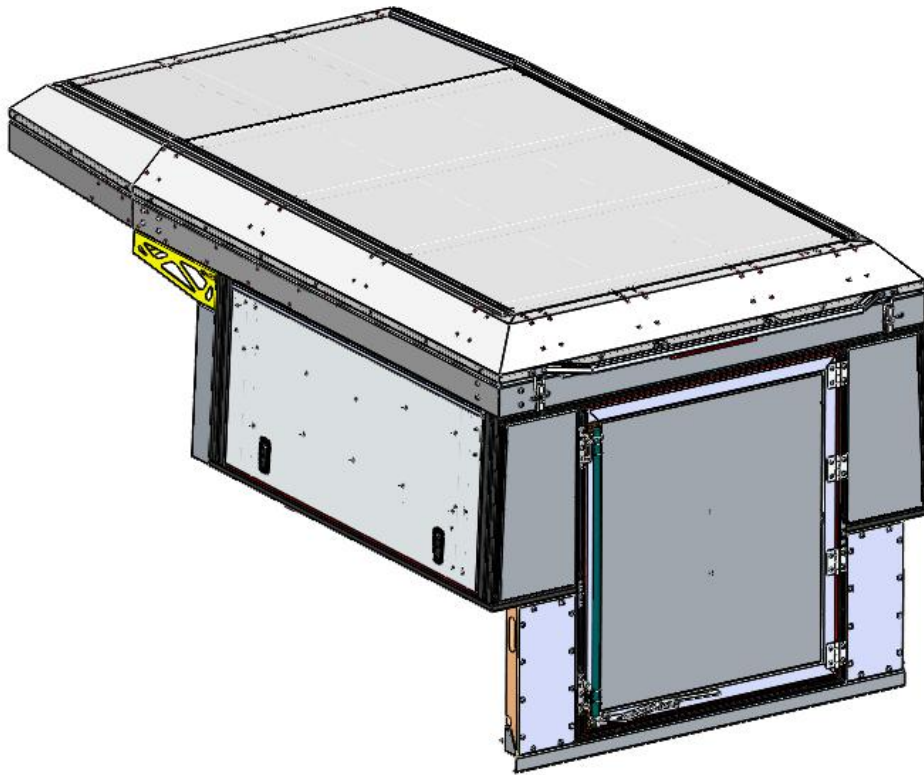


FITMENT INSTRUCTIONS

Alu-Cab™



TOYOTA TACOMA GEN2&3 SB & LB CANOPY CAMPER

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Review all instructions information carefully before installation.

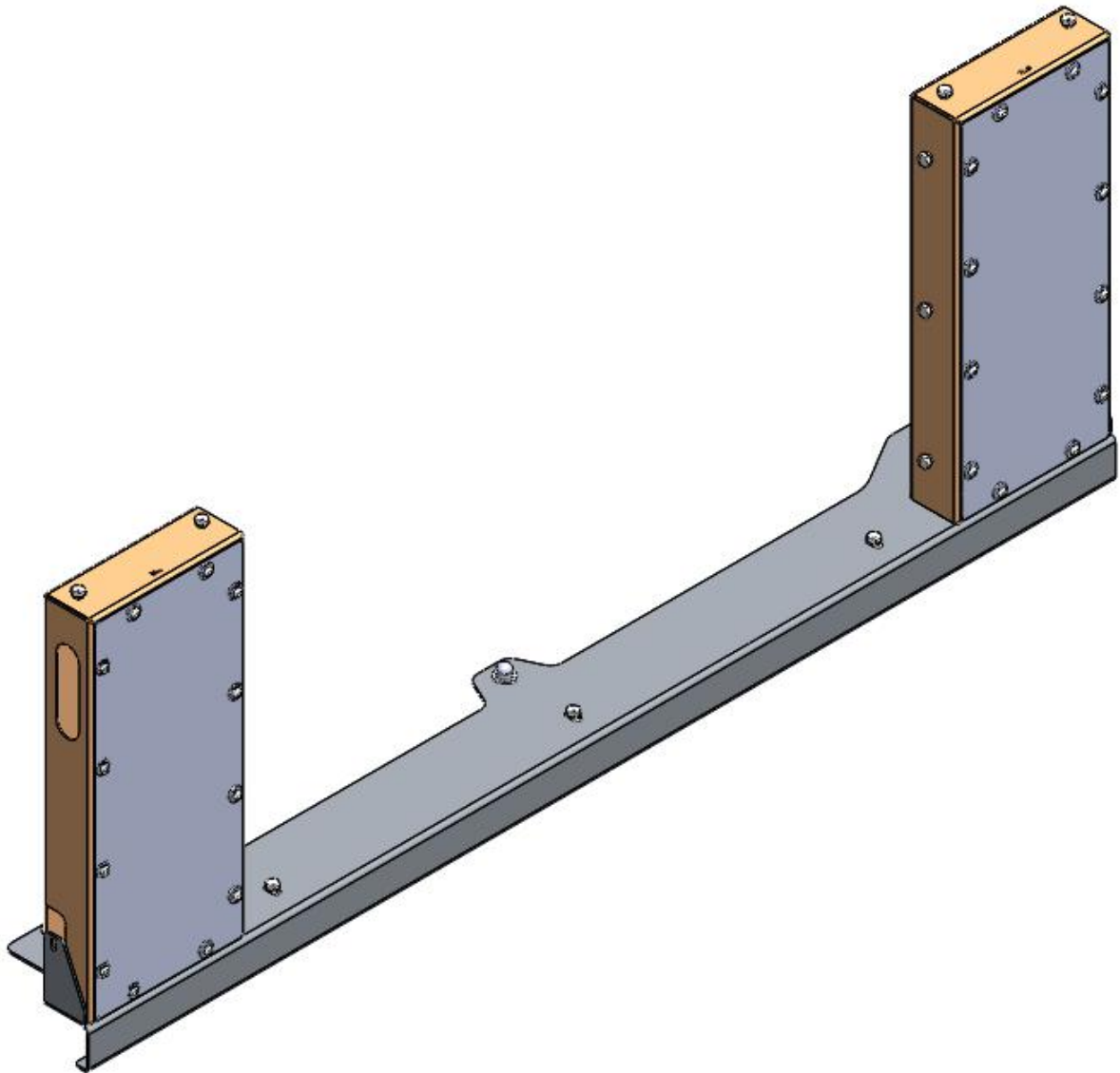
Any damages, direct or incidental to the installer and/or property due to incorrect installation of any parts are the responsibility of the installer. Due to the various applications and fitment options available, the responsibility lies with the user to ensure all mounting points are secure and tight before every trip. If unsure, consult with your Distributor regarding the operations of our products.

Users are advised to be mindful of the load they are carrying and drive in accordance with road conditions.

DISCLAIMER

Alu-Cab

1.Rear filler panel assembly for (GEN2 SB,LB & GEN 3 SB,LB)



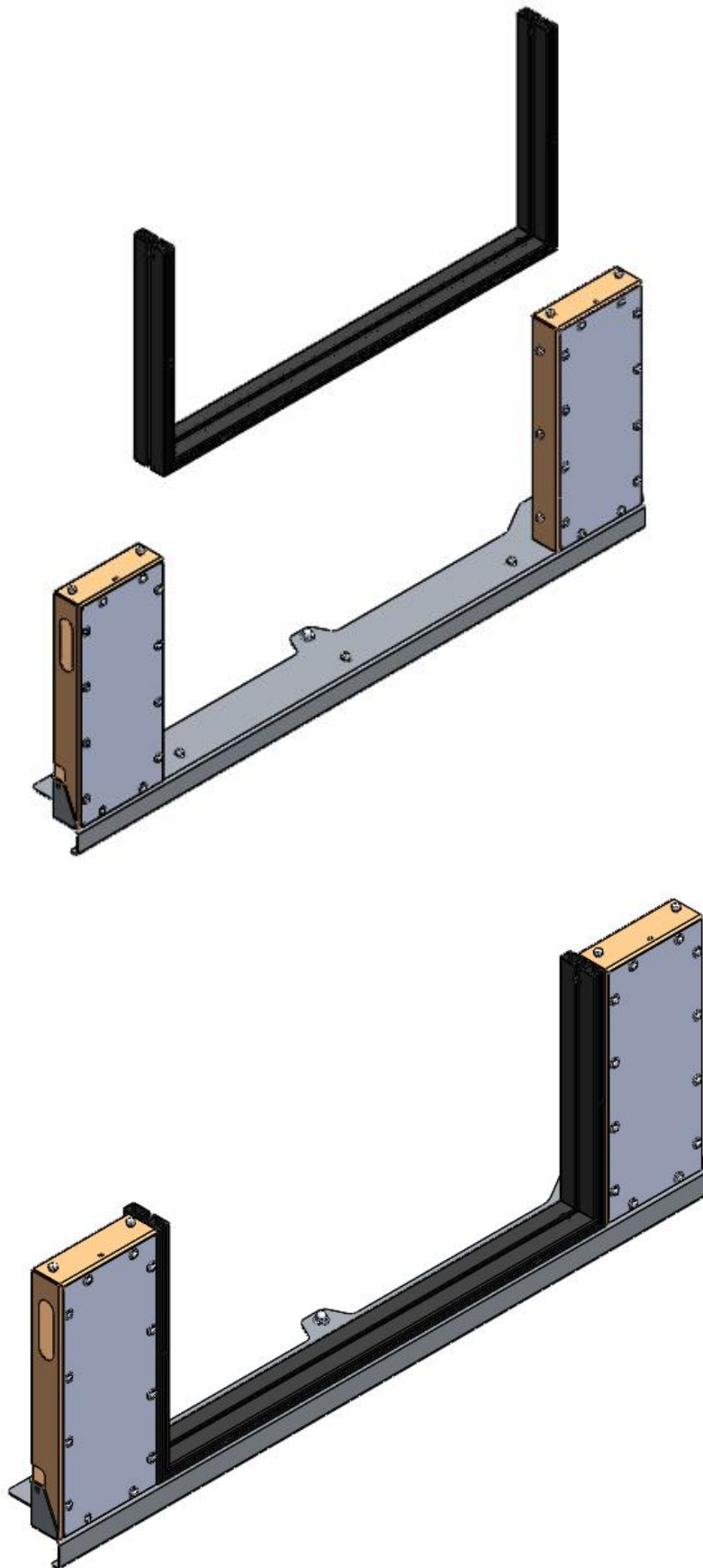
162-TAC-RER-FILLER-KIT-ASSY-01-00



WARNING

Always wear appropriate PPE (Personal protection equipment) when fitting this product. Although the mounting kit is designed to be DIY, if you have any doubts or concerns, contact an accredited fitment centre to carry out the work. Alu-Cab will not be liable for any injury to persons, and/or damage to products and/or vehicles.

