



**INSTALLATION MANUAL**  
**TOYOTA TACOMA OVERLANDING RACK**  
**PRODUCT NUMBER: TTOR-01**  
**APPLICATION: 2016+ TOYOTA TACOMA**



## **IMPORTANT SAFETY GUIDE** | Your safety and the safety of others is very important.

In order to help you make informed decisions about safety, we have provided the following warnings, safety precautions, installation instructions, and other important information to alert you to potential hazards that could hurt you or others.

Please do a job safety analysis before each task to identify potential hazards for your situation and remove/protect against them. Use own good judgment and take your time.

Check packaged materials immediately upon arrival to ensure that all listed parts are included and undamaged.

**Read and understand all warnings, safety precautions, and instructions before installing this product.**

**SENSORS FIELD OF VIEW MAY BE ALTERED WITH USE OF THE REPLACEMENT BUMPER.**

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### **WARNINGS**

- Failure to observe the following warnings and instructions provided in this manual could lead to severe injury and/or death.
- For professional installation only. Careless installation and/or operation can result in serious injury, death, and/or equipment damage. All liability for installation and use rests with the user or consumer.
- Fab Fours, Inc. only approves installing this product according to these written instructions with the hardware provided. Failure to install according to these instructions will invalidate the warranty. This includes, but is not limited to, using alternative installation methods, hardware, or materials.
- This product is for off road use only.

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### **SAFETY PRECAUTIONS**

- Always remove jewelry and wear eye protection.
- Always use extreme caution when jacking up a vehicle for work. Set emergency brake and use tire blocks. Locate and use the vehicle manufacturers designated lifting points. Use jack stands.
- Always use appropriate and adequate care in lifting components into place.
- Always ensure components will remain secure during installation and operation.
- Always wear safety glasses when installing this kit. A drilling operation will cause flying metal chips. Flying chips can cause serious eye injury.
- Always use extreme caution when drilling a vehicle. Always disconnect power before welding. Thoroughly inspect the area to be drilled (on both sides of material when possible) prior to drilling, and relocate any objects that may be damaged.
- Always use extreme caution when welding a vehicle. Thoroughly inspect the area to be welded (on both sides of material when possible) prior to welding, and relocate any objects that may be a fire hazard. When welding in a cab, make sure the interior surfaces are covered (e.g., welding blanket) and a fire extinguisher is at hand.
- Always use extreme caution when cutting and trimming during fitting.
- Always tighten all nuts and bolts securely per installation instructions.
- Always route electrical cables carefully. Avoid moving parts, components that become hot, and rough or sharp edges.
- Always insulate and protect all exposed wiring and electrical terminals.
- Perform regular inspections and maintenance on mounts and hardware.



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# A MESSAGE FROM THE OWNER

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Fab Fours' was born out of a passion for customizing vehicles and a love of the outdoors. Our engineering team uses the latest 3D design software to turn new product ideas into reality. In our factory, designs come to life with the combination of cutting edge technology for metal cutting and forming and an American workforce that puts its' heart and pride into every product.

From design and manufacturing, to quality and delivery, Fab Fours' mission is to be the market leader for steel truck and jeep accessories. We make sure a quality product is delivered on time, more than expected, better than expected to our customers.

Enjoy your new Fab Fours product. Welcome to the family!

