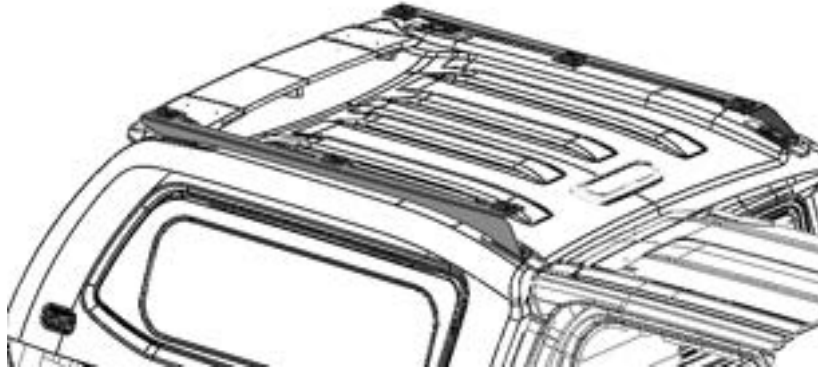




# FITTING INSTRUCTIONS

## Dual Cab Toyota Tacoma 2024+ ARB Base Rack fitting kit 17923050

(These are generic instructions that suit each Ascent Canopy application)



**! PLEASE PROVIDE A COPY OF THESE INSTRUCTIONS TO THE CUSTOMER !**

### IMPORTANT:

- These "Blade Brackets", are designed for fitment with ARB Base Racks and internal frame brackets (sold separately). **INTERNAL FRAME BRACKETS MUST BE FITTED PRIOR TO THE STAGE "SECTION2- PRE-FITTING THE BLADE BRACKETS TO THE RACK"**. Blade brackets are vehicle specific and sold separately, refer to the application chart via you ARB dealer, or call ARB.
- It is advisable to have the canopy rack fitted by an authorised dealer.
- It may be necessary to readjust the Ascent Canopy's lift up window and door latches after fitment of roof racks due to deflection of the canopy through the tightening of bolts. Please refer to the Ascent Canopy fitting instructions in section entitled "Operational Checks and Adjustments for Windows and Doors" for latching adjustment steps. Call ARB for a copy if required.
- Fitment can be undertaken with one person; however, two people are required to lift the rack into place and bolt it to the roof of the canopy.

### CARE OF YOUR CANOPY:

Please refer to the "Owner's Manual Supplement" to be given to the purchaser on installation, this is contained within the separate additional kit fitting instructions for the "Internal Frames".

### OWNERS MANUAL SUPPLEMENTS:

Please fill out the owner's manual supplement in the "Internal Frame" instructions and provide this to the customer. Please contact ARB should you require another copy of fitting instruction for internal frames.

### RECORDS OF FITMENT:

Please complete the last page Fitment Check List of the "Internal Frame" instructions and retain these records at the dealer.

### WARRANTY:

Please refer to ARB "Warranty against defects" booklet contained in the hardware kit of the "Internal Frames" or contact your dealer. A copy of this booklet should be given to the customer.

### SAFETY:

This kit and any other ARB roof bar or rack system must never be fitted to another product. Only use with the specific Ascent Canopy Internal Frames.

## **TOOL LIST FOR FITMENT:**

<ul style="list-style-type: none"><li>• Torque Wrench 0-25Nm</li><li>• Tape Measure</li><li>• Sharp scissors</li><li>• T40, T50 Torx Drive screwdriver and bits for socket drives and screw drivers</li><li>• Cleaning cloths / rags</li><li>• Socket set</li></ul>	<ul style="list-style-type: none"><li>• Engineer's scribe</li><li>• Alcohol wipe</li><li>• 5.2mm drill bit</li><li>• Battery drill</li><li>• Rivet Gun</li><li>• Wax and grease remover</li></ul>
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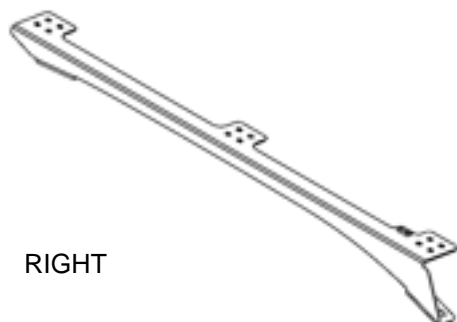
## **FITTING TO THE CANOPY IS UNDERTAKEN IN 4 STAGES:**

1. Preparing the frame brackets, seals and fitting the roof mount spacers.
2. Pre-fitting the Blade brackets to rack.
3. Fitting to the Internal frame brackets.
4. Clean, and check list sign off for record keeping and Owner's Manual Supplement.

