

Section I - Installation Preparation

Part Number: PT329-34100

PT329-34040 (Tundra D-cab)

Section I - Installation Preparation

Kit Contents

Item #	Quantity Req'd.	Description
1	1	Curved Tube Assembly - Right
2	1	Curved Tube Assembly - Left
3	3	Center Tube
4	1	Hardware Bag
5	1	Right Bracket Assembly (Tundra D-cab only)
6	1	Left Bracket Assembly (Tundra D-cab only)

Hardware Bag Contents

Item #	Quantity Req'd.	Description
1	6	Thin Wedge
2	6	Thick Wedge
3	6	PT Screw
4	4	M8 x 25 Torx Head Bolt (Tundra D-cab only)
5	2	Anti-Chip Tape (Tundra D-cab only)

Additional Items Required For Installation

Item #	Quantity Req'd.	Description
1	1	PT329-35101-Tacoma Bracket Kit
2	1	PT329-34101-Tundra Bracket Kit (not required for D-cab)

Conflicts

Note: Bed Mat

Recommended Tools

Safety Tools	
Safety Glasses	
Special Tools	
None	
Installation Tools	
Tape Measure	
Torque Wrench	For Torx and Philips Bits
Rubber Mallet	Small
Screwdriver	Torx T-20
For Tundra	
Screwdriver	Torx T-40
Hex Key	4 mm (not required for D-cab)

For Tacoma	
Screwdriver	Philips, #3
T-handled Driver	
Utility Knife	For pre-MY2000 only.
Special Chemicals	
Cleaner	3M™ Prep Solvent-70

General Applicability






PT329-34100:-
 Tacoma - Short and long bed, MY1997 to present.
 Tundra - Short and long bed, MY2000 to present.
 PT329-34040:-
 Tundra - D-cab, MY2004 to present.

Recommended Sequence of Application

Item #	Accessory
1	
2	
3	

*Mandatory

Legend

	STOP: Damage to the vehicle may occur. Do not proceed until process has been complied with.
	OPERATOR SAFETY: Use caution to avoid risk of injury.
	CRITICAL PROCESS: Proceed with caution to ensure a quality installation.
	GENERAL PROCESS: This highlights specific processes to ensure a quality installation.
	TOOLS & EQUIPMENT: Calls out the specific tools and equipment recommended for this process.

Section II - Installation Procedure

A. Install Mounting Brackets.

NOT REQUIRED FOR TUNDRA D-CAB VEHICLES. (Step A. 1.)

1. If bedliner is installed, use a #3 Philips Screwdriver to loosen the bedliner bolts nearest to the tailgate.

NOTE: Some bedliners are mounted using T-20 Torx bolts, and some (under-the-rail) have no hardware.



2. Using the appropriate tool (T-40 Torx or #3 Philips), remove the two bolts that attach the right (passenger side) cargo tie-down loop to the body (Fig. A-1).
 - i. Discard the old bolts.

NOT REQUIRED FOR TUNDRA D-CAB VEHICLES. (Step A. 3.)

3. While flexing the bedliner (if applicable) to allow a sufficient gap (not to exceed 154 mm or 6 in.) between bedliner and truck bed, position the mounting bracket onto the truck bed (Fig. A-2).
 - i. The mounting section of bracket will be positioned underneath the bedliner while the pivot section will be on top of the bedliner. (Fig. A-2).

