

Preparation

Part Number: PT973-35242, PT973-352423

Kit Contents

Item #	Quantity Reqd.	Description
1	1	Swingcase
2	1	Hardware Bag
3		

Hardware Bag Contents

Item #	Quantity Reqd.	Description
SM1126BD	1	Truck Bracket
SM0344SD	1	Striker Bracket
100933	2	Bolt Plate
FS1028PR	6	3/16" Pop Rivets
IH1293FW	2	M6 Washer
IH1292LW	2	M6 Lock Washer
100144	2	M6 Nut

Additional Items Required For Installation

Item #	Quantity Reqd.	Description
1		
2		
3		

Conflicts

Bed Extender, Spray in Bed Liner, Bed Rack

Recommended Tools**Personal & Vehicle Notes****Protection**

Eye protection	When drilling
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Special Tools

Drill Jig	
5 mm drill bit with stop	
6.5mm drill bit with stop	
1/16" drill bit with stop	
1/8" drill bit with stop	
13/64" drill bit with stop	

Installation Tools

10mm wrench or socket	
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Special Chemicals

	Notes
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General Applicability**Recommended Sequence of Application**

Item #	Accessory
1	
2	
3	

Vehicle Service Parts (may be required for reassembly)

Item #	Quantity Reqd.	Description
1	1	PT973-35242-BL(BR), Bracket Kit
2	1	PT973-34221-KS, Key Set
3		

Legend

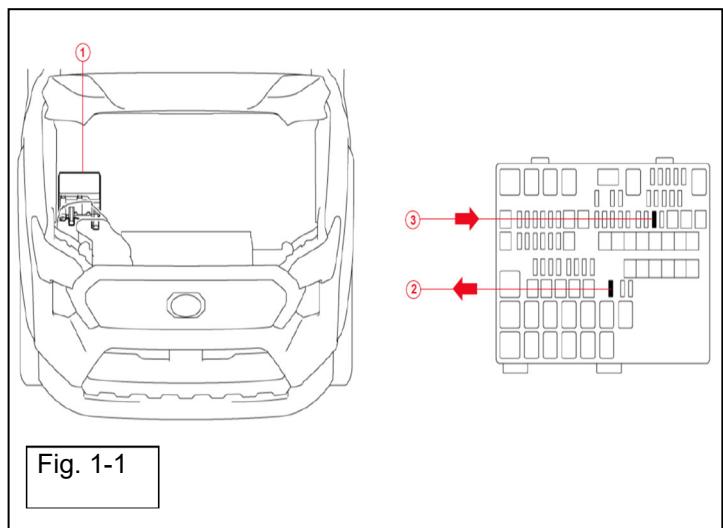
	STOP: Damage to the vehicle may occur. Do not proceed until process has been complied with.
	OPERATOR SAFETY: Use caution to avoid risk of injury.
	CAUTION: A process that must be carefully observed in order to reduce the risk of damage to the accessory/vehicle and to ensure a quality installation.
	TOOLS & EQUIPMENT: Used in Figures calls out the specific tools and equipment recommended for this process.
	REVISION MARK: This mark highlights a change in installation with respect to previous issue.
	SAFETY TORQUE: This mark indicates that torque is related to safety.
	REGULATORY MARK: This indicates the component is related to regulatory compliance.

Procedure

Care must be taken when installing this accessory to ensure damage does not occur to the vehicle. The installation of this accessory should follow approved guidelines to ensure a quality installation. These guidelines can be found in the "Accessory Installation Practices" document. This document covers such items as:

- Vehicle Protection (use of covers and blankets, cleaning chemicals, etc.).
- Safety (eye protection, re-checking torque procedure, etc.).
- Vehicle Disassembly/Reassembly (panel removal, part storage, etc.).
- Electrical Component Disassembly/Reassembly (battery disconnection, connector removal, etc.).

Please see your Toyota dealer for a copy of this document.



1. For 25MY vehicles equipped with Power Tailgate, install short pin to open/close tailgate if vehicle is not equipped with Power Tailgate, proceed to Step 2.

