

# Installation Instructions



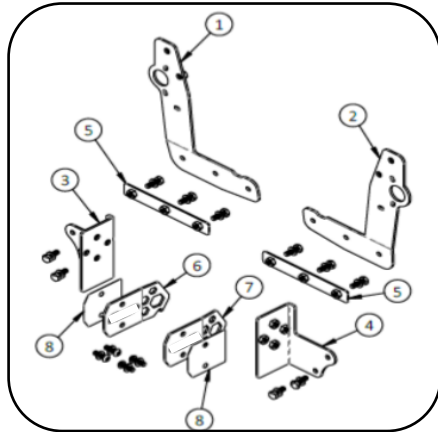
Toyota Tacoma Bed Stiffener  
Part # S/B61748W



For Technical Support / Warranty Information please call 800-776-0767 EXT 1317  
or Email at [info@smittybilt.com](mailto:info@smittybilt.com)

## Introduction

Thank you for choosing Smittybilt accessories for your Toyota Tacoma. If you would like to view our full range of available accessories, please visit us at [www.smittybilt.com](http://www.smittybilt.com)



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## Important Notes Before Starting

### **!** IMPORTANT NOTE

Carefully read through this entire instruction manual thoroughly before attempting to install this part.

The following tools will be required to complete the installation of this part:

#### **TOOLS REQUIRED**

General mechanic tool set

Power drill

Allen & Torx head drivers

Torque Wrench

(Y) or 13/32" & a 1/8" or similar drill bits

### **!** WARNING

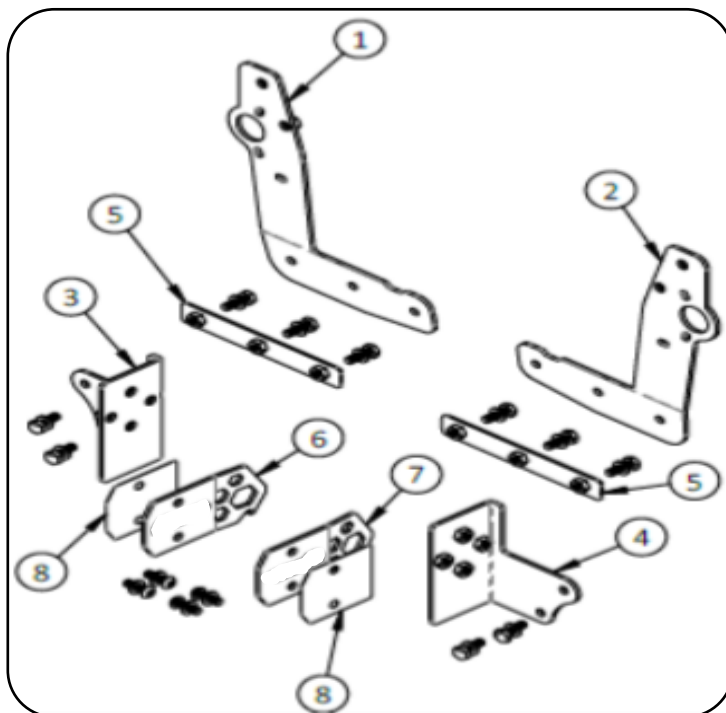
Serious injury can occur when working on vehicles alone.

When possible, work with another person to reduce risk of injury from strain or other dangers that can occur when working alone.



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## Box Contents & Hardware Parts



### SB61748W BOX CONTENTS

ITEM NO.	PART NO.	DESCRIPTION	QTY
1	84-12219	BED STIFFENER DRV.	1
2	84-12221	BED STIFFENER PASS	1
3	84-12223	CORNER BRKT DRV.	1
4	84-12225	CORNER BRKT PASS.	1
5	84-12227	NUT PLATE	2
6	84-12229	TIE DOWN BRKT DRV.	1
7	84-12230	TIE DOWN BRKT PASS.	1
8	102-12231	BACKING PLATE	2

### HARDWARE PACK 90-60794

QTY	DESCRIPTION
4	M10x1.5x30 BUTTON HEAD SST 18-8
10	M10x1.5x30 HEX BOLT, CLASS 10.9
14	M10 FLAT WASHER ZINC



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## ! WARNING

Check all four wheels and make sure parking brake is engaged before starting this install. Failure to do so could result in serious injury.