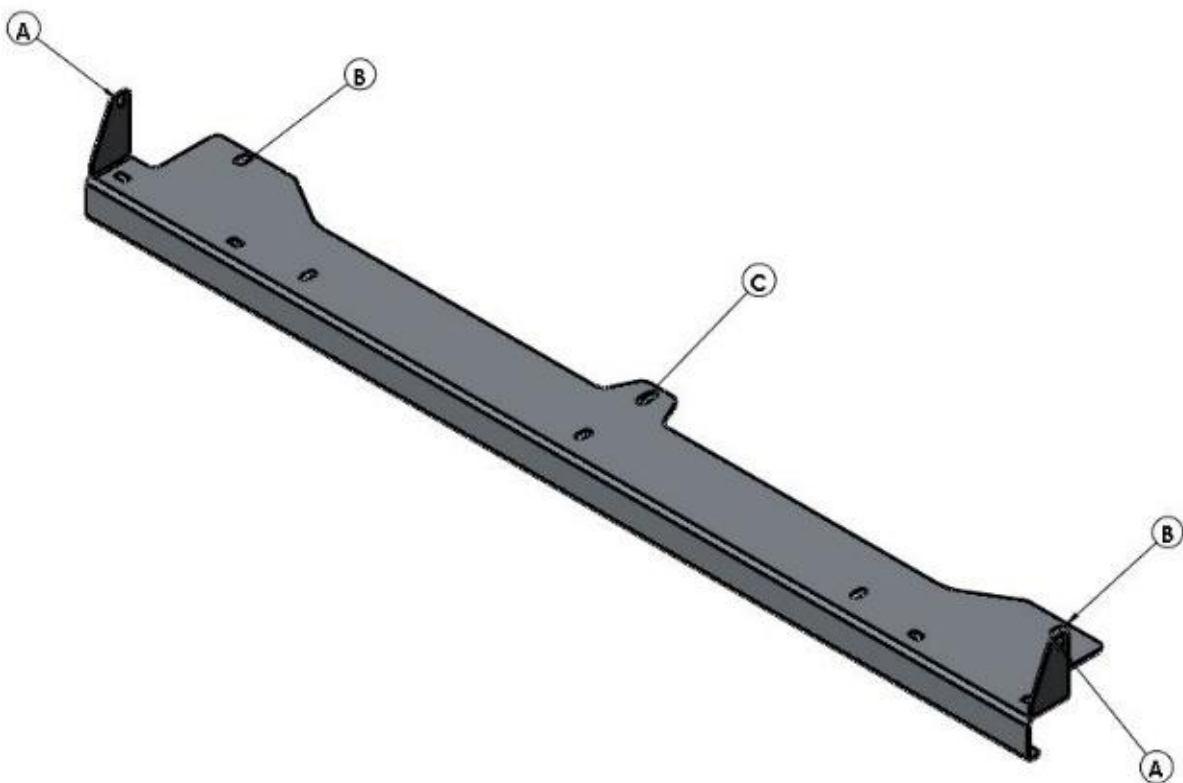
1. Fit lower door frame to filler panel assembly as shown.



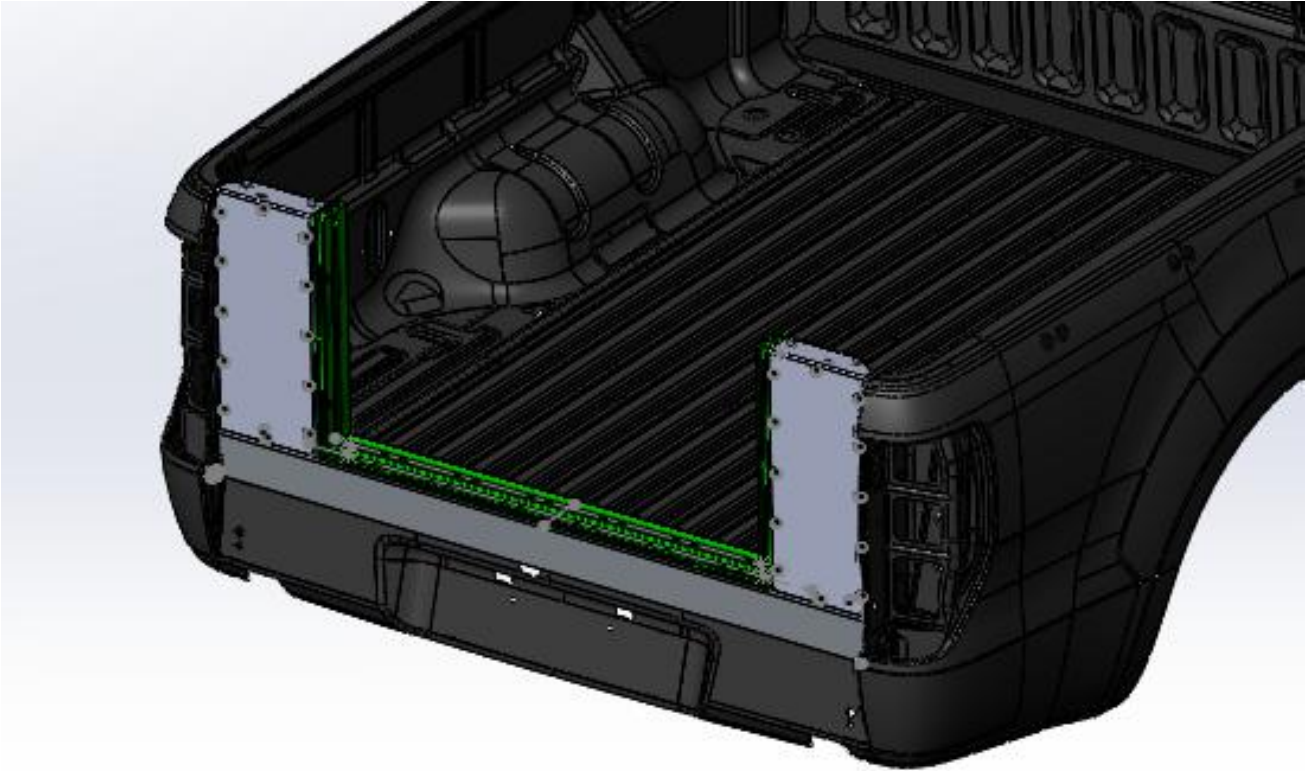
2. Image below indicates the mounting points for rear filler panel assembly.



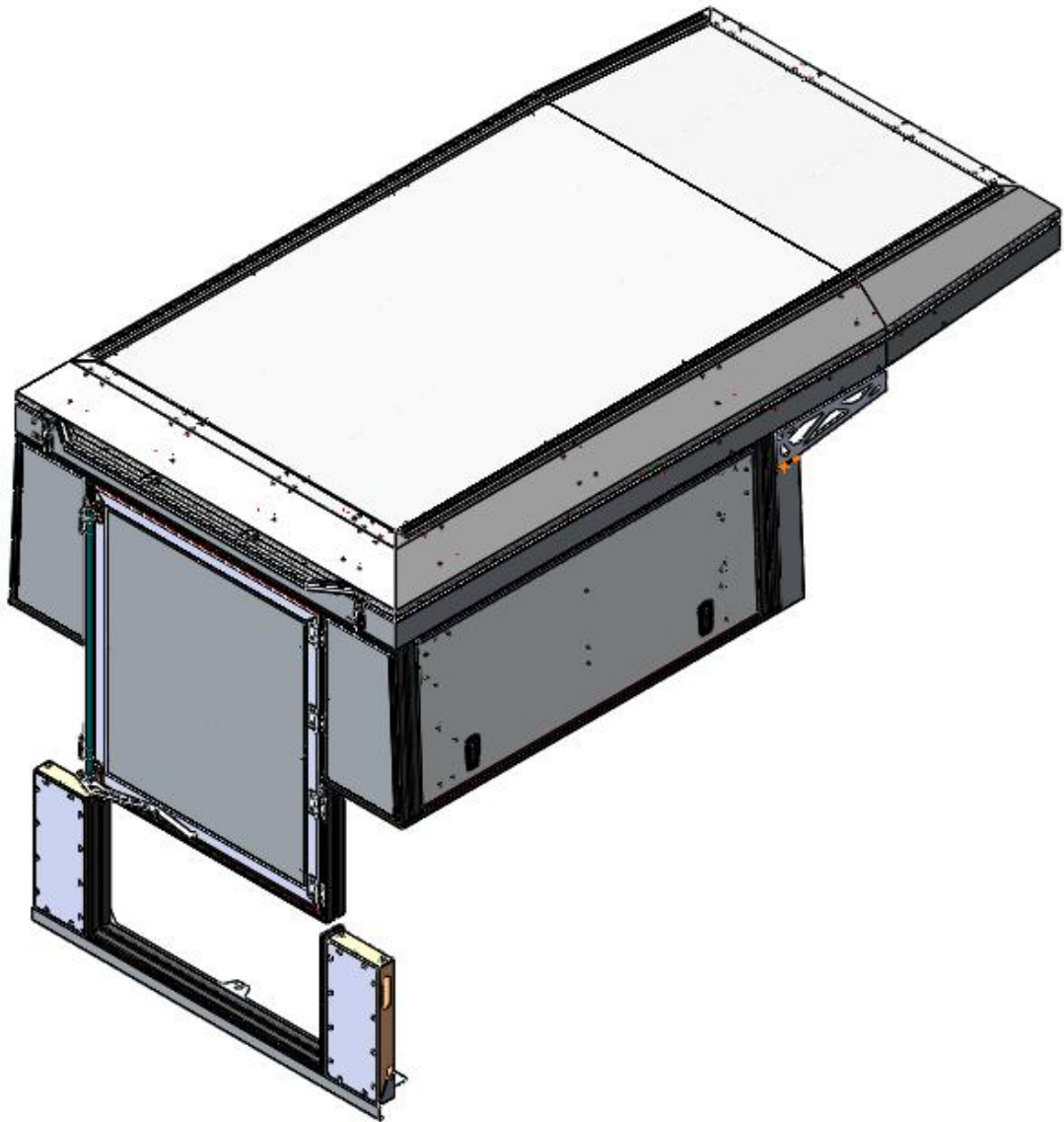
2.1 Point C needs to be drilled through plastic liner to match up with existing hole in load bin.