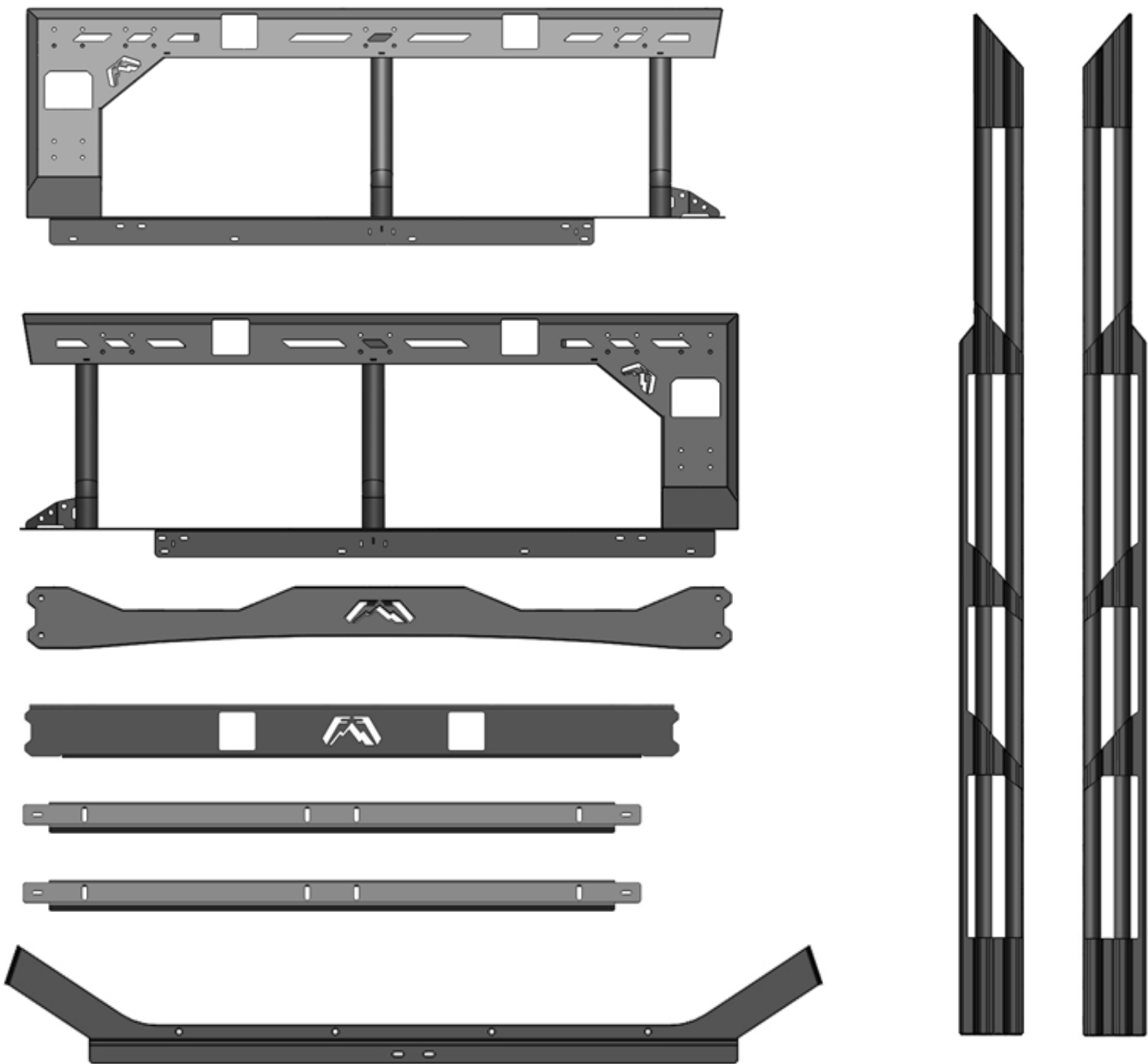
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**FOUNDER, FAB FOURS**

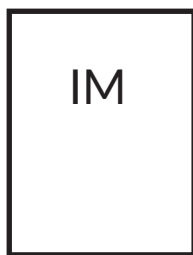
# GETTING STARTED

Before you begin the installation process of your new Fab Fours product, we suggest laying out all materials and parts on a pad or protective surface.

Failure to fully account for all components before beginning installation may leave vehicle immobile until part is acquired. Refer to the next pages as an inventory check.



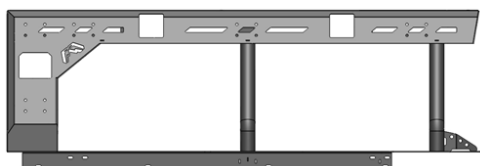
# PROVIDED MATERIALS



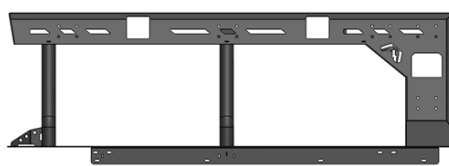
TTOR-01 IM



50224-HW



22154



22155



22158



22159



21960 x3



22156



22157

## HARDWARE KIT | 50224

FAB FOURS IDENTIFICATION	COMPONENT DESCRIPTION	QTY
50224-HW	M6 X 1.0 X 25 Bolt Zinc Steel	10
50224-HW	M6 Flat Washer Zinc Steel	10
50224-HW	M6 Lock Washer Zinc Steel	10
50224-HW	3/8"-16, 1.5" Yellow Zinc Hex Head Bolt, Grade 8	12
50224-HW	3/8"-16, Yellow Zinc Hex Nut, Grade 8	12
50224-HW	3/8" Yellow Zinc Flat Washer, Grade 8	24
50224-HW	3/8" Yellow Zinc Lock Washer, Grade 8	12
50224-HW	5/16"-18, 1" Button Head Bolt, Stainless Steel	26
50224-HW	5/16"-18, Hex Nut, Stainless Steel	26
50224-HW	5/16" Flat Washer, Stainless Steel	52
50224-HW	5/16" Lock Washer, Stainless Steel	26