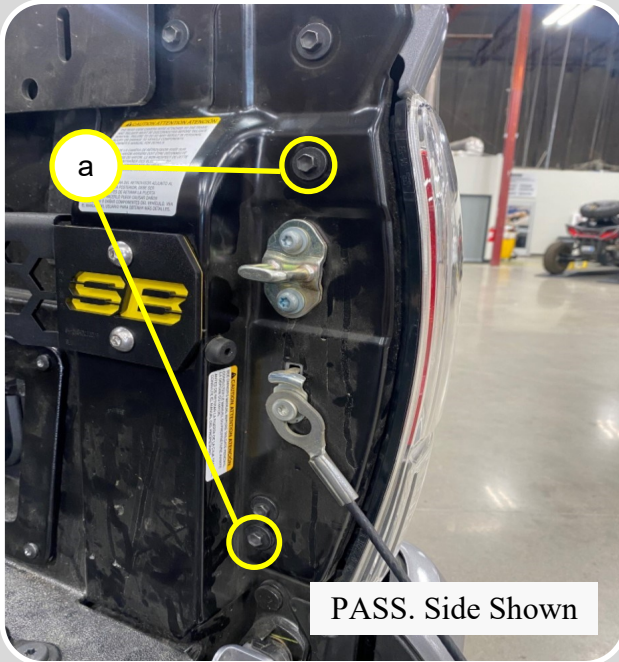
### Step 1: Check Box Contents

Open the box containing your Toyota Tacoma Bed Stiffener, check all parts against the Bill of Materials outlined in the first pages of these instructions. Use masking tape to protect painted surface.

If anything is missing, contact Smittybilt Technical Support immediately.

## ! IMPORTANT NOTE

Product in illustrations is shown in contrasting colors for clarity.



### Step 2: Open the tailgate

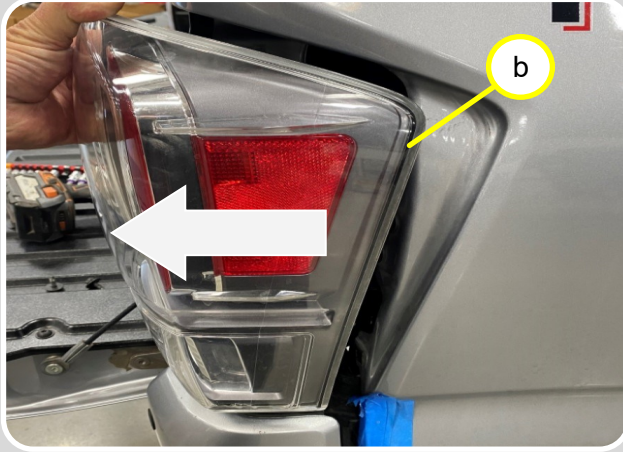
Open the tailgate. Starting on either side, use a 10mm socket to remove the two bolts shown (a), that retain the taillight housing. (*in fig pass side shown*)



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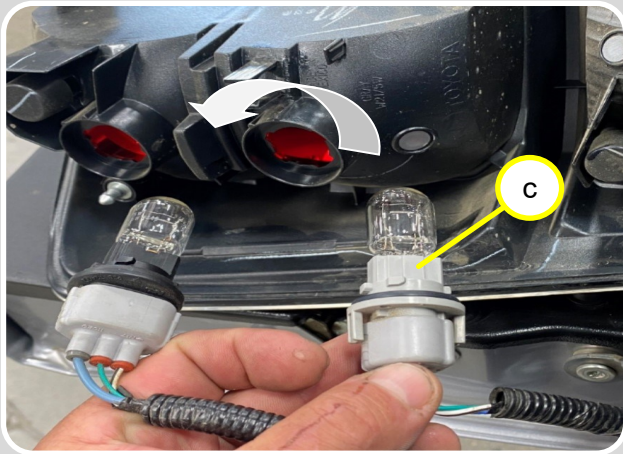


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## Step 3: Remove The Taillight Housing.

