

ARB **BED RACK**

Part Number: **17915100**
Suits Vehicle: **TOYOTA TUNDRA 5' BED**
Product Description: **BED RACK MOUNT KIT**
Optional kits: **1780850 BED RACK CROSS BARS PR 1400MM**
1780800 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

Corporate Head Office

42-44 Garden St
Kilsyth, Victoria
AUSTRALIA 3137

Tel: +61 (3) 9761 6622
Fax: +61 (3) 9761 6807

Australian enquiries
North & South American enquiries
Other international enquiries

sales@arb.com.au
sales@arbusa.com
exports@arb.com.au

www.arb.com.au

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
Ø8.5MM AND Ø10.5MM DRILL BIT	7/8" (22.0MM) HOLE SAW
TORQUE WRENCH Minimum 22Nm	DEBURRING TOOL
TOUCH UP PAINT	SCISSORS
BASIC TOOL KIT	PPE

HAVE AVAILABLE THESE SAFETY ITEMS WHEN FITTING PRODUCT:

Protective eyewear		Hearing protection	
--------------------	---	--------------------	---

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.



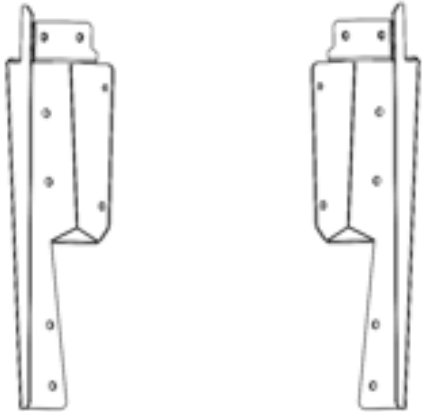
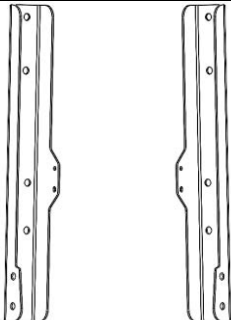
FASTENER  TORQUE SETTINGS:


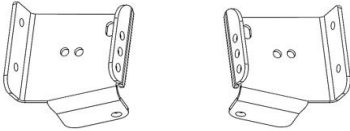
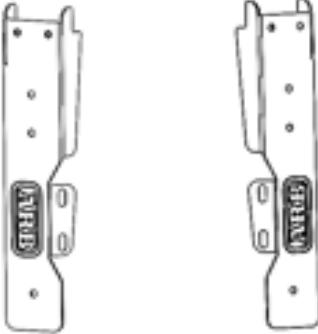
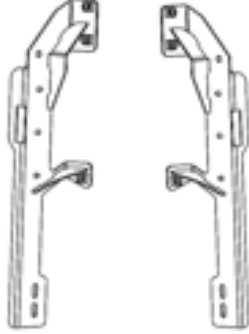


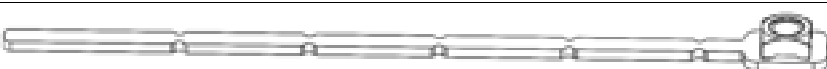
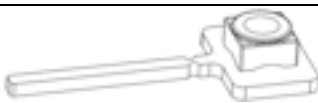



SIZE	Torque Nm	Torque lbft
M6	9Nm	7lbft
M8	22Nm	16lbft
M10	44Nm	32lbft




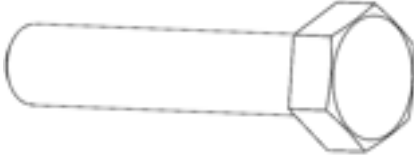

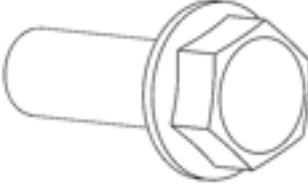
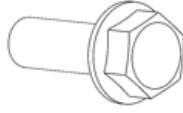
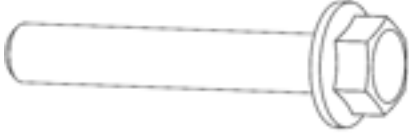
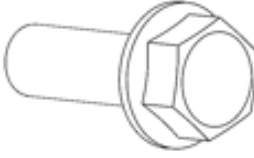
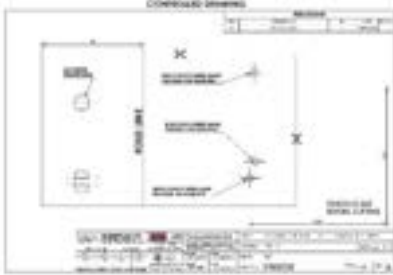
FACTORY FASTENER  TORQUE SETTINGS:

SIZE	Torque Nm	Torque lbft
M12 Sway bar nut	75Nm	55lbft
M12 Sway bar bracket	96Nm	71lbft
M14	160Nm	118lbft

PARTS LISTING

PART NUMBER	DESCRIPTION	QTY	DIAGRAM
6136706R	RH BED RACK FRAME WELDMENT	1	
6136706L	LH BED RACK FRAME WELDMENT	1	
4655478L&R	FRONT BED MNT	1L & 1R	
4601321L&R	FRONT TUB INTERNAL MNT	1L & 1R	

4601322L&R	FRONT LINKING CHANNEL	1L & 1R	
6317679L&R	FRONT CHASSIS SWAYBAR LINK	1L & 1R	
4601312L&R	REAR LOGO CHANNEL	1L & 1R	
4655510L&R	REAR INTERNAL BRACE	1L & 1R	
4655511L&R	BR REAR CHASSIS MNT	1L & 1R	
3759081	ASSY WELD NUT T6 RP	2	
4655055	NUT PLT M8x1.25	4	
3195864	M10 NUT PLT 35X25X4	2	
6253444	Ø22XØ11X28 SPACER	4	
6253345	SPACER OD19 X ID9 X14	2	
6253445	Ø22XØ10X9 SPACER	2	

