable panel, this can be removed to provide easier access to the backside. Remove 6x M6 screws to release the panel.



22. Identify the lower rear gusset





23. Place the lower rear gusset over the two bolts installed in [Step 20](#) protruding through sheet metal. Loosely fasten two M10 flange nuts.



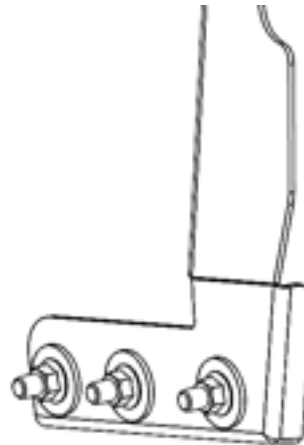
- 24. (Optional) Use a transfer punch to mark the center of the holes
- 25. Drill each of the 3 holes in the rear lower gussets with a 10.5mm drill bit ( $\frac{13}{32}$  inch bit)
- 26. Paint raw edges to prevent corrosion.



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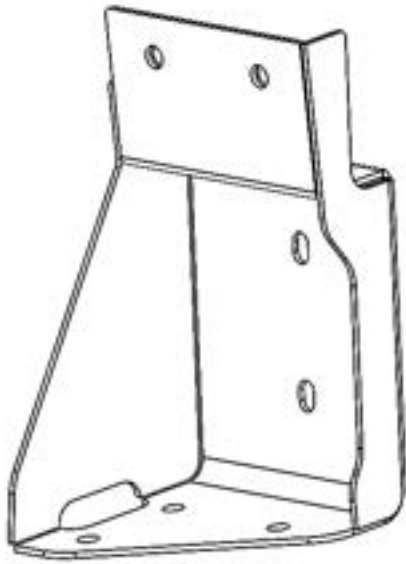


27. Loosely fasten three M10x1.5x30mm flange bolts, 35mm washers, and M10 flange nuts through the lower rear gusset.





28. Remove two M8 Torx screws from the tie down point at the front of the bed, retain these screws for use later.



29. Identify the front brace



30. Place the front brace into place and lightly fasten with the two M8 Torx screws removed in the previous step.



31. Identify bed rack frame weldment



32. Place bed rack frame weldment onto the mounts and lightly fasten down using M10x1.5x30mm flange bolts



33. Use a transfer punch or mark the center of the front hole to be drilled through the tub cap.



34. Remove the bed rack frame weldment to drill a 9mm ( $\frac{11}{32}$  inch) hole.



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35. Mark a hole to be drilled 100mm forward and 1mm outboard on the tub cap.



36. Drill the marked hole with a 10.5mm drill bit ( $\frac{13}{32}$  inch).



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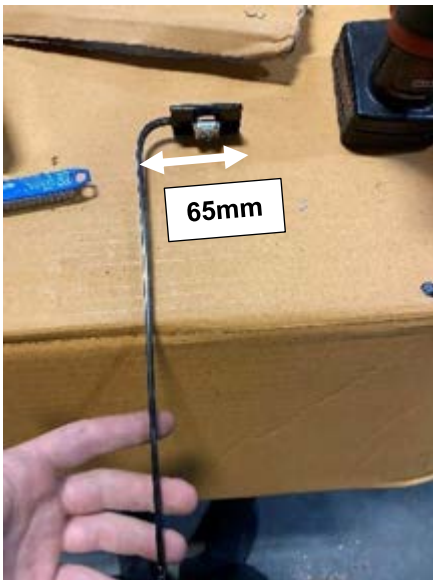




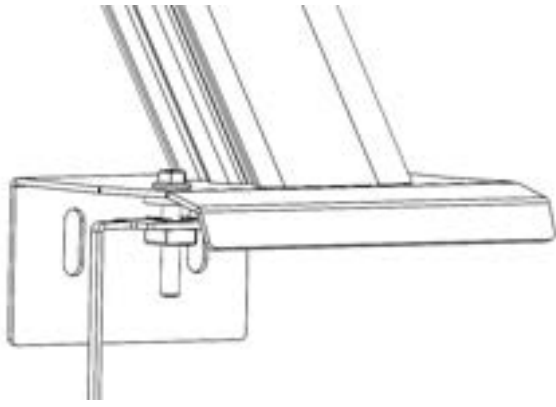
37. Put bed rack frame weldment back on the mounts using the two M10x1.5x30mm flange bolts at the front and two M10x1.5x30mm flange bolts at the rear.



