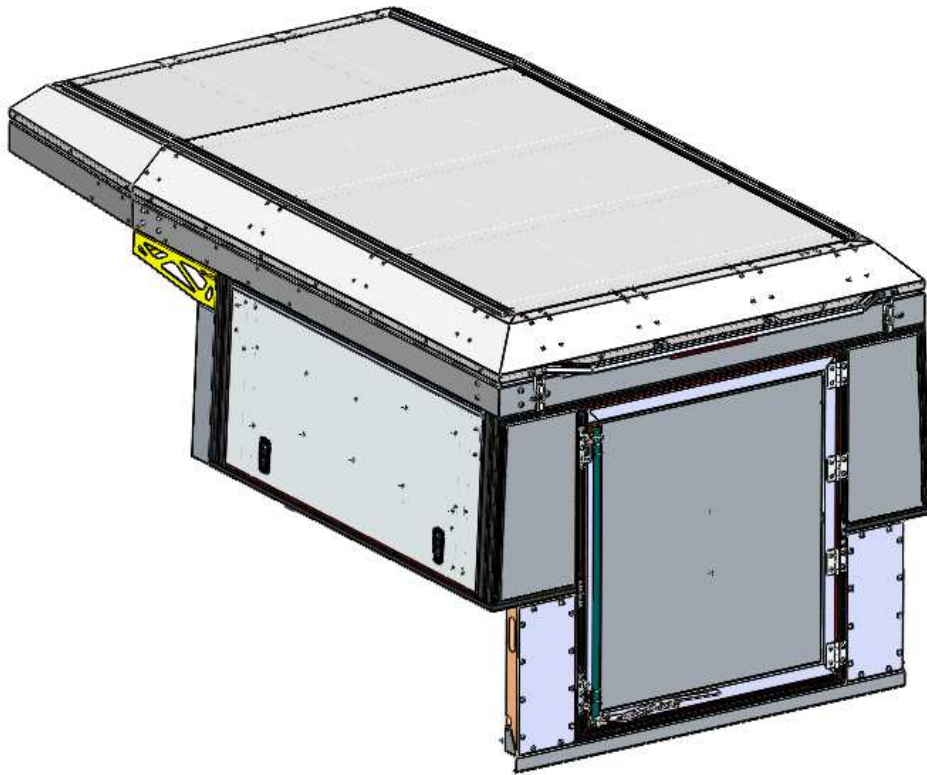


FITMENT INSTRUCTIONS

Alu-Cab™



TOYOTA TACOMA GEN2&3 SB & LB CANOPY CAMPER

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Review all instructions information carefully before installation.

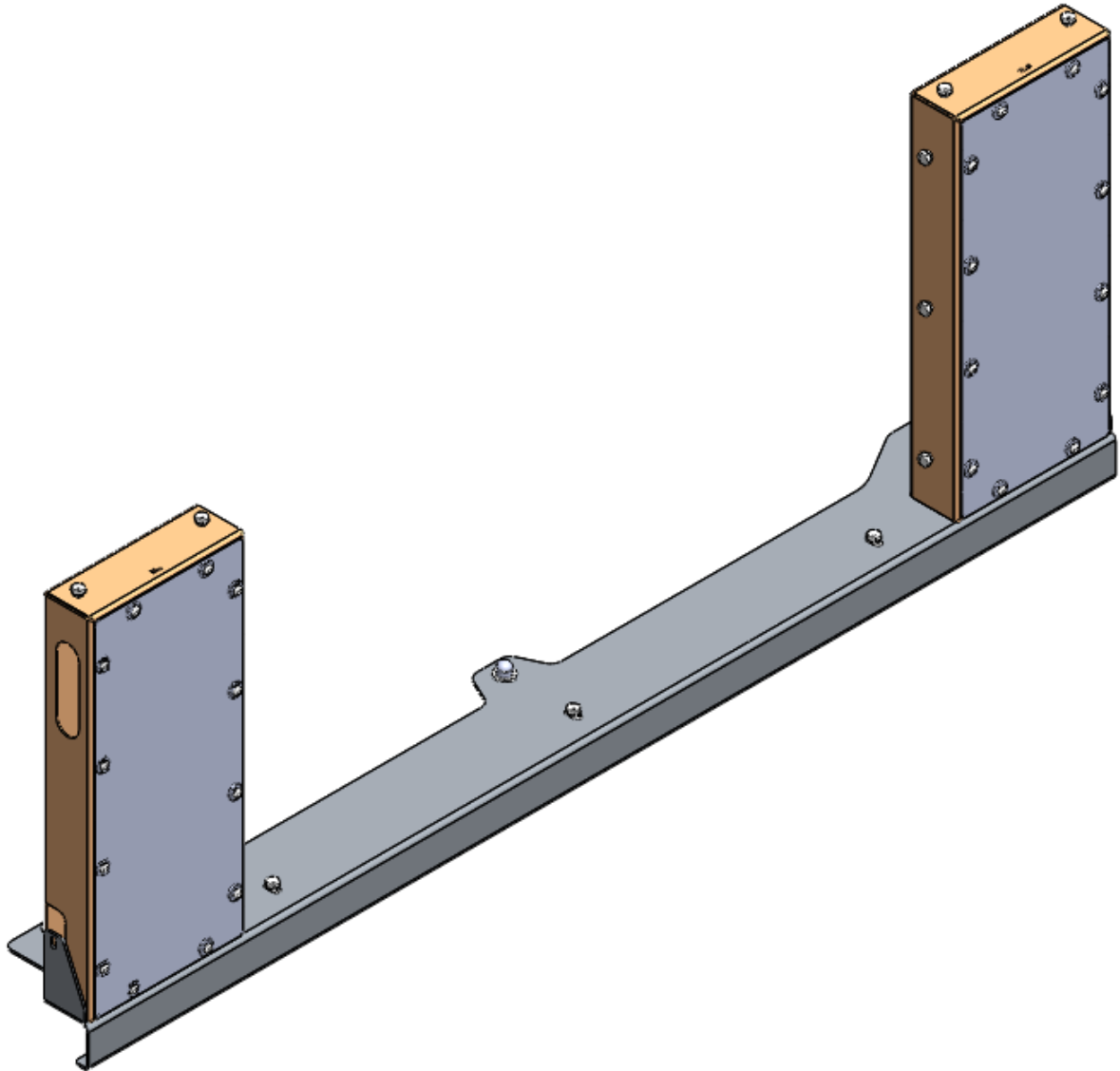
Any damages, direct or incidental to the installer and/or property due to incorrect installation of any parts are the responsibility of the installer. Due to the various applications and fitment options available, the responsibility lies with the user to ensure all mounting points are secure and tight 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)



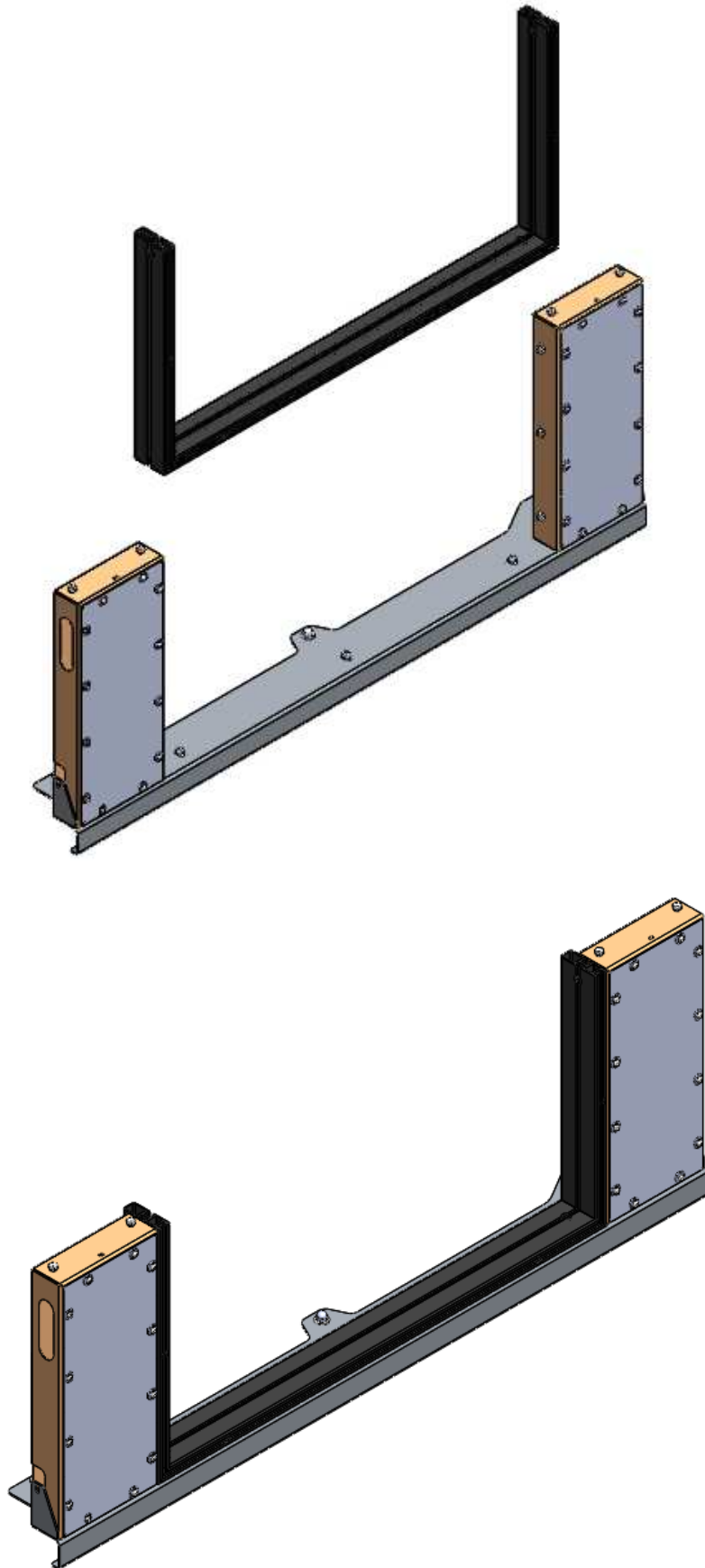
162-TAC-RER-FILLER-KIT-ASSY-01-00



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.