4581083	WASHER FLAT M10x20.6x2 TZP HARDENED	2	
4584393	WASHER FLAT M8x19x2 HV300 BTZP480	4	
6151173	NUT FLANGE M6 ZNB480 SERRATED	2	
6151217	BOLT HXHD M10x1.5x50 PC8.8 ZP	2	
6151321	NUT FLANGE M10x1.5 PC8.8 TZP480 SERRATED	20	
6151965	BOLT HXHD FL M10x1.5x30	38	
6152008	BOLT HXHD FL M6x1.0x25 PC8.8 ZNB480	6	
6152042	BOLT HXHD FL M8x1.25x50 FT PC8.8 ZNB480	2	
6152153	BOLT HXHD FL M8x1.25x30	8	
37800236	DRILLING TEMPLATE	1	

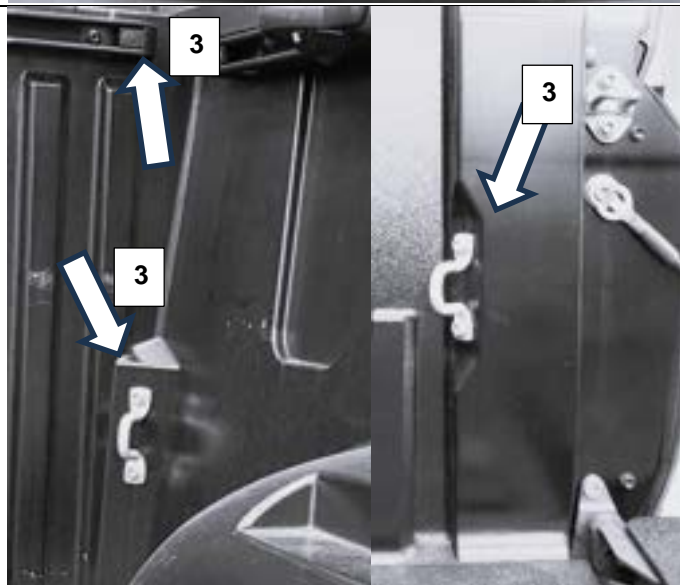
BEFORE STARTING, READ ALL STEPS OF THE INSTRUCTIONS



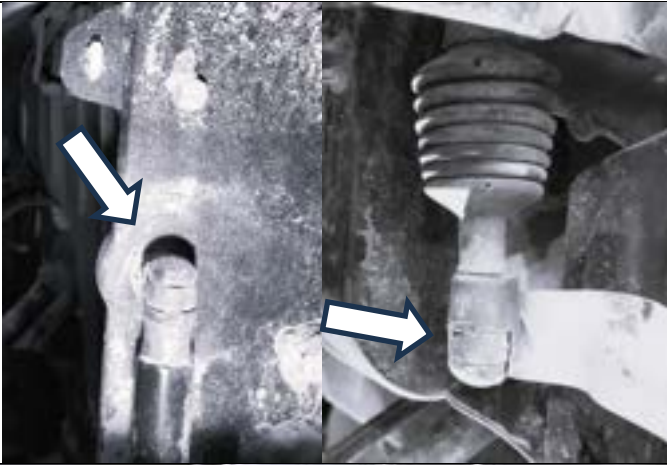
1. Remove both left and right tail lights, unplug the lamps and place in a safe location.



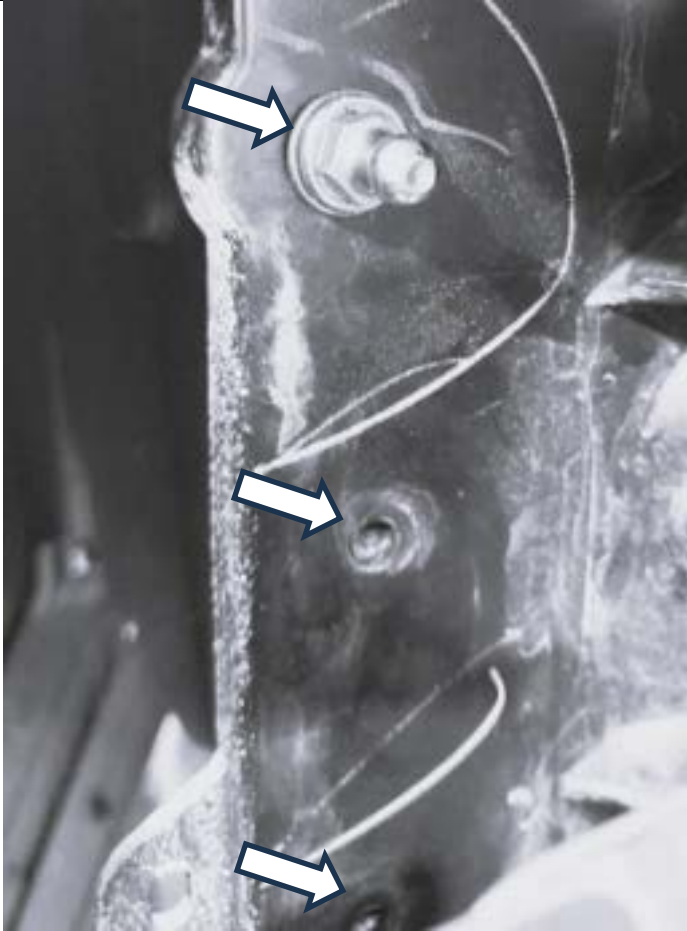
2. Remove the BED RACK carton lid, remove the large staples and place into the tub. The carton lid will protect the tub from scratches.



3. If fitted, remove all tie down points, set aside for refitment later. Remove the two end caps from the head board CMS rail.