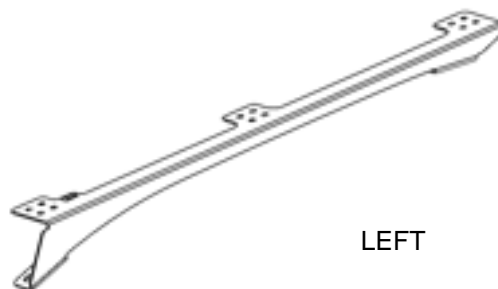
**!! IMPORTANT !! other than specifically specified in this instruction**

**REQUIRED SCREW TORQUES:      M6=9Nm                      M8=22Nm                      M10=25Nm**

Screw torques must be adhered to avoid warranty issues and should be checked at vehicle service intervals.



RIGHT

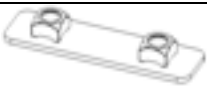












LEFT

## **THE BOXED FITTING KIT CONTAINS:**

### **BLADE BRACKETS:**

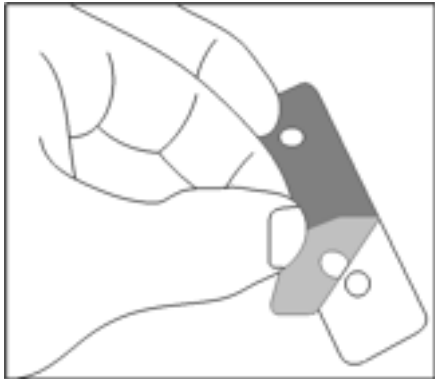
<b>VEHICLE APPLICATION:</b>	<b>BRACKET "RIGHT"</b>	<b>QTY</b>	<b>BRACKET "LEFT"</b>	<b>QTY</b>
TOYOTA TACOMA DC 2024+	37500630R	1	37500630L	1

FITTING KIT: 6178541	Part No	Picture	Qty	Description
	668AQ013		4	RACK NUT PLATE
	6151881		8	M8 x 35 TORX HEAD SCREW- BLACK
	6250056		8	ROOF SPACER
	4581303		12	M8 x 25.4 x 3 FLAT WASHER- BLACK
	3195184		6	STUD PLATE
	6151921		12	M8 x 20 COACH HEAD BOLT
	6151212		12	M8 NYLOC NUT
	665015		4	RACK NUT PLATE SEAL
	665509		4	BLADE BRACKET SEAL
	4581085		8	M8 x 19 x 1.2 FLAT WASHER- BLACK
	6151934		1	T40 TORX ALLEN KEY

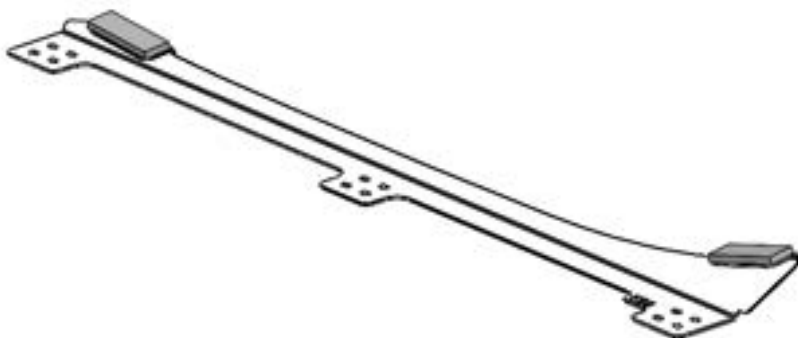
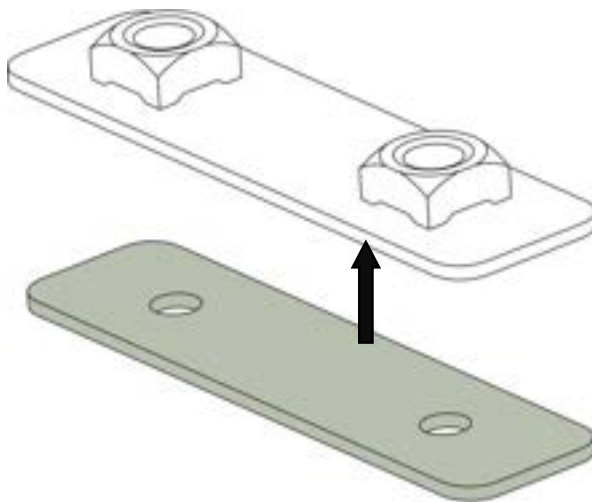
**BEFORE STARTING, READ ALL STEPS OF THE INSTRUCTIONS  
CAREFULLY AND CHECK ALL PARTS**