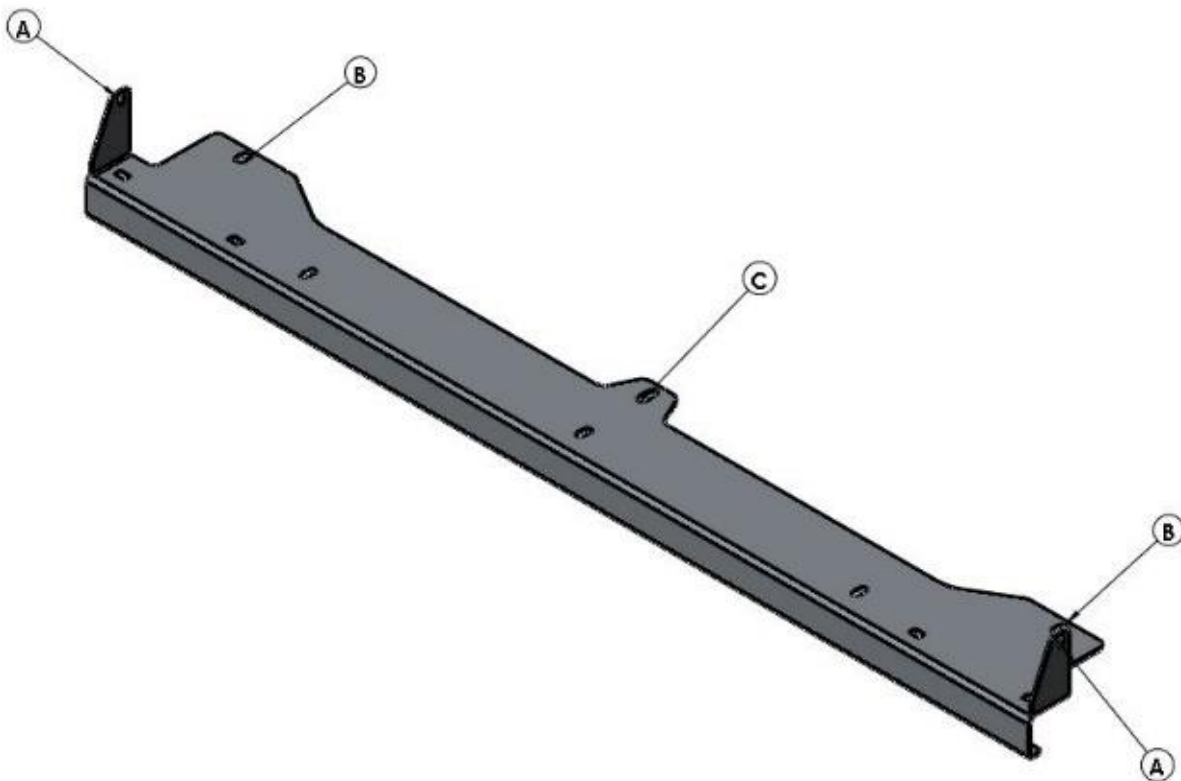
1. Fit lower door frame to filler panel assembly as shown.



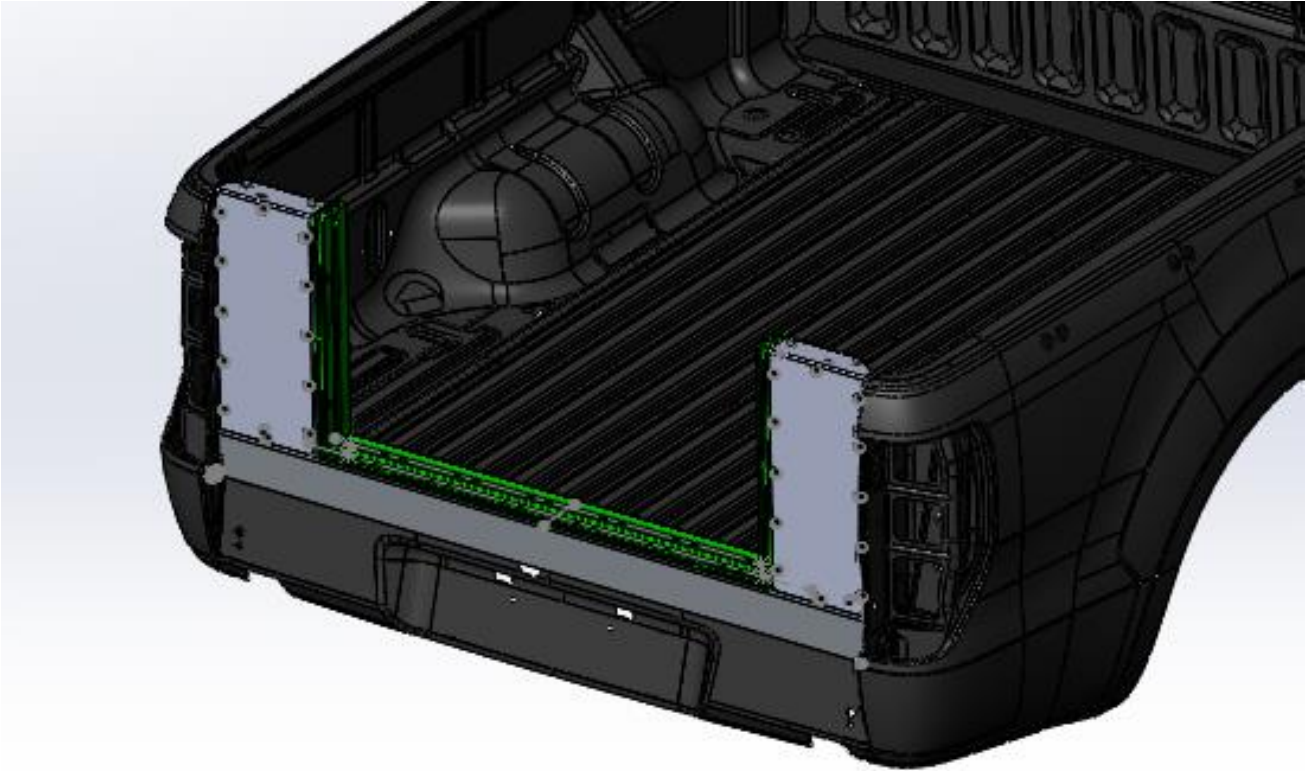
2. Image below indicates the mounting points for rear filler panel assembly.



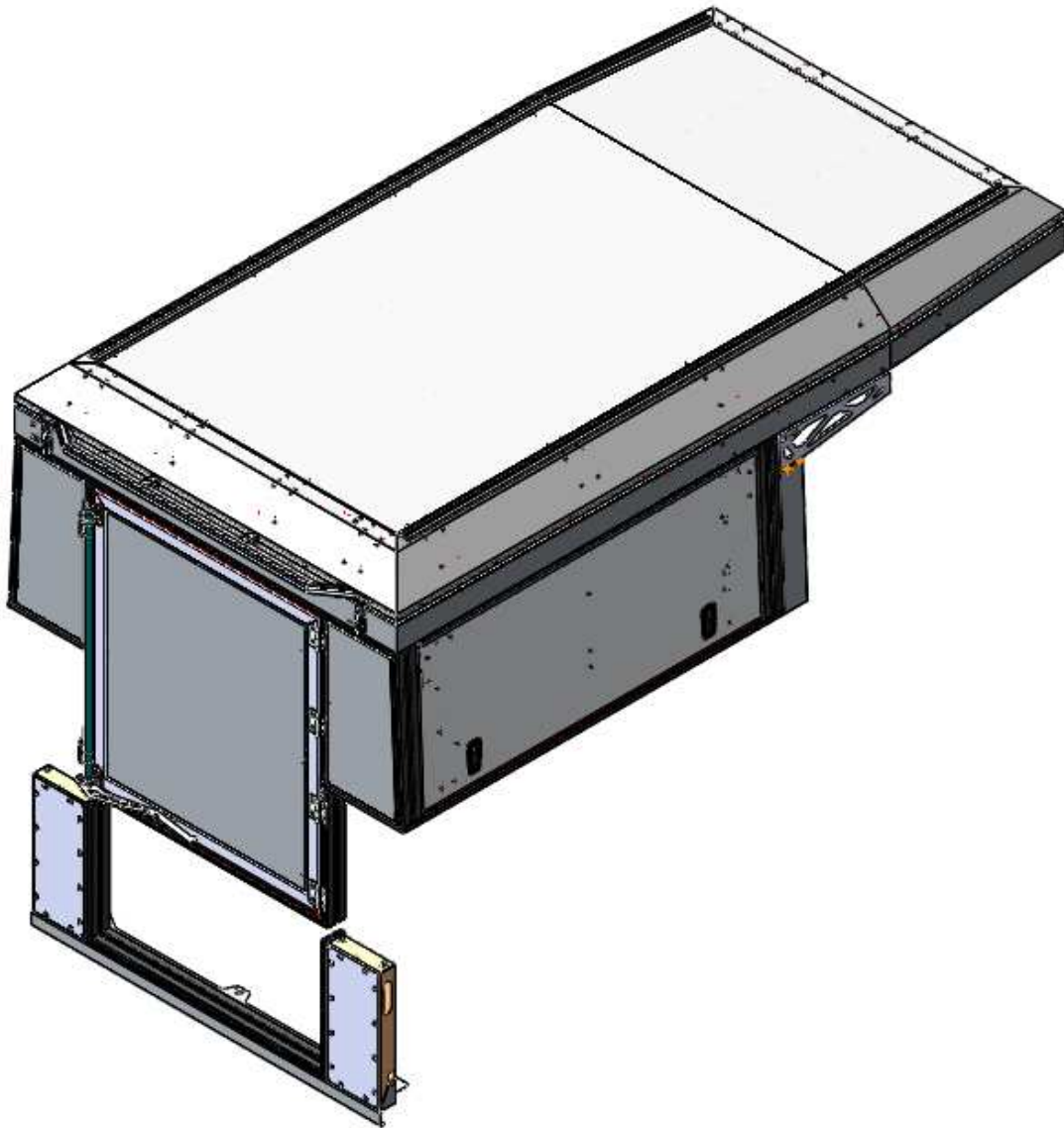
2.1 Point C needs to be drilled through plastic liner to match up with existing hole in load bin.