- (a) To open/close the power tailgate, install the short pin
- (b) Identify Relay Block/Fuse Panel in engine compartment (1). (Fig. 1-1)
- (c) Remove short pin from home location (2) and insert short pin into designated location (3). (Fig. 1-1)

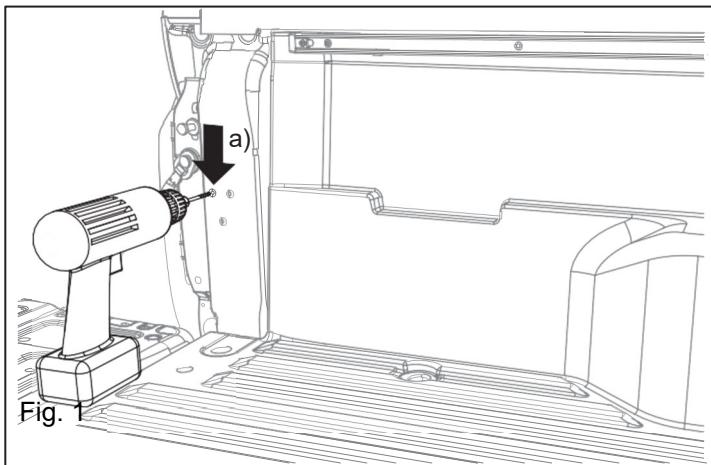
Procedure

Fig. 1

1. Drill through bed wall dimple, Fig. 1.

(a) Use a series of drill bit sizes with depth stops set for 25mm, drill through the upper-rear dimple in the truck bed metal. First with a 1/16" bit, then a 1/8" bit and last with a 13/64" bit.

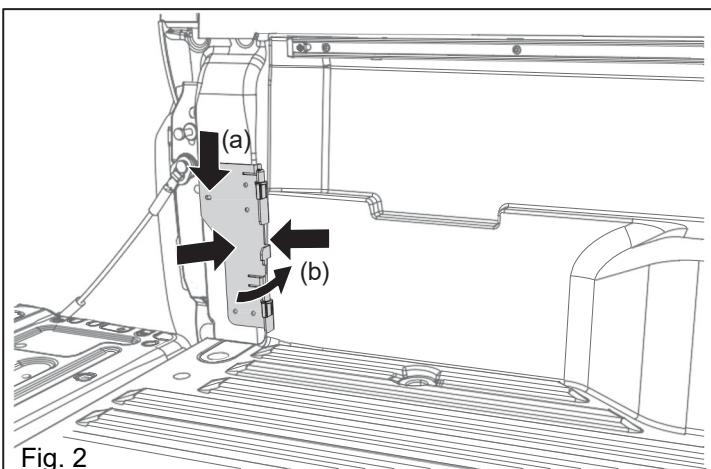


Fig. 2

2. Use the truck bracket as a guide, Fig. 2.

(a) Place the bracket on the truck bed and line up the hole in the bracket with the hole drilled in Step 1, Fig. 1. Use a rivet in the hole to temporarily place the bracket's location.

Make sure that the holes line up and that the bracket is flat against the truck bed and firmly set around the
(b) outside edge of the bed wall.

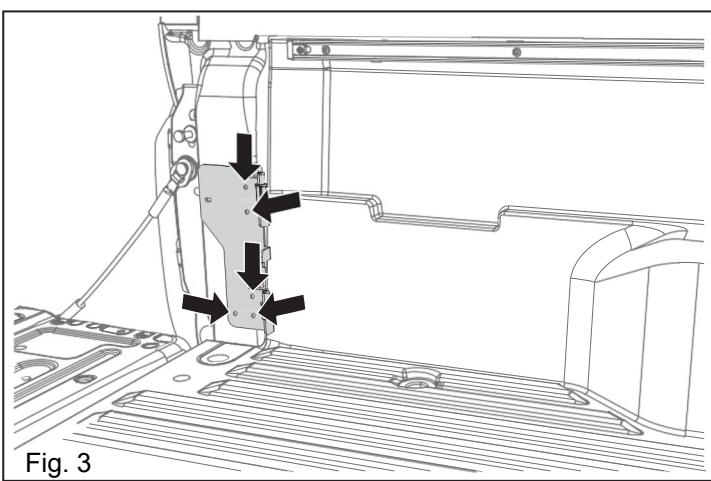


Fig. 3

(c) With the holes aligned and the bracket held firmly in place, mark the location on the truck bed of the five holes shown with a transfer punch.

Fig. 3.

