

# INSTALLATION INSTRUCTIONS

## ALUMINUM BED TOPPER

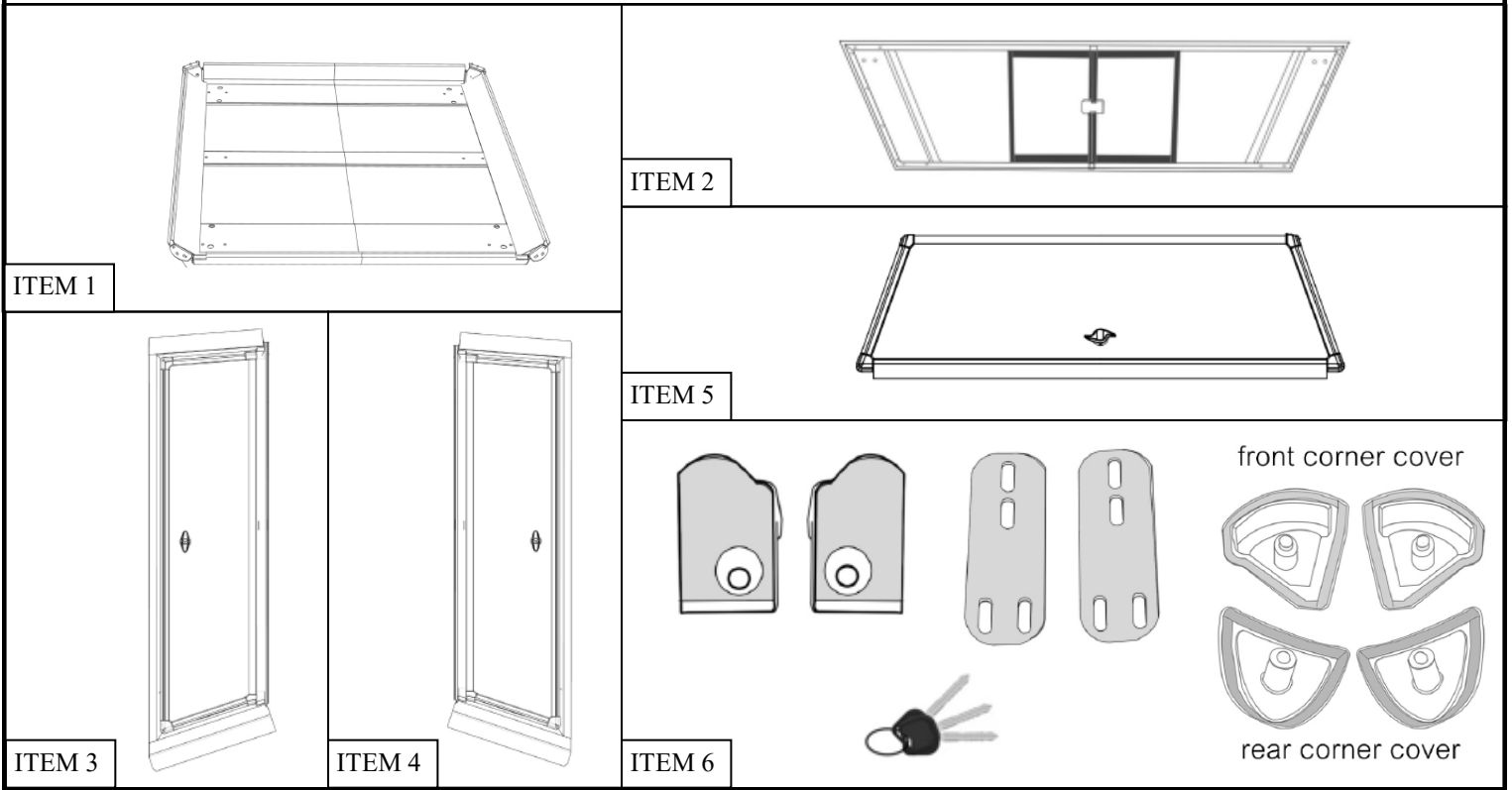


**APPLICATION:**  
2024-2025 Toyota Tacoma 5.2' bed

**PART NUMBER:** 16-12785S  
16-12785

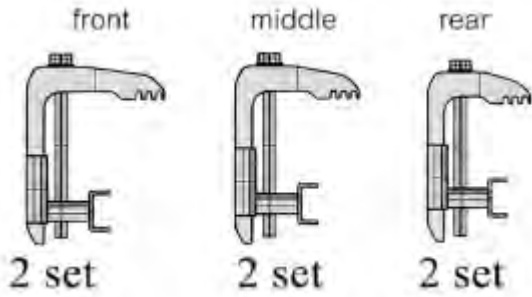
CONTENT			
ITEM	QUANTITY	DESCRIPTION	TOOLS NEEDED
1	1	ROOF PANEL	13mm SOCKET
2	1	FRONT PANEL	12mm SOCKET
3	1	LEFT SIDE PANEL	10mm SOCKET
4	1	RIGHT SIDE PANEL	RATCHET
5	1	REAR DOOR	TORQUE WRENCH
6	1	PARTS KIT #1	5MM ALLEN KEY
7	1	PARTS KIT #2	PHILLIPS SCREW-DRIVER
8	1	PARTS KIT #3	
9	1	FRONT BED RAIL SUPPORT PARTS	
10	1	INTERIOR LOCK HARNESS	
11	1	LOCK/UNLOCK HARNESS	

**ANTI-SEIZE LUBRICANT MUST BE USED ON ALL STAINLESS STEEL FASTENERS TO PREVENT THREAD DAMAGE AND GALLING**



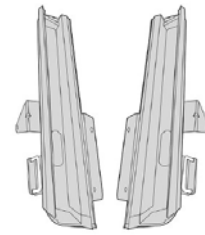
**WESTIN** Westin Automotive Products, Inc.  
320 W. Covina Blvd  
San Dimas, Ca. 91773

Thank you for choosing Westin products  
for additional installation assistance please call  
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ITEM 7

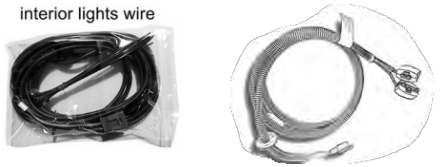
ITEM 8



ITEM 9



ITEM 10-11



**PROCEDURE**

1. Remove contents from box, verify if all parts listed are present and free from damage. Carefully read and understand all instructions before attempting installation. **Failure to identify damage before installation could lead to a rejection of any claim.**
2. With the roof panel secured on a flat surface, slide the rear door into the roof panel. (Fig. 1)
3. Next, use a Phillips screwdriver to screw the three (3) #6 x 3/8 pan head tapping screws from **Parts Kit #1 (Item 6)** to secure the rear door panel onto the roof panel. Cross section view A-A shows how the railing system works to attach these components together. (Fig. 2)