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

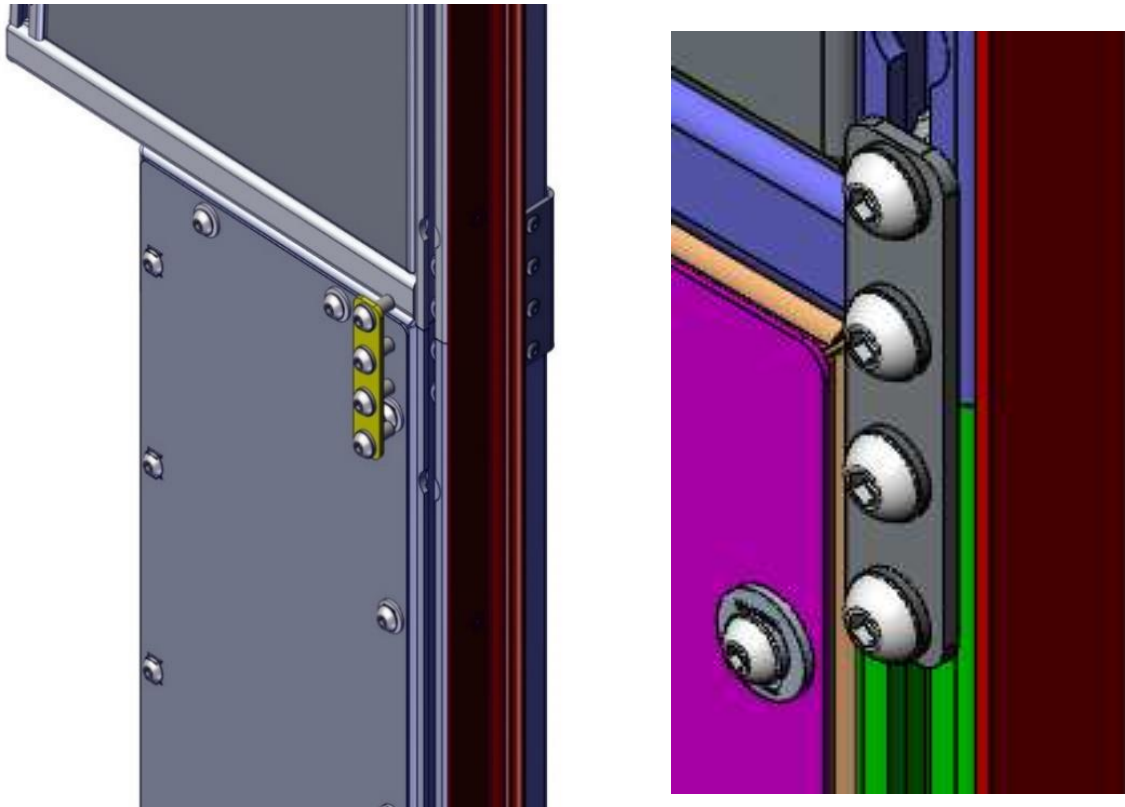


3.1. Then mount canopy camper base unit on top of load bin.

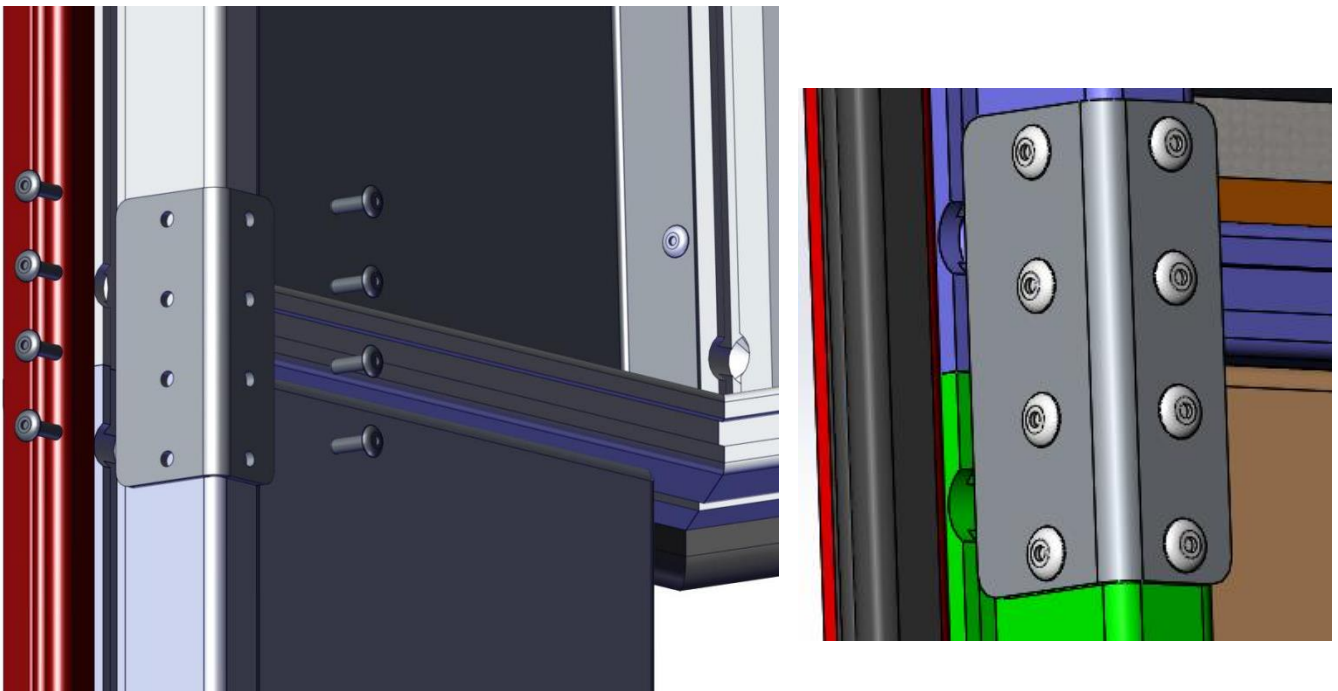


4. Connect rear filler panel assembly and base unit as shown.

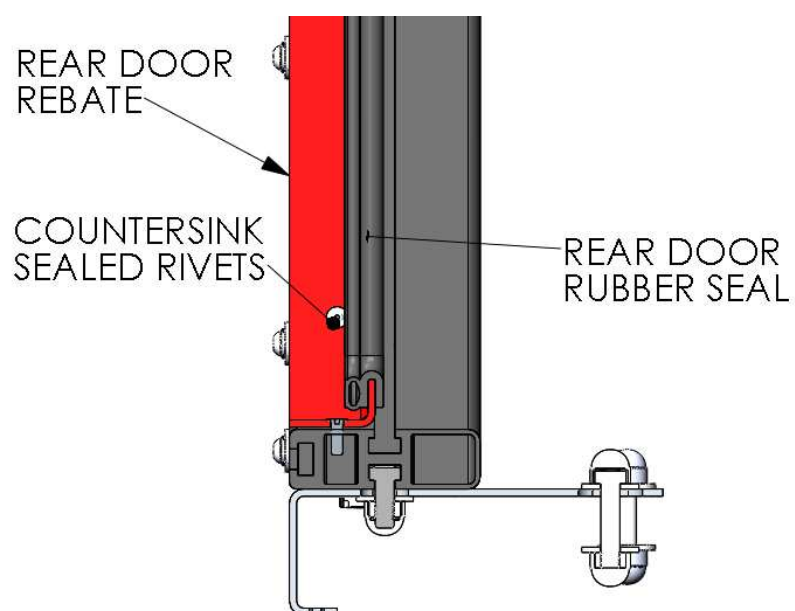
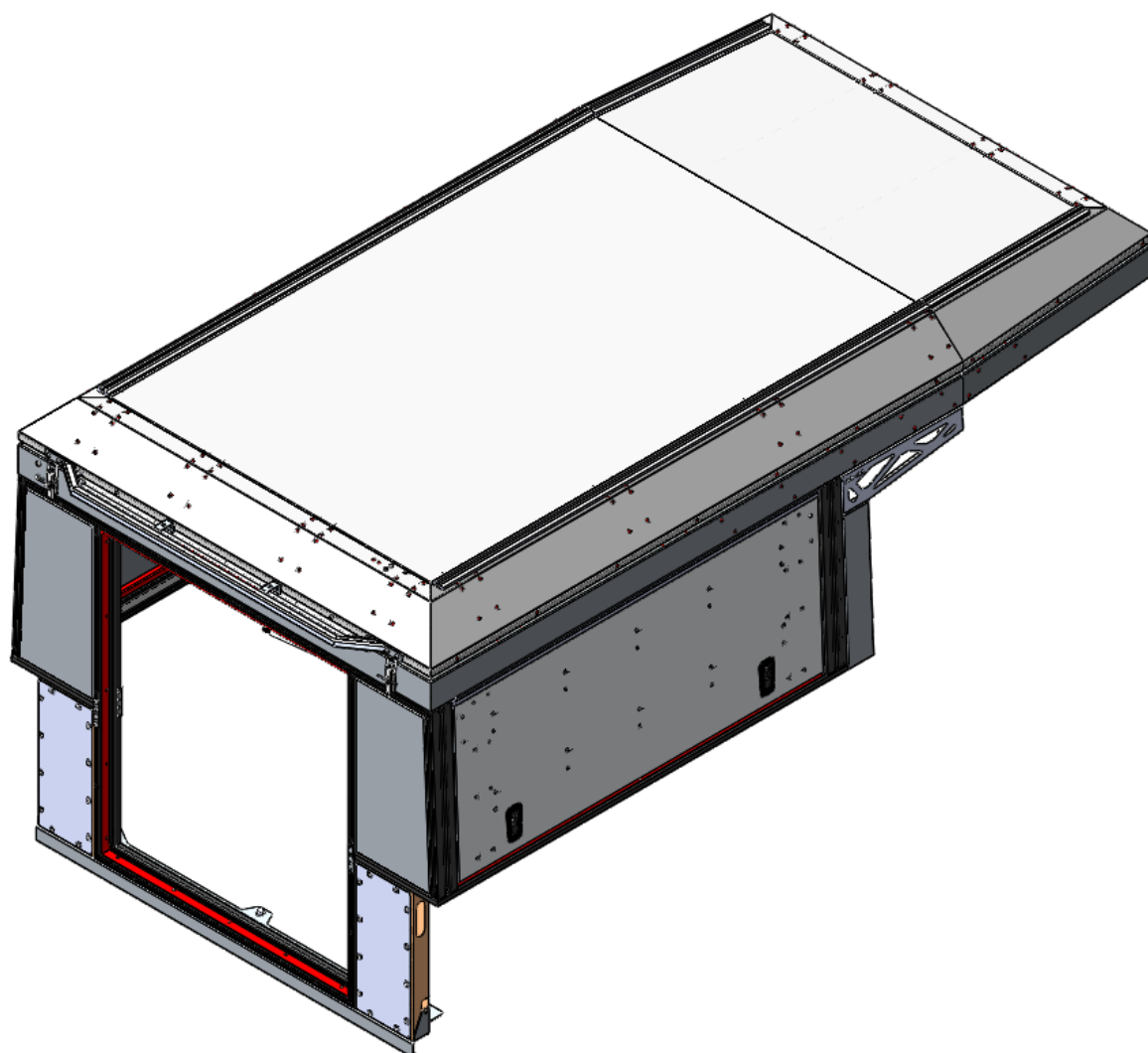
OUTER MOUNTING ON BOTH JOINTS