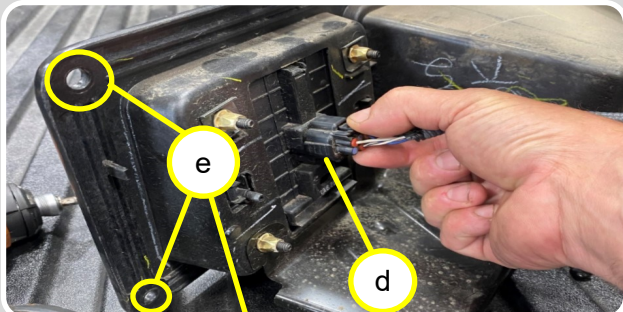
Remove the taillight housing (*b*) by pulling straight back (*pull taillight housing by direction shown in fig*),  
Newer vehicles may require some extra encouragement to release the locating pins.



## Step 4: Remove The Light Sockets.

To prevent damage to the taillight or wiring harness, remove the light sockets (*c*) from the housing with a 1/4 twist. Set the housing aside in safe place, lens side up to prevent scratches, until reassembly.

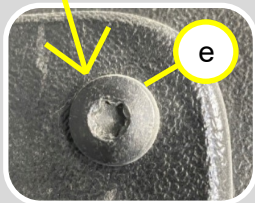
Repeat this process on the opposite side.



## Step 5: Remove The Panel.

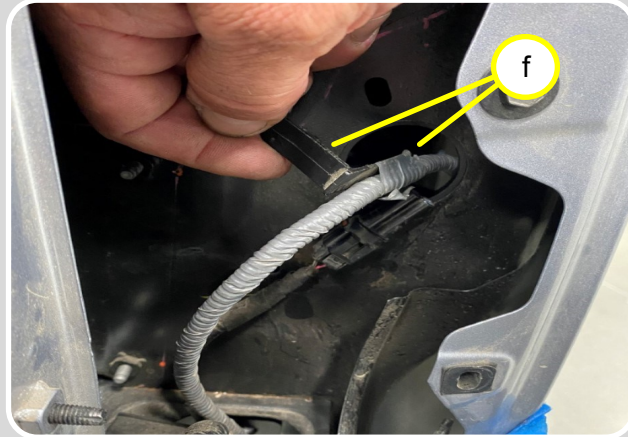
If your vehicle is equipped with the optional Cubby hole/110v power inverter in the bed, remove the 6X T30 Torx screws (*e*) that secure the panel the bed.

Carefully remove the panel and unplug the power wire from the back side (*d*).



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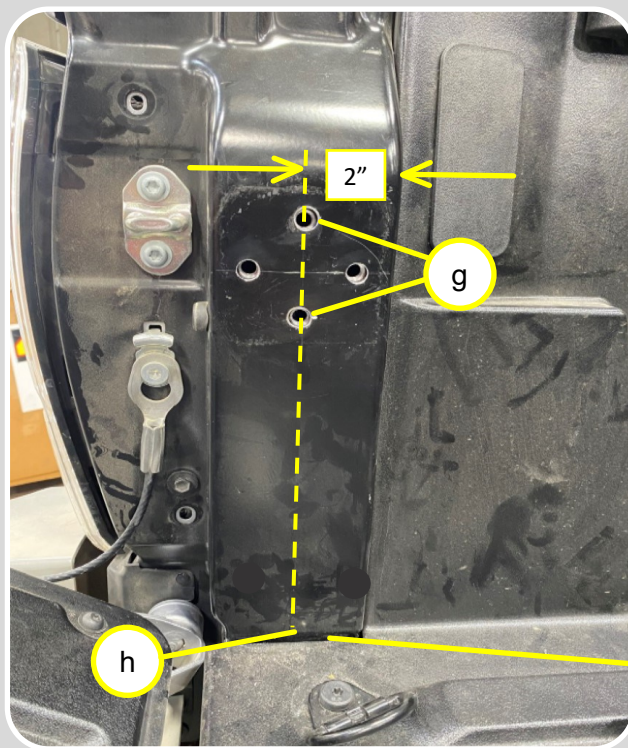
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### Step 6: Remove The Harness.