FIGURE 1

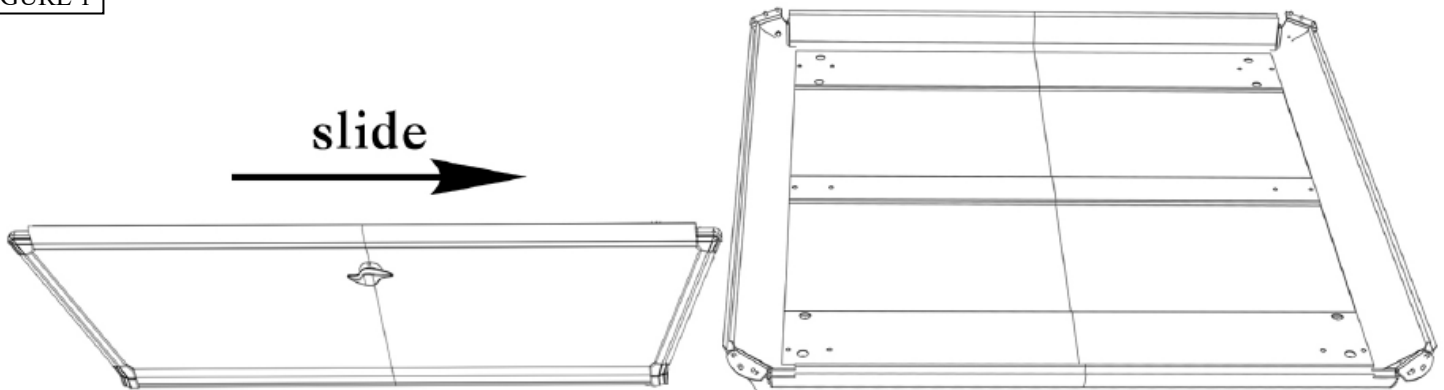
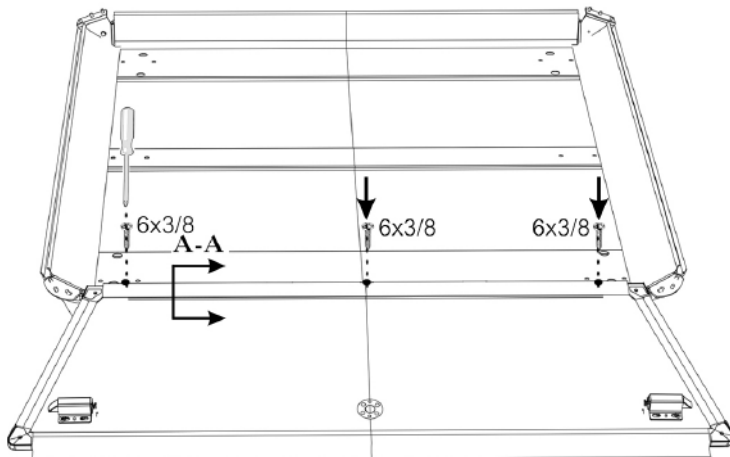
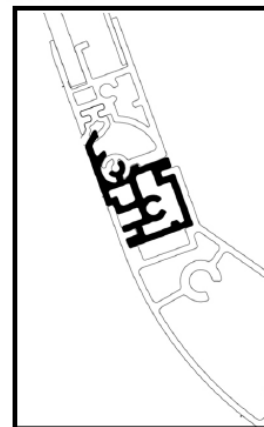


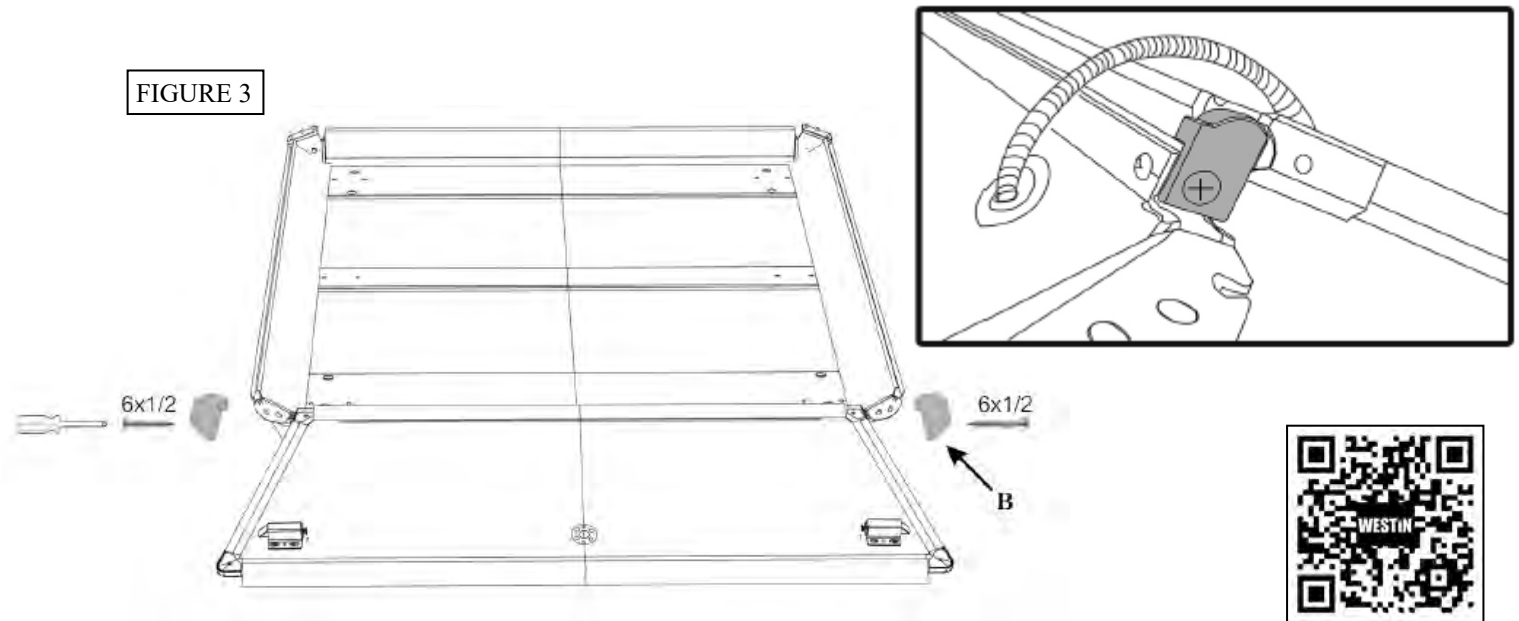
FIGURE 2



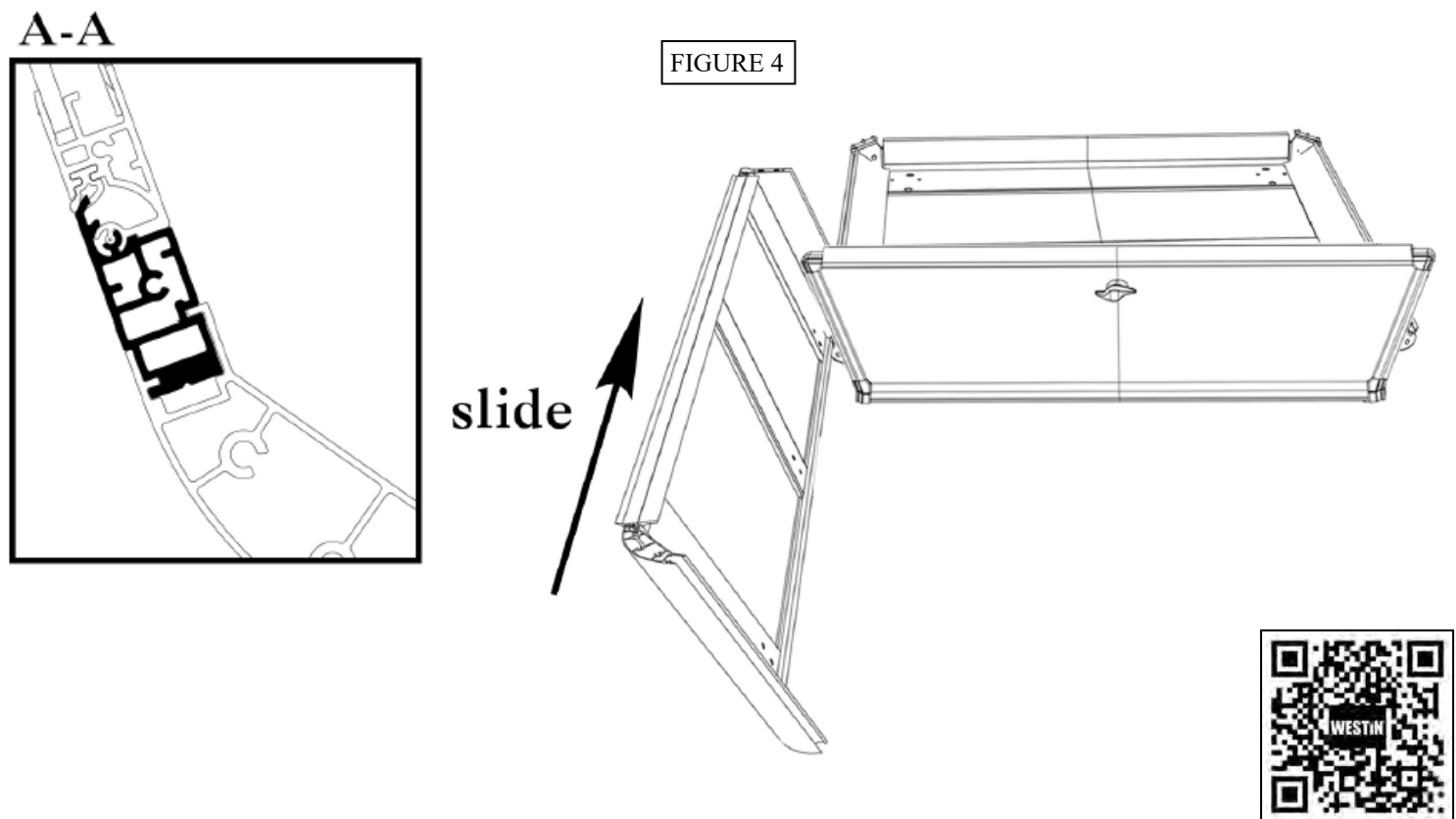
A-A



4. Screw in the rear door side covers using the two (2) #6 x 1/2 flat head tapping screws from **Parts Kit #1 (Item 6)**. The installation should look like the image below. **(Fig. 3)**