**COMPLETE INTERNAL FRAME FITTING TO THE SECTION ENTITLED  
“FITTING THE BLADE BRACKETS/FOOT PACKS”**

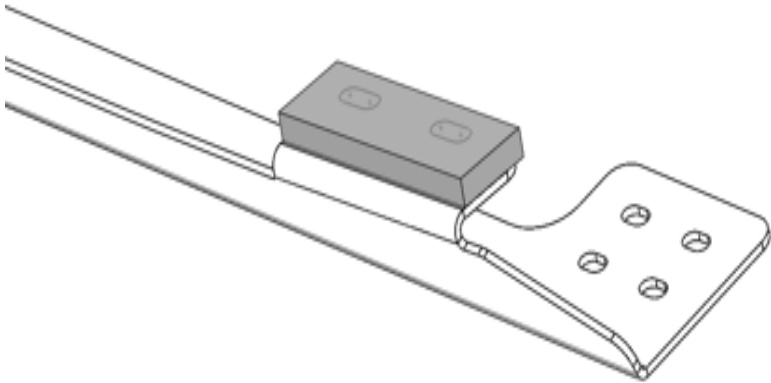
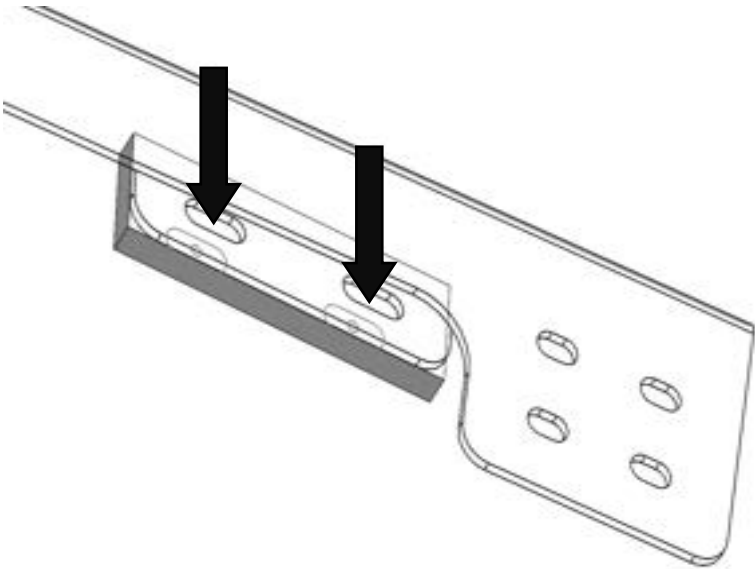
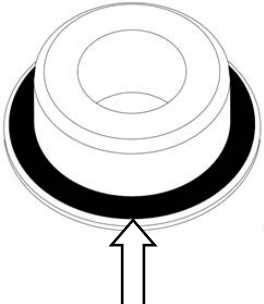
**SECTION 1: PREPARING THE FRAME BRACKETS & SEALS**

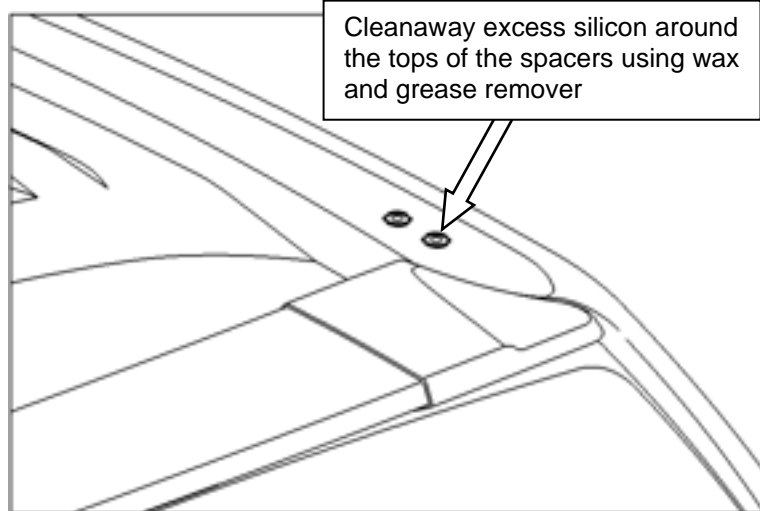


- 1.1) Remove the adhesive backing paper from the rack nut plate seal (665015) and apply to the rack nut plate (668AQ013). Repeat this step for all 4 rack nut plates.



- 1.2) Locate the blade bracket seals (665509) to the blade bracket lower tabs. Cut them to length to suit the length of the tabs on the brackets.