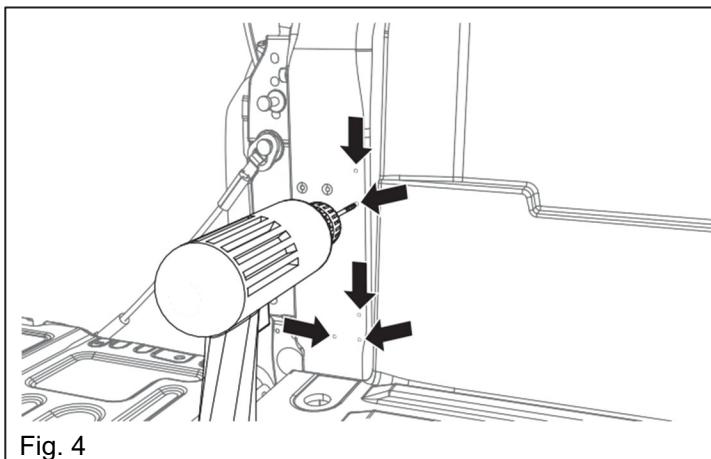
Procedure

Fig. 4

3. Drill through bed wall, Fig. 4.

(a) Use a series of drill bit sizes with depth stops set for 25mm, drill through each of the five transfer punch locations.

First with a 1/16" bit, then a 1/8" bit and last with a 13/64" bit.

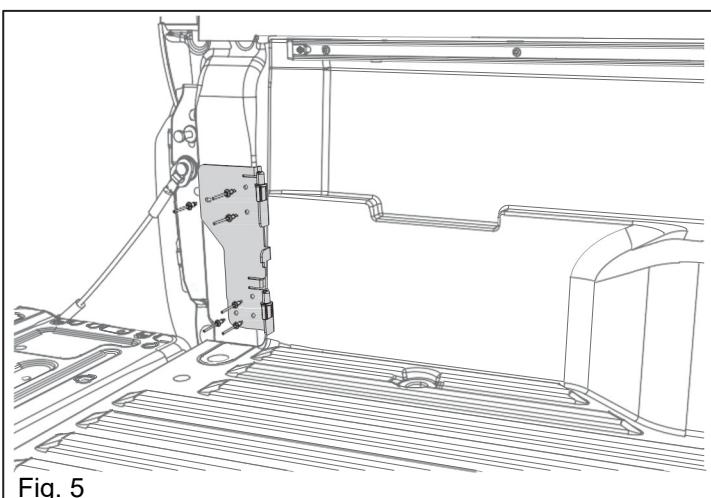


Fig. 5

4. Install the truck bracket, Fig. 5.

(a) Place the bracket over the holes drilled in Step 3, Fig. 4.

(b) Use six 3/16" stainless steel pop rivets to mount the bracket to the truck bed.

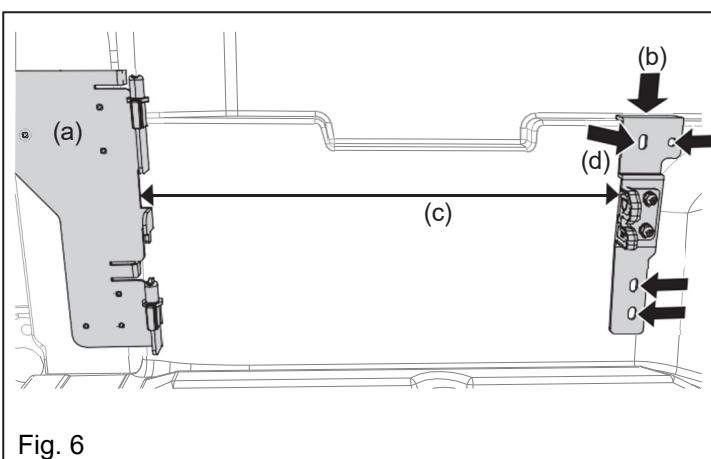


Fig. 6

5. Install the latch bracket, Fig. 6.

(a) With the truck bracket mounted,
(b) Hang the latch bracket on the bed wall edge.

(c) Measure 18" from the inside edge of the truck bracket to the edge of the latch bracket.

(d) Mark each of the four hole locations with a transfer punch.