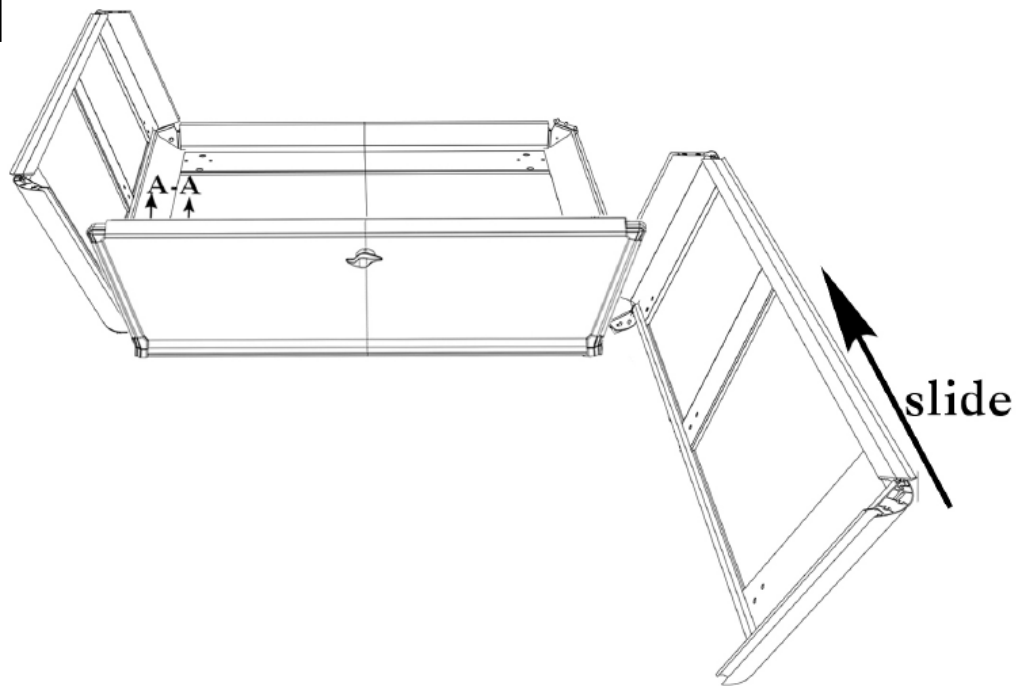


5. While lifting the rear door up, slide the left panel into the railing system. Section view A-A shows how the left panel slides into the roof panel. **(Fig. 4)**



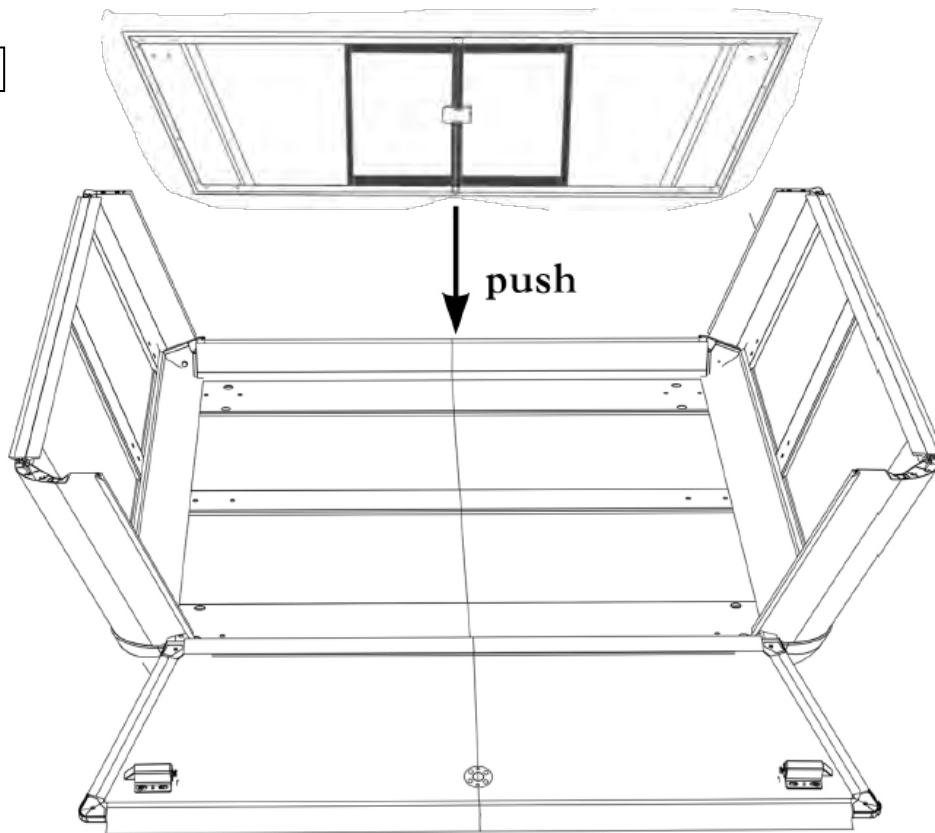
6. Repeat step 5 for the right panel. (Fig. 5)

FIGURE 5



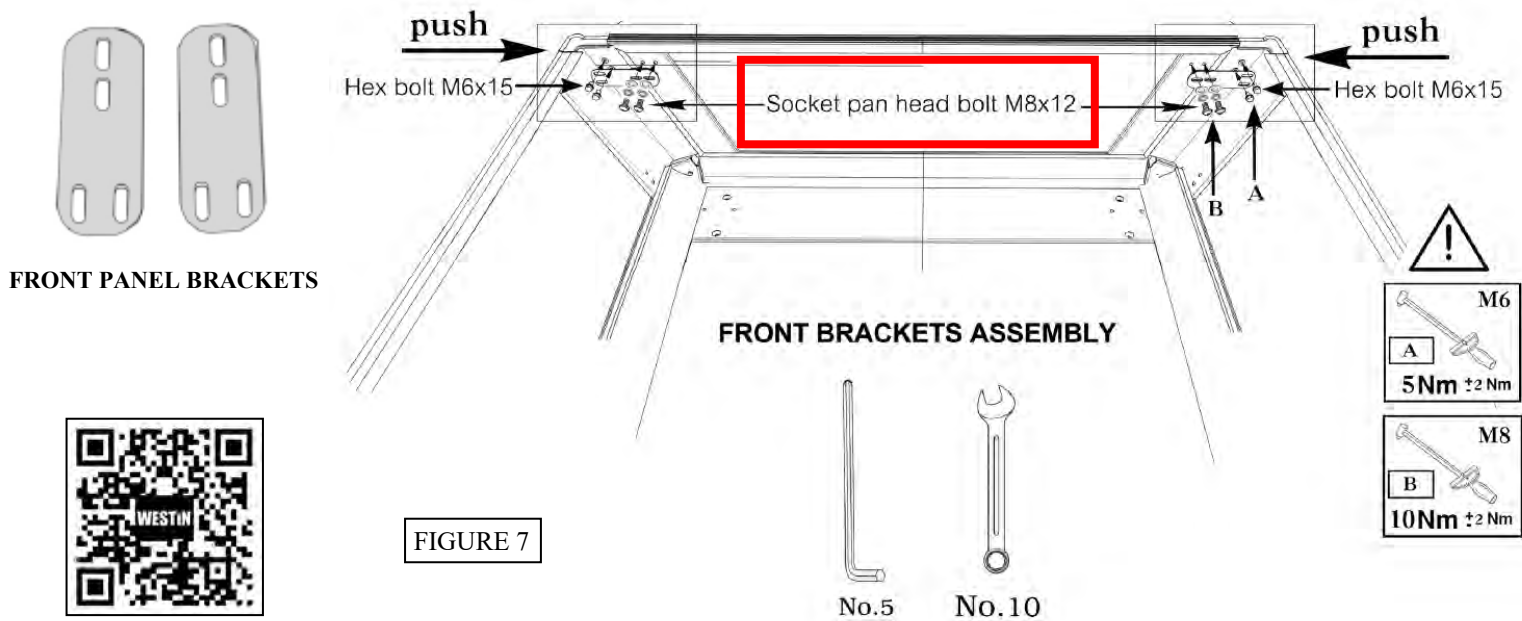
7. Next, push the front panel into the roof panel. (Fig. 6)