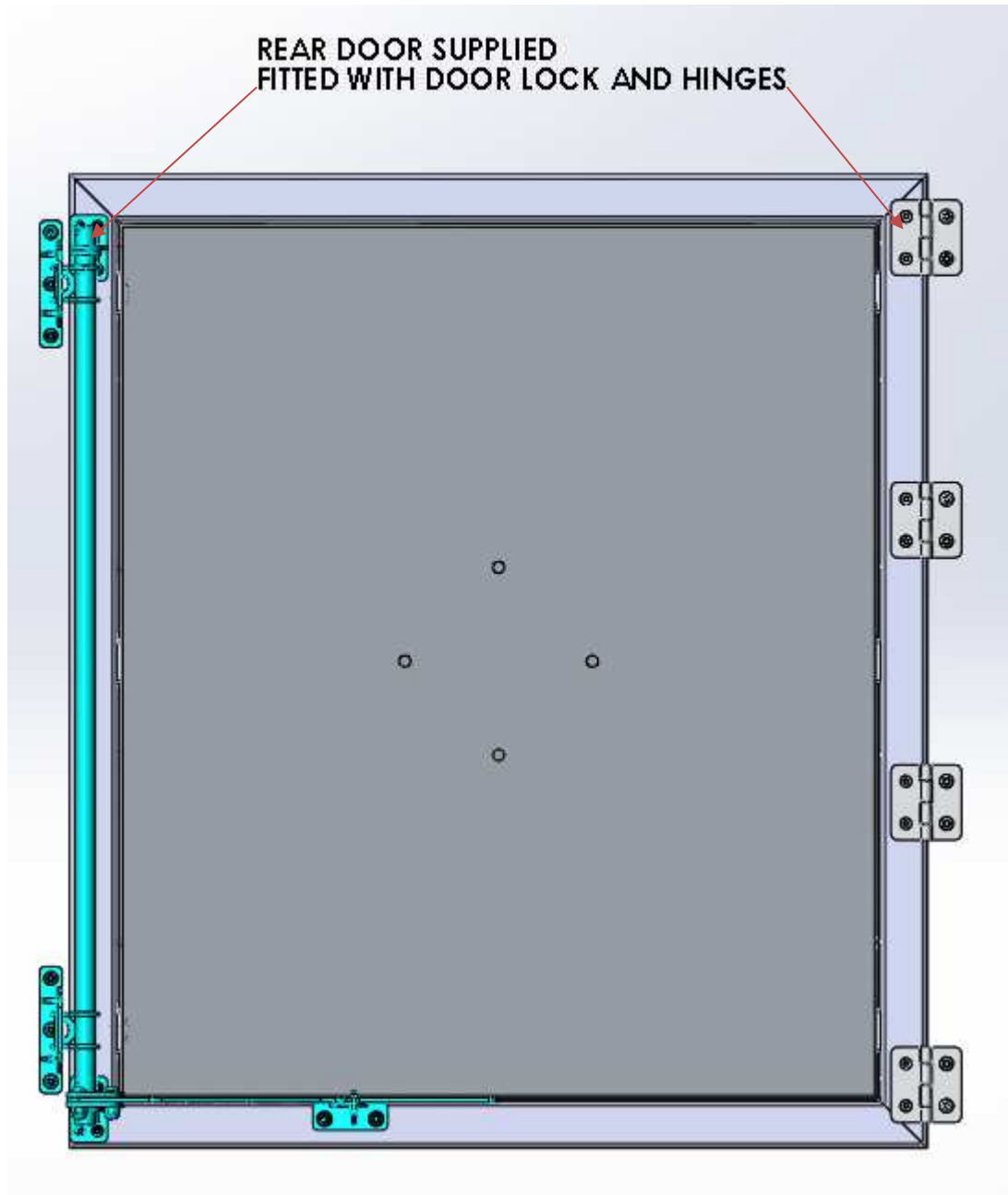
INNER MOUNTING ON BOTH JOINTS



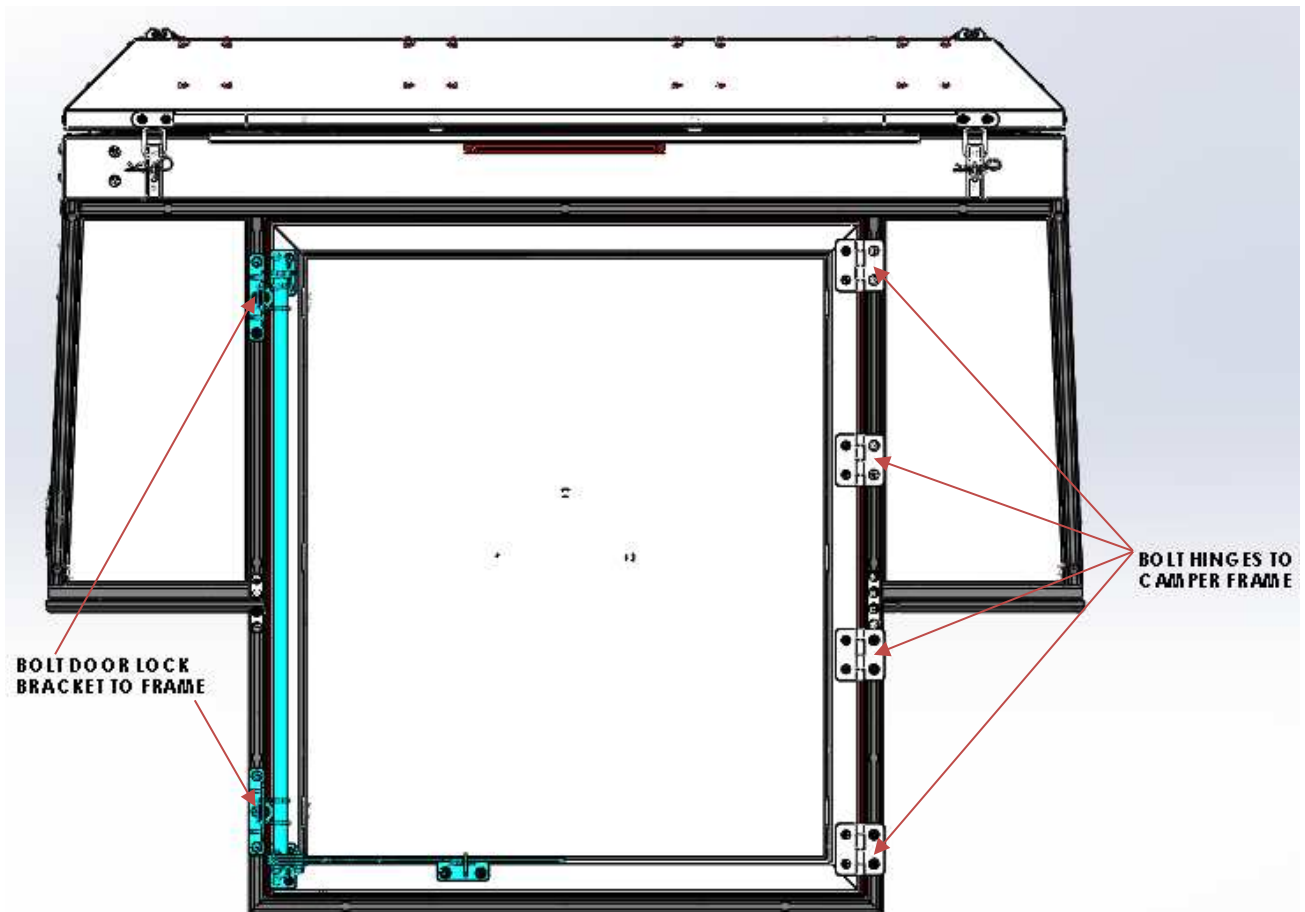
6. Fit rear door rebate with $\text{Ø}4.8 \times 15$ sealed countersink rivets as shown.



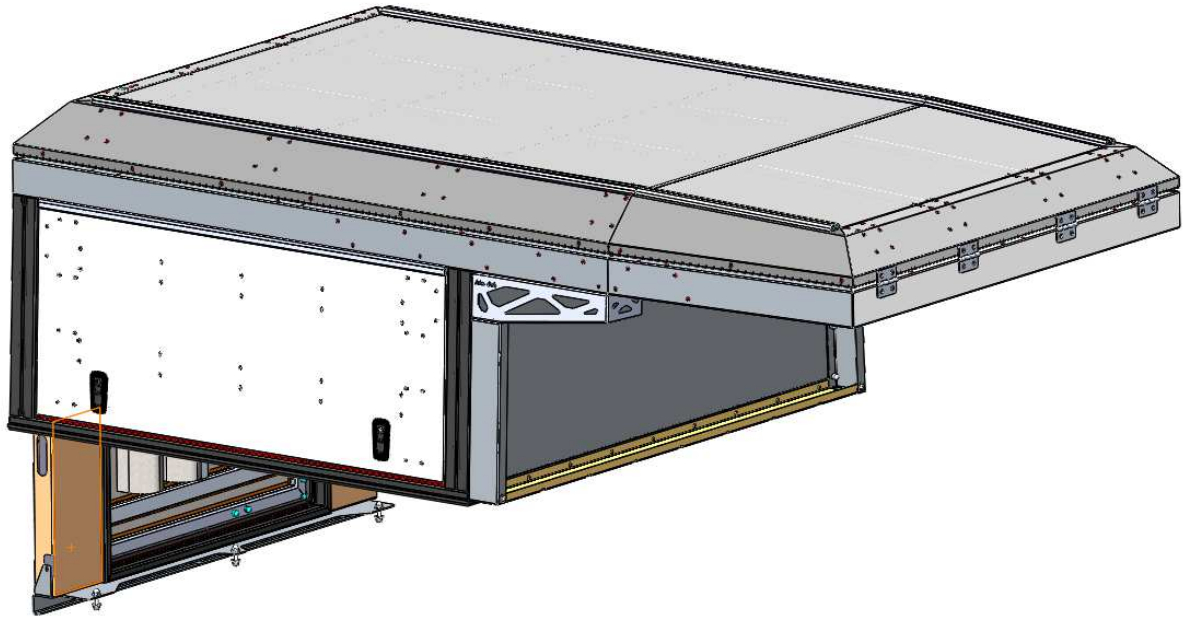
5. Fit rear door by mounting 4 x Butt hinges to camper frame as shown. Centre rear door, top to bottom and the hinge centres left to right. Also mount the door lock to the camper frame.



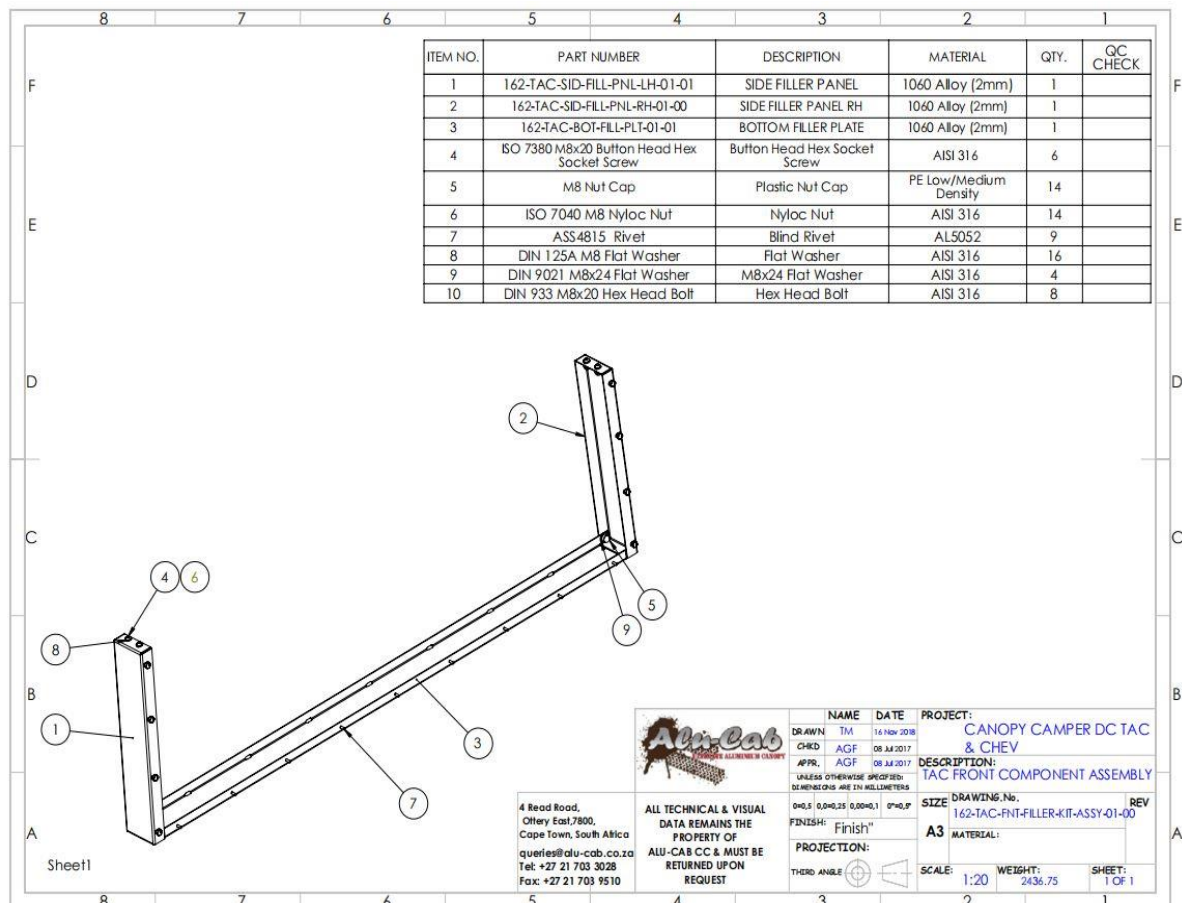
6. Attach hinges and lock to camper frame.