Procedure

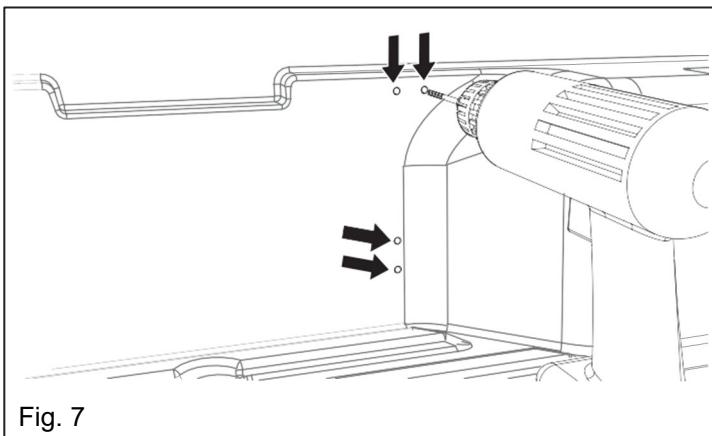


Fig. 7

6. Drill through bed wall, Fig. .

- (a) Use a series of drill bit sizes with de stops set for 25mm, drill through each of the five transfer punch locations. First with a 1/16" bit, then a 1/8" bit and last with a 6.5mm bit.

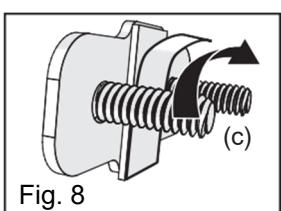


Fig. 8

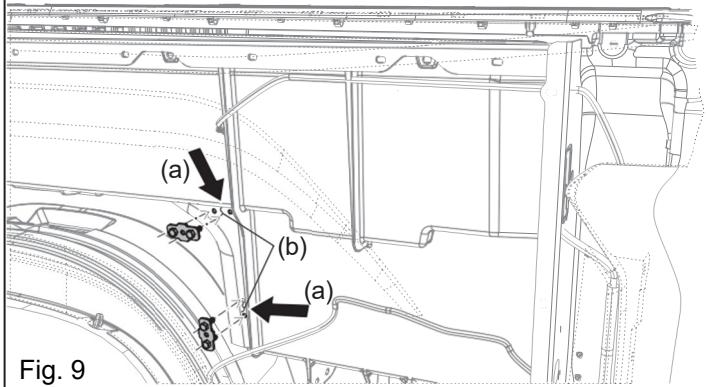


Fig. 9

7. Locate the four holes, install the bolt plates, Fig's 8 & 9.

- (a) Access the inside of the bed wall and locate the four drilled holes, Fig. 9. Clean surface area with shop towel.
! Caution that burs and edges can be sharp. Careful to not crease fender liner.
(b) Check that the area between the drilled holes where the adhesive must stick is clear of dirt and debris, Fig. 9.
(c) Remove the protective film from the adhesive prior to installing each plate, Fig. 9. Install a bolt plate into each (2 total) pair of drilled holes, Fig. 9. Apply pressure to the bolt plate to ensure adhesion.

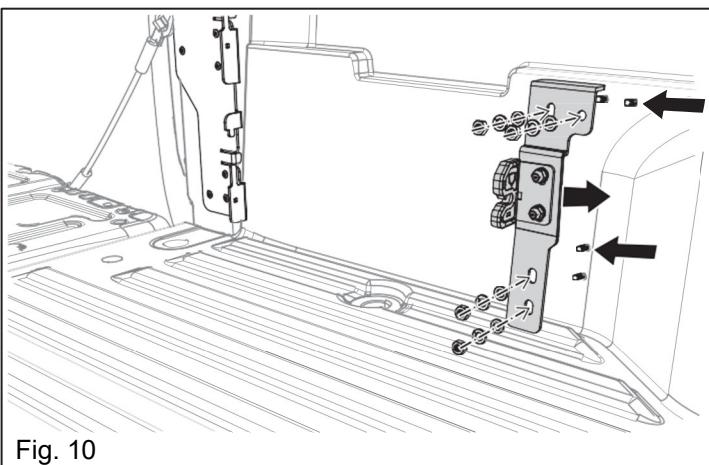
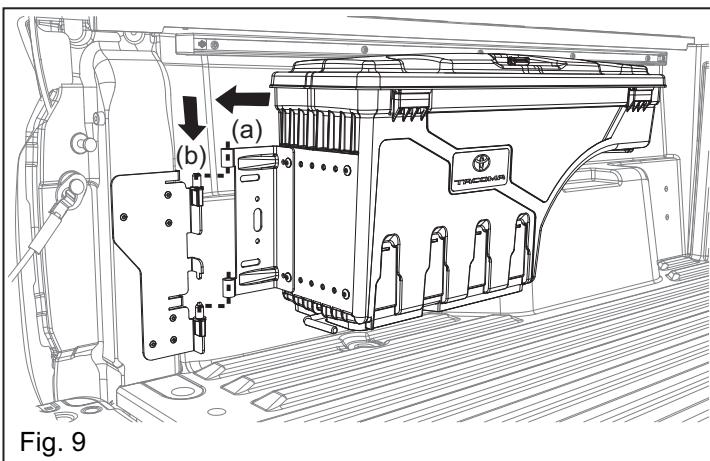