FIGURE 6

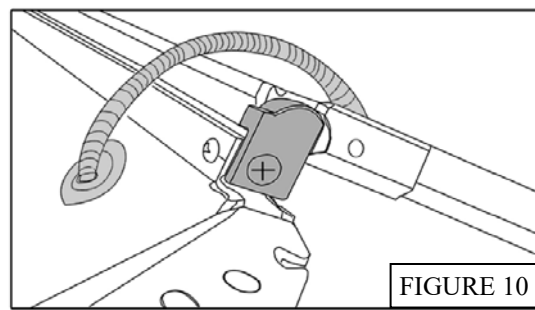
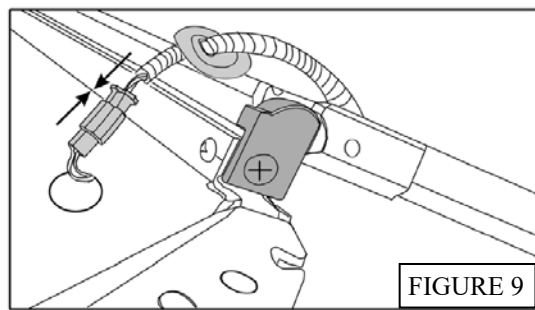
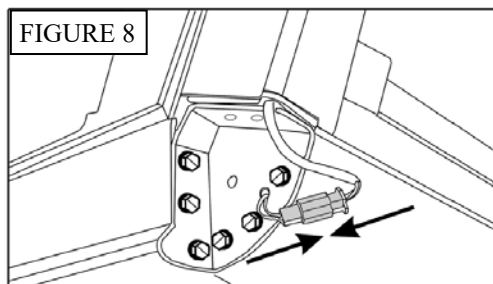


8. Push the left panel inwards towards the front panel. Using a front panel bracket, two (2) M8 x 12 socket pan head bolts, two (2) M8 split washers, two (2) M8 flat washers, two (2) M6 x 15 hex bolts, two (2) M6 split washers, and two (2) M6 flat washers provided in **Parts Kit #1 (Item 6)**, fasten the left panel to the front panel. Use a 5mm Allen Key and 10mm socket to initially tighten the bolts, then use a torque wrench to torque the M8 bolts to **10Nm (8ft-lbs)** and the M6 bolts to **5Nm (4 ft-lbs)**. Repeat this process to fasten the right panel to the front panel. (Fig. 7)

**CAUTION: MAKE SURE TO USE THE M8 X 12 SOCKET PAN HEAD BOLTS FOR THE MOUNTING HOLES ON THE FRONT GLASS, THEY REQUIRE A 5MM ALLEN KEY TO FASTEN. DO NOT USE THE M8 X 20 HEX BOLTS AS THIS MAY DAMAGE THE FRONT GLASS PANEL.**

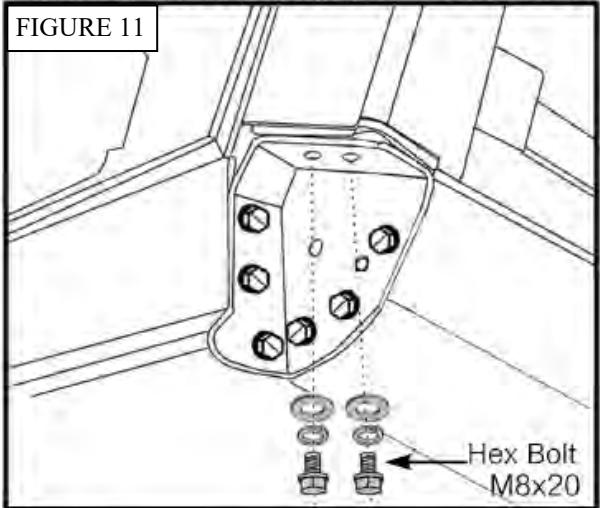


9. Connect the front wire found at the corner of the roof panel and front panel (Fig. 8). Then connect the rear wire (Fig. 9) and tuck the connectors into the roof panel. (Fig. 10)



10. Next, use two (2) M8 x 20 Grade 8.8 hex bolts, two (2) M8 split washers, and two (2) M8 flat washers to fasten the front panel to the roof panel at one corner. Use a 13mm socket to initially tighten the bolts, then torque the bolts to **25Nm (19ft-lbs)**. Repeat this process for the other corner where the roof panel and front panel meet. (Fig. 11)

FIGURE 11



11. Repeat Step 10 for both corners where the roof panel and rear door meet. Use the same kind of hardware as in the previous step (Fig. 12). Connect the roof panel wire to the rear door connector as shown below. (Fig. 13)