Carefully unclip the retainer and fish the inverter harness out through the hole behind the taillight.

Remove retainer clip and carefully pull the harness out through the hole (f).

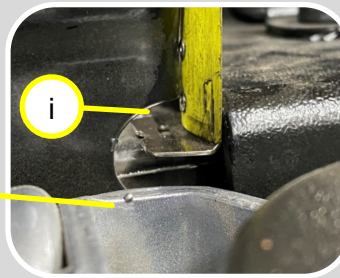


### Step 7: Horizontal Installation Marking.

Starting on either support pillar. With a thin ruler or tape measure (i).

Measure up from the center of the metal crossmember (**not the plastic bed**) and place marks 2" from the leading edge of the pillar at 9 11/16" (246mm) and 11 15/16" (303mm) show in fig (g).

Be sure to measure from center of crossmember, not plastic bed (h).



## ! IMPORTANT NOTE

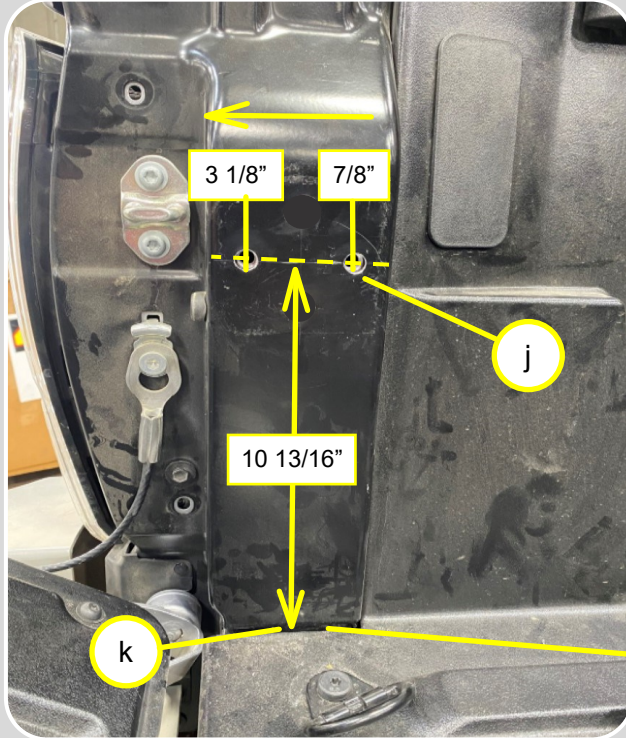
- The Tie Down Brackets can be mounted vertically or horizontal depending on your needs. (Refer After Step 15).
- If you have bed storage boxes, install the tie down brackets vertically to clear the slide out drawers. (Refer Step 8)
- If there aren't any clearance concerns, install the brackets horizontally. (Refer Step 7)



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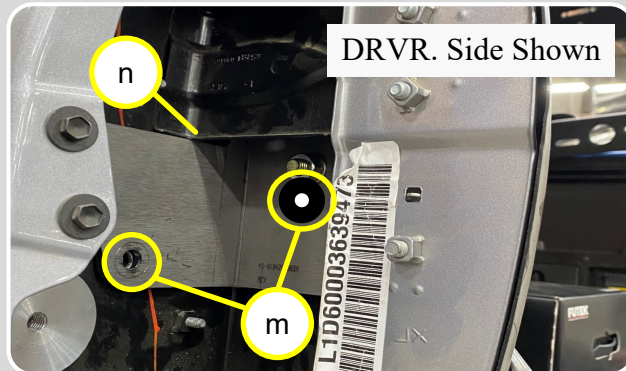
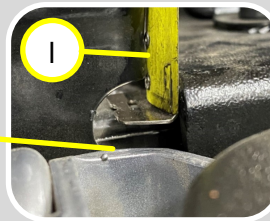


## Step 8: Vertical Installation Marking.

Starting on either support pillar. With a thin ruler or tape measure (*l*).