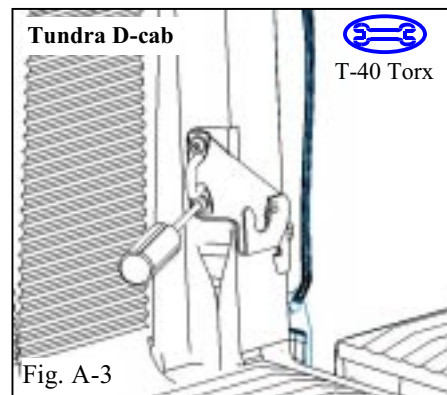
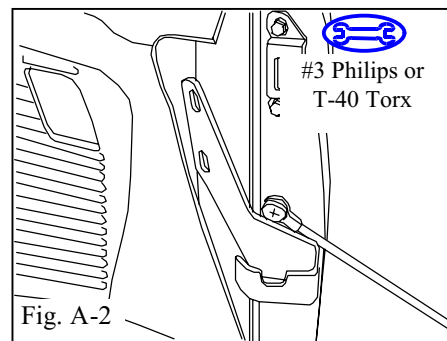
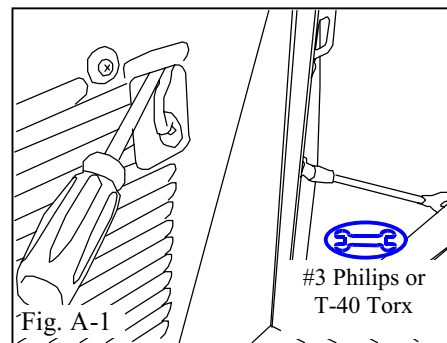


- ii. Be careful not to scratch the vehicle.

TUNDRA D-CAB VEHICLES ONLY.
(Step A. 4.)

4. Position the mounting bracket onto the truck bed. (Fig. A-3).

- i. If equipped with bedliner, mounting bracket lies on top of bedliner.
- ii. Be careful not to scratch the vehicle.



Section II - Installation Procedure

5. Using the appropriate tool (T-40 Torx or #3 Philips), bolt down mounting bracket using OE tie-down loop and the provided bolts. (Fig.s A-3 & A-4).

- i. Tighten fasteners to following torque.
Tundra: 17.5 N-m (156 lbf-in.)
Tacoma: 11.5 N-m (102 lbf-in.)



- ii. The slotted mounting holes to the bracket allow an adjustment to the height of the bracket, high for trucks with a bedliner and low for trucks without (Fig. A-5).

6. Retighten the bedliner bolts (if applicable) that were loosened in Step A. 1..

7. Repeat procedure (Steps A. 2. to A. 6.) for the left (driver's side) cargo tie-down loop and the left mounting bracket.