FIGURE 12

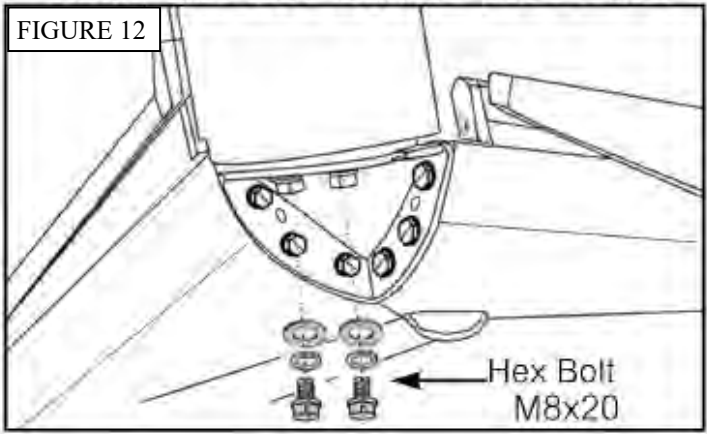
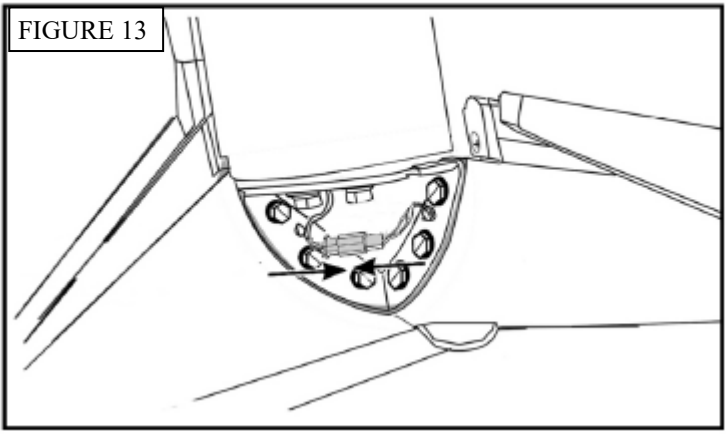
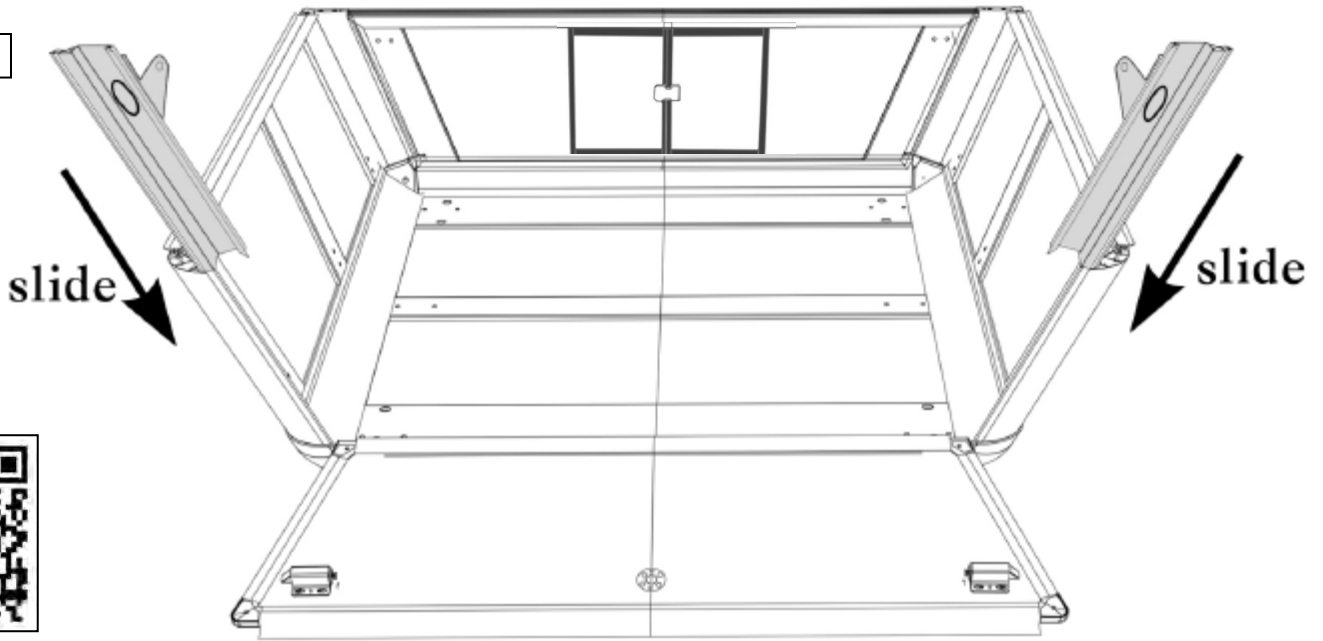


FIGURE 13



12. Slide the water channels downwards on the left and rear panels toward the rear door (Fig. 14). The water channels are found in **Parts Kit #3 (Item 8)**.

FIGURE 14



13. An inside corner of the rear door and side panel is shown below. Using the contents of **Parts Kit #3 (Item 8)** and a 12mm socket, fasten two (2) M8 x 20 hex bolts through the water channel bracket and into the side panel, torque to **10Nm (8ft-lbs)**. (Fig. 15) Next, use two (2) #6 x 3/8 pan head tapping screws and fasten the water channels to the side panels. (Fig. 16) Repeat this step for the other side of the topper.

FIGURE 15

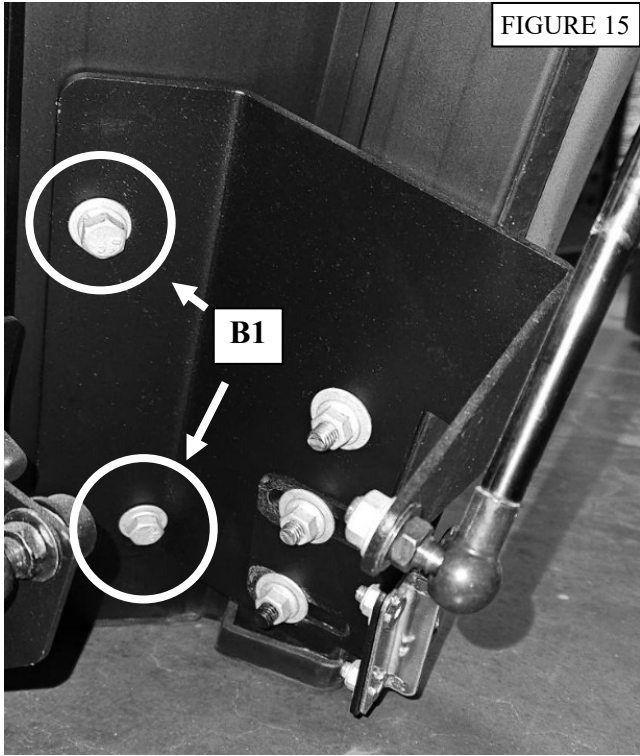
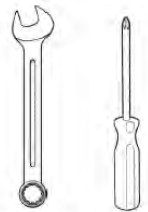


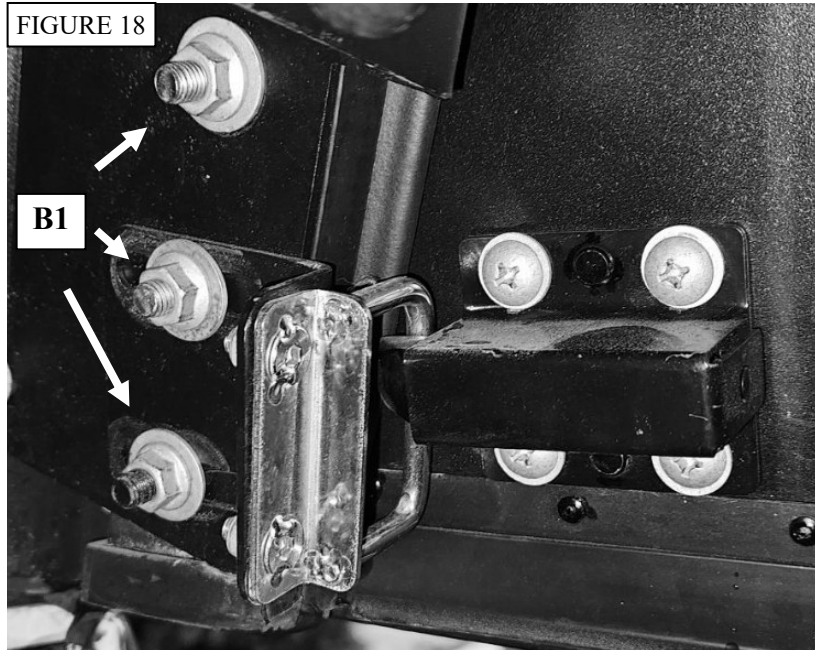
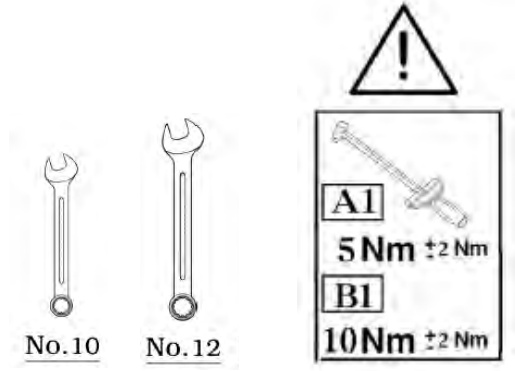
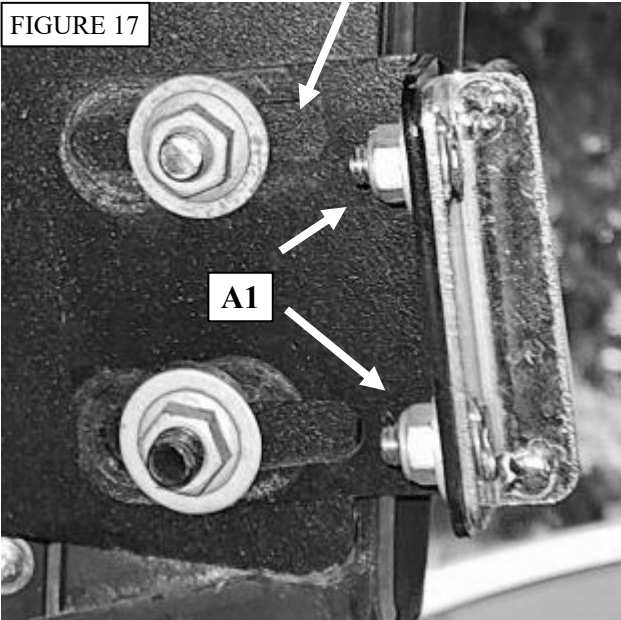
FIGURE 16

No. 12

14. Torque the nuts on the door latch to **5Nm (4ft-lbs)** using a 10mm socket. There are slots on the door latch bracket that allow for the latch to be adjusted so the rear door can close correctly. (**Fig 17**) Once the rear door is shut and the door latch is adjusted properly, torque the bolts in **Fig. 18** to **10Nm (8ft-lbs)**.