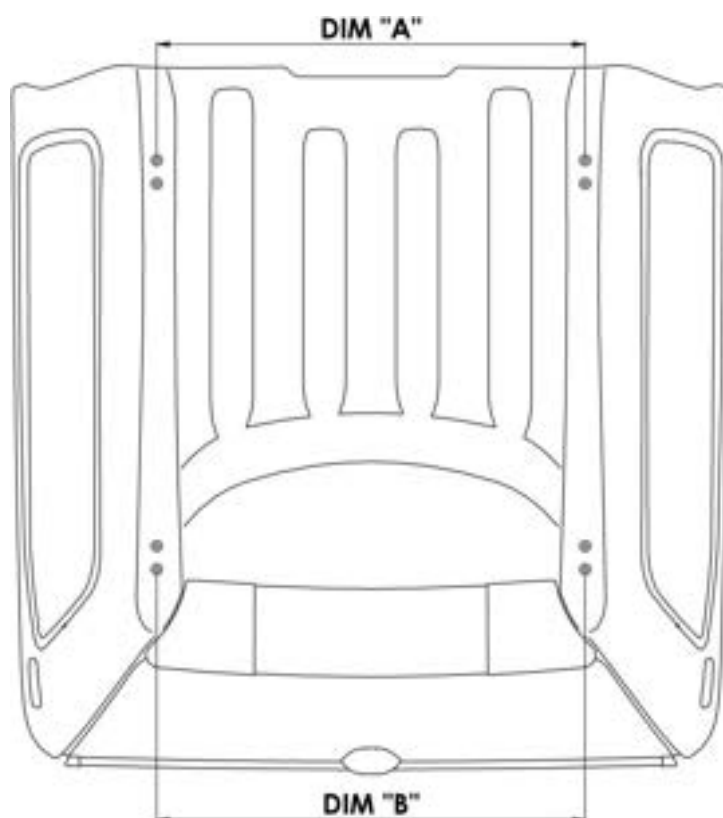
	<p>1.3) Place the adhesive side of blade bracket seals on the face of the blade bracket tabs facing up as shown, central to the edge of the bracket tabs.</p> <p>1.4) Mark the positions of the slots using a suitable marker</p> <p>1.5) Repeat this step for all blade bracket seals</p>
	<p>1.6) Pierce the centre of each slot in the blade bracket seal using a sharp pointed instrument such as an engineer's scribe or drill bit through the blade bracket slots. This is in aid to create tight holes in the seal for bolts to pass through later.</p>
 <div data-bbox="336 1783 743 1917"> <p>Apply neutral cure non-acetic silicon around the lip of the spacers</p> </div>	<p>1.7) Go the roof of the canopy shell.</p> <p>1.8) Apply neutral cure non acetic silicon to the stepped edge of the 8 roof spacers.</p>



- 1.9) **Refer to the separate internal frame fitting instructions for drilling the canopy shell roof.** Then fit the spacers into the 8 holes in the roof of the canopy from the outside.
- 1.10) Clean away excess silicon using wax and grease remover

## SECTION 2: FITTING BLADES TO RACK

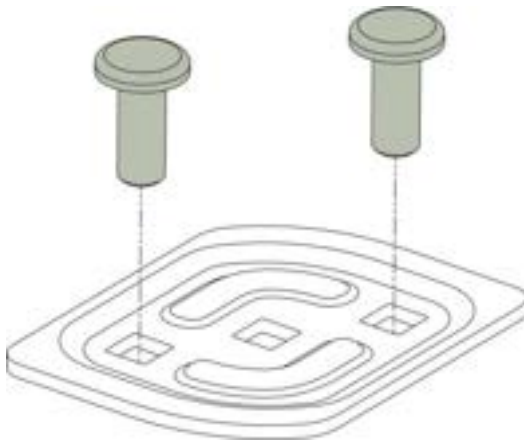
### FRONT OF CANOPY



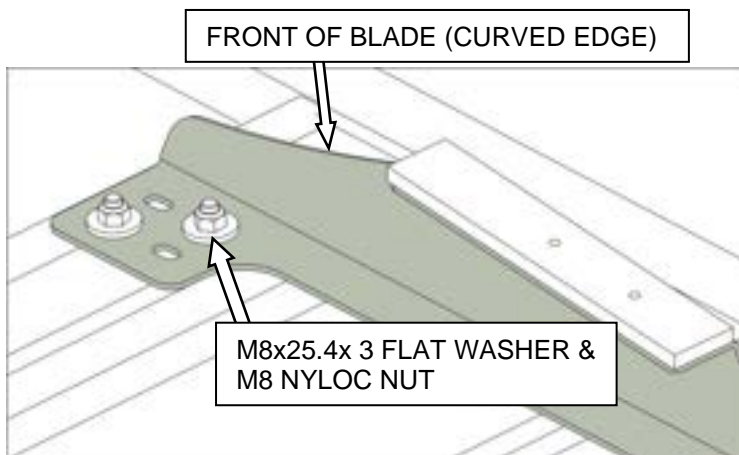
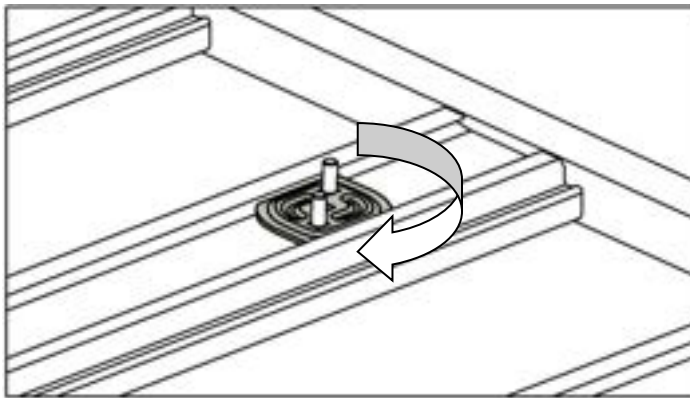
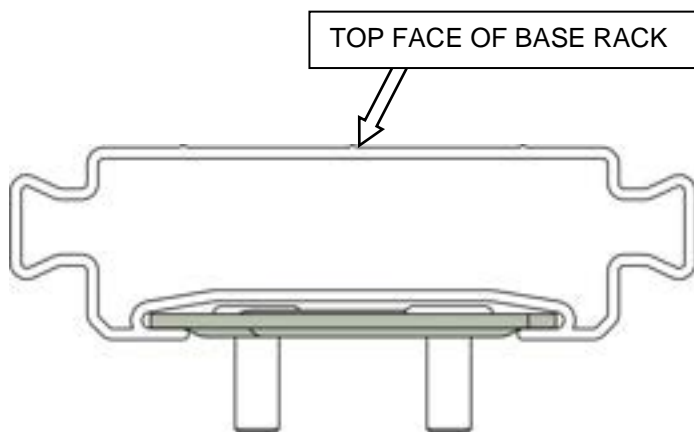
- 2.1) Clean the roof of the canopy.
- 2.2) Measure the centre distances of the spacers the were previously installed and write them down to record the dimensions.

