

Southeast Toyota Tacoma

4-Door Roof Rack – DEALER INSTALLED

Parts list 1- Right side rail assembly 1- Left side rail assembly 2- Cross bars 4- Protective gaskets 4- Screws M5 x 13mm long 8- Riv-nuts 1/4"-20 8- Screws 1/4"-20 x 3/4"	Tools needed for installation Safety glasses Lint free cloth and 50/50 alcohol/water solution #2 Phillips screw driver Tape measure Hammer & Centre punch Drill & drill bits- 1/8", 1/4" & 25/64" Vacuum Torque wrench Required Equipment: Manually Operated Riv-Nut Gun and/or a Powered Riv-Nut Gun w/ 1/4" - 20 Mandrel
Materials needed Minimum 1/2" masking tape Rust inhibitor or a zinc rich primer	

Safety First

Always Wear Safety Glasses

Read all instructions thoroughly before attempting installation

1. Insure all pieces on parts list have been included in kit as shown below.



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2. Attach cross bars to side rail assemblies with 5mm stainless steel screws.
The resultant assembly should be as shown below.



3. Clean roof surface with a clean lint free cloth and 50/50 alcohol/water solution to avoid marring or scratching the painted surface.

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4. Use roof rack as template to mark location of holes. **Note:** To position roof rack correctly the load capacity label affixed to roof rack side rail must be toward the rear of the vehicle, as well, the arrows on the bottom of each crossbar should point to the front of the vehicle. Center and locate roof rack on vehicle so the rearmost point of each rear support is 6.75” (171.5mm) from the top of the rear window opening as illustrated below. Also, please use the rain gutters that are located on both sides of the roof panel as a centring device for the side to side positioning of the rack.



5. Apply masking tape on area to be drilled to protect roof from metal chips.

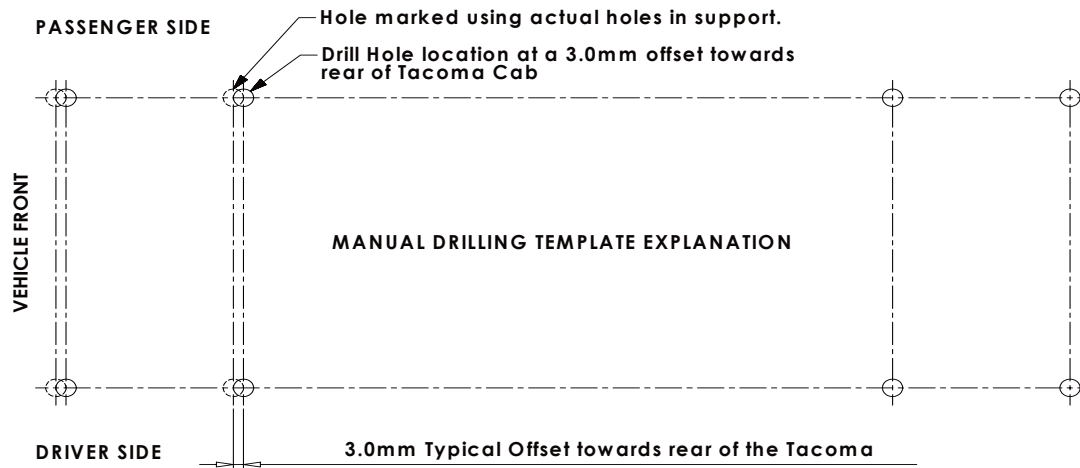
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6. Mark holes, remove roof rack and center punch holes as is shown below.



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CAUTION: RACK MUST BE INSTALLED WHILE UNDER TENSION

Before actually drilling the holes, set a drill stop for each diameter to stop any headliner damage occurring, a 1/4" inch depth stop is recommended.

7. Drill a 1/16" pilot hole, then open up this pilot hole to 1/4", and then finally to 25/64". **Before actually drilling the holes, set a drill stop for each diameter to stop any headliner damage occurring, a 1/4" inch depth stop is recommended.** Take care when drilling the 25/64" diameter hole, because the correct installation and sealing of the riv-nut requires a quality, round hole. Repeat this step 7 times.
8. Vacuum metal filings from roof, remove masking tape and apply a rust inhibitor or zinc rich primer to holes for corrosion protection.

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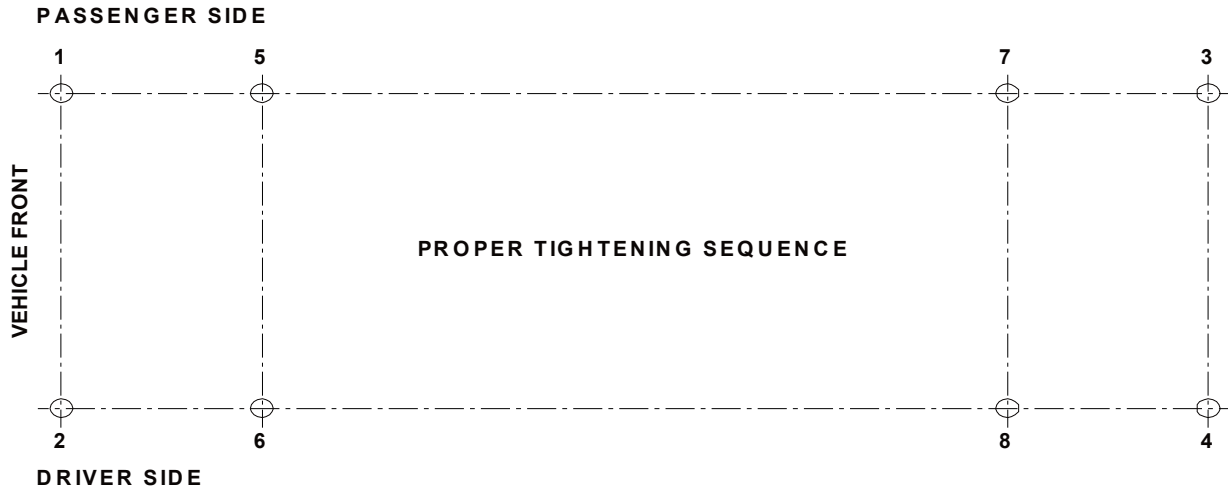
9. Install a ¼”-20 riv-nut into a drilled hole as per the picture below. The required torque for the proper seating of the riv-nut to the roof panel is 4-5ft./lbs. Ensure that the riv-nut head is flush with roof panel. Repeat this step 7 times.



10. Locate protective gaskets on roof panel; install roof rack assembly on gaskets. Install one ¼”-20 screw in each side rail support. Make sure gasket is aligned with supports. Install second ¼”-20 screw in supports, then tighten rearmost screws first. Repeat for remaining screws. Torque screws to 50 inch-pounds. Please see the sketch below for the proper tightening sequence.

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ROOF RACK AND ACCESSORY MAINTENANCE

The ultraviolet rays of the sun, oxygen, and moisture attack the thermoplastic rubber, plastics and powder-coated components. For protection we recommend periodic application of a lubrication/protectant such as Armour All. An added benefit is that the surfaces become anti-static, repelling road dirt and dust. Keep your roof racks and accessories looking good and working well all the time.