Measure up from the center of the metal crossmember (**not the plastic bed**) mark a horizontal line at  $10 \frac{13}{16}$ " (275mm). From the leading edge of the pillar measure back and place marks at  $\frac{7}{8}$ " (22mm) &  $3 \frac{1}{8}$ " (79mm) show in fig (*j*).

Be sure to measure from center of crossmember, not plastic bed (*k*).

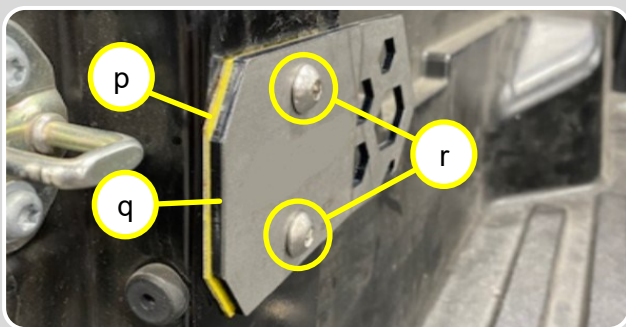


## Step 9: Drilling Of Pilot Holes.

Drill the (2) marks (*m*) on each pillar with a small ( $\frac{1}{8}$ "- $\frac{3}{16}$ " ) drill bit. Install the corresponding **Corner Bracket** (*n*) behind the pillar and against the latch brace, as shown in fig.

Make sure the holes are align, if not, carefully clearance the holes as necessary.

**Pilot holes** need to align with Corner Bracket mounting holes (*m*).



## Step 10: Installation of Tie Down Bracket

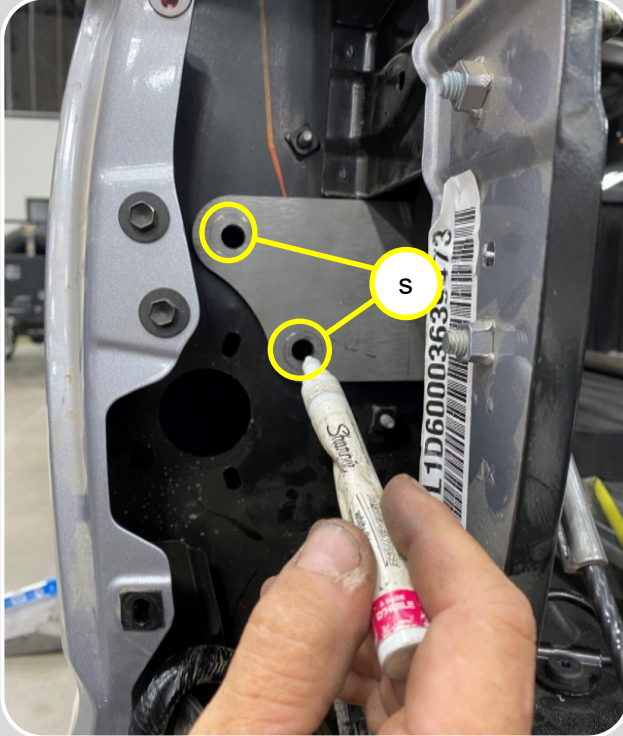
When satisfied with alignment of the pilot holes, drill them out to  $\frac{13}{32}$ ". Locate a **Backing Plate** (*p*) and the corresponding **Tie Down Bracket** (*q*). Install using **2X M10x1.5x30 SST Button Head Screws** (*r*), Washers.

Adjust as needed and tighten just until snug. Repeat on opposite side.