3. Mount filler panel assembly to load bin as shown.

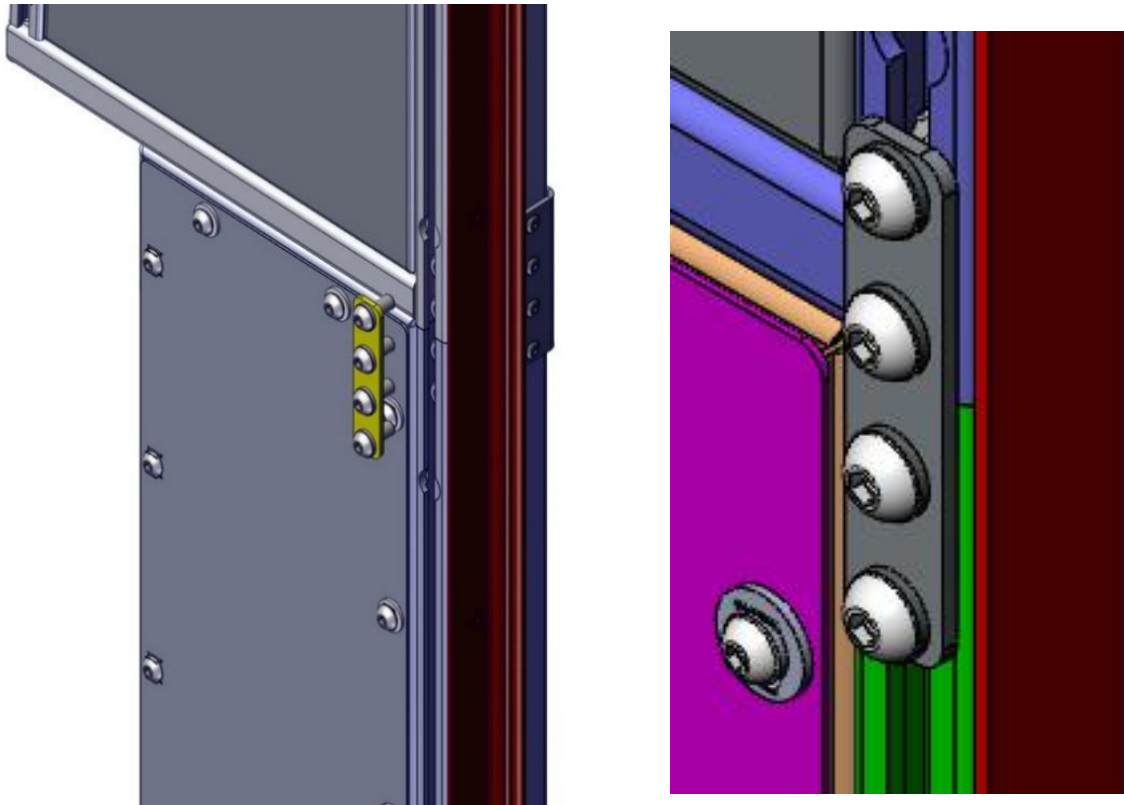


3.1. Then mount canopy camper base unit on top of load bin.

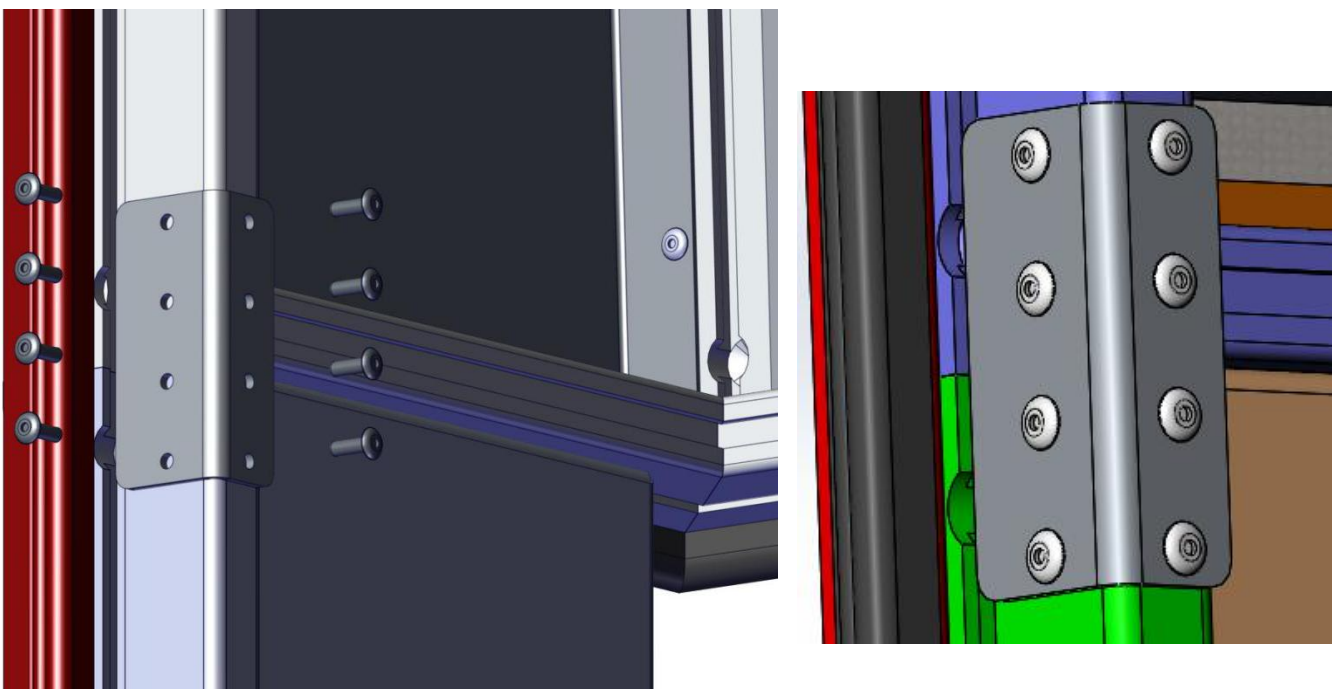


4. Connect rear filler panel assembly and base unit as shown.

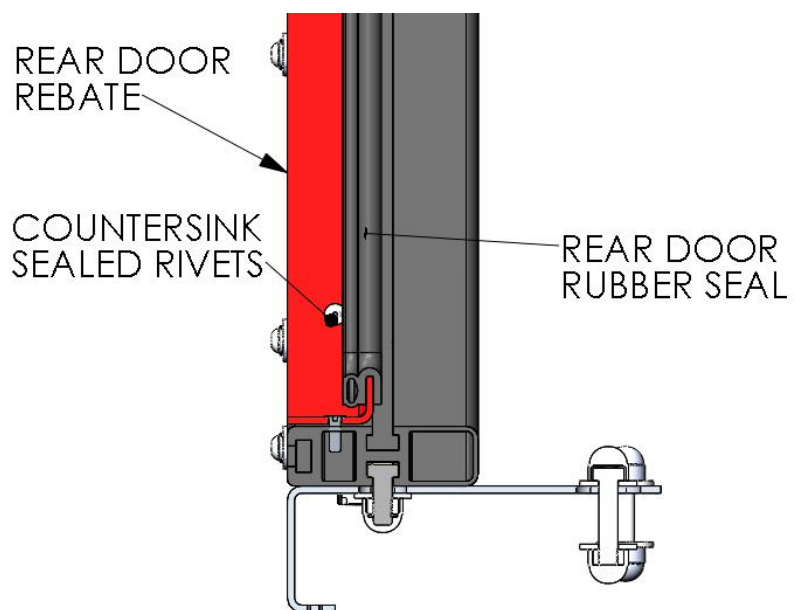
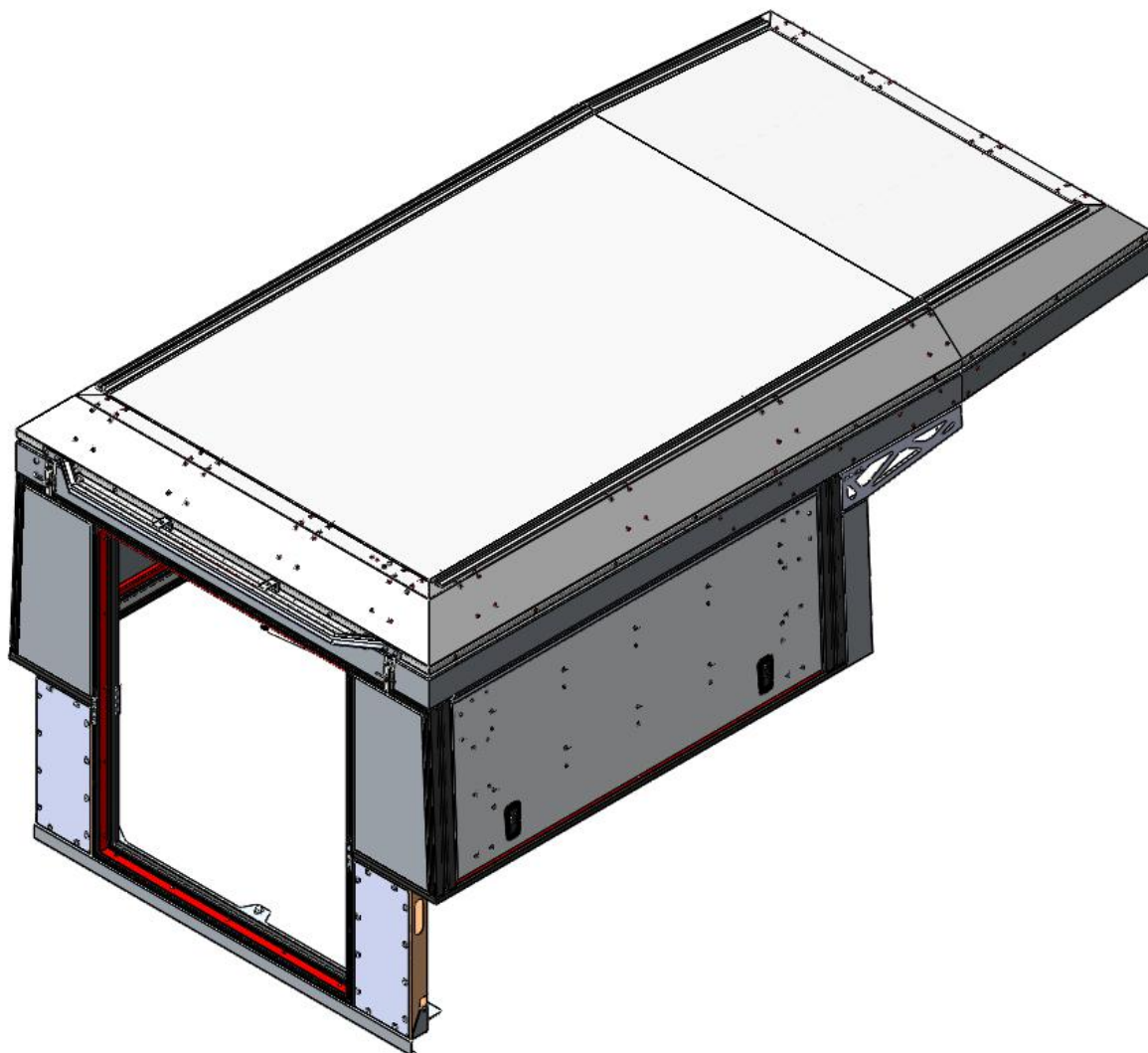
OUTER MOUNTING ON BOTH JOINTS