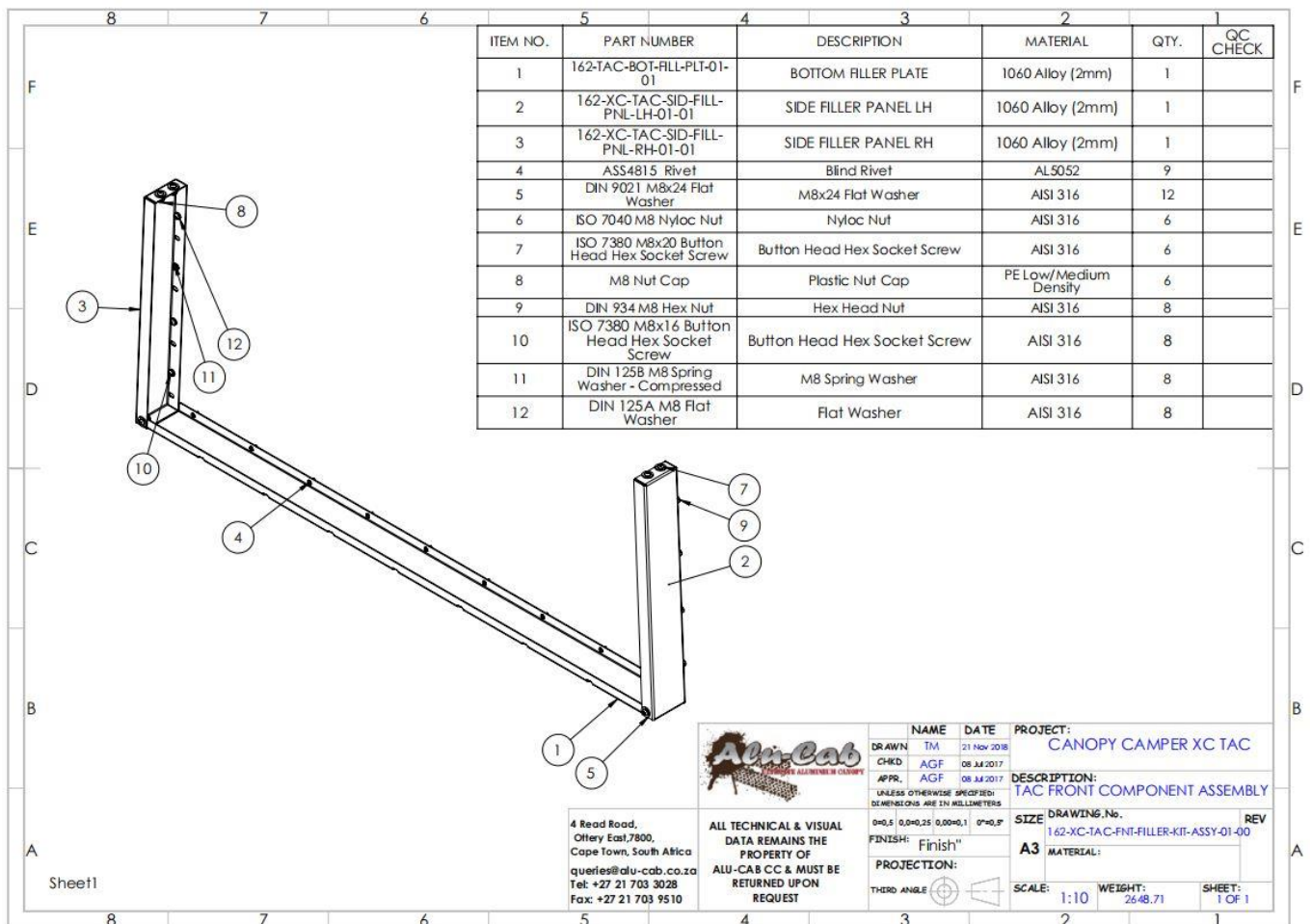
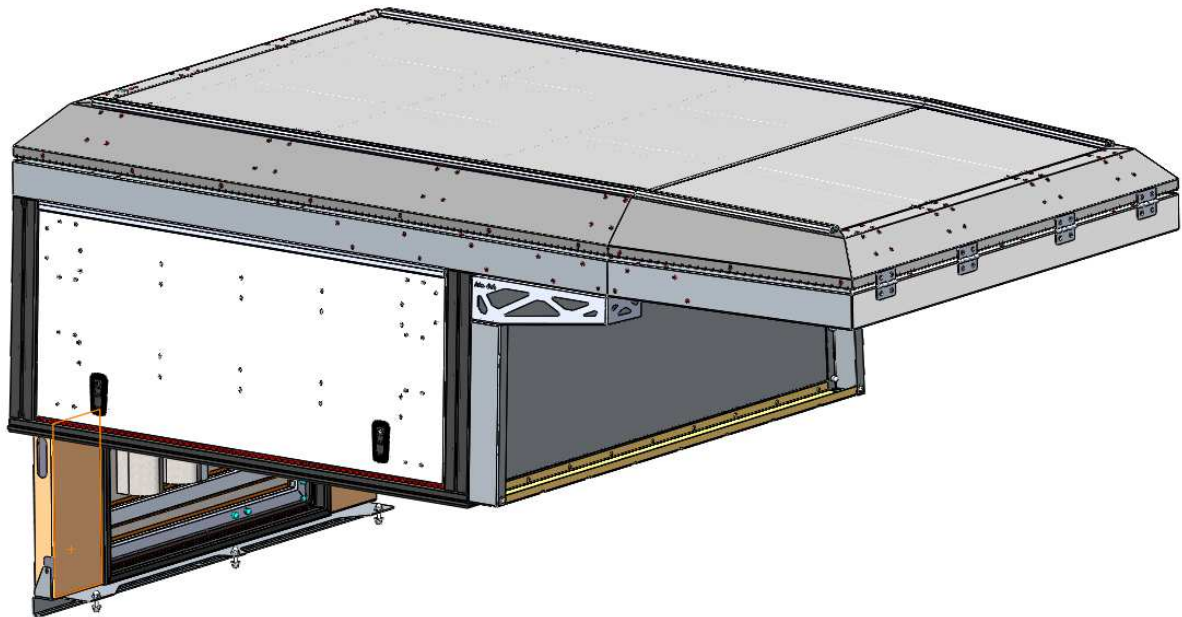
7. Fitting of front filler panels for GEN 2& 3 LB Tacoma's.



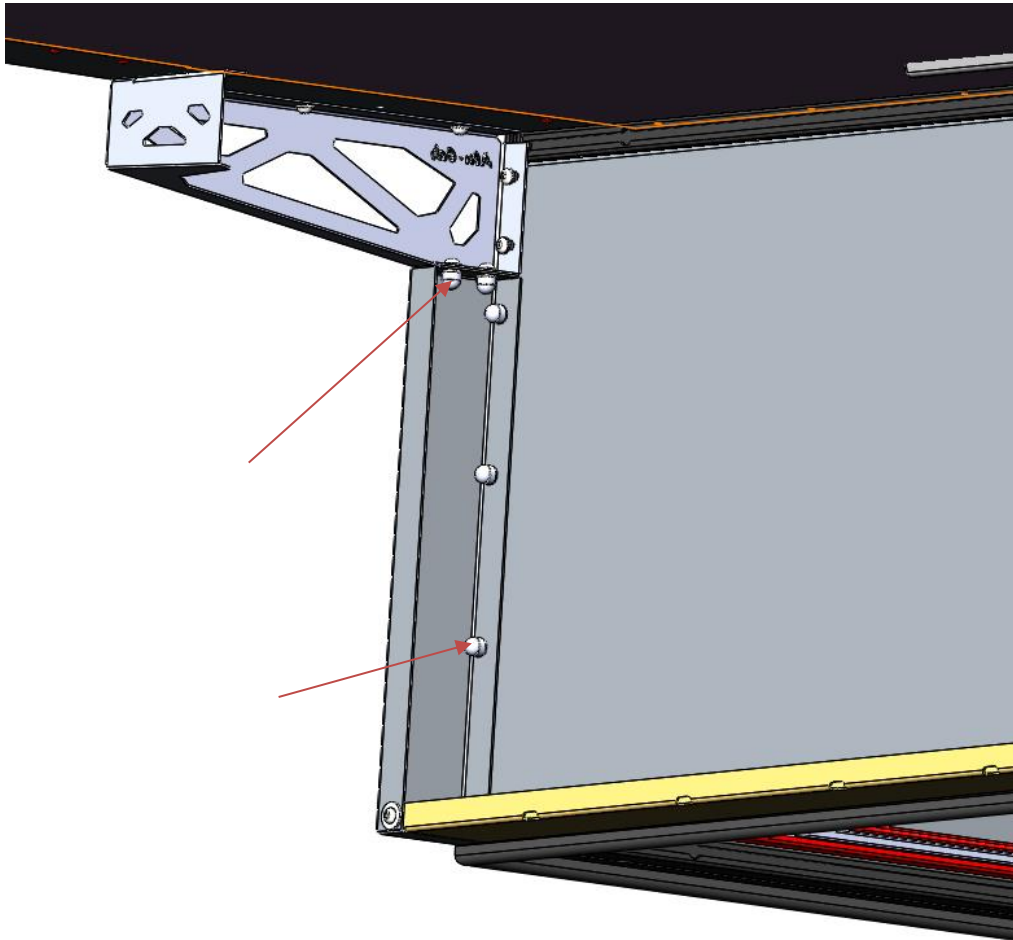
7.1 Front filler panel assembly.



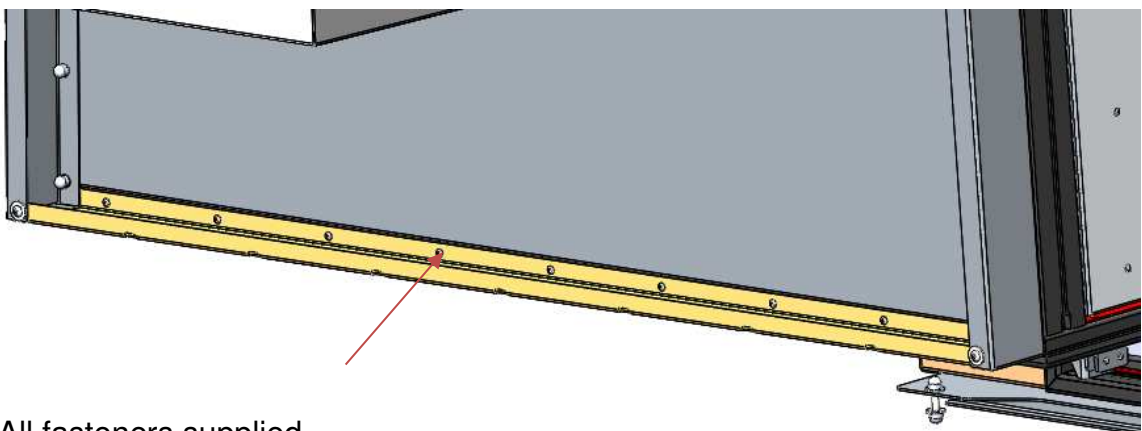
7.1 (b) Fitting of front filler panels for GEN 2 & 3 SB Tacoma's.