**SLOTS FOR ADJUSTABILITY**



15. Next, clean the surface of the perimeter of the corner where the roof panel and left panel meet. Locate the silicone corner covers in **Parts Kit #1 (Item 6)** and remove the tape over the adhesive on the covers. While tucking the wires inwards into the roof panel, firmly press the cover over the corner (**Fig. 19**). Fasten the corner cover to the topper assembly using one (1) M6 x 10 pan head bolt and one (1) M6 flat washer also found in the same parts kit. The hardware fastens from the inside of the topper assembly. Repeat this step for installing the corner cover on the other side where the right panel meets the roof panel. (**Fig. 20**)

FIGURE 19

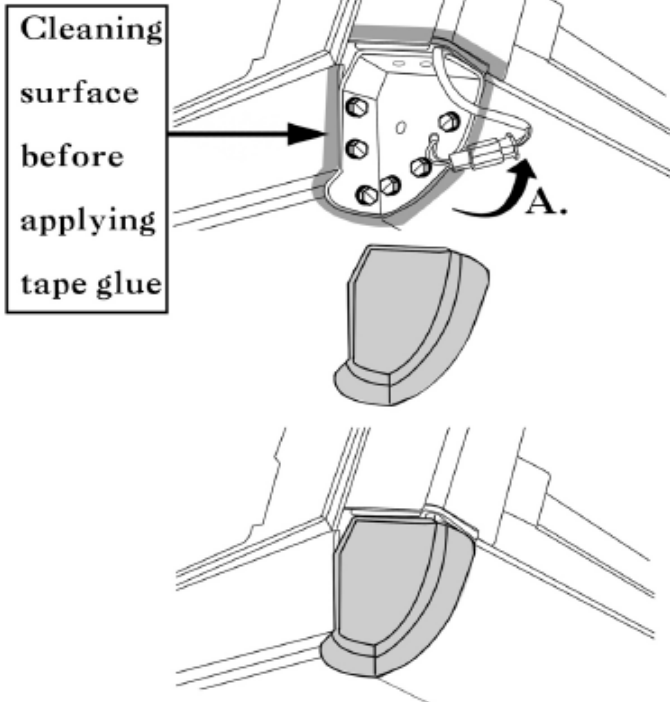
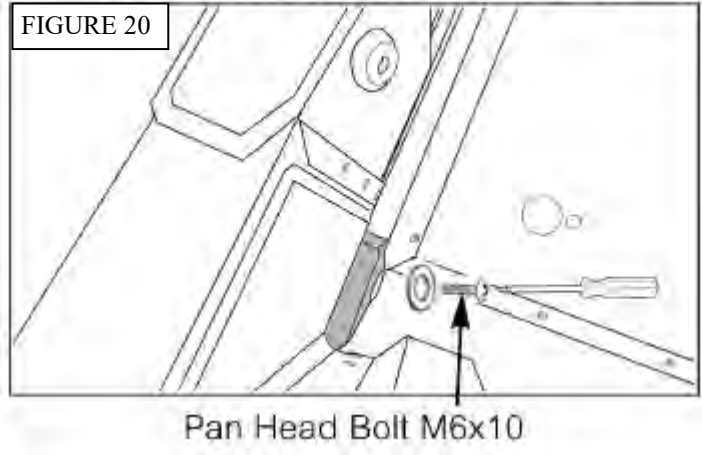
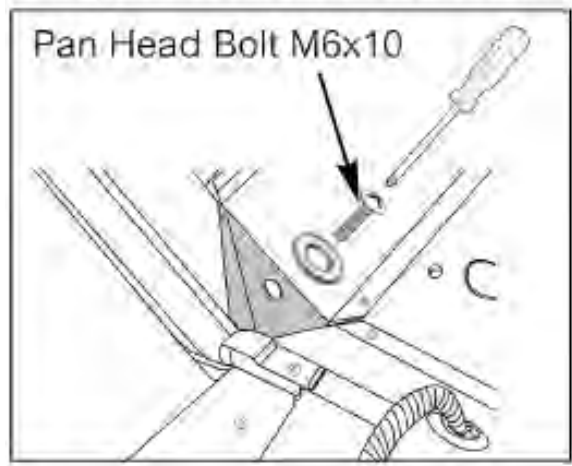
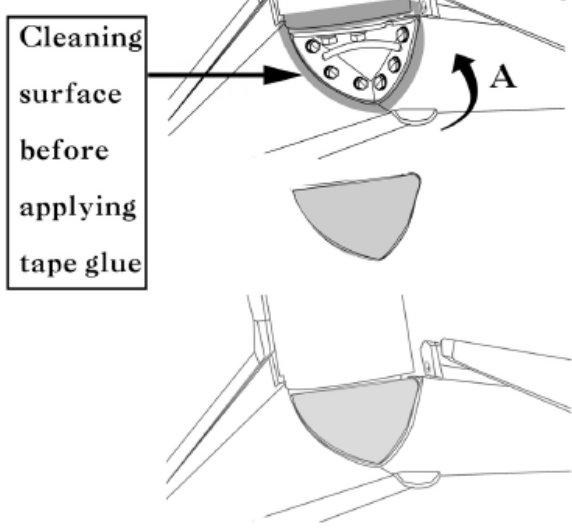


FIGURE 20



16. Repeat the process in Step 14 to install the corner covers on the rear corners of the topper assembly. (**Fig. 21**)

FIGURE 21



17. Next, apply the rubber strip to the front bed rail. The strip is located in the box with the **Front Bed Rail Support Parts (Item 9) (Fig. 22)**. Slide the Front Bed Rail Support Brackets into the front rail system (**Fig. 23**) and then fasten the Front Bed Rail Support Bar using a 5mm Allen Key and two M8 x 25 Socket Pan Head Bolts (**Fig. 24**). Finally, remove the adhesive inside the Front Bed Rail Cover and place the cover on top of the support bar. (**Fig. 25**)

FIGURE 22

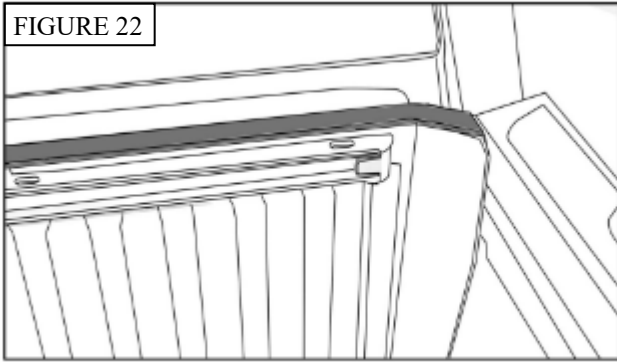


FIGURE 23

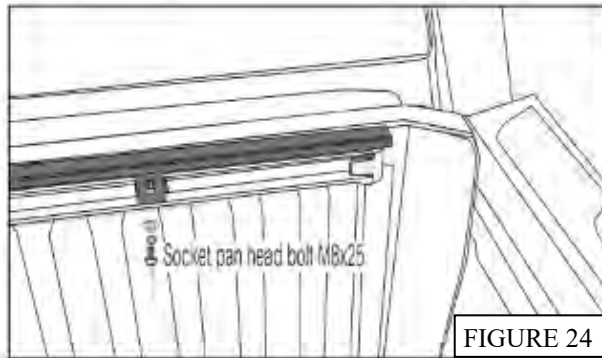
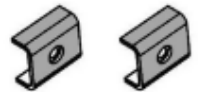
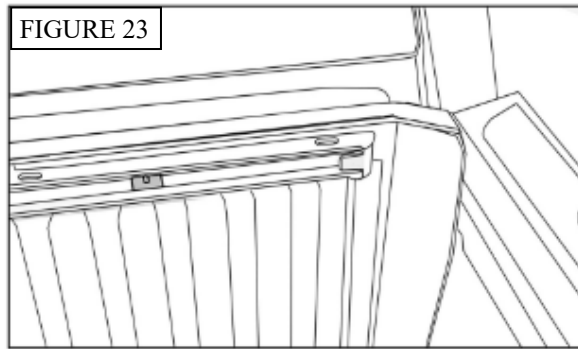