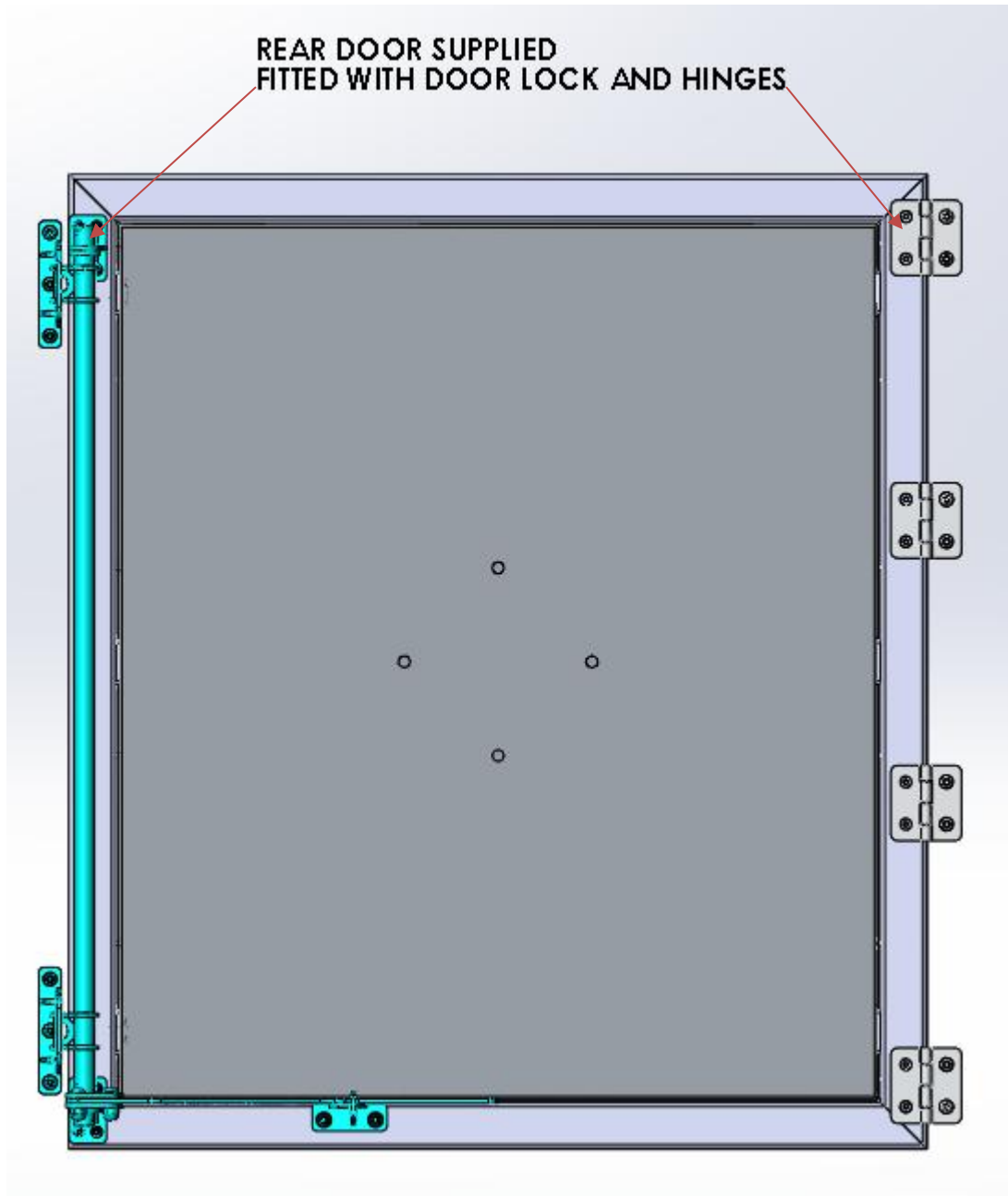
INNER MOUNTING ON BOTH JOINTS



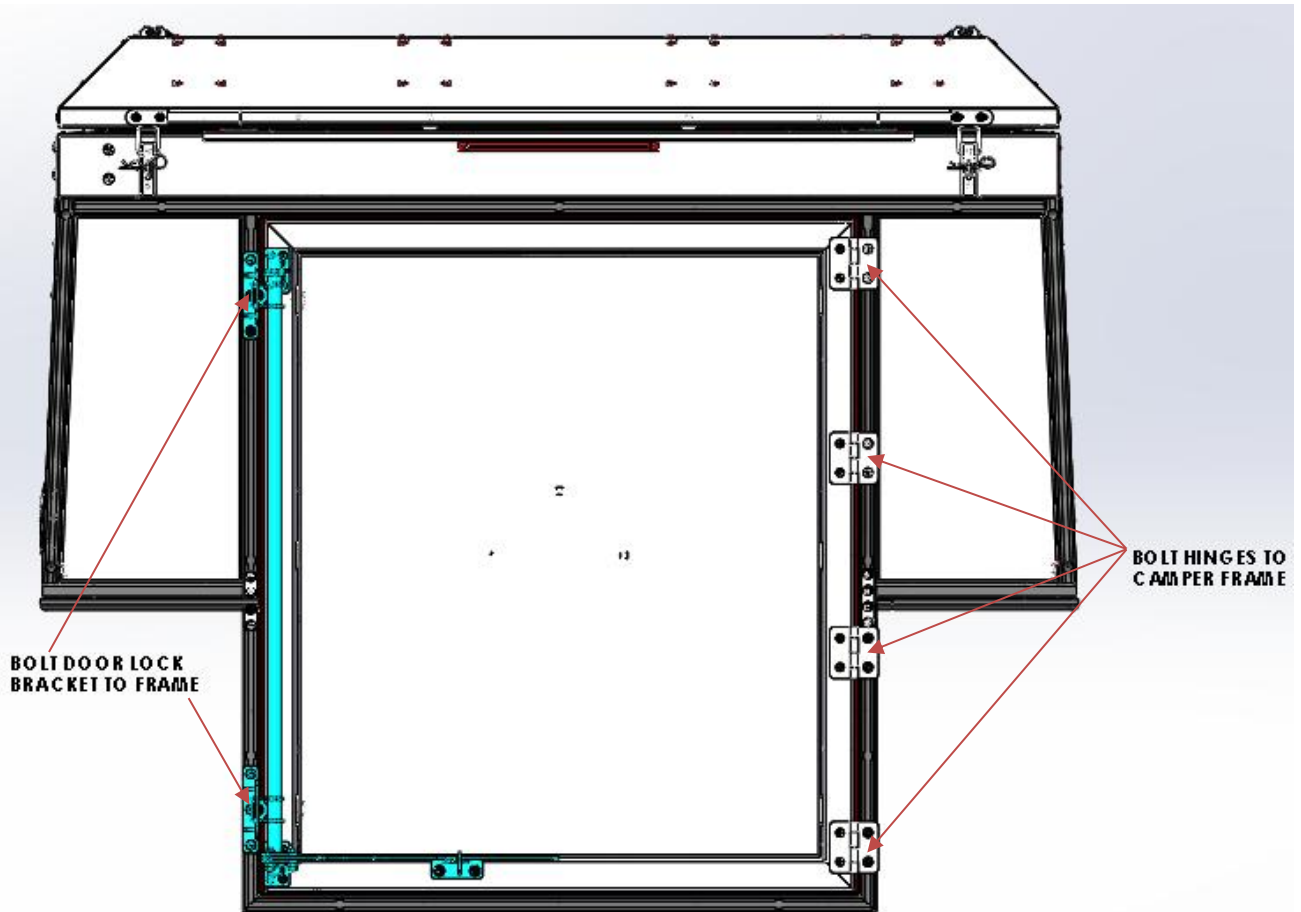
6. Fit rear door rebate with $\text{Ø}4.8 \times 15$ sealed countersink rivets as shown.