7.2 Bolt side panels to frame of camper and onto the Reinforcement bracket as shown.

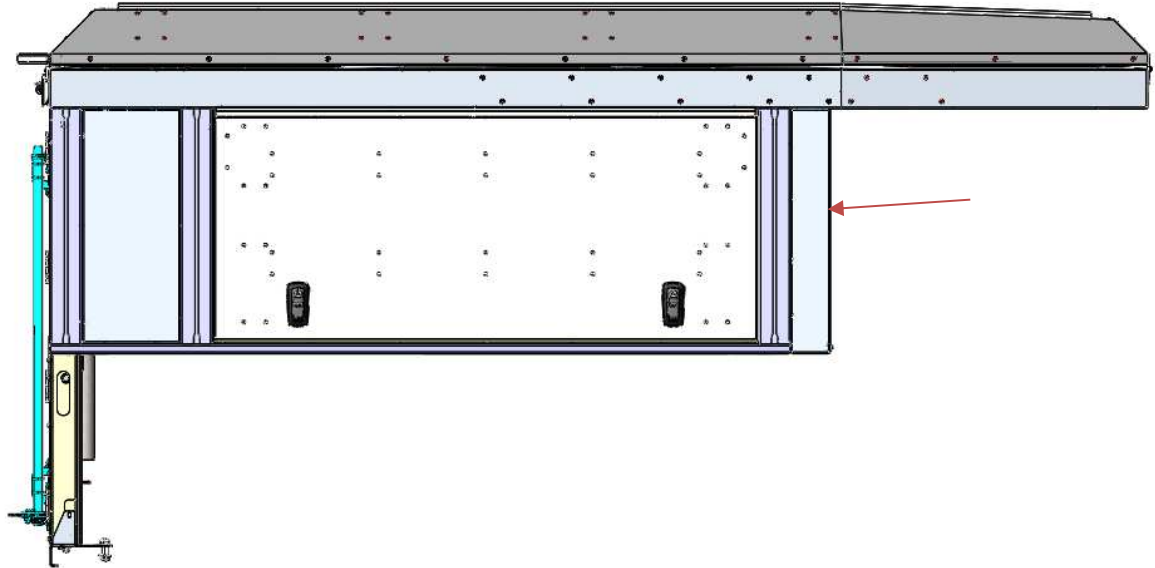


7.3 Rivet bottom filler panel on to bottom frame member using Ø4.8x15 sealed rivets

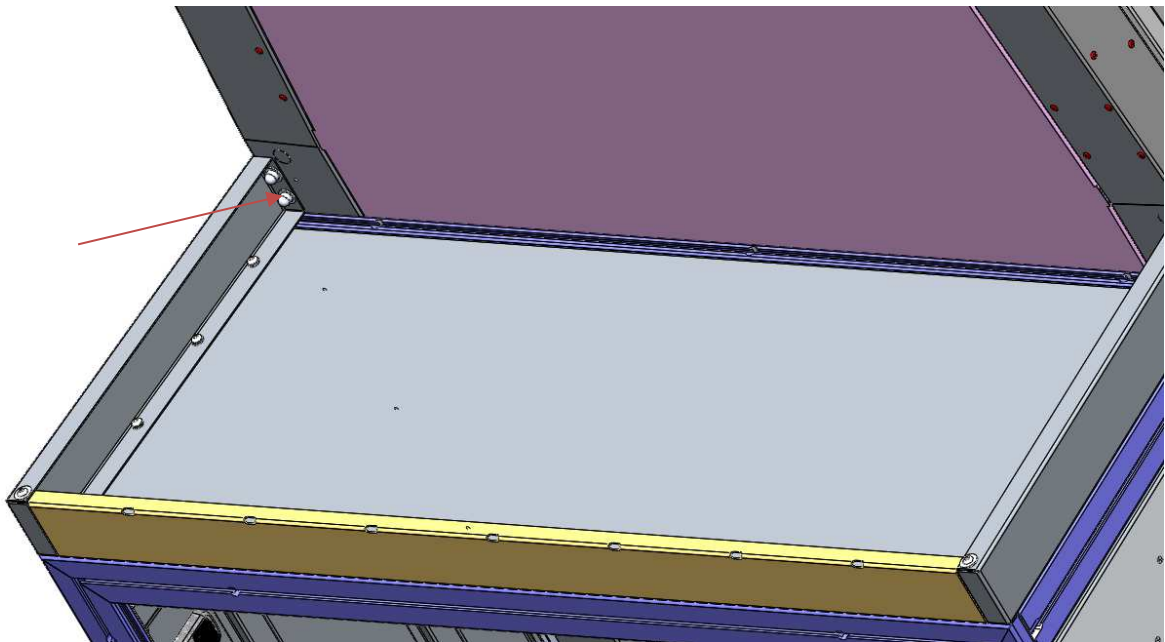


7.4 All fasteners supplied.

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.

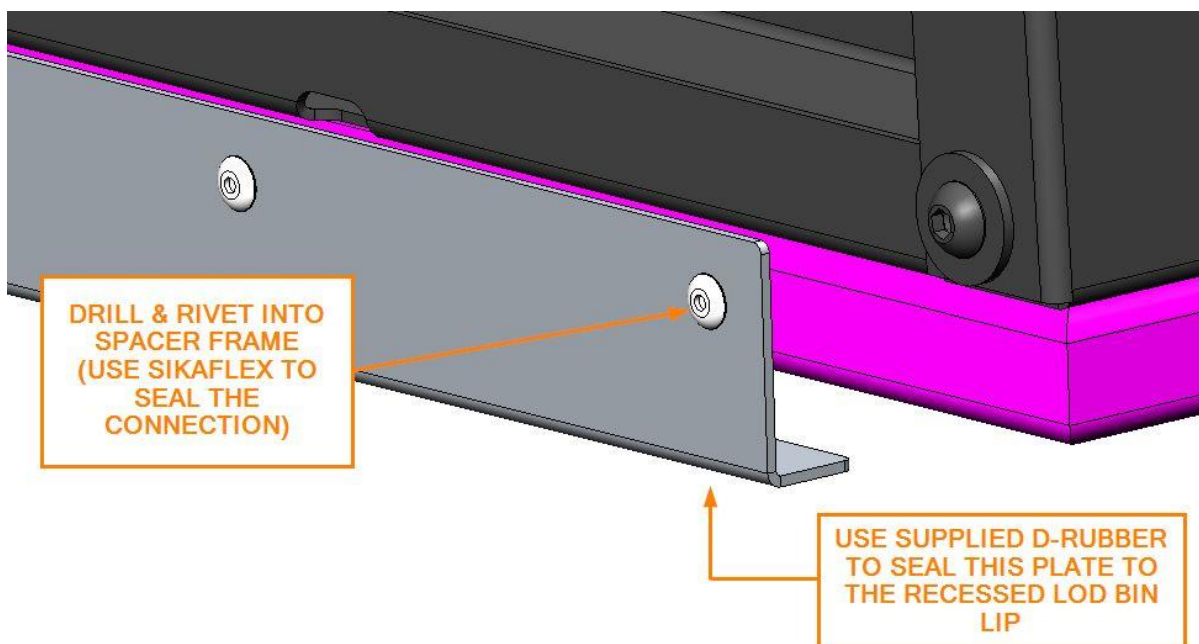
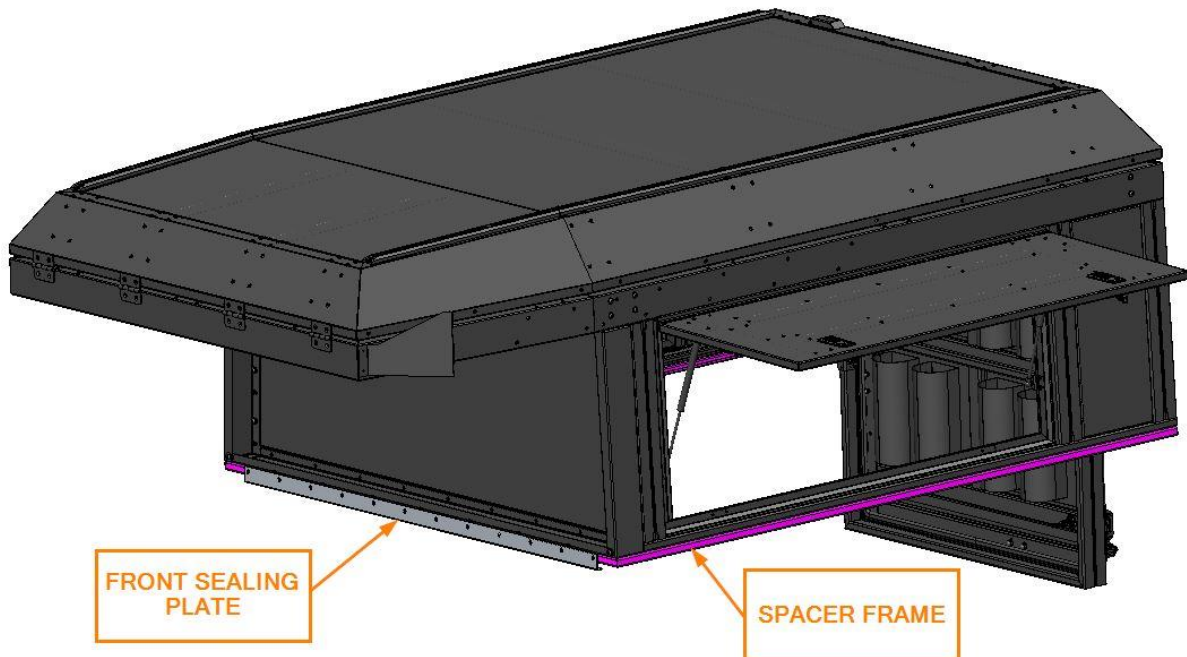


8.2



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

Tacoma GEN 2 - Front Sealing Setup



FRONT SEALING PLATE

RELEASED FOR MANUFACTURE					
DATE	03 October 2019				
SIGNED					

E

D

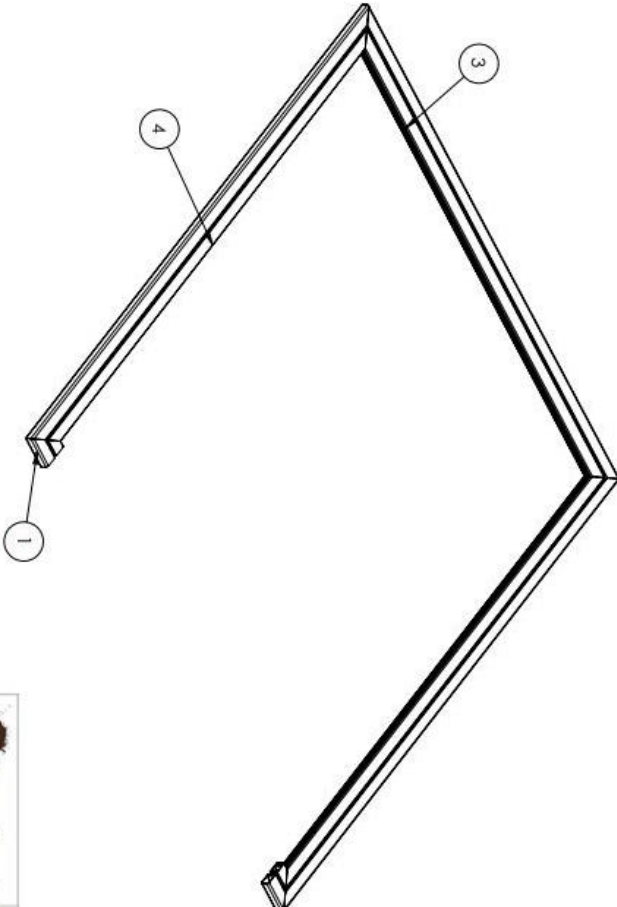
C

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY.	QC CHECK
1	292-SB-2015-FNT-SEAL-01-00	FRONT SEAL	1060 Alloy (2mm)	1	
2	AS4815 Rivet	Blind Rivet	AL5052	12	