B. Minor Modification for Pre-MY2000 - Tacoma.

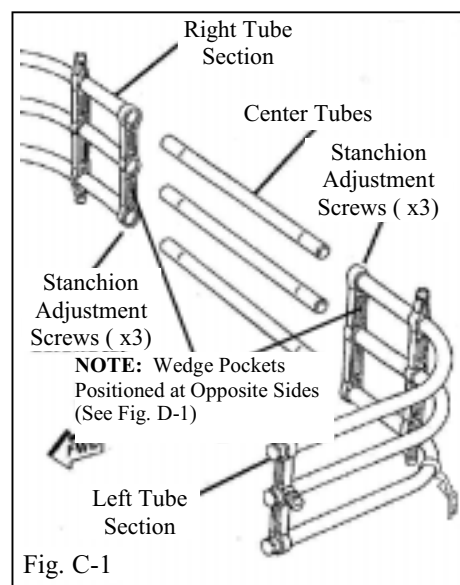
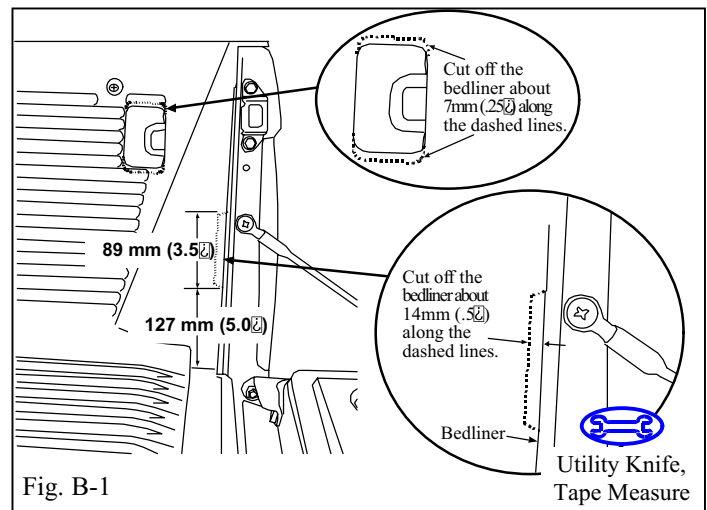
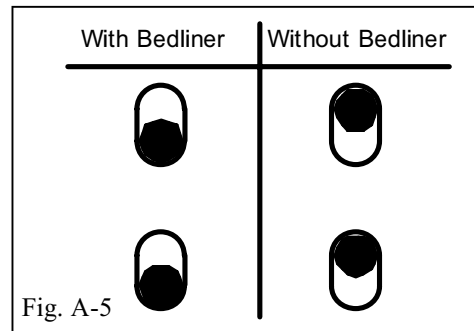
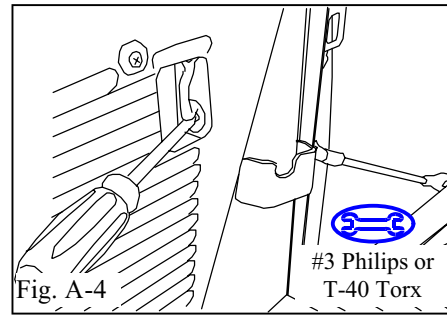
NOTE: If a Pre-MY2000 Bedliner is used, some minor modifications will be required to the Bedliner prior to installing the Bed Extender Brackets.

- 1. The bedliner should be cut with an utility knife as shown in Fig. B-1, to allow for proper clearance for installing the Bed Extender Brackets.

C. Assemble and Install Bed Extender.

- 1. Loosely join the center tubes to the right tube section, then the left tube section, as shown, beyond the non-powder coated sections (Fig. C-1).

- i. Do not allow bare metal to be exposed.



Section II - Installation Procedure

2. Adjust the bed extender assembly width by sliding the right/left tube sections in or out on the center tubes so that the assembly can drop down vertically into the mounting brackets as shown in Fig. C-2.



- i. Make sure that the two straps are facing rearward.

D. Positioning of Center Tube Stanchions.

1. Rotate the assembly onto the open tailgate.

NOTE: It is normal for the Bed Extender to have some resistance, when first rotated in the bracket.

2. Move the right center stanchion over the right tube section by tapping with a rubber mallet.
 - i. Be careful not to scratch the center tubes.



- ii. Excessive force may damage extender and/or vehicle.

3. Insert wedges into the three (3) wedge pockets of stanchion on both sides of the each stanchion (Fig. D-1).



- i. The thinner wedges face the center of the Bed Extender.