4. Close the tailgate. Behind the tail light on the LHS, remove the tailgate assist and set aside.

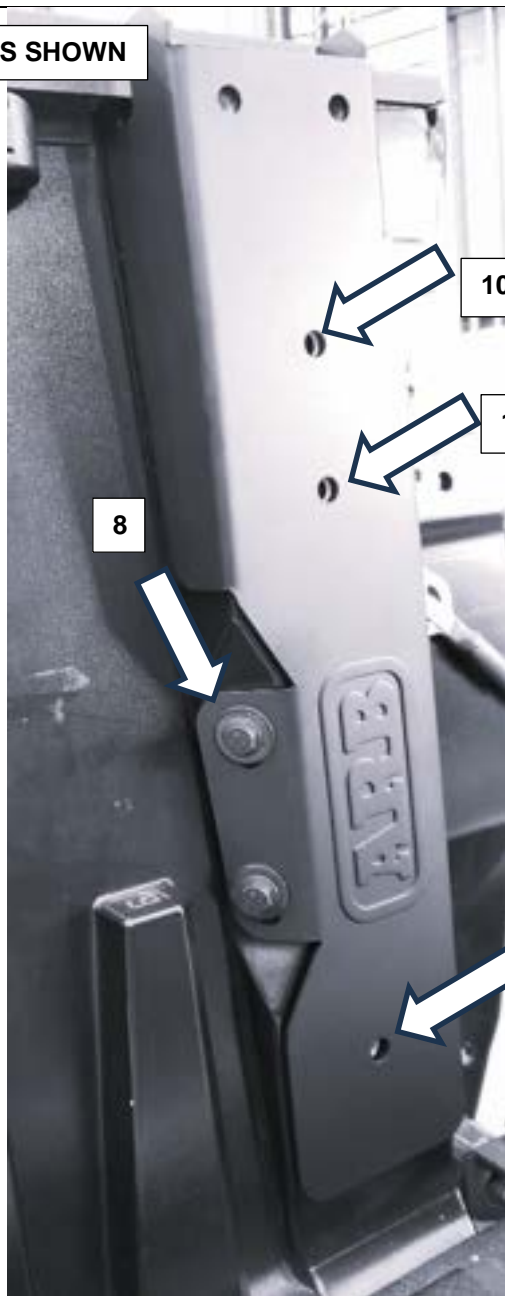


5. Remove top tailgate ball mount and the three M6 bolts below it. The same three M6 bolts must be removed from the RHS as well. Set these aside with the piston removed above.
6. CAREFULLY lower the tailgate.



7. Open fit kit box and layout all brackets and fasteners.

RHS SHOWN

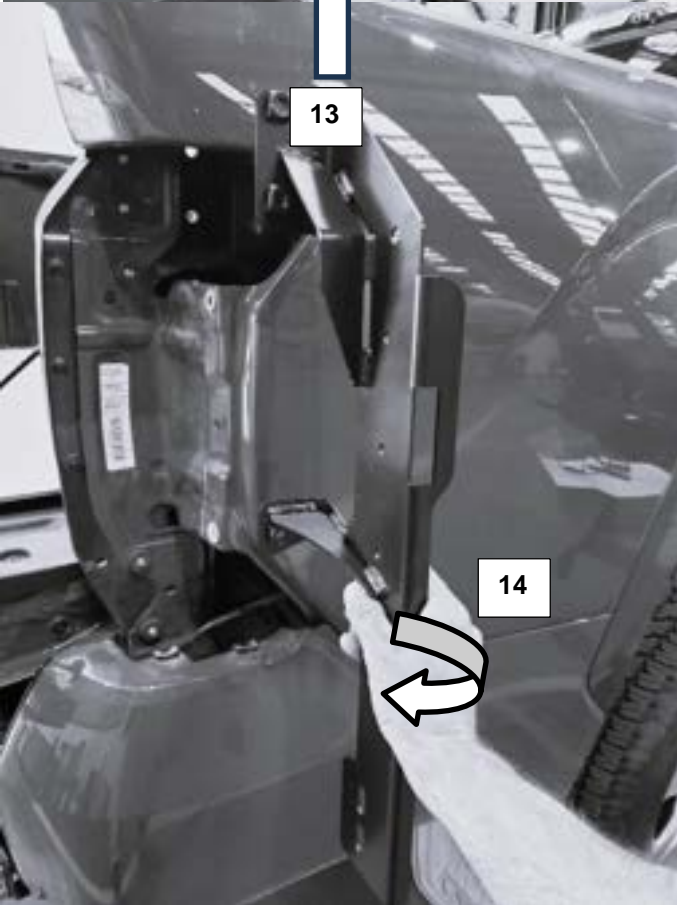


8. Fit both the rear mounts using two M8x30 FL bolts into the tie down positions.
9. Adjust the height of the mounts to be approximately 5mm down from the top of the tub cap, tighten the two M8 bolts to hold the mount in position.
10. Using a $\text{\O}10.5\text{mm}$ bit, drill through the tub frame in three positions per side.
11. Remove both mounts and debur the holes.