Spacer frame for (GEN2 SB)

RELEASED FOR MANUFACTURE			
DATE	09 September 2019		
SIGNED			

ITEM NO.	QTY.	DESCRIPTION	LENGTH	CHECK
1	2	Std Load Bar	97	
2	1	Std Load Bar	1640	
3	1	Std Load Bar	1600	
4	1	Std Load Bar	1640	



NAME	DATE	PROJECT
T.M.	18 Apr 2019	TAC 2G DC CANOPY CAMPER

DESCRIPTION	SIZE	REV
FILTER PIECE FRAME	162-TAC-2G-DC-FILTER-FRA-01	
	A3	
	6063-T6	
	SCALE: 1:10	
	WEIGHT: 5854.73	
	SHEET: 1 OF 2	

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Space frame 3 GEN2 LB

REPRODUCED FOR MANUFACTURE		DATE		09 September 2019		SIGNED	
ITEM NO.	QTY.	DESCRIPTION	LENGTH	Q/C 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				

Technical drawing of a space frame structure. Callout 1 points to a corner joint, callout 3 points to a top horizontal bar, and callout 4 points to a diagonal support bar.

NAME	DATE	PROJECT
DRAWN: TM	18 Apr 2019	TAC 2G XC CANOPY CAMPER
CHECKED:		
APPROVED:		

DESCRIPTION: FILLER FRAME XC

SIZE: DRAWING No. 162-TAC-2G-XC-FILLER-FRA-01

REVISION: 6063-16

MATERIAL: 6063-T6

SCALE: 1:10

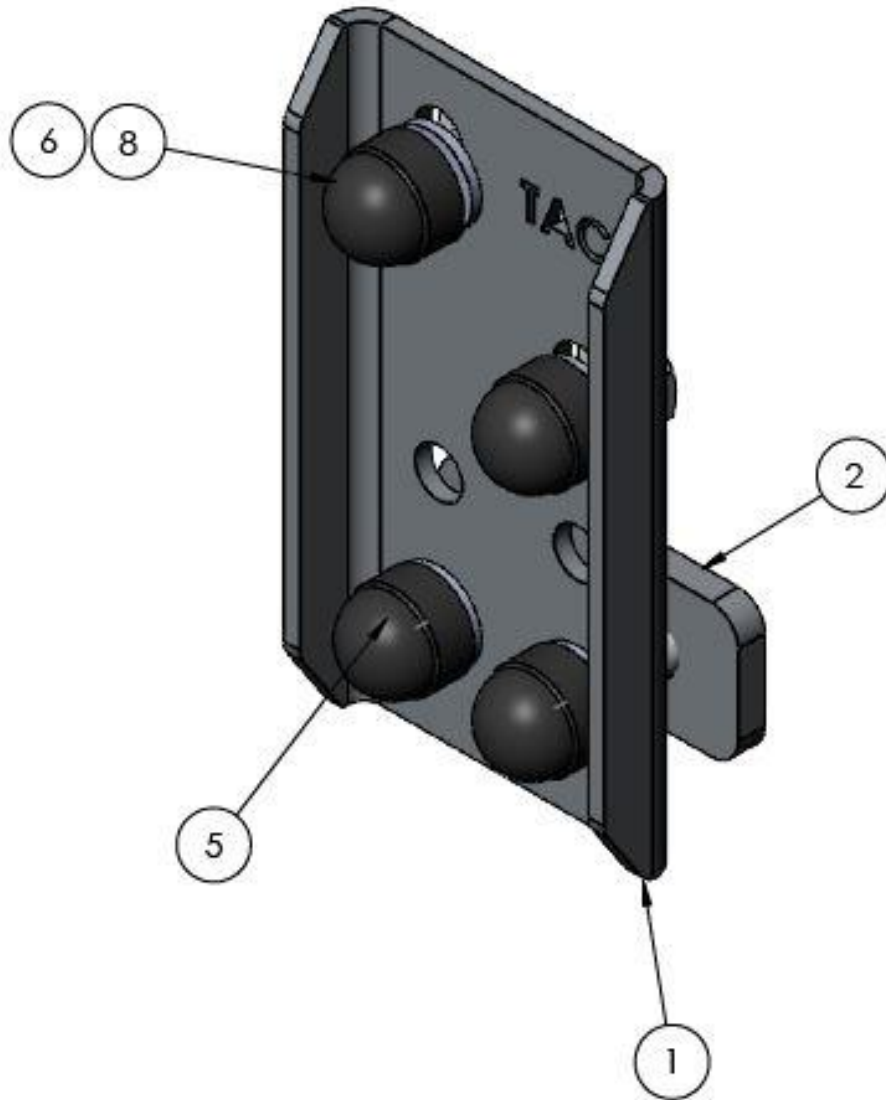
WEIGHT: 11223.68

SHEET: 1 OF 2

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Fax: +27 21 703 9510

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:

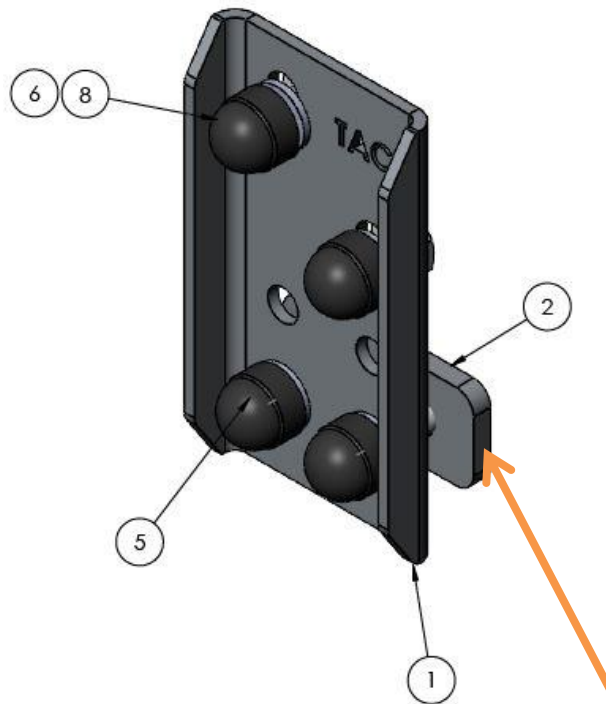


Figure 1: The above Plate with threaded holes is inserted into the below rail inside the Load Bin



Figure 2: Rail inside the Load Bin

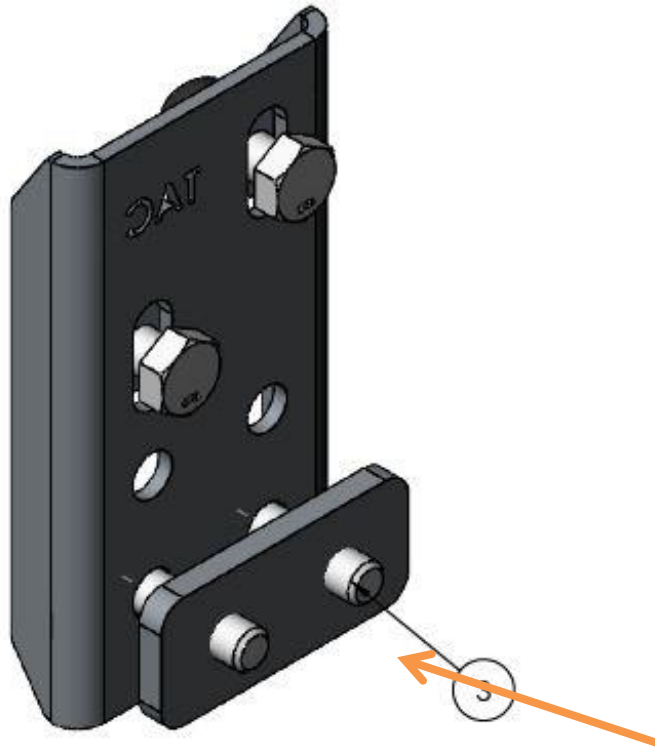


Figure 3: The above Plate is a spacer between the Load Bin Rail and Bracket, the gap between the 2 Plates represents where the Rail would fit between

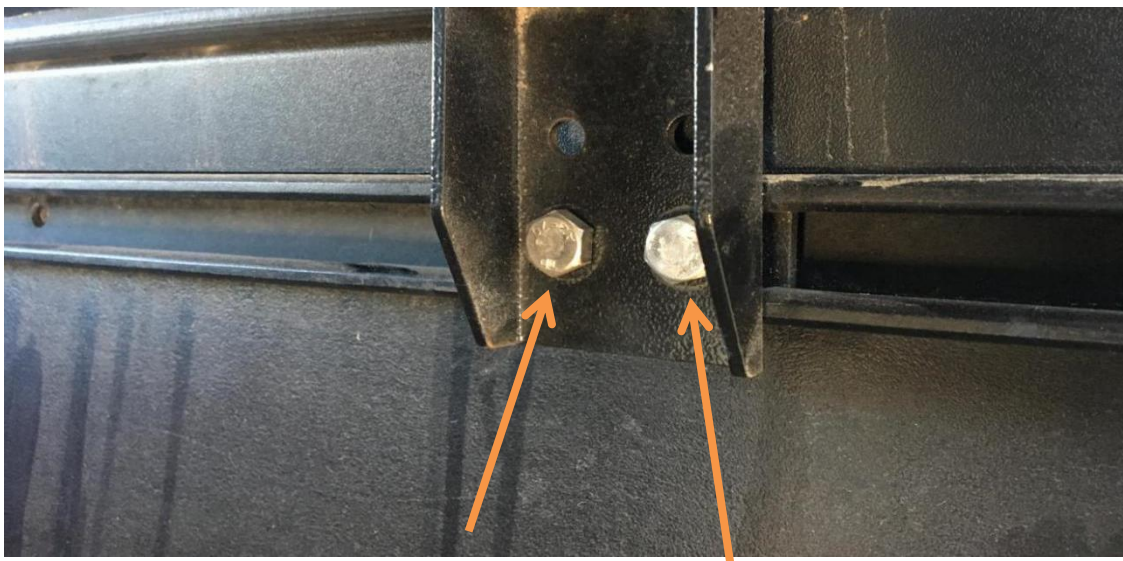


Figure 4: You will fasten through these holes with 2 Button Head Bolt, Flat Washers and Spring Washers