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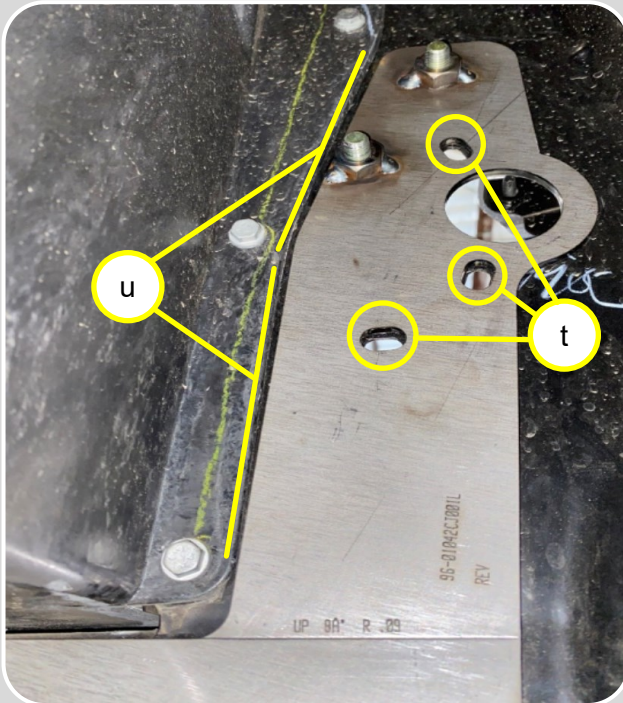
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### Step 11: Drill Marking.

Mark the remaining (2) holes in the **Corner Plate (s)** and drill out with the 13/32" drill bit

Repeat on opposite side.



### Step 12: Installation Of Bed Stiffener.

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 (t)**.

Secure using **2X M10 Hex Bolts and Washers** through the holes you just drilled.

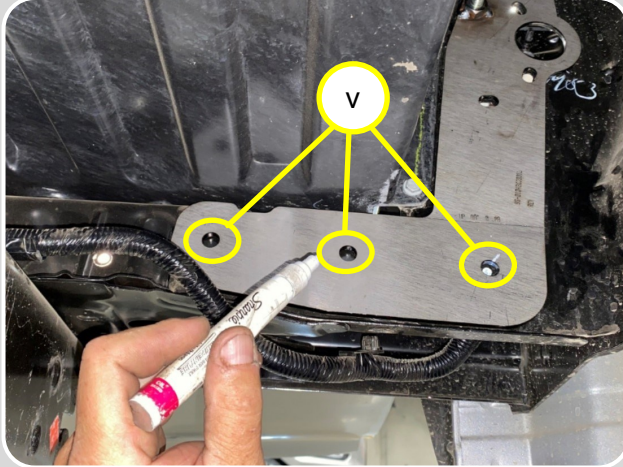
Tighten the bolts snug, adjust the **Bed Stiffener (u)** so it has an even reveal with the bedliner.



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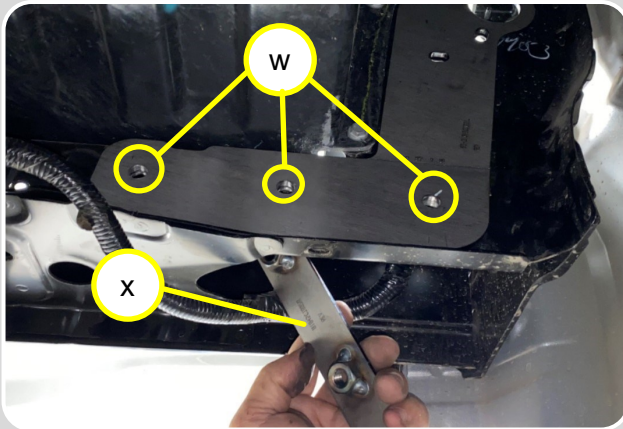
## Installation Instructions



### Step 13: Drilling Corresponding to Bed Stiffener.

Mark the (3) holes (v) along the bottom of the **Bed Stiffener** and drill out with the 13/32" drill bit.