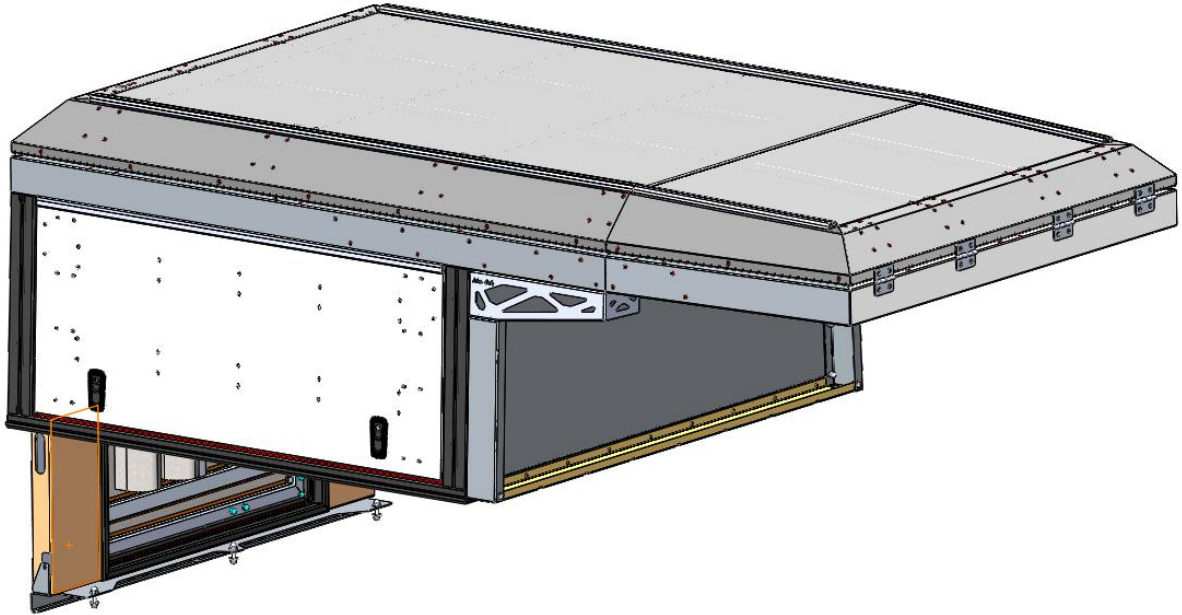
5. Fit rear door by mounting 4 x Butt hinges to camper frame as shown. Centre rear door, top to bottom and the hinge centres left to right. Also mount the door lock to the camper frame.



6. Attach hinges and lock to camper frame.



7. Fitting of front filler panels for GEN 2& 3 LB Tacoma's.



7.1 Front filler panel assembly.

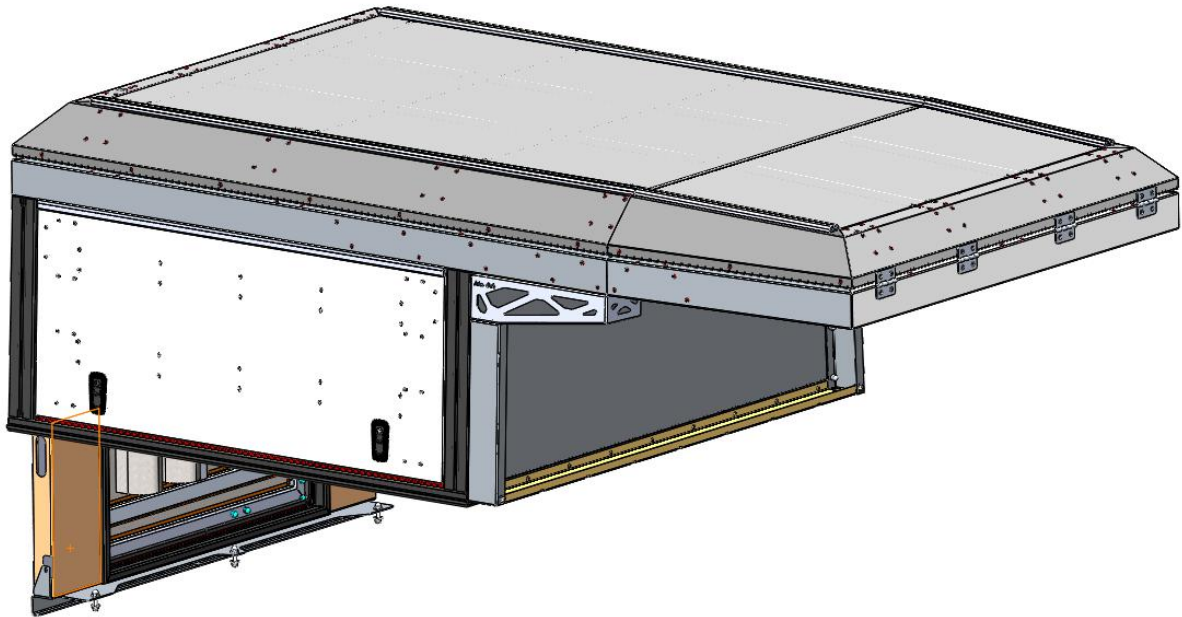
ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY.	QC CHECK
1	162-TAC-SID-FILL-PNL-LH-01-01	SIDE FILLER PANEL	1060 Alloy (2mm)	1	
2	162-TAC-SID-FILL-PNL-RH-01-00	SIDE FILLER PANEL RH	1060 Alloy (2mm)	1	
3	162-TAC-BOT-FILL-PLT-01-01	BOTTOM FILLER PLATE	1060 Alloy (2mm)	1	
4	ISO 7380 M8x20 Button Head Hex Socket Screw	Button Head Hex Socket Screw	AISI 316	6	
5	M8 Nut Cap	Plastic Nut Cap	PE Low/Medium Density	14	
6	ISO 7040 M8 Nyloc Nut	Nyloc Nut	AISI 316	14	
7	ASS4815 Rivet	Blind Rivet	AL5052	9	
8	DIN 125A M8 Flat Washer	Flat Washer	AISI 316	16	
9	DIN 9021 M8x24 Flat Washer	M8x24 Flat Washer	AISI 316	4	
10	DIN 933 M8x20 Hex Head Bolt	Hex Head Bolt	AISI 316	8	

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DATA REMAINS THE
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RETURNED UPON
REQUEST

NAME	TM	DATE	16 Nov 2018	PROJECT:	CANOPY CAMPER DC TAC & CHEV
CHD	AGF	DATE	08 Jul 2017	DESCRIPTION:	TAC FRONT COMPONENT ASSEMBLY
APPR	AGF	DATE	08 Jul 2017	DRAWING No.	162-TAC-FNT-FILLER-KIT-ASSY-01-00
<small>UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN MILLIMETRES.</small>				SIZE	A3
FINISH:	Finish	PROJECTION:	1:20	WEIGHT:	2436,75
THIRD ANGLE		SCALE:	1:20	SHEET:	1 OF 1

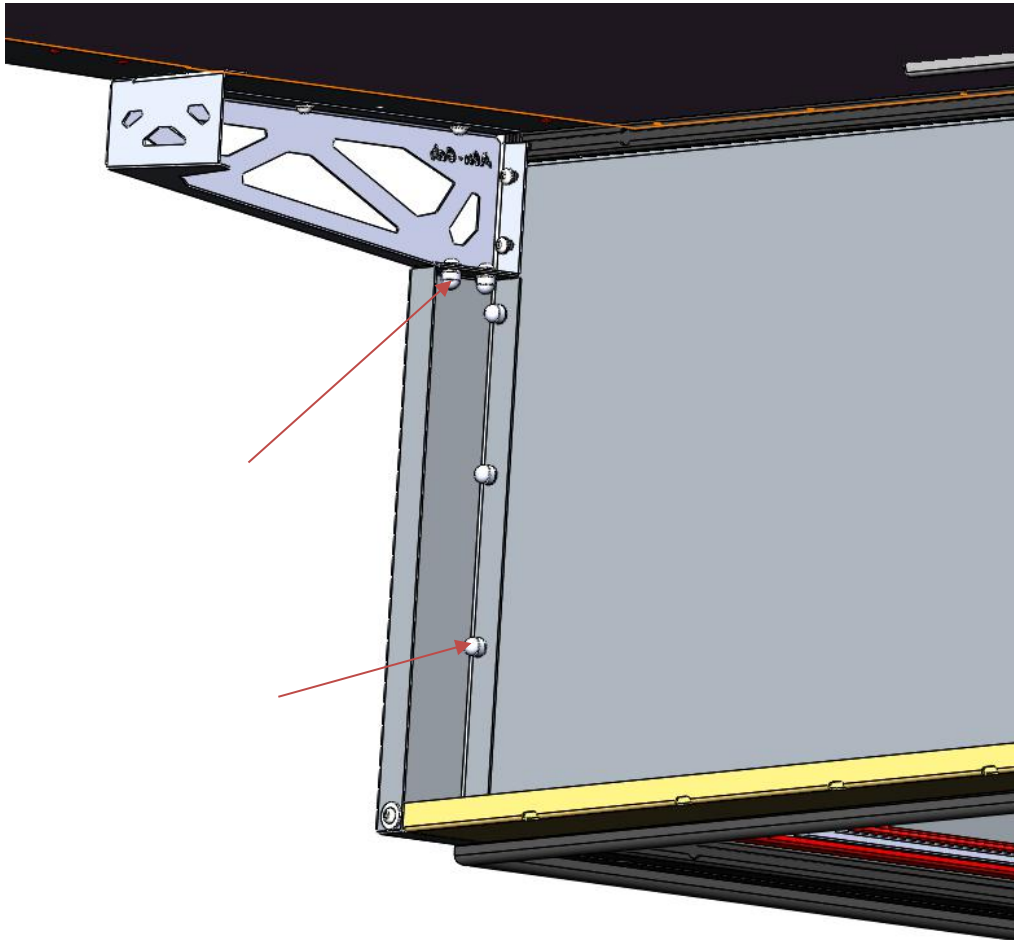
7.1 (b) Fitting of front filler panels for GEN 2 & 3 SB Tacoma's.