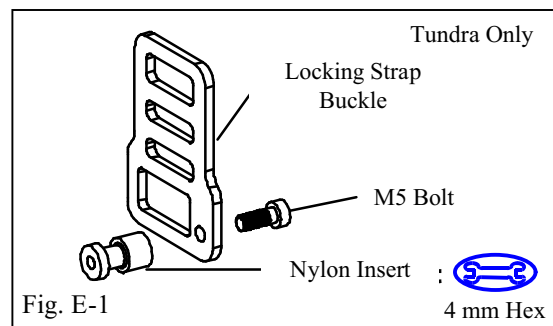
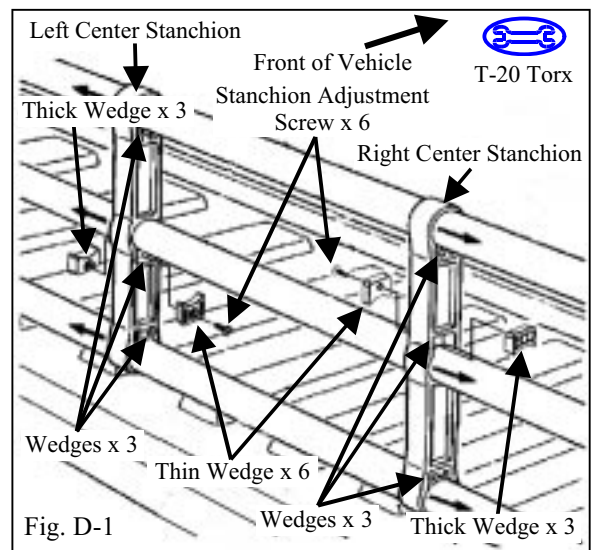
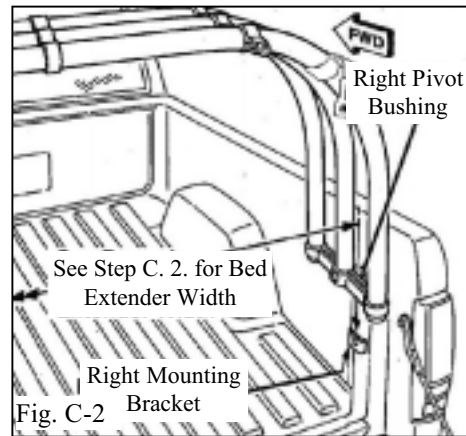
4. Insert three (3) stanchion adjustment screws from center of Bed Extender.
5. With a T-20 Torx wrench, tighten the three (3) screws after stanchion is securely in place to 2.3 N-m (20 lbf-in.).
6. Repeat steps D. 2. through D. 5. for the other (left) center stanchion.

E. Adjustment of Locking Straps.

FOR TUNDRA VEHICLES ONLY.
(Steps E. 1. and E. 2.)



1. Attach nylon insert to locking strap buckle with M5 bolt, nylon insert facing inward (2.3 N-m or 20 lbf-in.). (Fig. E-1)



Section II - Installation Procedure

2. Install Anti-Chip Tape onto tailgate latch area as shown in Fig. E-2.
 - i. Clean surface before installing Anti-Chip Tape using 3M™ Prep Solvent-70.
 - ii. When cleaning with 3M™ Prep Solvent-70 follow the manufacturer's directions. Do not allow cleaner to air dry.



3. Adjust strap length and position, in order to allow locking strap buckles to lock into tailgate.



- i. When the Extender is in the inward position, clip the straps onto the Strap Latch Retainer as shown in Fig. E-3. This will prevent the buckles from rattling.

F. Operation of Quick Latch Brackets (Tundra D-cab Only)

Tundra D-cab Bed Extender can be installed and removed in two (2) positions.

Horizontal

1. To install the Bed Extender in the horizontal position.
 - i. With Bed Extender in the horizontal position, place pivots on top of mounting brackets.
 - ii. Push down on stanchions until Bed Extender locks into place on both sides (Fig F-1).



- iii. Check to see if Bed Extender is securely in place by pulling up on stanchions.

2. To remove Bed Extender in horizontal position.
 - i. Pull on Quick Latch lever until it stops (Fig F-2)
 - ii. Lift up on stanchion until pivot is out of mounting bracket (Fig F-1).

