

INSTALLATION INSTRUCTIONS

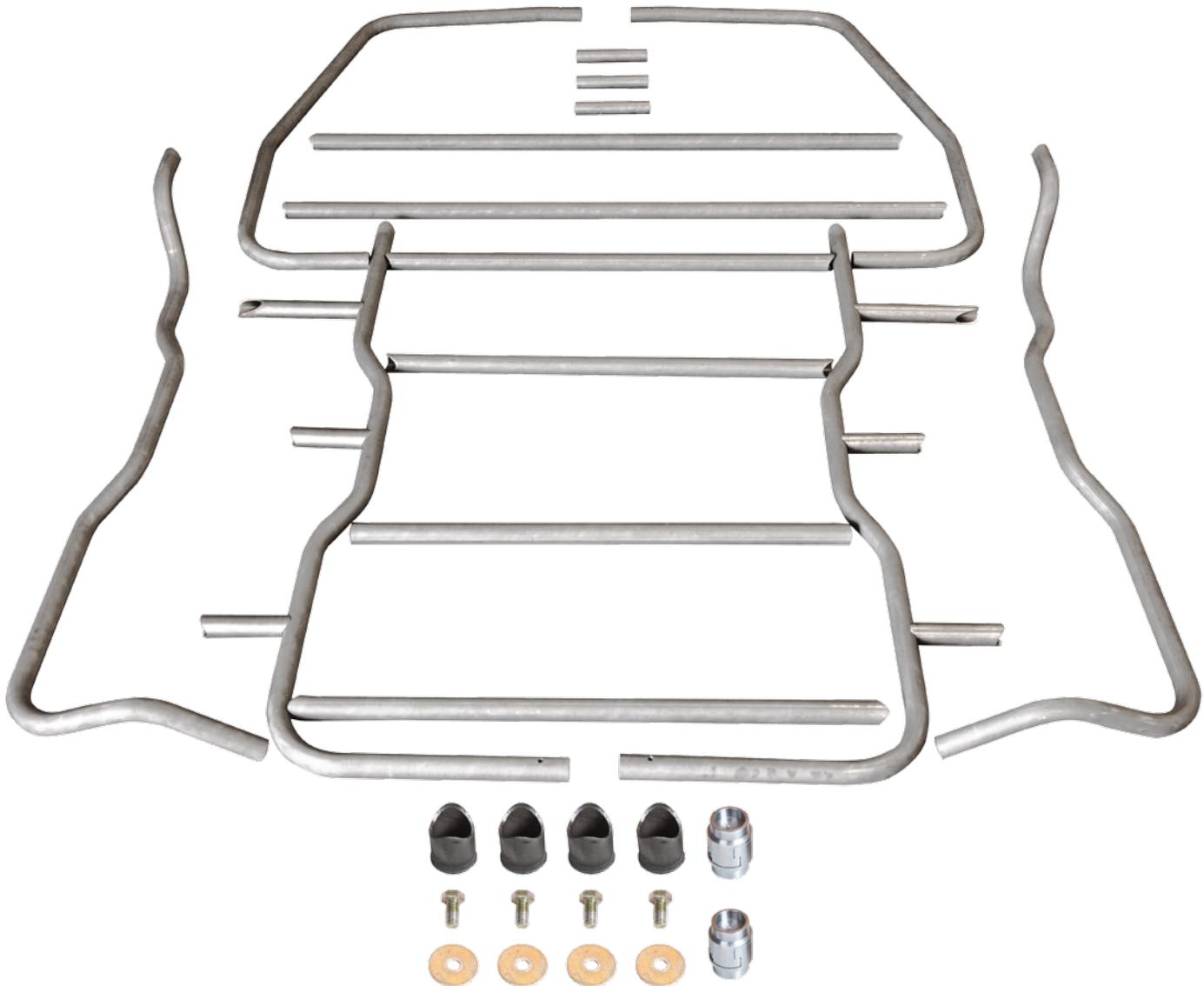


FLATBED KIT

300721-KIT (TACOMA 1995-2004)

301047-KIT (HILUX 1984-1995)