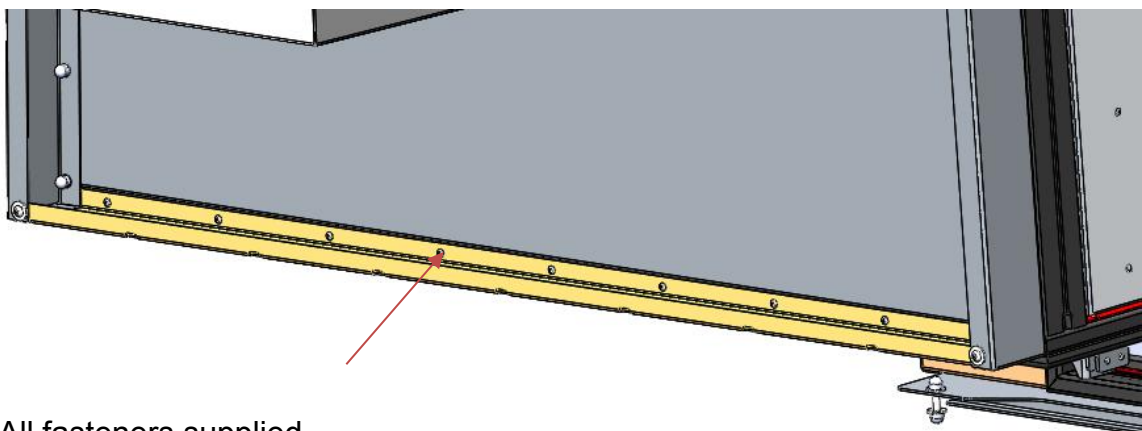
ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY.	QC CHECK
1	162-TAC-BOT-FILL-PLT-01-01	BOTTOM FILLER PLATE	1060 Alloy (2mm)	1	
2	162-XC-TAC-SID-FILL-PNL-LH-01-01	SIDE FILLER PANEL LH	1060 Alloy (2mm)	1	
3	162-XC-TAC-SID-FILL-PNL-RH-01-01	SIDE FILLER PANEL RH	1060 Alloy (2mm)	1	
4	ASS4815 Rivet	Blind Rivet	AL5052	9	
5	DIN 9021 M8x24 Flat Washer	M8x24 Flat Washer	AISI 316	12	
6	ISO 7040 M8 Nyloc Nut	Nyloc Nut	AISI 316	6	
7	ISO 7380 M8x20 Button Head Hex Socket Screw	Button Head Hex Socket Screw	AISI 316	6	
8	M8 Nut Cap	Plastic Nut Cap	PE Low/Medium Density	6	
9	DIN 934 M8 Hex Nut	Hex Head Nut	AISI 316	8	
10	ISO 7380 M8x16 Button Head Hex Socket Screw	Button Head Hex Socket Screw	AISI 316	8	
11	DIN 125B M8 Spring Washer - Compressed	M8 Spring Washer	AISI 316	8	
12	DIN 125A M8 Flat Washer	Flat Washer	AISI 316	8	

<p>4 Read Road, Ottery East, 7800, Cape Town, South Africa queries@alu-cab.co.za Tel: +27 21 703 3028 Fax: +27 21 703 9510</p>	<p>ALL TECHNICAL & VISUAL DATA REMAINS THE PROPERTY OF ALU-CAB CC & MUST BE RETURNED UPON REQUEST</p>	<p>NAME: TM DATE: 21 Nov 2018</p> <p>CHKD: AGF 08 Jul 2017</p> <p>APPR: AGF 08 Jul 2017</p> <p>UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN MILLIMETERS</p> <p>DIM: 0,0+0,25 0,0+0,1 0+0,05</p> <p>FINISH: Finish</p> <p>PROJECTION: </p> <p>THIRD ANGLE</p>	<p>PROJECT: CANOPY CAMPER XC TAC</p> <p>DESCRIPTION: TAC FRONT COMPONENT ASSEMBLY</p> <p>SIZE: DRAWING No. 162-XC-TAC-FNT-FILLER-KIT-ASSY-01-00 REV</p> <p>A3 MATERIAL:</p> <p>SCALE: 1:10 WEIGHT: 26.48.71 SHEET: 1 OF 1</p>
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7.2 Bolt side panels to frame of camper and onto the Reinforcement bracket as shown.

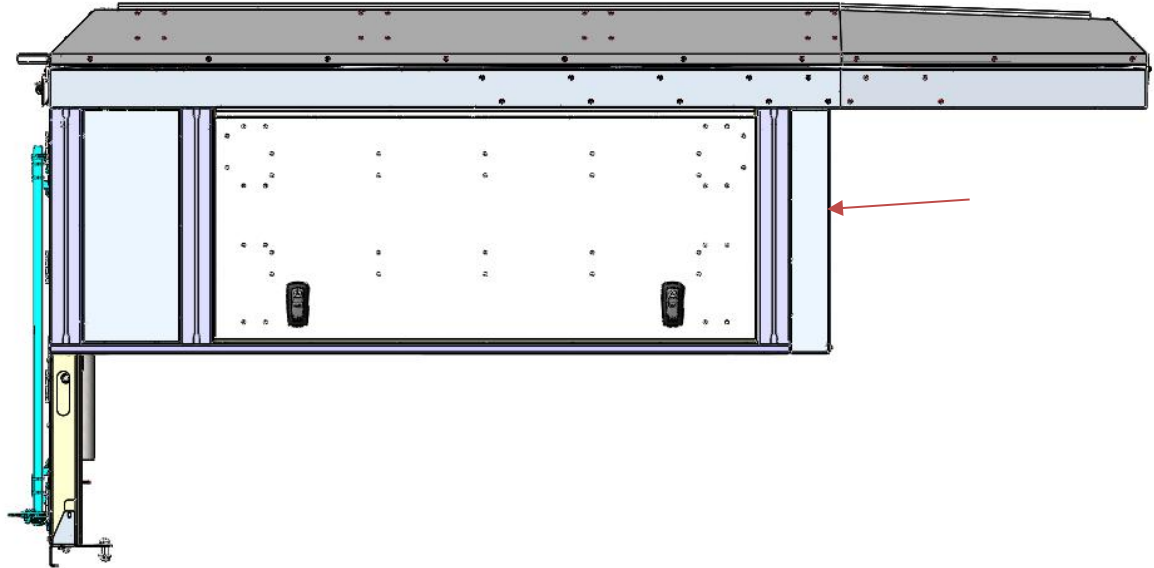


7.3 Rivet bottom filler panel on to bottom frame member using $\text{Ø}4.8 \times 15$ sealed rivets

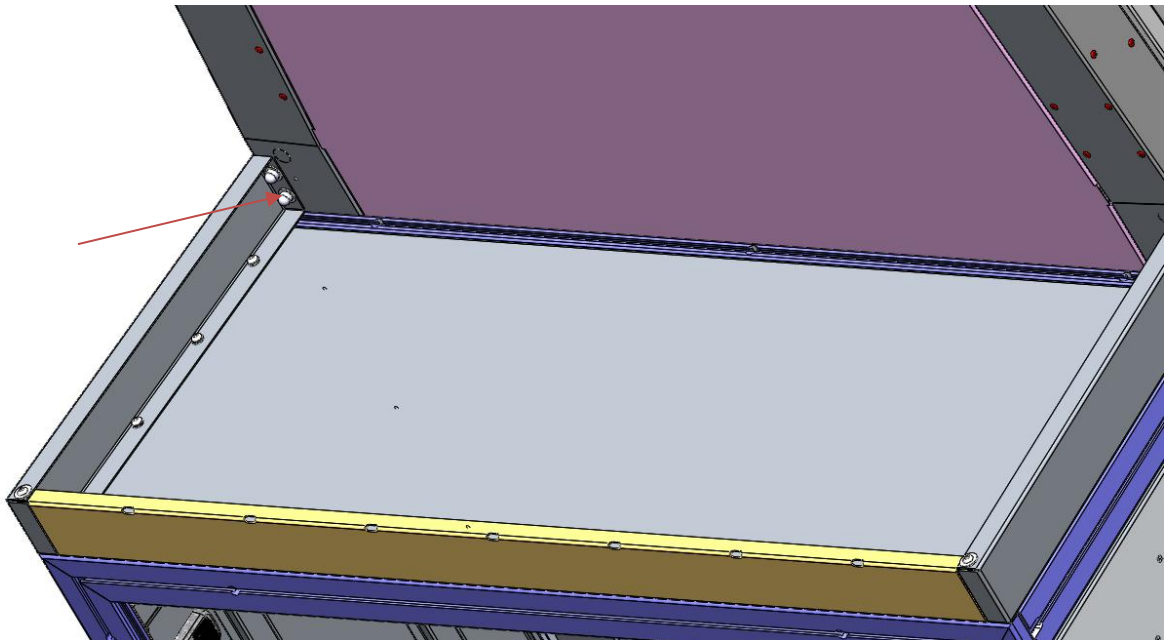


7.4 All fasteners supplied.

8. For the long bed Tacoma filler panels, holes need to be drilled into roof and bolted from the inside as there is no reinforcement bracket used on the long bed.