DIM "A" =

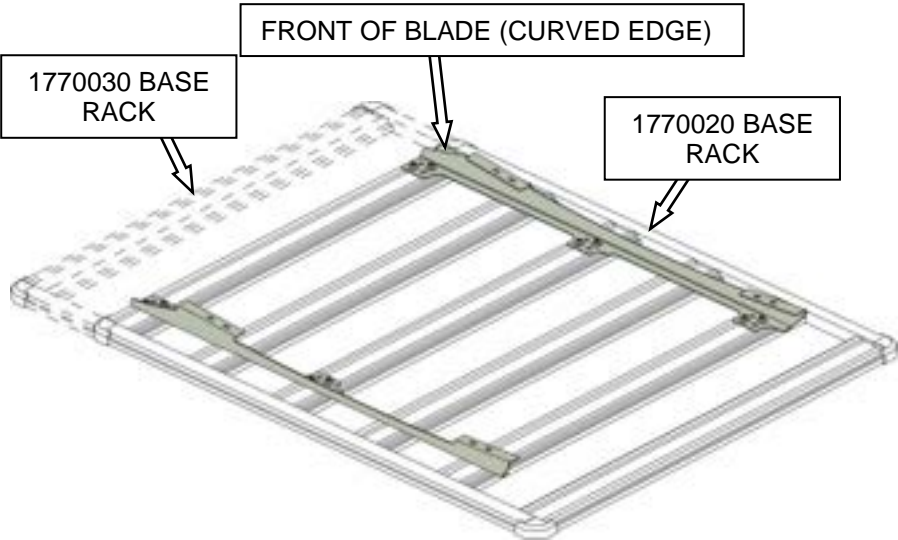
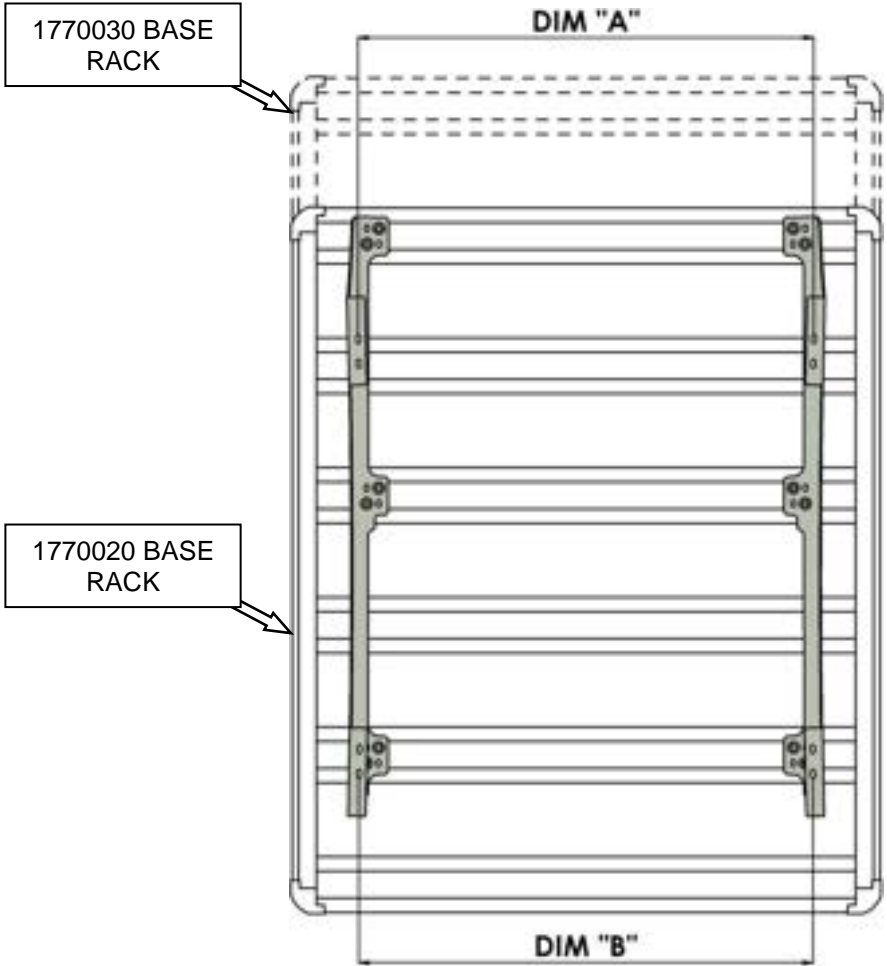
DIM "B" =