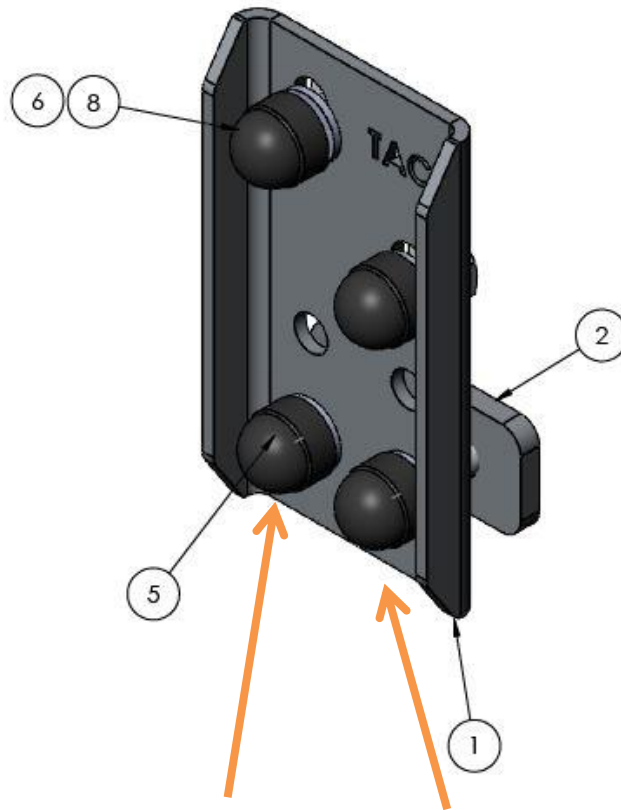


Figure 5: Button Head Bolts with Flat Washers and Spring Washers

Step 2: Installing Top Half of the Tacoma Mounting Brackets

Figure 6: Insert Hex Bolt into the Side Nut Slot of the Canopy Camper Frame

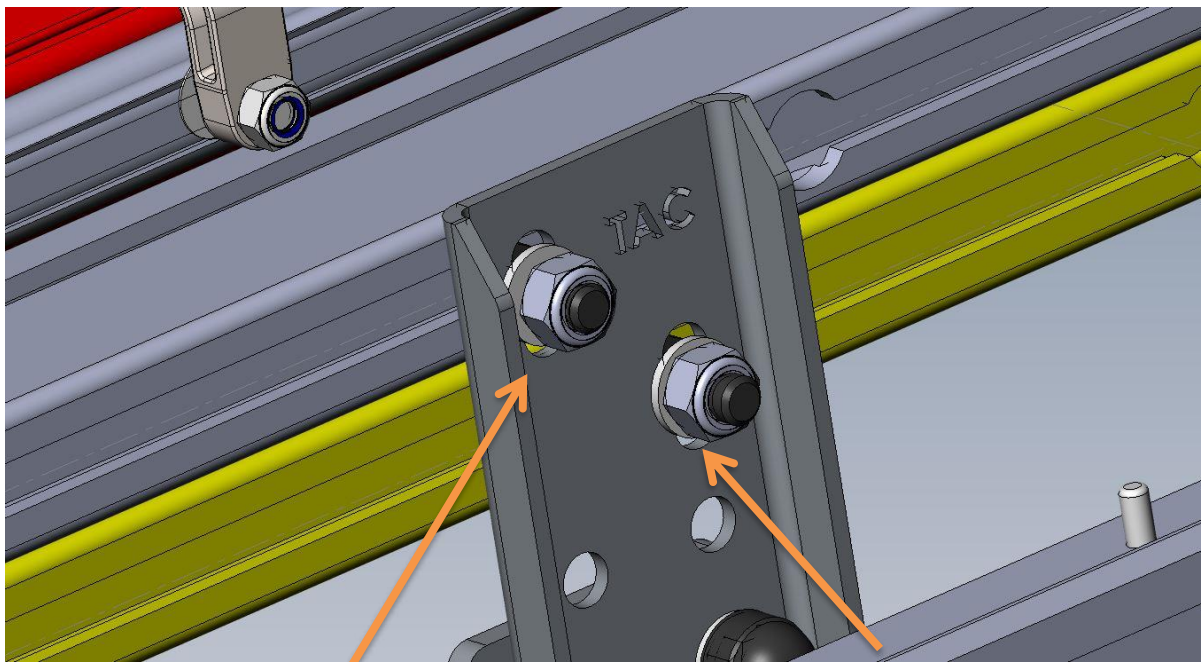


Figure 7: Next we need to place the Hex Bolt in the Nut Slot and place a Flat Washer afterwards. Fit nut caps to all bolt heads

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

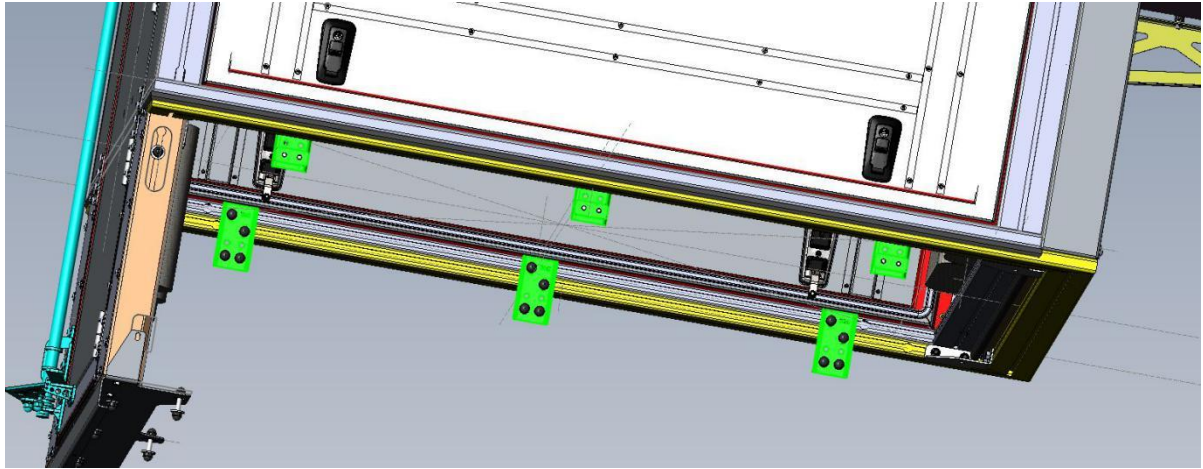
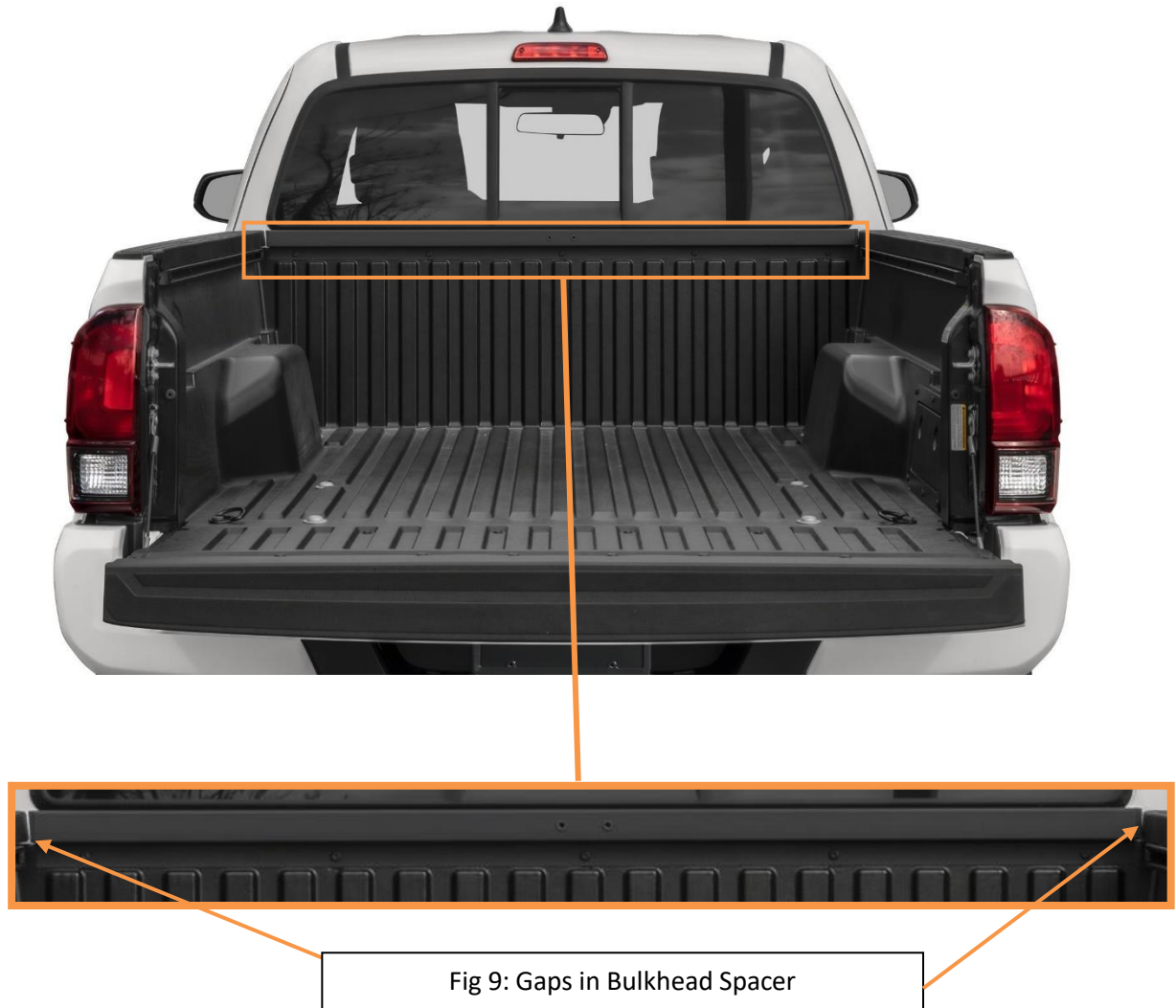


Figure 8: All Mounting Brackets in their correct positioning

NB! The Canopy Camper must rest solely on the mounting brackets and no load is allowed on the load bin. Once this is completed, the Canopy Camper has been installed successfully and sealing can begin.

3. Sealing the Front Bulkhead Spacer

The Gen 3 models of the Tacoma have a front bulkhead spacer bracket is included as a stock item. The mounting and fitment kit for the Gen 2 models comes with a front sealing bracket which needs to be sealed as indicated below.



The bulkhead spacer bracket pictured above does not seal on to the load bin. To remedy this butyl tape (3M window weld) can be used. The butyl tape is applied to the gaps indicated above, apply it as a putty and ensure that a large amount is used to ensure the best seal possible.

The finished Canopy Camper should look like figures 10 and 11 below.

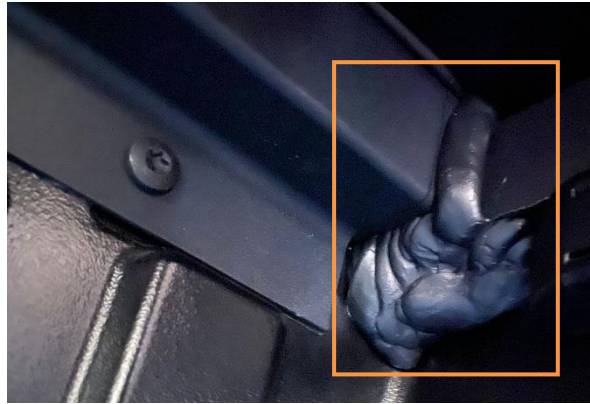


Figure 10: Window Weld Applied on Inside of Load Bin



Figure 11: Window Weld Applied on Outside of Load Bin