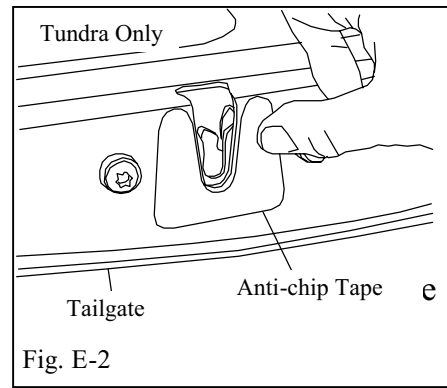


Fig. E-2

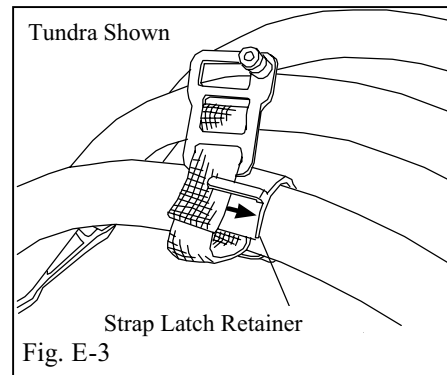


Fig. E-3

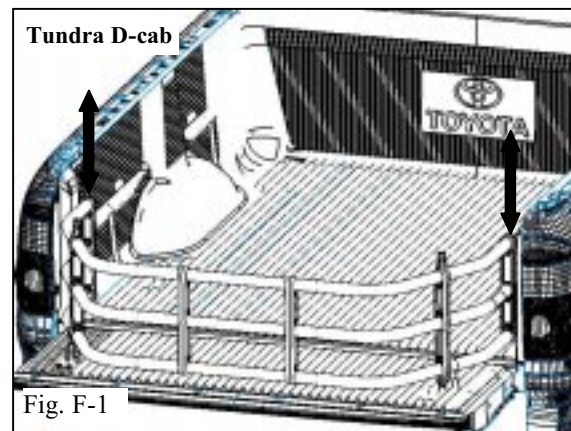


Fig. F-1

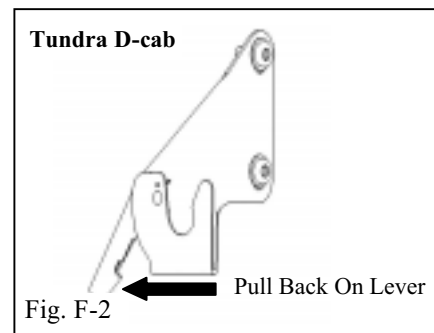
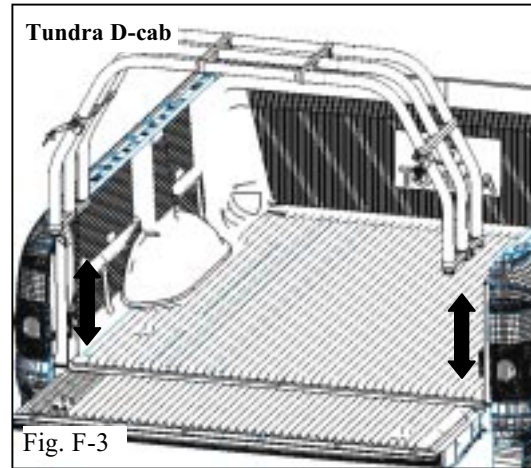


Fig. F-2

iii. Repeat for other side.

Vertical

- 3. To install Bed Extender in vertical position.
 - i. With Bed Extender in the vertical position, slide pivots into mounting brackets (Fig. F-3).
 - ii. Rotate Bed Extender to horizontal position.
- 4. To remove Bed Extender in vertical position.
 - i. Rotate Bed Extender from horizontal to vertical
 - ii. Lift up on Bed Extender and slide pivots out of mounting bracket (Fig. F-3).



Section III - Functional Verifications

Check: _____

- Bed extender adjustment.
- Tailgate strap adjustment.
- Torque adjustment of stanchion screws.
- Torque adjustment of bracket mounting bolts.
- Upright foot positioning on tailgate.

Look For: _____

Bed extender pivot point must rest in mounting brackets.

Tailgate straps must be able to lock into tailgate locks.

Stanchion screws must be tightened to 2.3 N-m (20 lbf-in.).

Bracket mounting bolts must be tightened to:

Tundra: 17.5 N-m (156 lbf-in.)

Tacoma: 11.5 N-m (102 lbf-in.)

Ensure that upright feet sit properly on tailgate edge