FIGURE 24

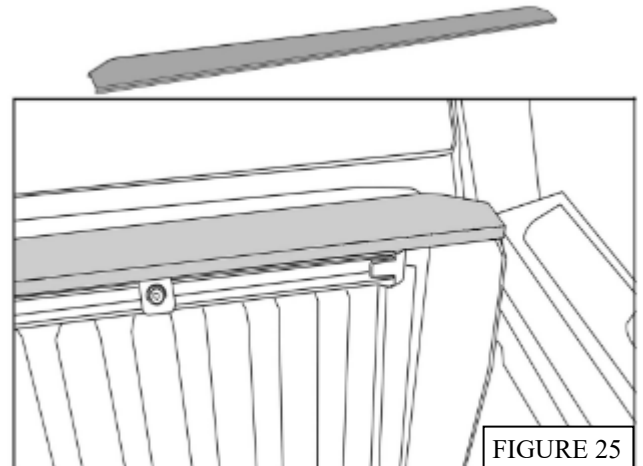
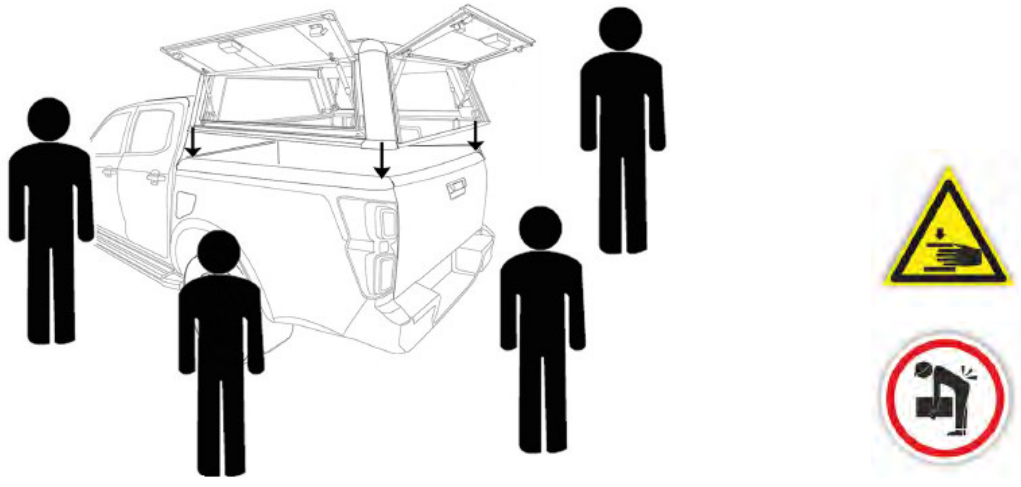


FIGURE 25

18. Apply the bed rail rubber strips from **Parts Kit #3 (Item 8)**, to the truck bed. Open the left, right, and rear panels before placing the topper onto the truck bed. A minimum of four people are recommended for this installation. Make sure to avoid dragging the topper across the truck bed rails. Handle with caution to avoid injury to hands and damage to the topper assembly and vehicle. (**Fig. 26**)

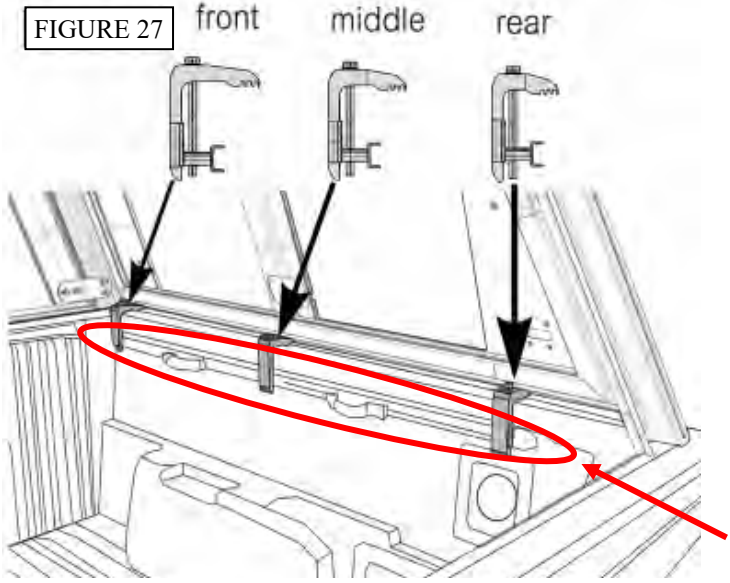
FIGURE 26



19. Locate the contents found in **Parts Kit #2 (Item 7)** and slide each labeled clamp into the bed rails and place at their proper locations (**Fig. 27**). Use a 13mm socket to initially tighten the clamps, then torque to **6Nm (4.4ft-lbs)**. The tightened clamp should resemble (**Fig. 28**).

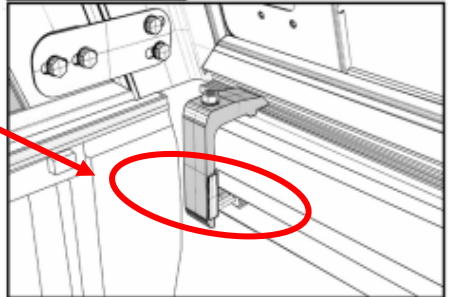
**Note:** Bed clamps will work with OE bedside rails only.

FIGURE 27



Slide into OE bedside rails

FIGURE 28

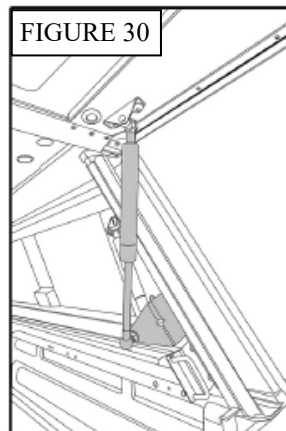


20. Once the bed topper is placed on the vehicle, adjustment may be required to allow for the topper to sit well onto the bed rails. If adjustment is needed, loosen the front bracket and push the sides doors inward towards each other and make sure the gap (**circled in Fig. 29**) is closed. Tighten the front bracket as mentioned in Step 8.
21. Use the nuts already installed on the end of the gas studs to secure the studs to the rear door using a 12mm socket. (**Fig. 30**)

FIGURE 29

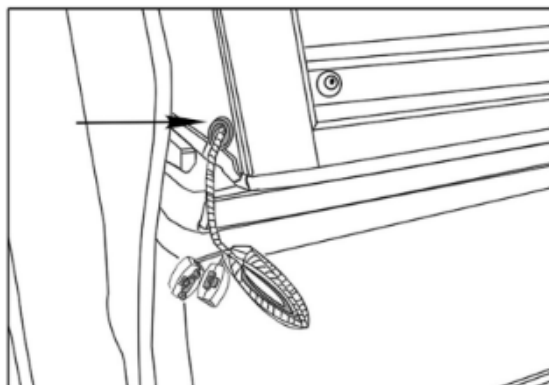
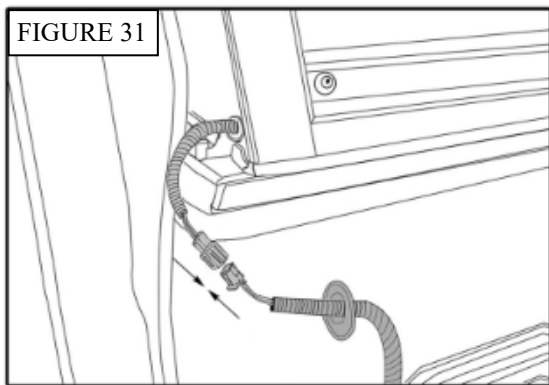