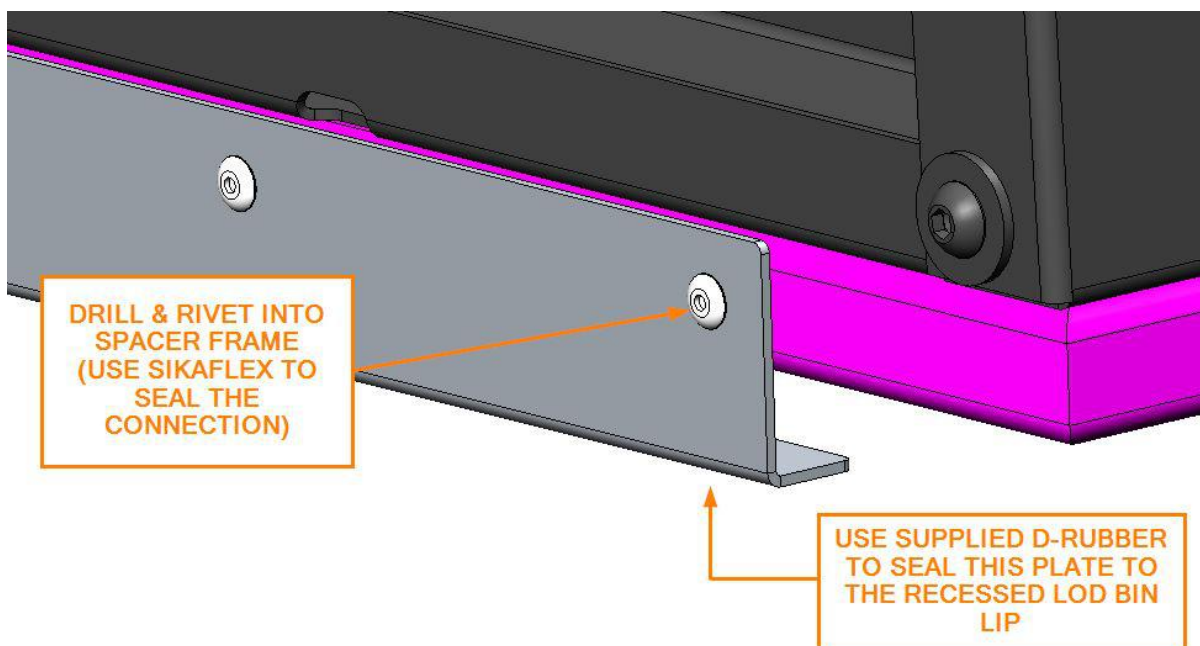
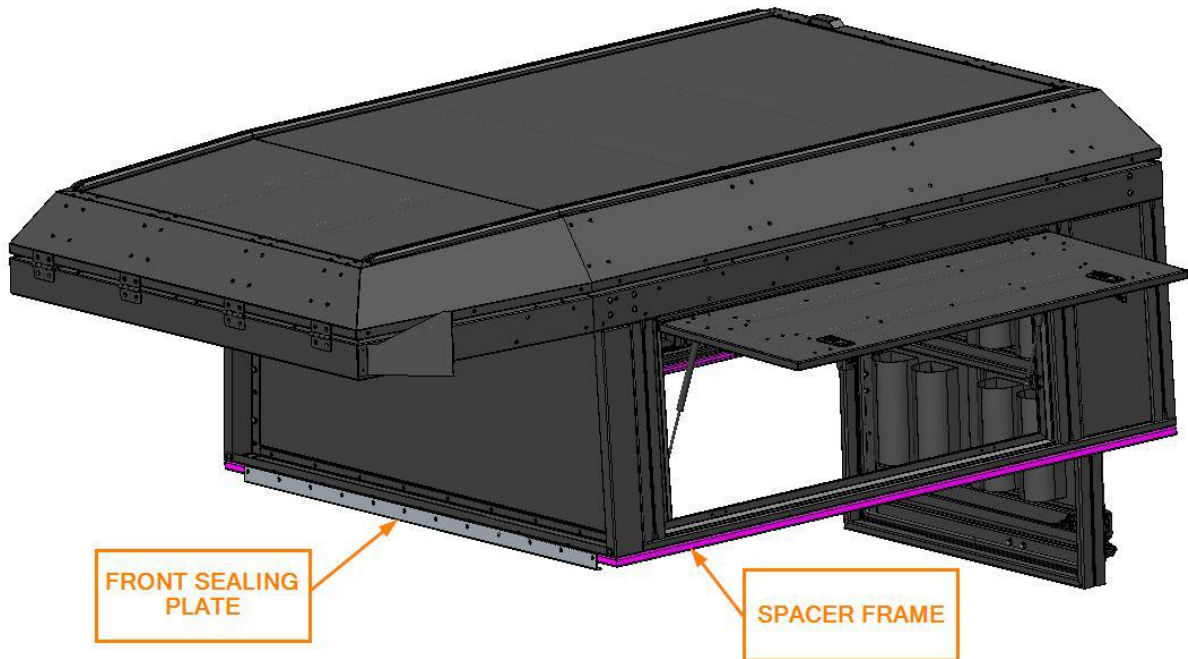


8.2



8.3 Lastly, seal all joints with Sika flex or similar.

Tacoma GEN 2 - Front Sealing Setup



FRONT SEALING PLATE

RELEASED FOR MANUFACTURE									
DATE	SIGNED	PART NUMBER	DESCRIPTION	MATERIAL	QTY.	QC CHECK			
03 October 2019		292-SB-2015-FNT-SEAL-01-00	FRONT SEAL	1060 Alloy (2mm)	1				
		AS4815 Rivet	Blind Rivet	AL5052	12				

E

D

C

Space frame 3 GEN2 LB

RELEASED FOR MANUFACTURE		DATE	09 September 2019	
SIGNED				

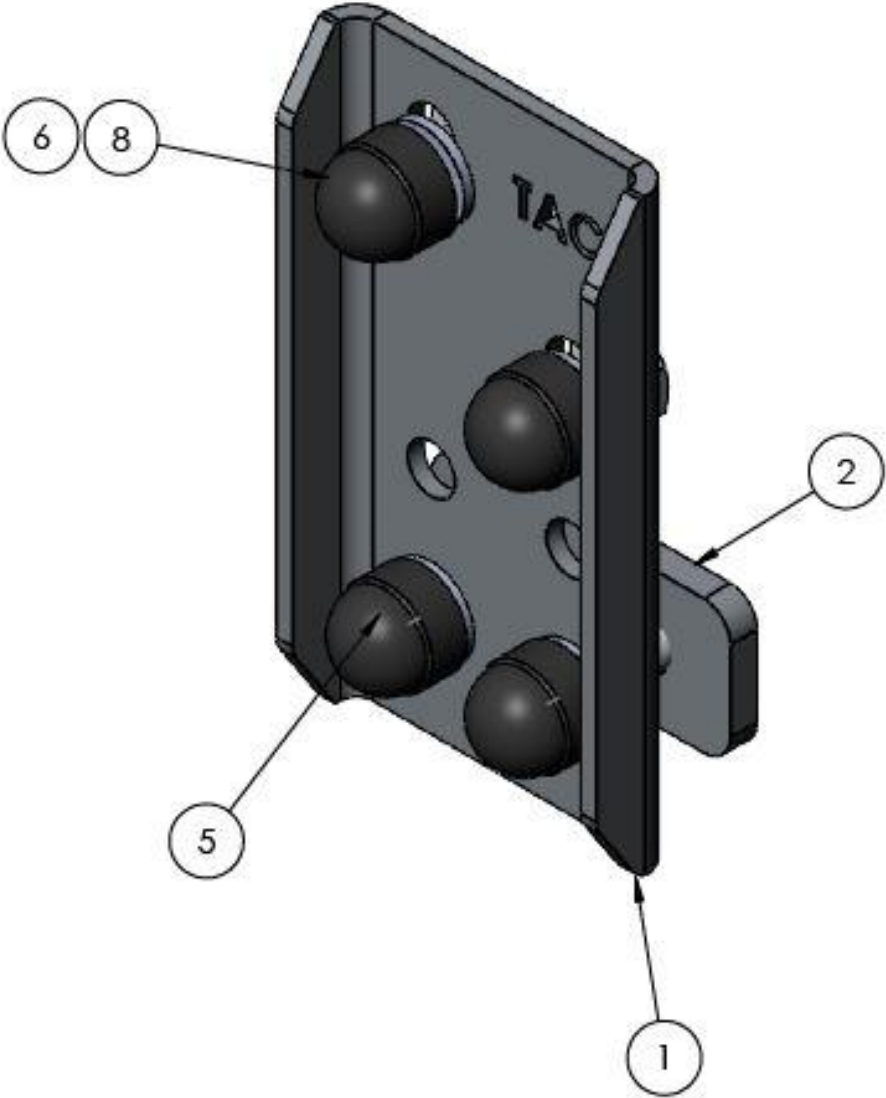
ITEM NO.	QTY.	DESCRIPTION	LENGTH	QC CHECK
1	2	Std Load Bar	97	
2	1	Std Load Bar	1967	
3	1	Std Load Bar	1600	
4	1	Std Load Bar	1967	

The drawing shows a space frame structure consisting of four bars. Callout 1 points to the top-left corner joint, callout 3 points to the top-right corner joint, and callout 4 points to the bottom-left corner joint. The bars are arranged in a diamond shape with a horizontal bar at the bottom.

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NAME	DATE	PROJECT	DESCRIPTION
TM	18 Apr 2019	TAC 2G XC CANOPY CAMPER	FILLER FRAME XC
DRAWN CHKD			
Appr.			
UNITS: OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			
0-0,5 0,5-0,25 0,25-0,1 0-0,5°		SIZE	DRAWING No.
FINISH: Finish "		A3	162-TAC-2G-XC-FILLER-FRA-01
PROJECTION:		MATERIAL:	6063-T6
THIRD ANGLE		SCALE:	1:10
		WEIGHT:	1123,68
		SHEET:	1 OF 2
		REV	

TOYOTA TACOMA Canopy Camper Mounting Brackets



Fitment Instructions

1. Toyota Tacoma Canopy Camper Mounting Brackets - Tools, Fasteners & Materials

The tables below show the equipment, i.e tools, fasteners, hardware and consumables required to complete the fitment of the Toyota Tacoma Canopy Camper.