Fig. 10

8. Install the striker bracket, Fig. 10.

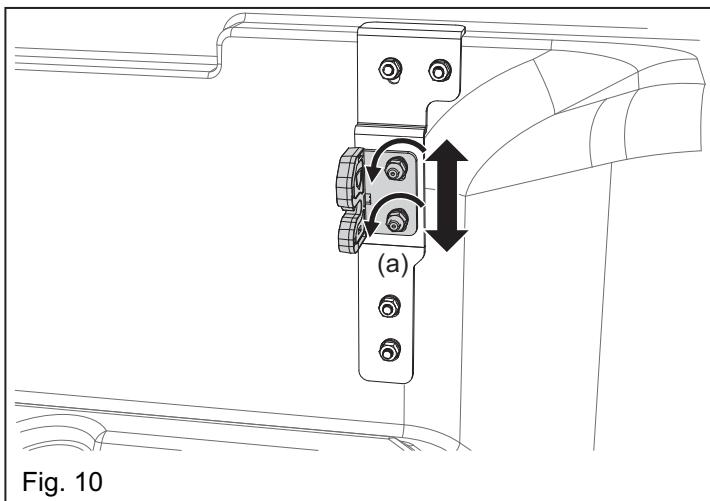
- (a) Install the striker bracket to the bolts in the bed wall.
(b) Install four M6 flat washers, four M6 lock washers and four M6 nuts to each bolt. Use a 10mm wrench or socket and tighten the four nuts to 10 +- 1.0 Nm.

Procedure



9. Install the Swingcase, Fig. 9.

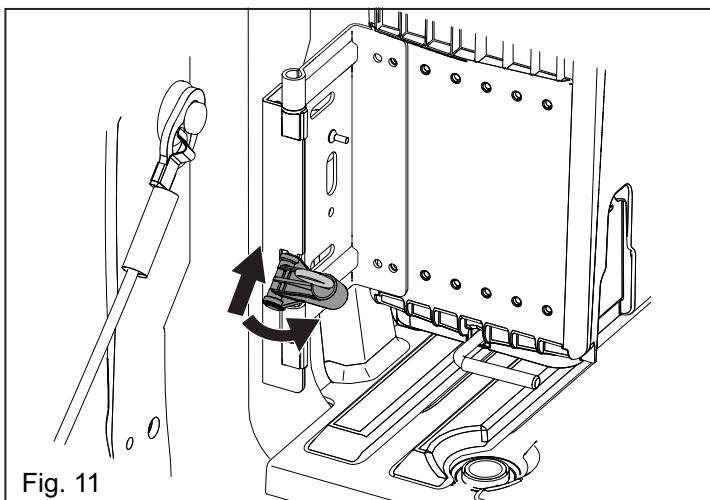
Lift the case, align the openings of the (a) case bracket to the pins of the truck bracket (b) and lower the Swingcase onto the pins. Swing the case closed to the truck bed and latch.



10. Latch adjustment, Fig. 10.

After installation the latch mechanism can be adjusted to level or better engage with the Swingcase.