- 2.3) Insert 2, M8 x 20 coach head bolts (6151921) into each of the Stud Plates (3195184) as shown

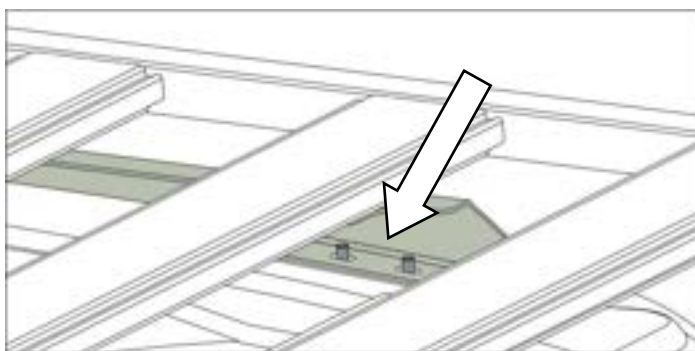
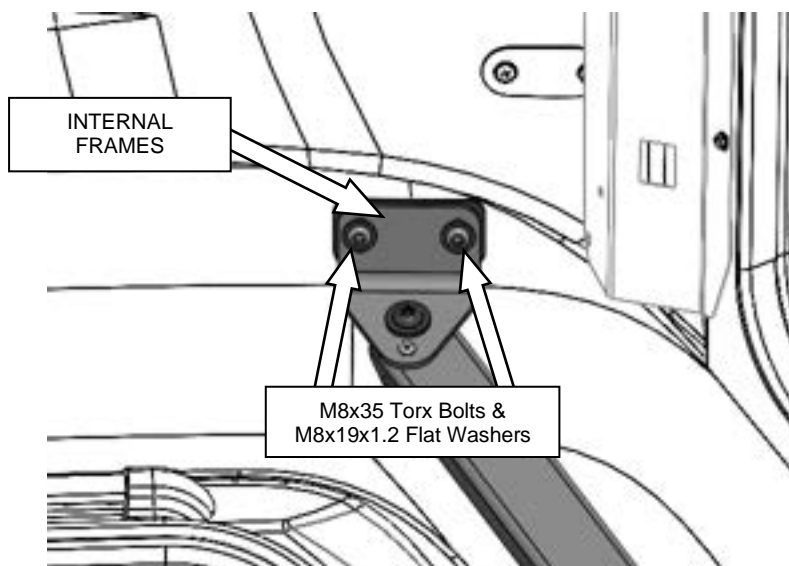
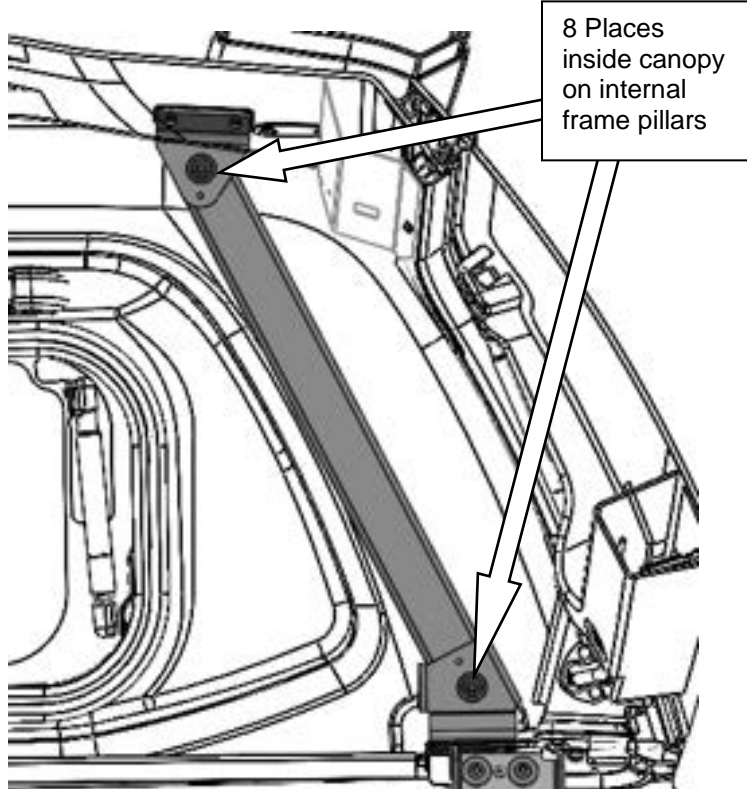


- 2.4) Place the Base Rack on a clean flat surface. Provide protection to the top face of Base Rack to avoid marking or scratching the surfaces.
- 2.5) Insert the previously assembled stud plates into the Base Rack channels as shown
- 2.6) Assemble the roof blades to the Base Rack using M8x 25.4x 3 flat washers (4581303) and M8 nyloc nuts (6151212). Do not fully tighten M8 nyloc nuts at this stage.