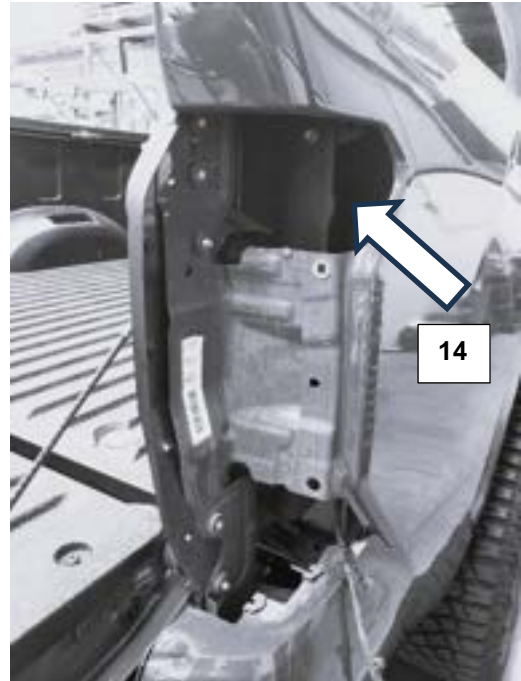


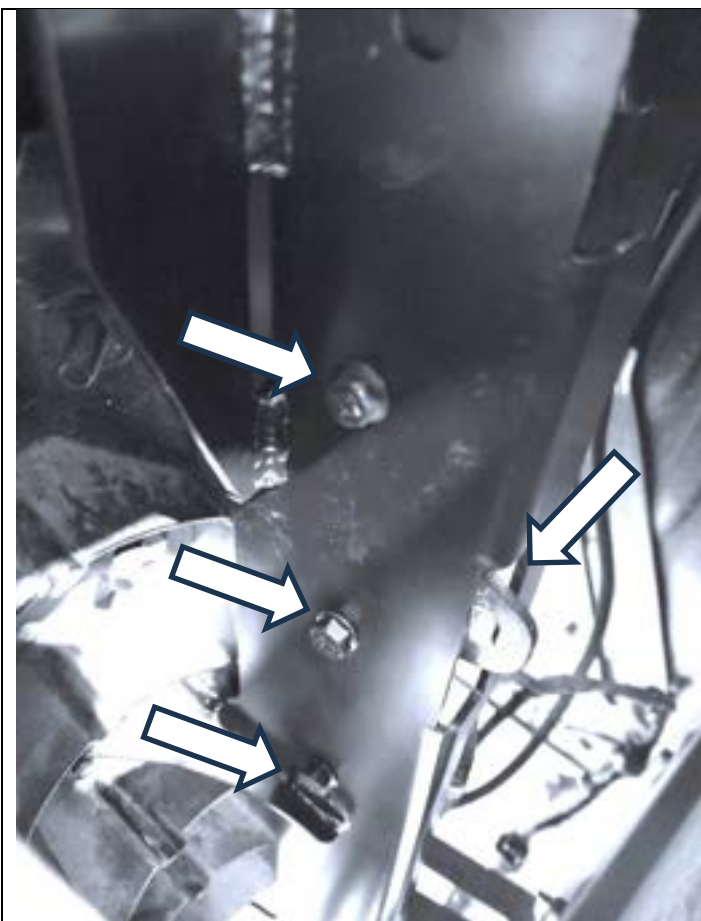
WARNING: Drilling & Cutting operations can result in flying debris. Eye and ear safety protection should be worn.

RHS SHOWN



12. Locate the RHS Rear Internal Brace.
13. From under the vehicle behind the mud flap, lift the brace up and back towards the tail light opening.
14. As the part is lifted, rotate the part around the Tub area where the three M6 bolts were removed.

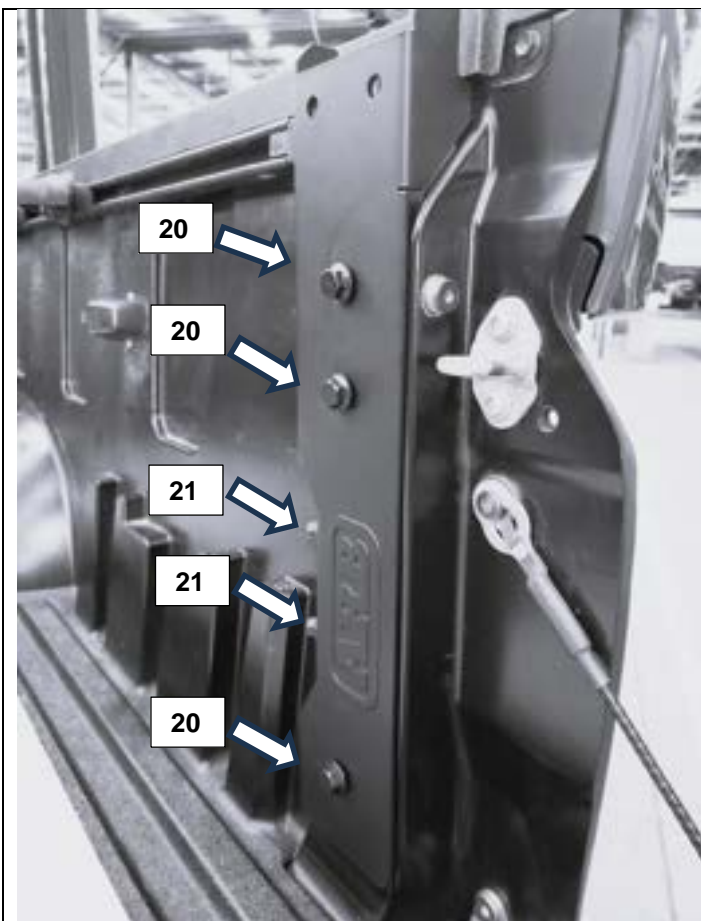





15. Once rotated, lift the brace up into the webbed tub frame to align with the drilled holes.
16. The tub cable mount fits through the brace if in the correct position.
17. Loosely fit three M6x25 FL bolts to hold the mount in position.




18. Repeat the brace fitment for the LHS.
19. Refit the top tailgate ball mount when fitting the three M6x25 FL bolts leaving loose.




20. Install both the rear mounts with three M10x30 FL bolts into the internal brace.
21. Refit the rear tie down points using two M8x30 FL bolts and M8 washers.
22. Tighten the M8 and M10 bolts to specification.

 M8 - 22 Nm.

 M10 - 44 Nm.



23. Tighten the three M6 FL bolts per side to specification.
24. Tighten the Tailgate ball mount to specification.

 M6 - 9 Nm.

 M8 - 22 Nm.

RHS SHOWN




25. Remove the three towbar nuts leaving the bolts in place. A G-clamp can be used as shown to prevent the plates spreading.




26. Install the Rear chassis mount using the towbar bolts and nuts.



27. Fit two M10x30 FL bolts with M10 FL nuts.
28. Torque the M10 and M14 fasteners to specification.
29. Repeat the chassis mount fitment for the LHS.

 M10 - 44 Nm.

 M14 - 160 Nm.



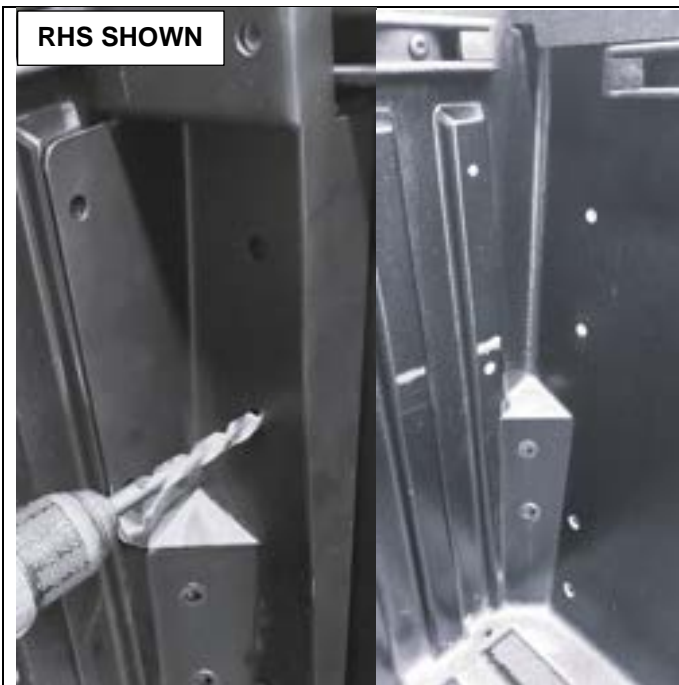
30. With the tailgate closed, refit the tailgate assist piston and secure the locking clamps.