KIT CONTENTS





RECOMMENDED TOOLS

Welder

Level

Tape Measure

Ratchet Straps

Clamps

Square

Grinder with Grinding Wheel, and Cutoff Wheel

Sockets 11/16", 3/4", 10mm, 12mm

1/4" Allen Wrench / Socket

CAUTION

1. Read all instructions completely and carefully before you begin.
2. Check to make sure the kit is complete and that no parts are missing (refer to the Kit Contents List on the first page of these instructions). If anything is missing, please contact Trail-Gear at 559.252.4950.
3. Park vehicle on a clean, dry, flat, level surface and block the tires so the vehicle can not roll in either direction.

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NOTES:

1. This kit is not for novice welders. Minor fabrication and welding skills will be necessary. Some grinding to improve fitment may be required.
2. This kit requires cutting off the back of your frame.
3. The Tacoma Test vehicle was already equipped with the Tacoma Rear Frame Box Kit (part #120165-1-KIT). Reinforcing the frame will be required, but is not covered in these instructions.
4. It is highly recommended that as you proceed through these instructions, you only tack tubes in place until all parts are assembled.

STEP 1

Remove bed, and bumper from truck.



STEP 1 CONTINUED



STEP 2

Hilux only: Front most bed mount must be cut off, and frame ground smooth. If you want this kit to be a true bolt on / bolt off bed drilling out the remaining bed mount holes to 1" will be required. Otherwise you can weld frame mounts directly to mount locations.



STEP 3

Pickup Only: Install flatbed frame mounts. Don't tighten them all the way. Keeping them a little loose will help with aligning the flatbed.



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STEP 4

Install lower flatbed tubes using provided 1.5" x 8" tube sleeve to connect each side. Measure 4" to center of sleeve to insure equal engagement. Locate lower flatbed tubes by measuring approximately 8" from notch to the center of frame mount on the Tacomas and approximately 10.25" on Hilux models.



STEP 5

Install Flatbed cross support tubes.

STEP 6

Install Upper Bed Tubes and the 4 rear most vertical supports.



STEP 7

Strap Mid Support tube and use level to confirm Location of Front Support Tubes. Front Support Tube should mount in line with Frame Mounts. Center Mid Support Tube and tack into place, making sure the notches are oriented vertically.

STEP 8

Connect Headache rack using 1.5" x 8" sleeves, again marking center of tube at 4" to insure equal engagement. Confirm frame width behind Cab stock measurement should be 41.5" on the Tacoma and 40.75" on Hilux models. Grind mount location to prep for weld-



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STEP 8 CONTINUED

Grind mount location to prep for welding. **Note:** Our test vehicle had rock sliders previously installed; as such, we cut an additional 3/16" (thickness of bracket) off of each side of the headache rack to compensate.



STEP 9

Install headache rack, and Lower Cross support tube.



STEP 10

At this point your progress should look close to this. You can now weld up your flatbed kit. **Note:** Do not weld headache rack to frame yet.



STEP 11

Mark Desired tube clamp location, and cut legs off of headache rack.



STEP 12

Mark and cut an additional 1 5/8" from tubing



STEP 13

Install tube clamp as shown, clamp bolts should be verticle and finish welding removal of flatbed bolts will be required.



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STEP 14

With mounting bolts tight, weld all accessible joints. Allow flatbed to cool, remove bed and weld remaining joints slowly to prevent warping. Your kit is complete.



FINISHING TOUCHES

We finished off our flatbed with a 1/8" Aluminum Deck, and 1/16" Aluminum Fenders. We also mounted our Hi-lift Jack Mount, and Power Tank. To finish off the rear of the frame, we installed a Tacoma Universal Rear Bumper Kit (part #300978-KIT).



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SERVICE PARTS

300721-KIT (TACOMA 1995-2004)

301047-KIT (HILUX 1984-1995)

NO.	PART NUMBER	QTY.
1	300726	4
2	300716	2
3	300713	2
4	300715	1
5	300719	4
6	300720	1
7	300730	1
8	300765	2
9	300717	2
10	300718	2
11	300714	1
12	300768	2