## TOOLS REQUIRED

- 10mm socket wrench
- 1/2" socket wrench
- 9/16" socket wrench
- 3/16" allen wrench

## ASSISTANCE

We recommend two people perform the installation as items are heavy and may need to be held in place while installing.

## ORGANIZATION

Disassemble the vehicle where you can catalog and store everything. We suggest labeling and bagging all the OEM bolts when removing from the vehicle. Failure to keep track of parts could lead to an inability to properly reinstall components.

# INSTALLATION

*NOTE: Save all OEM parts until installation is complete!*

**1. Carefully remove the plastic rail cover by pulling the front corner to disengage the clips. Work your way down the rail until all clips are free to remove the rail from the truck bed. (Figure-1)**



Figure 1

**2. Take the lower cross stiffener (22161) and loosely install it on the back rail with two (2) M6 bolts with flat/lock washers using a 10mm socket wrench (50224-HW). (Figure-2)**



Figure 2

**3. Install the driver side base assembly (22154) by placing it on the rail and installing four (4) M6 bolts with flat/lock washers using a 10mm socket wrench (50224-HW). Repeat this on the passenger side with the (22155) assembly. (Figure-3)**



Figure 3



**4. Attach the base assemblies (22154 and 22155) to the stiffener (22161) using eight (8) 5/16" bolts flat washers, lock washers and nuts with a 1/2" socket wrench and 3/16" Allen wrench (50224-HW). (Figure-4-5)**



Figure 4



Figure 5

**5. Attach the driver side tube assembly (22156) to the base assembly (22154) using six (6) 3/8" bolts, flat washers, lock washers and nuts using a 9/16" socket wrench (50224-HW). Repeat this step for the passenger side tube assembly (22157). (Figure-6)**

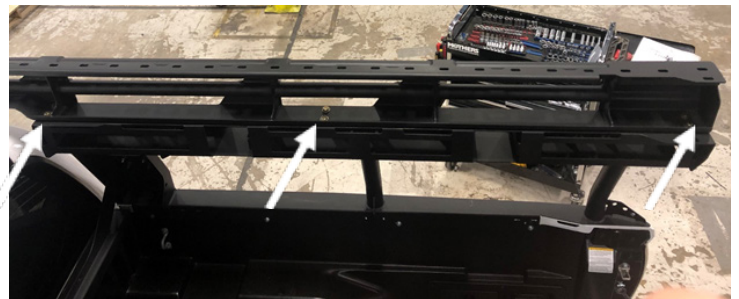


Figure 6



# INSTALLATION

6. Loosely install the rear cross bar (22159) with six (6) 5/16" stainless steel bolts, flat washers, lock washers and nuts using 1/2" socket wrench and 3/16" Allen wrench (50224-HW). (Figure-7)



Figure 7

7. Loosely install the front visor (22158) with six (6) 5/16" stainless steel bolts, flat washers, lock washers and nuts using 1/2" socket wrench and 3/16" Allen wrench (50224-HW). (Figure-8)



Figure 8

8. Install the three (3) crossbars as desired with the remaining stainless steel hardware using 1/2" socket wrench and 3/16" Allen wrench (50224-HW). (Figure-9)

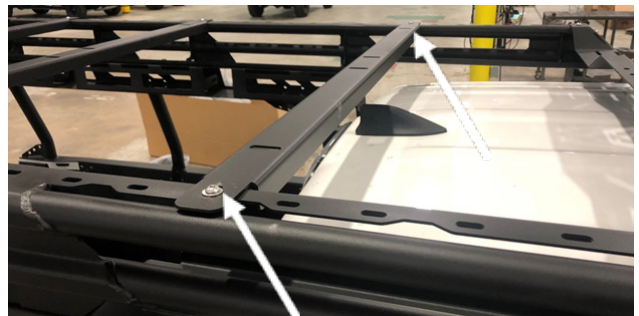


Figure 9

9. Fully tighten all mounting hardware.