Lower tailgate and check function.

RHS SHOWN



31. Place the front mount into the corner as shown with the corner sitting on the angled tub surface.



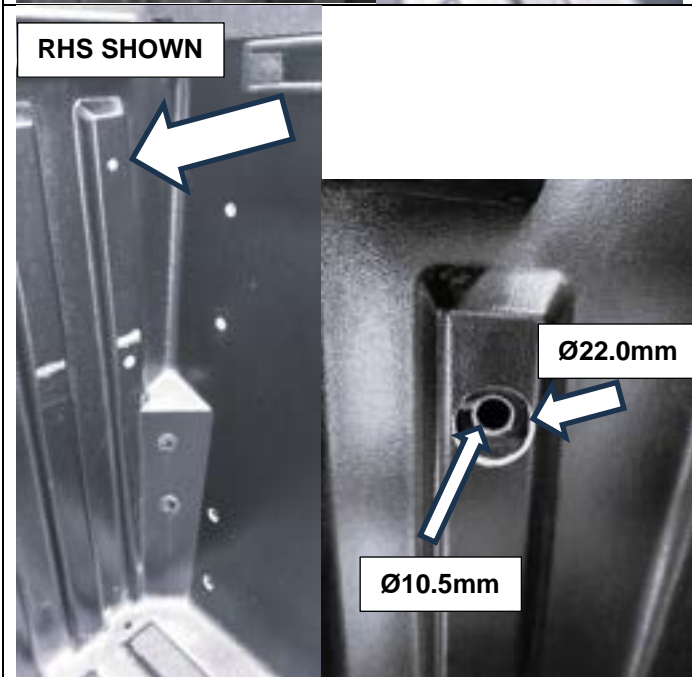
RHS SHOWN

32. Using a Ø10.5mm bit, spot drill the six hole positions through the mount.

DO NOT DRILL THROUGH



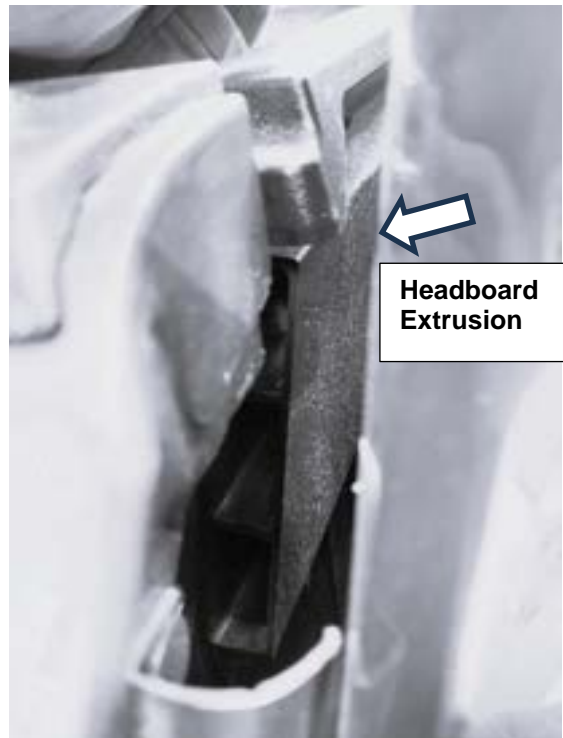
WARNING: Drilling & Cutting operations can result in flying debris. Eye and ear safety protection should be worn.



RHS SHOWN

33. Using a Ø22.0mm (7/8") hole saw, drill through the TOP spot drilled position only on the headboard. Behind the headboard is an Aluminium extrusion, drill through the first layer only with the hole saw pilot drill.

34. Open the pilot drilled hole in the extrusion to Ø10.5mm.



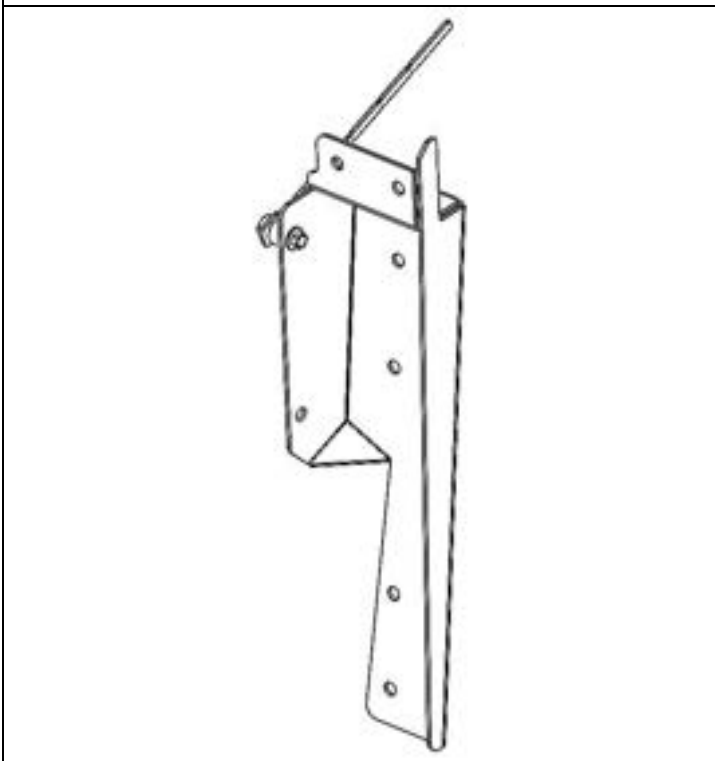
Headboard Extrusion



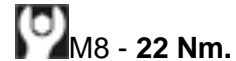
35. Bend two M8 nut sticks as shown.



