

Weld Together Pack Rack Instructions

Important notices:

These instructions are intended only as a general guide for installing All-Pro products. For some items, specialized mechanical skills, metal fabrication and/or welding skills may be needed for proper installation. If you have any doubts or questions about installing these or other parts please call us at the shop 951-926-4777 or contact a competent mechanic, fabricator, welder or other appropriate professional.

Aftermarket accessories are intended to modify and/or prepare a vehicle for uses that exceed conditions anticipated by the vehicle manufacturer. These uses may include high performance demands and negotiation of rough terrain. These conditions have extreme variance and cannot be controlled by the vehicle manufacturer or aftermarket accessory manufacturer, therefore, the safe control of your vehicle is entirely your responsibility. Do not purchase parts from All-Pro Off Road unless you are willing to accept this responsibility. Do not install any All-Pro part that you do not feel competent at installing without causing present or future injury to yourself or others; consult a professional installer.

All parts sold by All-Pro Off Road are for off road racing use only and are not intended for use on the street. Modification of your vehicle to enhance performance with the parts sold by All-Pro Off Road can result in dangerous situations that may result in bodily harm. The buyer hereby assumes all risks associated with any such modifications. All-Pro Off Road will not accept responsibility for personal injury or property damage arising from the failure of any parts manufactured or sold by All-Pro Off Road.

In an effort to provide both durability and safety, All Pro Off Road recommends you carefully read the entire installation procedure before beginning, then rigidly follow these instructions during installation. Also, it is extremely important that you abide by proper safety procedures including the use of jack stands, setting the parking brake, wearing eye protection, etc.



Parts Check List:

- 2 Bed Rails
- 3 Bed Hoops
- 4 Connector Pieces
- 4 Corner Gussets
- 8 Square Rail Inserts (05+ only)
- Hardware

Assembly Instructions:

Park vehicle on level ground, apply parking brake. Protect back and sides of cab from welding slag. Mount bed rails on truck using 4 bolts and square plates, slid into side rails as far forward as possible (95-04 Tacomas require drilling bolt hole on inside of bed rail). Be sure and double check that they are even from side to side. Measure bed rails lengthwise and mark a center line.



Place Front hoop $\frac{1}{4}$ " from front edge of bed rail, centered from side to side and tack weld in place. Be careful welding on top of plastic bed rails, they will melt with too much heat. Place center hoop on center line from earlier, centered left to right and tack weld in place. Place rear hoop $\frac{1}{4}$ " from rear of bed rail and tack in place.

Carefully place connector pieces on top side of hoops, 3"-5" inside from the start of the top bends. Once placed, wrap a ratchet strap from the front hoop to the rear hoop and apply a small amount of pressure to hold the connectors in place. Square and line up connector tubes and tack weld in place. Position corner gussets on 4 upper corners of the Pack Rack (inside or outside of connector tubes), and tack weld in place.



At this point add a few more tack welds to each joint, and add any desired additional gussets/strap hooks/mounts at this time. Carefully remove rack from vehicle (requires 2 people), keeping ratchet strap in place to help hold the rack together. Place on a welding table or on the ground and finish welding each joint carefully. Try not to distort the rack too much. After welds have cooled off, clean with paint thinner and finish as desired (semi-gloss automotive enamel recommended). Install rack using 8 bolts and square rail plates (it might be helpful to apply *light* pressure with ratchet strap to squeeze together rails when setting in place). Enjoy your new All Pro Pack Rack!