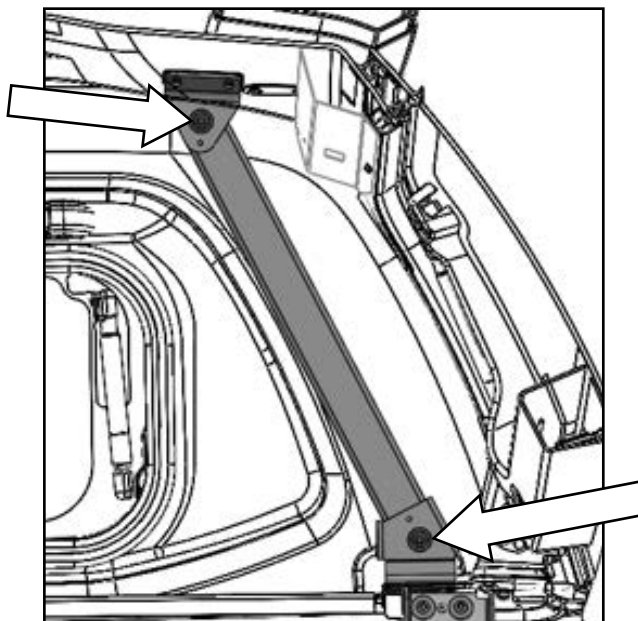
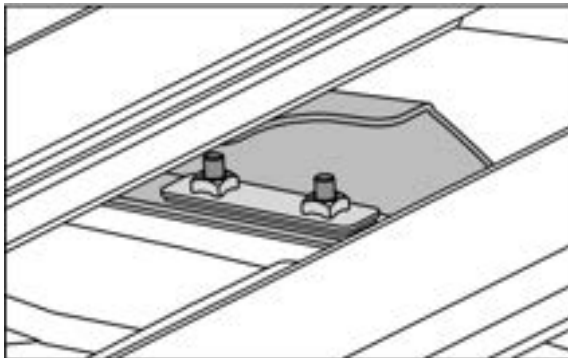
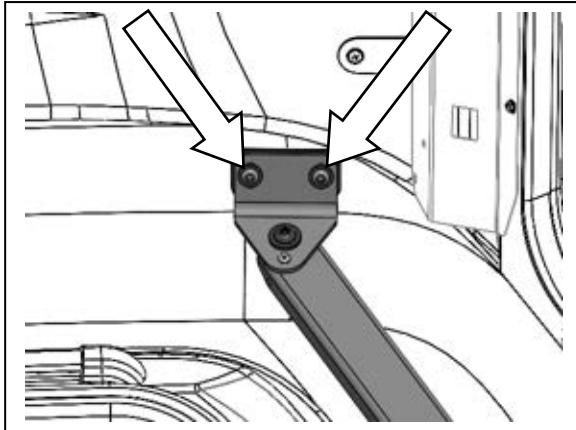
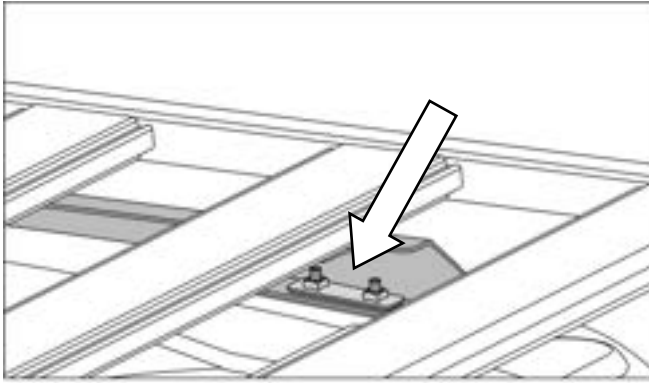
 <p>1770030 BASE RACK</p> <p>FRONT OF BLADE (CURVED EDGE)</p> <p>1770020 BASE RACK</p>	
<p><b><u>FRONT OF BASE RACK</u></b></p>  <p>1770030 BASE RACK</p> <p>1770020 BASE RACK</p> <p>DIM "A"</p> <p>DIM "B"</p>	<p>2.7) Using the measurements obtained in step 2.2 setup the blade brackets as shown. Ensure that the blade brackets are symmetric about the centre of the Base Rack.</p> <p>2.8) Once measurements are correct tighten all 12 of the M8 nyloc nuts to ensure blades cannot move freely. Do not torque fasteners at this stage.</p>