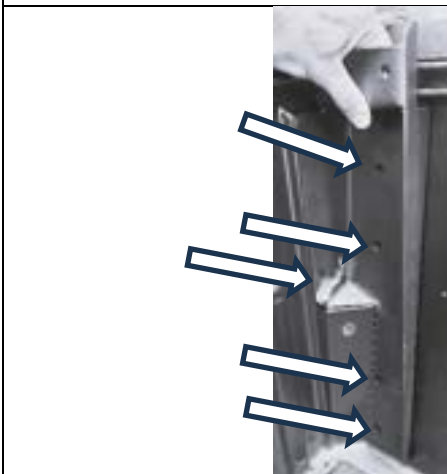
36. Insert one bent nut stick into the centre opening of the extrusion and align with the drilled hole.



37. Insert one 6253345 spacer into the hole in the headboard, refit the front mount to the tub using one M8x30 FL bolt. Tighten to specification.



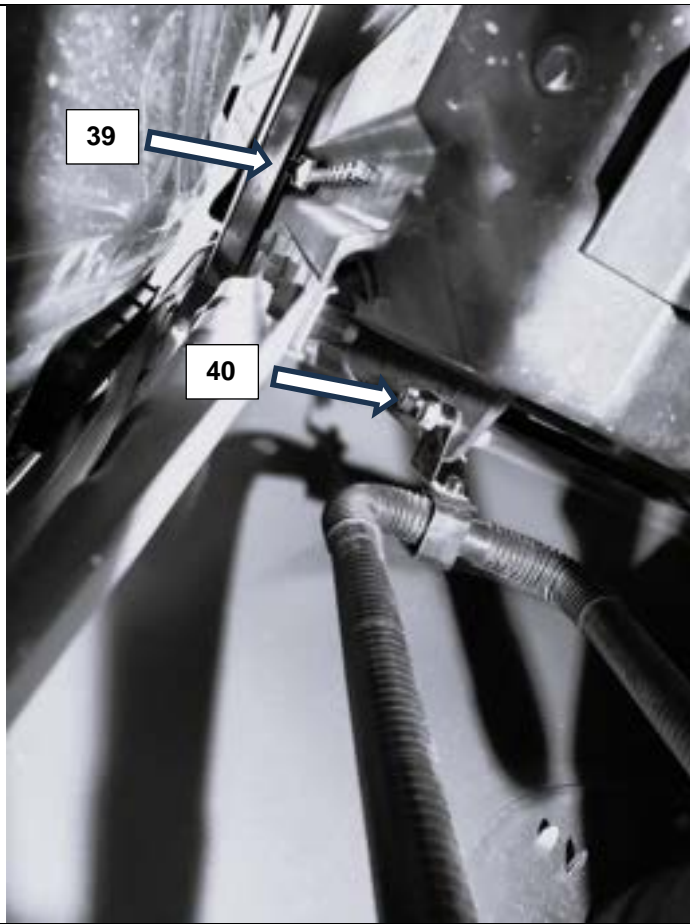
OD19 X ID9 X 14



38. Drill through the tub in the remaining five position taking great care to not drill too deep.



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




39. With the aid of a colleague, fit one M10x30 FL bolt through the bottom headboard hole with one M10 nut stick up from under the tub.
40. Remove the two M6 FL bolts from the tube bracket and set aside for use later.



41. Lift the Internal mounting bracket 4601321R up to align with the drilled hole in the side of the tub, fix in place using four M10x30 FL bolts and four M10 FL nuts.




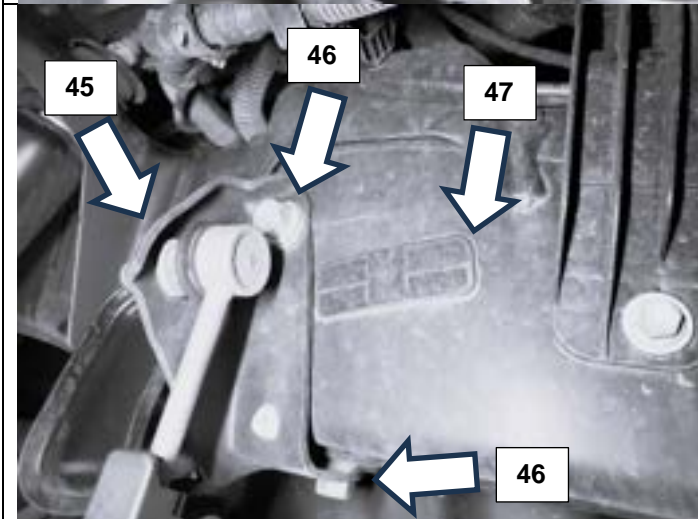
42. Torque the five M10x30 FL bolts to specification.

 M10 - 44 Nm.

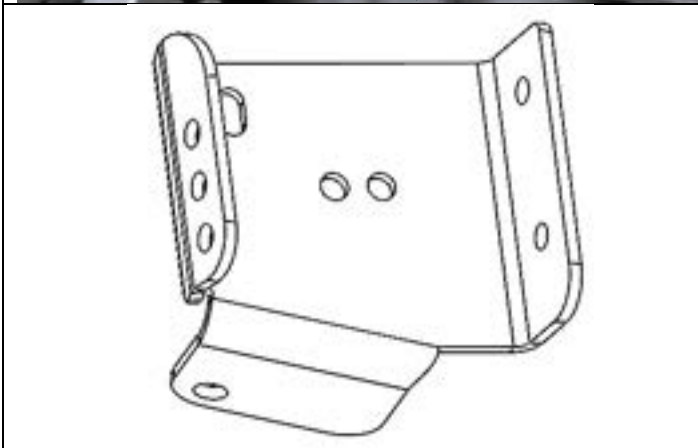


43. Using the two M6 bolts removed in step 40. along with two M6 FL nuts, Refit the tube bracket to the mount.
44. Torque to specification.

