



2007 Toyota Roll Pan

PART# 6403



- 1 - Cross Bar Support
- 1 - License Plate Light
- 2 - Brackets 
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- 4 - 1/4-20 x 3/4" Hex head bolts
- 4 - 1/4" Washers
- 4 - 1/4 -20 Nyloc Nuts
- 2 - 10-32 x 1 1/2" Black Studs
- 2 - #10 Fender Washers
- 2 - 10-32 Flange Nuts
- 6 - 10-24 Fender clips
- 8 - 10-24 x 3/4" Phillips head bolts
- 2 - 5/16-18 x 3/4" Hex head bolts
- 2 - 5/16 Nyloc Nuts
- 2 - 5/16 Washers
- 8 - #8 x 3/4" Self Tapping screws



Start by completely dropping the spare tire. Do so by following the manufactures instructions for lowering the spare tire.



Locate and remove the (2) bolts holding the spare tire centering brackets. Do so by drilling the rivets holding the brackets in place using a 3/8" drill bit.



Next slide the bracket back by one hole as shown.



Attach using the supplied 5/16-18 x 3/4" bolt with the 5/16" washer on the top side and 5/16-18 nyloc nut to secure.



Locate the roll pan support cross bar.



Attach using the stock bolts as shown.



Locate the supplied corner pieces and attach the 10-32 x 1 1/4" stud in the mounting location shown above.

WARNING: THIS IS NOT A TOW BAR, DO NOT ATTEMPT TO USE THIS IN ANY TOWING MANNER.



Place the corner piece on vehicle with the stud going thru the stock square hole. When placing corner piece let inner lip tuck around the support bracket. Attach corner using supplied 10-32 flange nut and washer.



Install the license plate light by using the supplied 10-24 x 3/4" stainless steel bolts and 10-24 nyloc nuts without overtightening. Overtightening can cause the plastic light lens to crack.



Use of a second person to help hold roll pan in place will be necessary. Place roll pan into opening and center.



Check alignment of the entire roll pan, paying attention to the corner pieces for alignment.



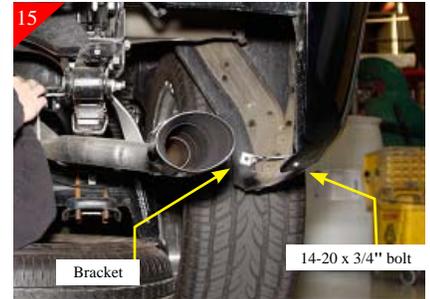
Locate the holes across top of roll pan, use these hole to attach roll pan. Tape using masking tape across the top of the roll pan and bottom of tail gate. This will protect both pieces during the attachment of the roll pan. Using the supplied self tapping screws attach roll pan as shown above. Note: when attaching roll pan place self tapping screw directly in the middle of the hole, this will give to a little adjustment for fine tuning the alignment.



Locate the holes placed in the back side of the roll pan directly behind license frame area. Place the supplied 10-24 fender clips on these holes. Attach roll pan to the cross bar by using the supplied 10-24 x 5/8" bolts.



Locate the pre-drilled hole in each end of the roll pan shown in (fig A). Using the pre-drilled hole as a guide drill into plastic of the corner piece using a 1/4" drill bit. Secure each end of the roll pan using the supplied 1/4-20 x 3/4" and 1/4-20 nyloc nuts.



Next you will be attaching the supporting brackets that attach to the corner piece and to the bottom of the roll pan. Bracket shown above is being shown without the roll pan in place in order to show the bracket and it's attachment point to the corner. Attach bracket by using the stock hole located in corner and drill using a 1/4" hole thru the plastic. Then attach bracket using the 1/4-20 x 3/4" bolt with washer on the head side of the bolt and 1/4-20 nyloc nut. Next locate the slotted hole in the roll pan, place supplied 10-24 fender clip and attach bracket to this area using the supplied 10-24 x 3/4" bolt.



Attach straight bracket to bottom of the roll pan using the pre-drilled hole. First place supplied 10-24 fender clip on pre-drilled hole and attach bracket using 10-24 x 3/4". Then attach to the cross bar as shown using the supplied #8 x 3/4" self tapping screws.



Secure the spare tire back using the manufactures instructions for putting the spare tire to its resting location.