## SECTION 3: INSTALLING BASE RACK TO INTERNAL FRAME BRACKETS



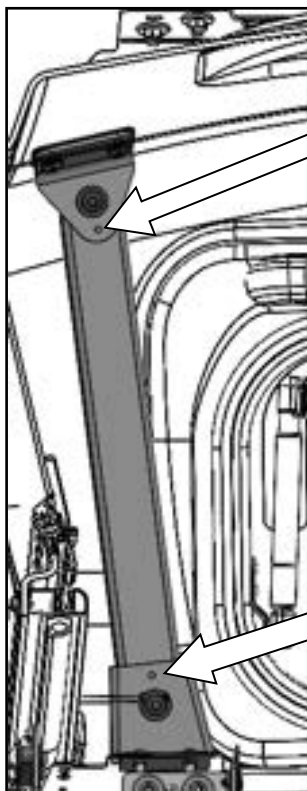
- 3.1) Clean the roof of canopy.
- 3.2) Ensure the eight M10 Torx bolts on the internal frame are loose (on the 4 internal frame pillars), and the internal frame support arm pillars are free to move so the upper and lower mounting brackets can pivot.
- 3.3) With the aid of another person lift the Base Rack assembly with blade brackets already fitted, into position onto the canopy roof and align the slots in the blade brackets with the spacers in the holes of the roof of the canopy shell. Never slide the Base Rack on the canopy roof as this will cause damage to the blade bracket seals and canopy shell paint.
- 3.4) Working from inside the canopy, fit M8x35 Torx Head bolts (6151881) and M8x19x1.2 washers (4581085) through each of the internal frame bracket holes whilst aligning the upper internal frame brackets to the spacers in the roof. Complete this for the top of all four internal frame pillars.
- 3.5) Ensure the Torx bolts protrude through the base foot tab of eh blade brackets in all 8 locations.



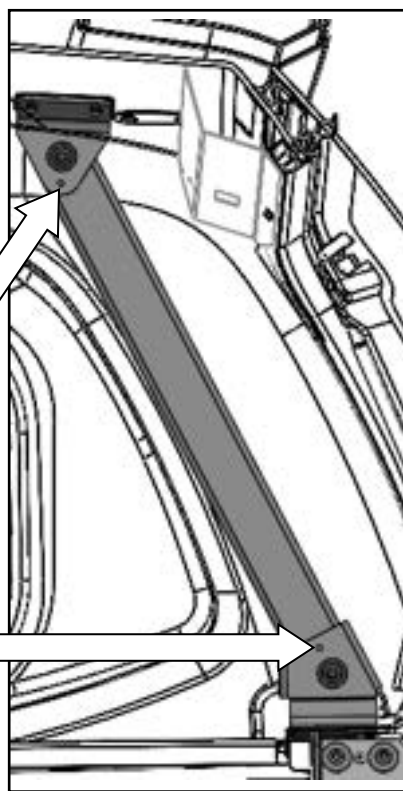
3.6) With the aid of another person outside, fit the blade bracket nut plates (668AQ013) in the four locations on top of the foot tabs of the blade brackets while threading the Torx bolts into them from the inside to secure the blade brackets to the canopy shell and internal frame brackets.

3.7) Using a **T40** Torx drive tighten all eight (8) fasteners to **22Nm**.

3.8) Once all roof blades are fastened, using **T50** Torx drive, torque all eight (8) internal frame M10 fasteners to **26Nm** at the top and bottom of the internal frame pillars.

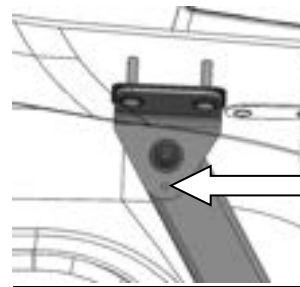


Front RH Internal frame shown – Complete both sides of canopy.



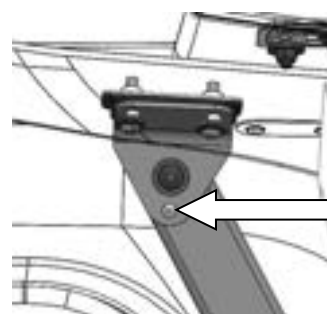
Rear RH Internal frame shown – Complete both sides of canopy.

- 3.9) Locate the smaller holes in the top and bottom brackets on the internal frame pillars. Drill 5.2mm holes through them and the main brace upright brackets.



Drill 5.2mm holes- 8 places

- 3.10) Install rivets provided in internal frame kit into the eight (8) places to secure the internal frames.



Rivet - 8 places

- 3.11) Perform a water leak test around mount points between blade brackets to the canopy shell.
- 3.12) **Fill in the last page of the “Internal Frame” fitting instructions “Check List” and retain records at dealer.**
- 3.13) **Fill in the second last page of Internal Frame fitting instructions “Owner’s manual supplement” and give a copy to the customer**
- 3.14) Place a copy of these fitting instructions in the vehicles owner’s manual

Completed ARB Base Rack and mount kit installation

1770030 BASE RACK

1770020 BASE RACK