Repeat on opposite side.



### Step 14: Installation Of Nut Plate.

Locate the **Nut plate (x)**, install behind the **Bed Stiffener** and secure with **3X M10 Hex Bolts and Washers (w)**.

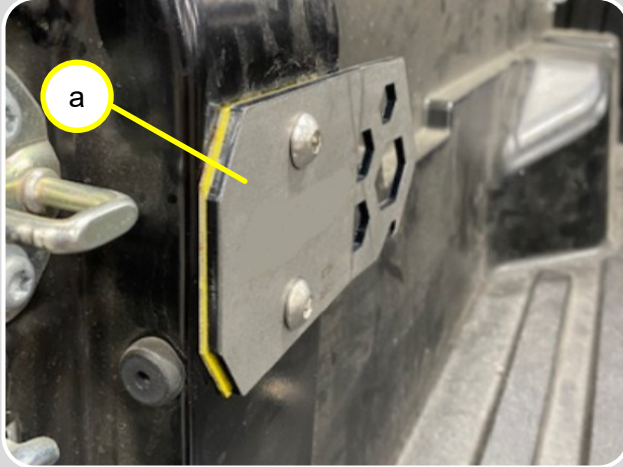
Snug all bolts and Double check alignment, then torque to **45ft-lbs**.

Repeat this process on other side.



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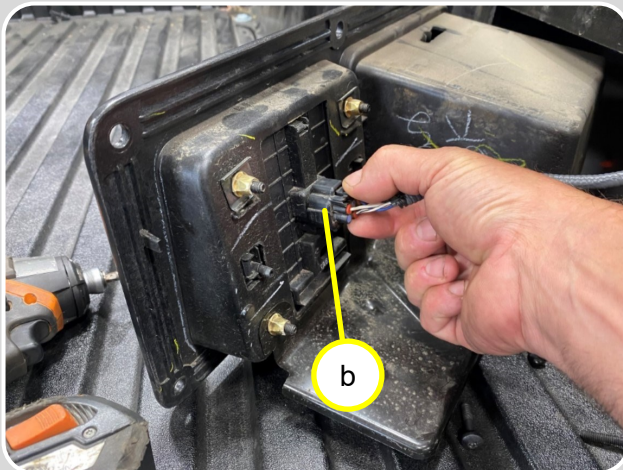
### Step 15: Over All Installation Verification .

Double check alignment of the **Tie Down Brackets (a)**, 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 (b) and Tail light mounting screws (c) to 5 ft-lbs.