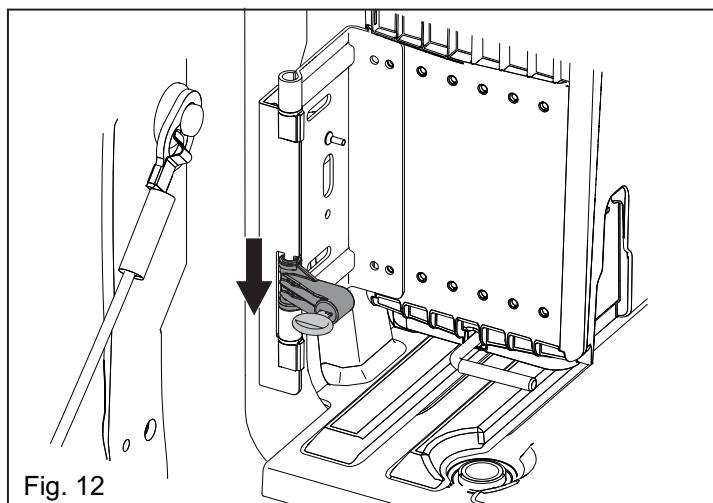
(a) Loosen the latch nuts and move the latch up or down. Retighten the latch when the adjustment is completed with a 10mm wrench or socket to 10+- 0.1 Nm.



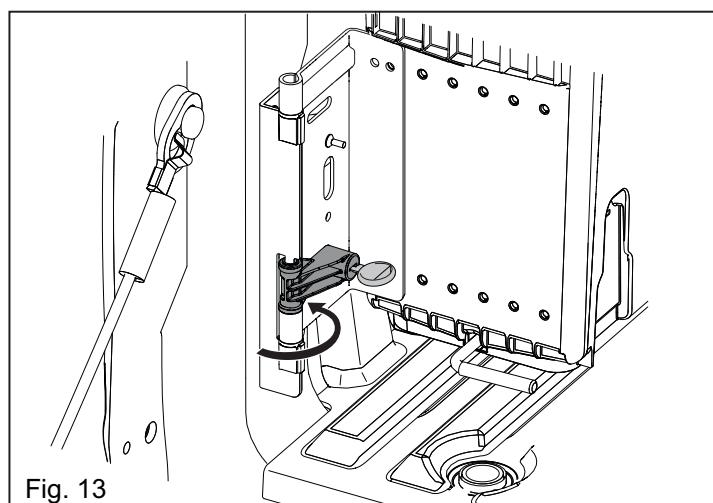
11. Install the Pivot Lock, Fig's. 11 - 14.

(a) Insert the supplied pivot lock at an angle between the lower tab and the top of the lower pivot bushing. While pushing upward on the pivot lock, rotate the pivot lock into position over the top of the lower pivot bushing.

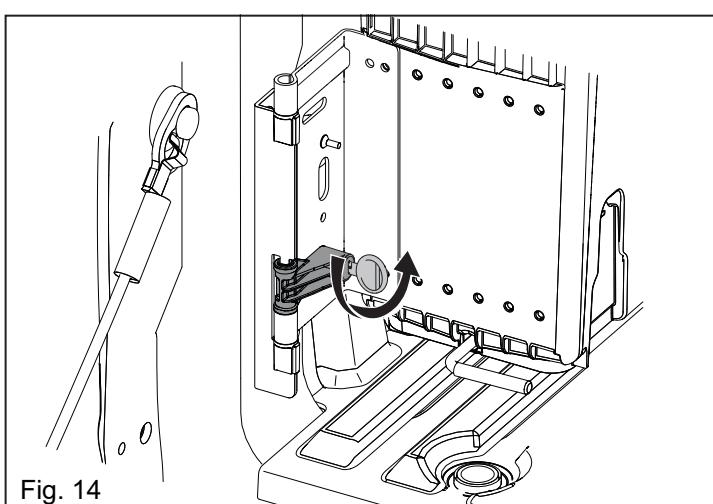
Procedure



(b) Once the pivot lock is over the top of the lower pivot bushing, slide the pivot lock down against the top of the pivot bushing.



(c) Rotate the pivot lock towards the box bracket, so that the pivot lock is against the bracket and lines up with the slotted hole in the bracket.



(d) Rotate the key 90 degrees into the locked position.

Note: Once the pivot lock is in the locked position, this will allow the user to still pull the release handle and swing the case out over the tailgate. The pivot lock will prevent the case from being fully removed.

Checklist - these points **MUST** be checked to ensure a quality installation.

Check:

Accessory Function Checks



Verify parts:

Look For:

Removed items have been discarded & replaced items are in place.

Vehicle Function Checks

Vehicle Appearance Check

- After accessory installation and removal of protective cover(s), perform a visual inspection.

Ensure no damage (including scuffs and scratches) was caused during the installation process.
(For PPO installations, refer to TMS Accessory Quality Shipping Standard.)