Hardware supplied with the Toyota Tacoma Canopy Camper Mounting Brackets:

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY.
1	162-TT-CC-VERT-MNT-BRKT-01-01	VERTICAL MOUNTING BRACKET	AISI 304 (3mm)	6
2	TT-NUT-PLT-01-00	NUT PLATE	AISI 304 (5mm)	6
3	483-080	SPRING WASHER - M8	AISI 304	24
4	M8 Flat Washer	M8 Flat Washer	AISI 316	24
5	M8 Nyloc Nut	M8 Nyloc Nut	AISI 316	24
6	M8x30 Hex Head Bolt	M8x30 HEX BOLT	AISI 316	12
7	M8x20 Hex Head Bolt	M8x20 Hex Head Bolt	AISI 316	12
8	M8 Nut Cap	Plastic Nut Cap	PE Low/Medium Density	24

1.1 Tools required to fit the Toyota Tacoma Canopy Camper Mounting Brackets:

Tool	Purpose
13mm Spanner/Ratchet	Fastening Nuts and Bolts

2. Fitting the Canopy Camper Mounting Brackets

Step 1: Installing the Tacoma Mounting Brackets

Firstly we need to install our bottom half of the mounting Bracket to the Load Bin of our Vehicle. This is illustrated below:

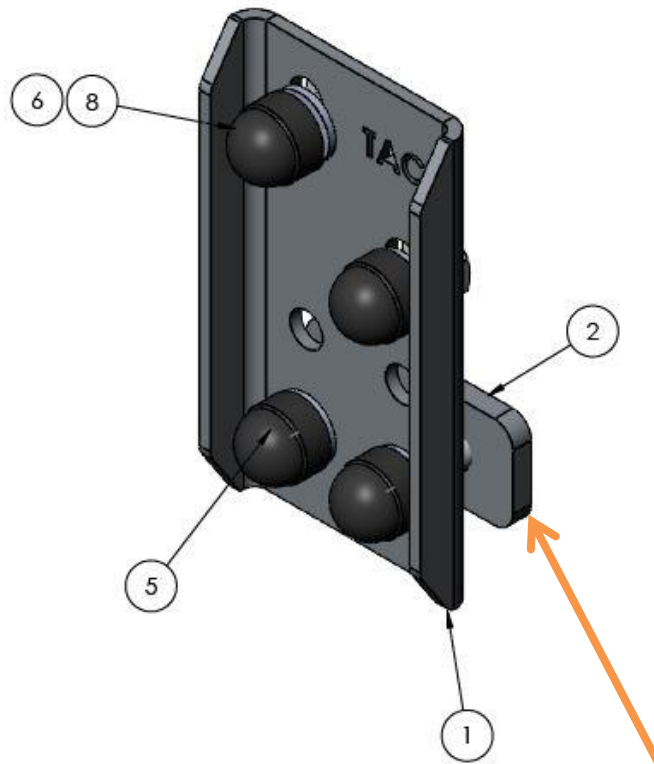


Figure 1: The above Plate with threaded holes is inserted into the below rail inside the Load Bin



Figure 2: Rail inside the Load Bin

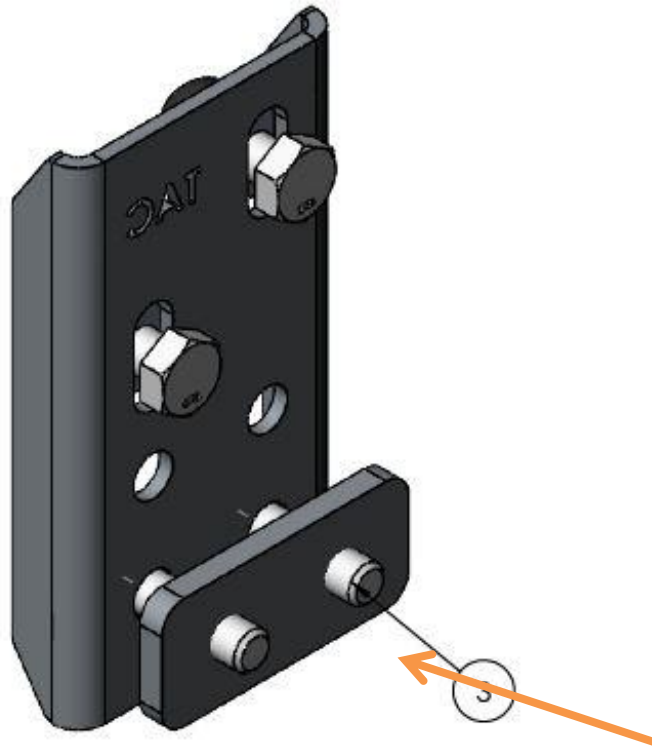


Figure 3: The above Plate is a spacer between the Load Bin Rail and Bracket, the gap between the 2 Plates represents where the Rail would fit between

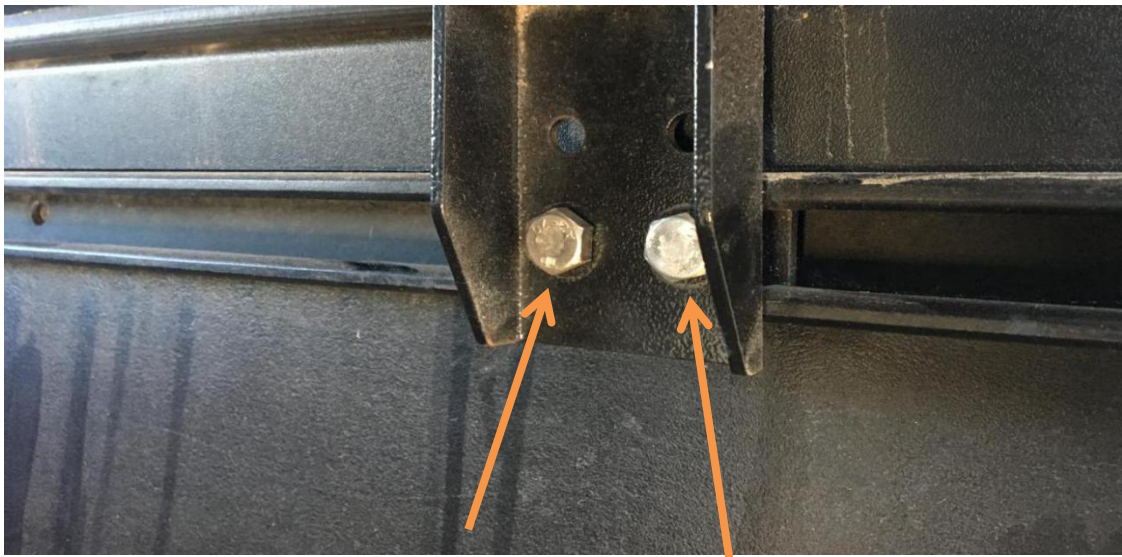


Figure 4: You will fasten through these holes with 2 Button Head Bolt, Flat Washers and Spring Washers

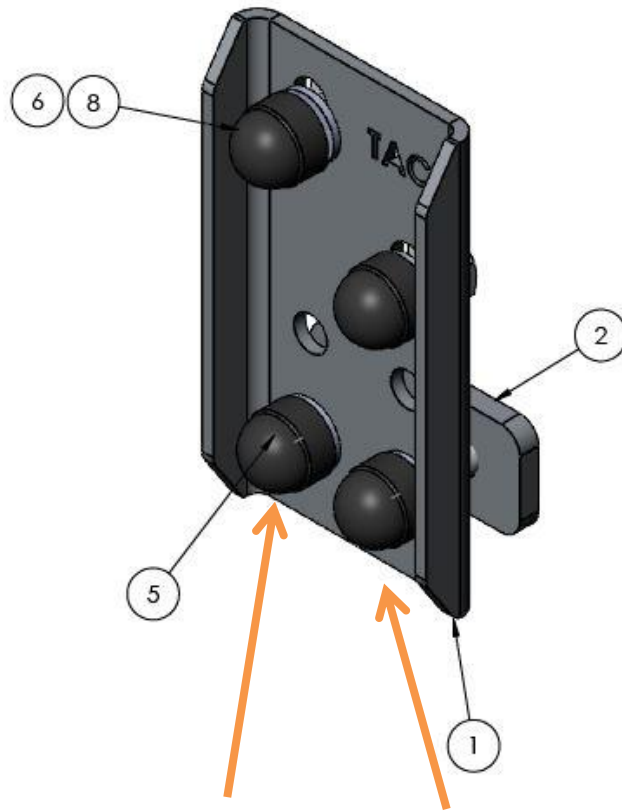


Figure 5: Button Head Bolts with Flat Washers and Spring Washers

Figure 6: Installed bottom half of Mounting Bracket

Step 2: Installing Top Half of the Tacoma Mounting Brackets

Figure 7: Insert Hex Bolt into the Side Nut Slot of the Canopy Camper Frame

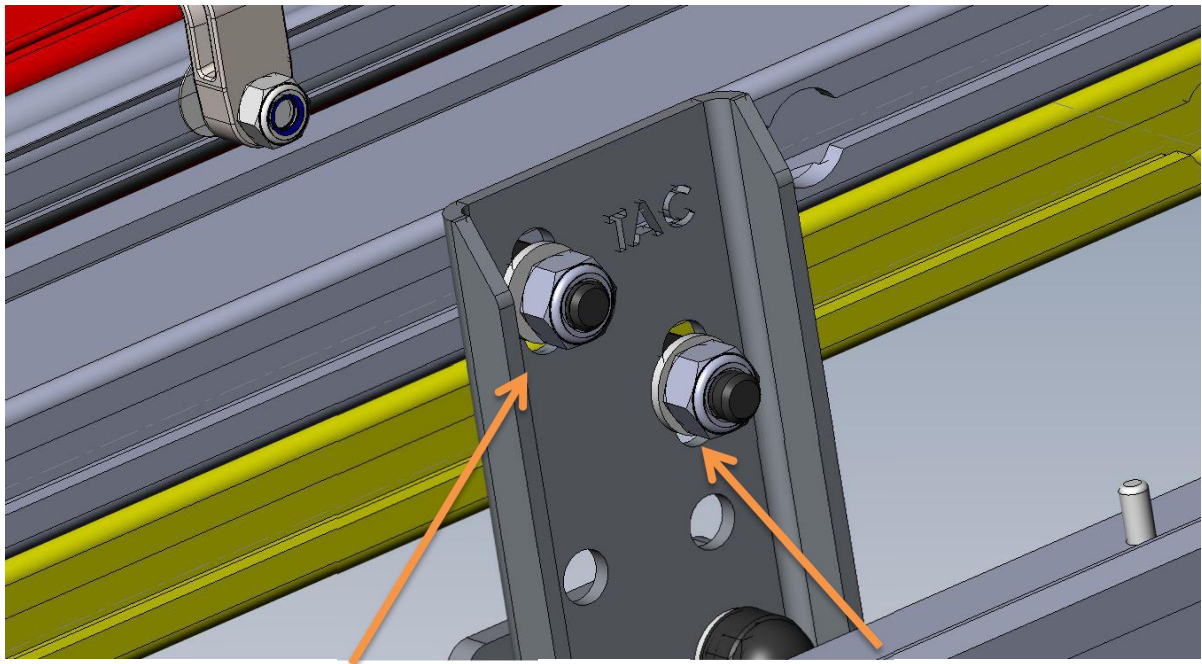


Figure 8: Next we need to place the Hex Bolt in the Nut Slot and place a Flat Washer afterwards. Fit nut caps to all bolt heads

Repeat the same process all around the camper, placing 3 brackets on each side .