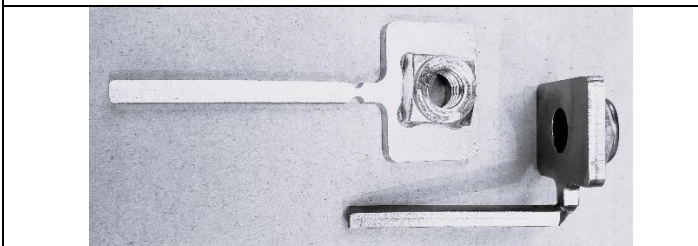
 M6 - 9 Nm.



45. Remove the sway bar link nut and move the link out of the way.
46. Remove the two bolts for the sway bar mount and set the bolts aside for later, bracket is discarded.
47. Remove the plastic cap from the chassis and discard.



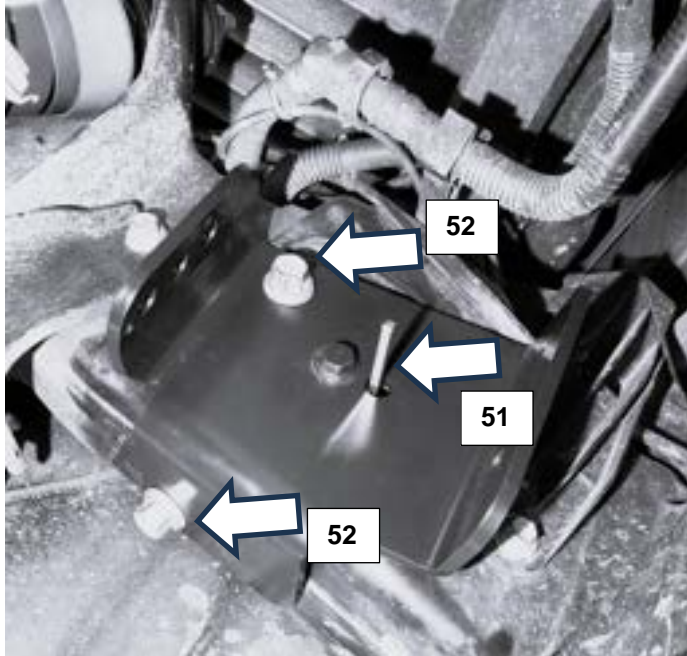
48. The RHS Front chassis swaybar link is fitted with two bolts removed in step 46. with one M10x30 FL bolt and one M10 nut stick.



49. Bend the M10 nut stick as shown, the tail bends away from the nut side.




50. Place the bent nut stick into the access hole in the chassis and rotate as shown.




51. While holding the nut stick tail, lift the mount place the tail through the hole provided. Install the M10x30 FL bolt into the nut stick and leave loose.
52. Refit the two factory bolts in the side and bottom of the chassis.

Torque to specification.

 M10 - 44 Nm.


FACTORY BOLTS

 M12 - 96 Nm.



53. Fit the Front linking channel with four M10x30 FL bolts and four M10 nuts.
54. Refit the sway bar link to the mount, (the top hole is the original position) the next two holes are for custom sway bar tension.

Torque to specification.

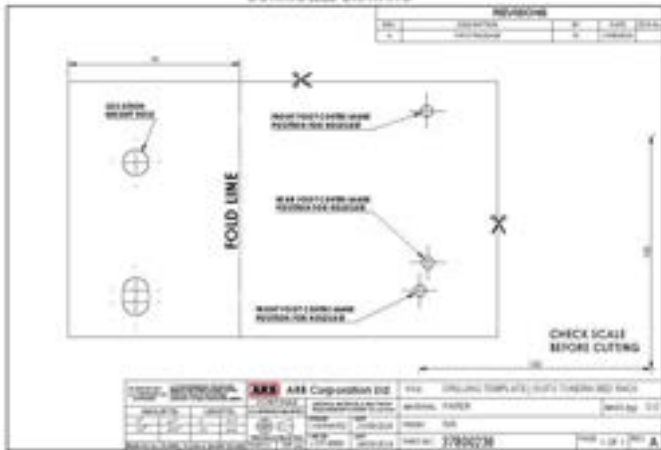
 M10 - 44 Nm.

SWAY BAR NUT  M12 - 75 Nm.

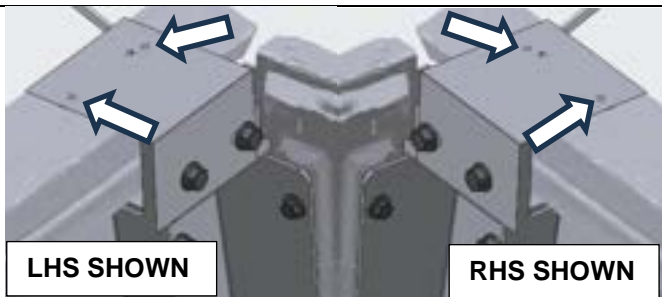


55. For the LHS fitment, repeat steps 31 through to 54 without steps 40 and 43.

CONTROLLED DRAWING



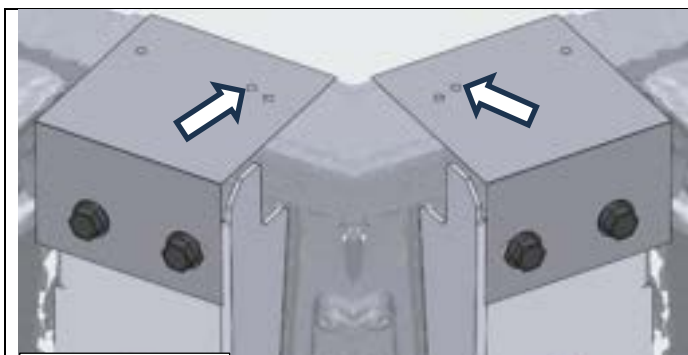







56. Retrieve the drilling template and check the scale.
57. Cut out the template and fold.



LHS SHOWN

RHS SHOWN

58. Using the template, align to the front RHS mount and mark the positions for drilling.
59. Reverse the fold on the template and repeat for the LHS.