**Your install is complete.**

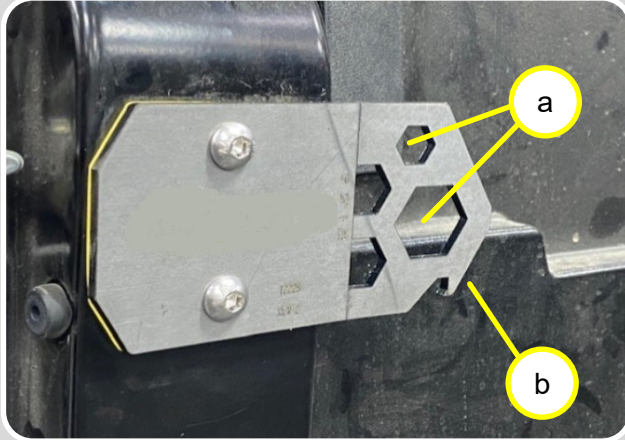


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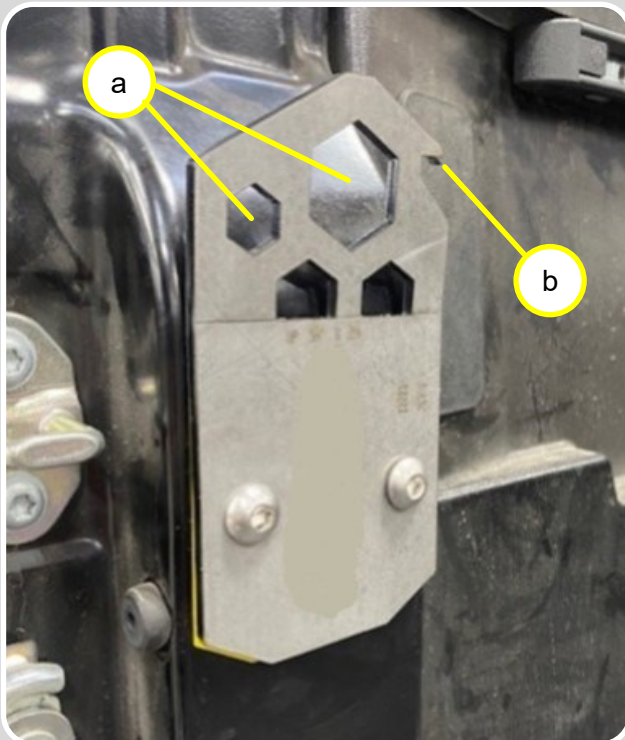
## ! IMPORTANT NOTE

The Tie Down Brackets can be mounted vertically or horizontal depending on your needs.



**Tie Down Brackets Mounted Vertical & Horizontal Position**

- (a) *Tie down Location*
- (b) *Bottle Opener*



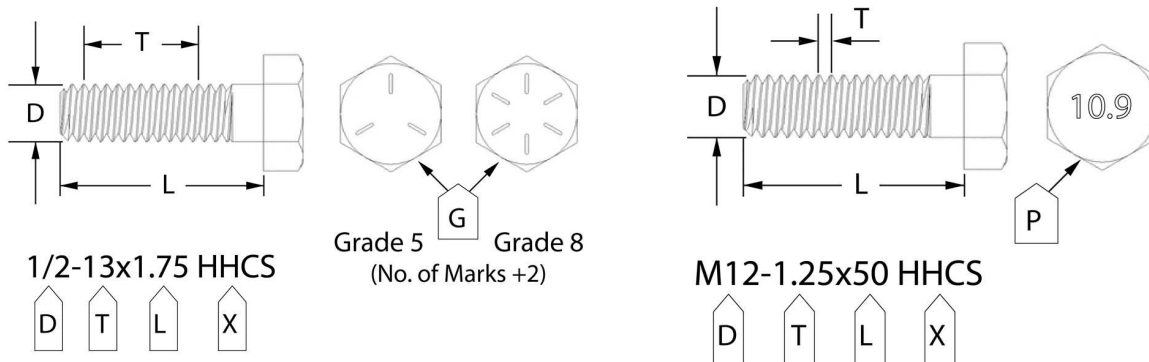
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# Bolt Torque Specifications

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

<b>Bolt Torque and ID</b>						
Decimal System			Metric System			
<i>All Torques in Ft. Lbs. Maximums</i>						
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



G= Grade (Bolt Strength)  
 D= Nominal Diameter (Inches)  
 T= Thread Count (Threads per Inch)  
 L= Length (Inches)  
 X= Description (Hex Head Cap Screw)

P= Property Class (Bolt Strength)  
 D= Nominal Diameter (Millimeters)  
 T= Thread Pitch (Thread Width, mm)  
 L= Length (Millimeters)  
 X= Description (Hex Head Cap Screw)



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## Notes and Disclaimers

### 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 wax 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 wax 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 wax that contains abrasive that could damage the finish.

### Limited Warranties

Smittybilt'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, Smittybilt 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. Smittybilt 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. Smittybilt strongly recommends returning the warranty registration card. Customer's remedy hereunder shall be limited only to repair or replacement (at Smittybilt's option) of any defective part(s) returned to Smittybilt 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 Smittybilt's sole discretion. To assure product quality, Smittybilt 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. Smittybilt 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. Smittybilt 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 Smittybilt 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 Smittybilt instructions, or additional safety information. Smittybilt 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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