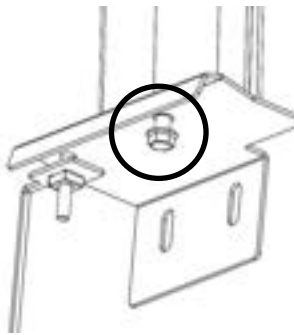
38. Remove front four screws holding the wheel liner in to allow it to be folded back for easier access.



39. Bend M8 nut stick as shown.



40. Use an M8x50mm flange bolt, 25x4mm packer, and M8 nut stick inserted from below the bed cap to fasten the bed rack frame weldment. Leave loose for now.



41. Using a long extension, install one M10x30mm flange bolt and 25x4mm packer into the forward location on the bed rack frame weldment.



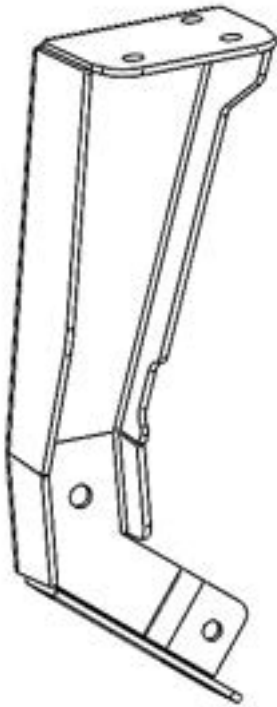
42. (Optional) Use a transfer punch to mark hole locations for the front brace lower holes.  
43. Drill three holes in the bed for the front brace.



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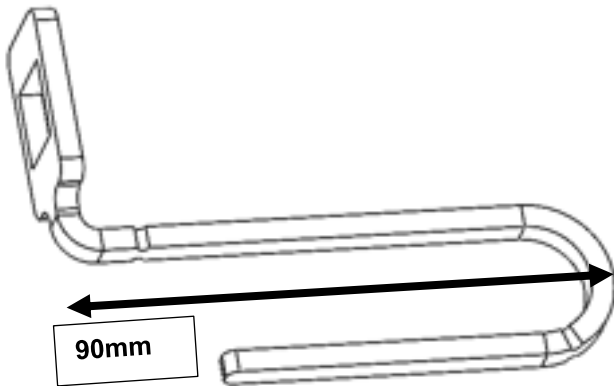
44. Insert three M10x30mm flange bolts into the front brace.



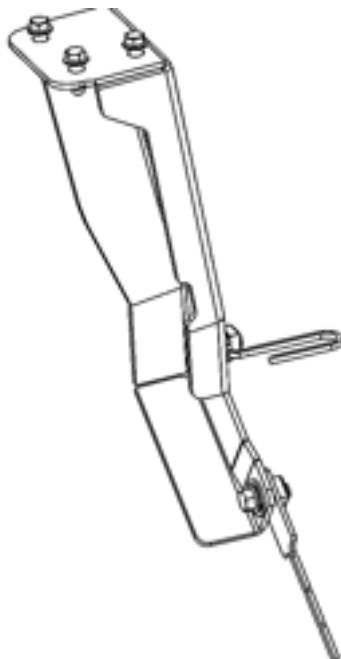
45. Identify the main brace.



46. Using three 25mm washers and M10 flange nuts, loosely fasten the front main brace through the bed to the front brace.



47. Bend the shorter M12 nut stick as shown.



48. Insert bent M12 cage nut wand into bed mount so that it lines up with the upper hole of the front main brace.

49. Insert the long M12 cage nut wand into the inboard side of the frame from the rear so that it lines up with the lower hole in the front main brace.

50. Using two M12x30mm flange bolts and 32mm washers, attach the main brace to the frame.

51. With all bolts installed, torque each of them down.



M6 bolt – 9Nm (7lbft)



M8 bolt – 22Nm (16lbft)



M10 bolt – 44Nm (32lbft)



M12 bolt – 77Nm (57lbft)



52. Reinstall the bolts for the tail lights with the original hardware

53. Reinstall the screws for the rear fender liner.



54. Repeat [Step 6](#) – [Step 53](#) on the left side of the vehicle.



## FITTED PRODUCT

