CHARVONIA DESIGN

Bed Stiffeners - 2024-25 4ᵗʰ Gen Toyota Tacoma

Tools Required:

- T55 Torx Bit
- 5/32" or 4mm Hex Bit
- 1/4" & 23/64" drill bit
- Rivnut installation tool

Parts Included:

- Bed Stiffeners, LS & RS
- M6x20mm Button Head Cap Screws, qty 6
- M6 Flat Washers, qty 6
- M6 rivnuts, qty 6

Parts Removed and Reinstalled:

- Rear bed bolts, qty 2

1. Remove rear bed bolts using a T55 Torx bit.

   *If you have a spray-in bedliner, cut around the washer with a knife, then remove the bedliner from inside the Torx using a small screwdriver or pick. Alternatively, you can use a small torch to melt the bedliner inside the Torx, being careful not to expose yourself to fumes. Use a hammer to lightly seat the T55 Torx bit into the bed bolt head, then remove bolts.

2. Position Bed Stiffener and re-install bed bolt. Check that the three bolt holes align with the factory dimples in the bed. Close tailgate to confirm clearance.

   *Note - These beds vary from truck to truck and Bed Stiffener may not align perfectly with dimples. Take care to align and install Bed Stiffeners properly.

3. Using Bed Stiffener as a guide, drill **ONE** 1/4" hole. Use a drill stop to avoid drilling into anything inside the bed.
4. Remove Bed Stiffener and use a 23/64" drill bit to carefully drill the first hole to its final size.
5. Using a rivnut installation tool, install the first M6 rivnut.
6. Re-install Bed Stiffener using bed bolt and one M6 Button Head Cap Screw. Tighten until snug, using care not to strip or spin rivnut.
7. Using Bed Stiffener as a guide, drill the remaining two holes using a 1/4" drill bit.
8. Remove Bed Stiffener, drill remaining two holes to final size using a 23/64" drill bit and install remaining two M6 rivnuts.
9. Install Bed Stiffener using factory bed bolt and three M6 Button Head Cap Screws with Flat Washers. Torque bed bolts to 60 ft/lbs. Tighten M6 Button Head Cap Screws securely, being careful not to cross-thread, strip, or spin rivnuts.
10. Repeat these steps on opposite side.