 <p>LHS SHOWN</p> <p>RHS SHOWN</p>	<p>60. Fit the template to the rear RHS mount and mark the position for drilling.</p> <p>61. Reverse the fold on the template and repeat for the LHS.</p>
	<p>62. On both front corners use the Ø22.0mm hole saw and drill through the plastic tub cap and the sheet metal tub below. Mark the composite tub below with the pilot drill, then use a Ø10.5mm drill to clearance the plastic.</p> <div style="display: flex; justify-content: space-around;">   </div> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> <p>WARNING: Drilling & Cutting operations can result in flying debris. Eye and ear safety protection should be worn.</p> </div>
	<p>63. For both rear corners, use the Ø22.0mm hole saw just through the plastic tub cap.</p> <div style="display: flex; justify-content: center; margin: 20px 0;">   </div> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> <p>WARNING: Drilling & Cutting operations can result in flying debris. Eye and ear safety protection should be worn.</p> </div>
	<p>64. Debur all drilled holes and paint raw steel edges to prevent corrosion.</p>

65. On both sides, fit two 6253444 spacers into the front holes in the tub cap and one 6253445 into the rear.



FRAME FITMENT

66. Identify the RHS as shown.



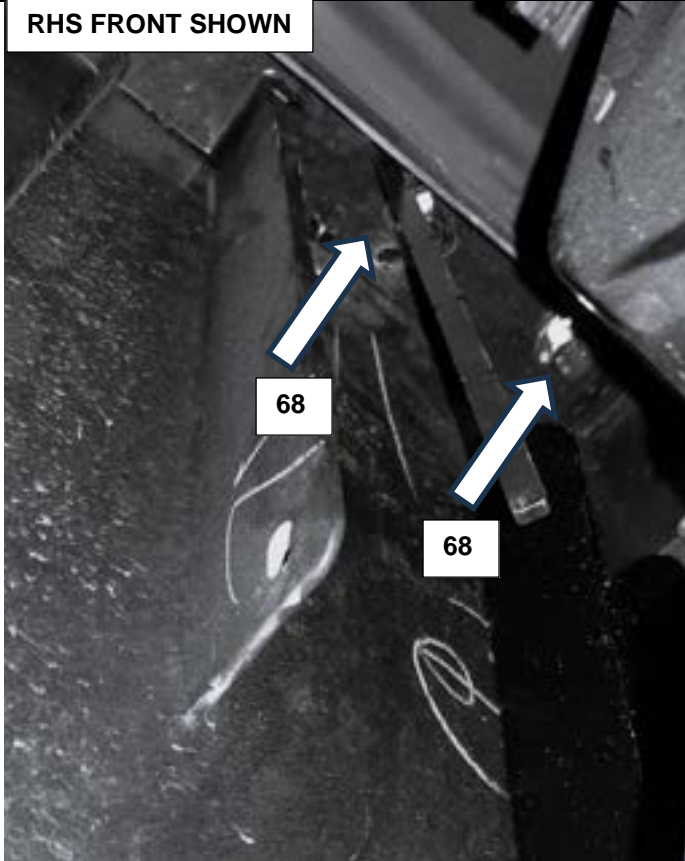
67. Carefully place Bed Rack Frames onto the mounts and fit four M10 x 30 FL bolts at the front and rear to support the frame.



68. Retrieve the two remaining M8 nuts sticks and bend up in the view, to 90° at the first segment.

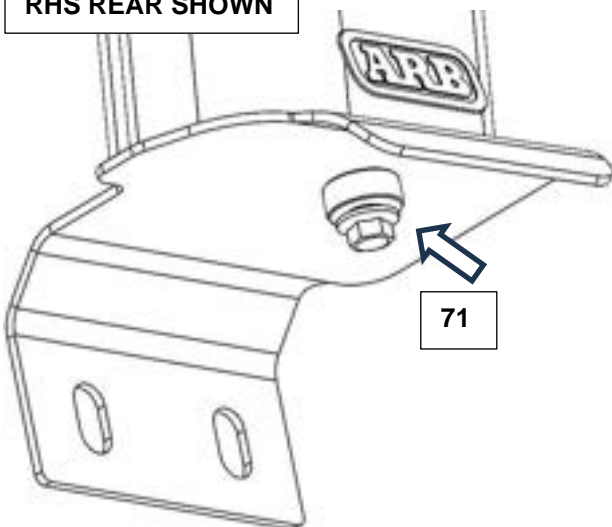


RHS FRONT SHOWN




69. Use an M8x50 FL bolt to fit the M8 nut stick to the bottom of the tub.
70. Fit an M10x50 bolt and washer up into the Bed Rack frame.


RHS REAR SHOWN



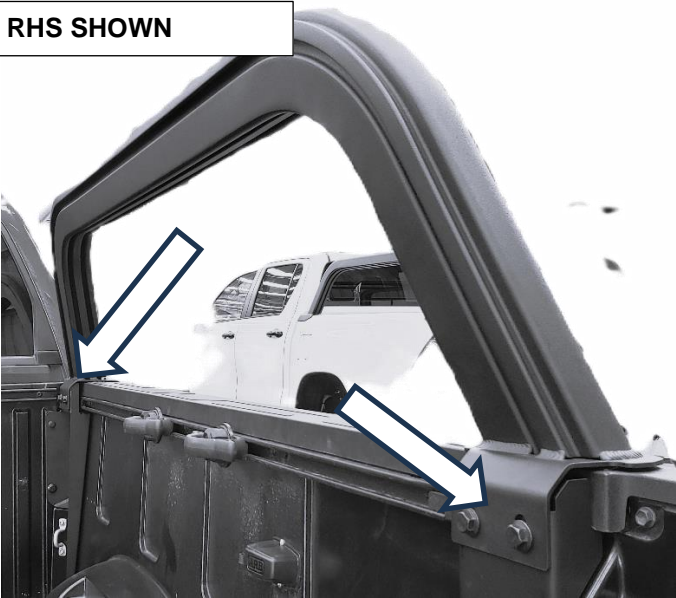
71. Behind the tail light fit an M8x30 FL up into the Bed Rack frame.

Torque these three fasteners to specification.


 M8 - 22 Nm.

 M10 - 44 Nm.

RHS SHOWN



72. Torque the four M10 fasteners to specification.

 M10 - 44 Nm.

73. Repeat steps 66 to 72 for LHS frame fitment.



74. Refit both taillights removed in step 1 along with the front tie down points.

75. Continue with mounting of selected BED RACK accessories.

FITTED PRODUCT WITH SIDE CHANNEL SHOWN