FIGURE 30



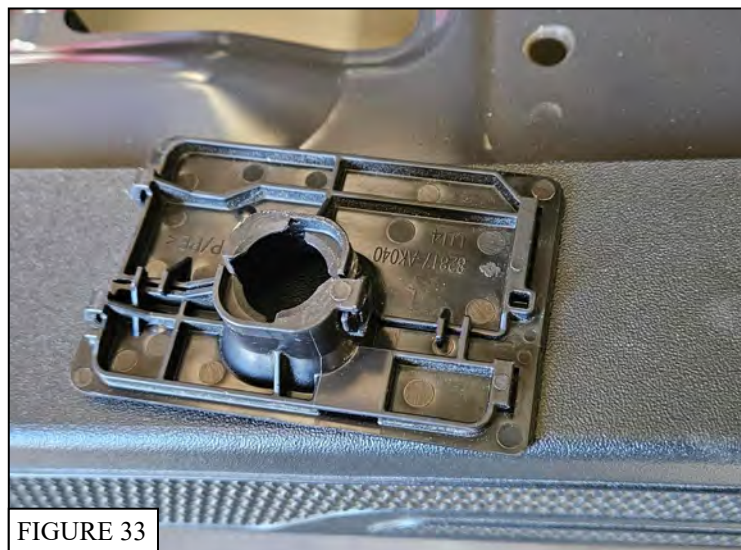
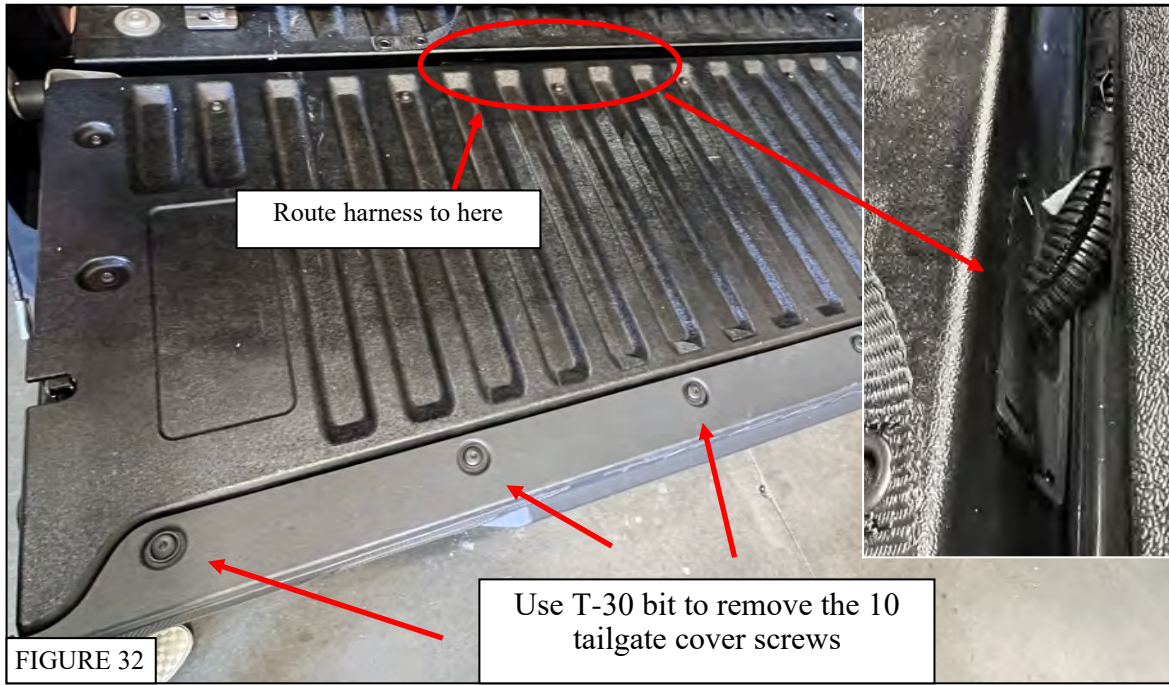
22. Plug the Lock/Unlock Harness (**Item 11**) into the wire coming from the driver side front corner of the topper (**Fig. 31**). Tuck the connector into the topper using the provided rubber grommet.

FIGURE 31



23. Route the harness coming from the front of the topper under the truck bed through the opening shown in (Fig. 32)
24. Remove tailgate cover using a T-30 bit to remove 10 Screws. See (Fig. 33)

**Note:** Remove cover seen in (Fig. 33) in order to route wires into the tail gate to reach tail gate actuator.



25. The specific plug used in this step is shown in (Fig. 34). Splice the red wire from the topper's longer harness into the black wire of the tail gate lock actuator plug. Then, splice the black wire from the topper's harness into the blue wire of the tailgate. (Fig. 35)

26. Finally, test that the topper locking harness functions properly.



27. Next, remove the tail light using a 10mm Socket and locate the tail light connector (Fig 36) .

28. Using the topper wiring harness that is located towards the rear of the topper, splice the yellow wire from the topper's harness into the white/black of the tail light , splice the red topper wire into the white/ light blue wire. (Fig. 37) Finally, test that the brake light on the topper.

29. Reinstall the brake light.

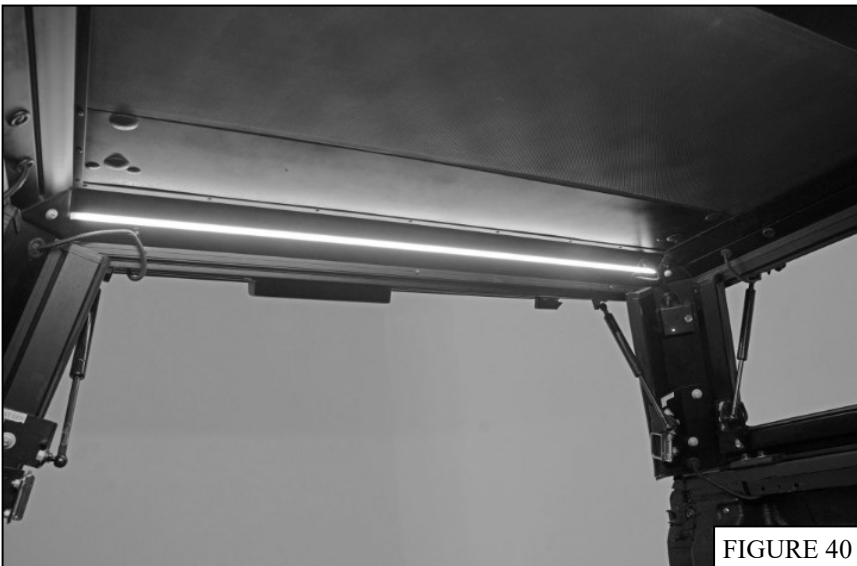
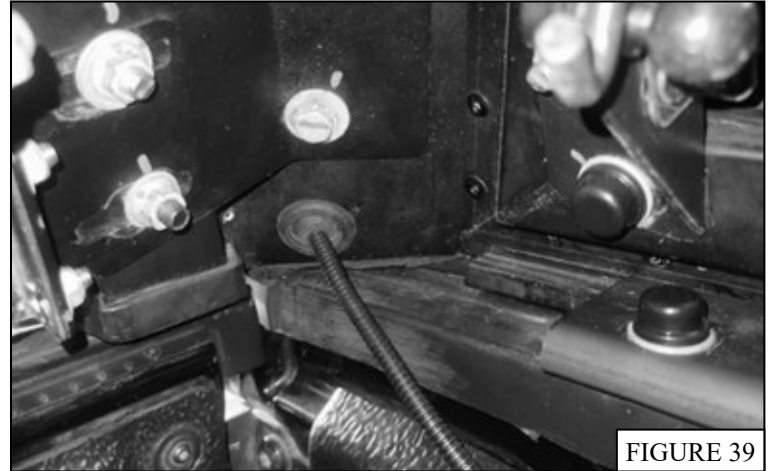
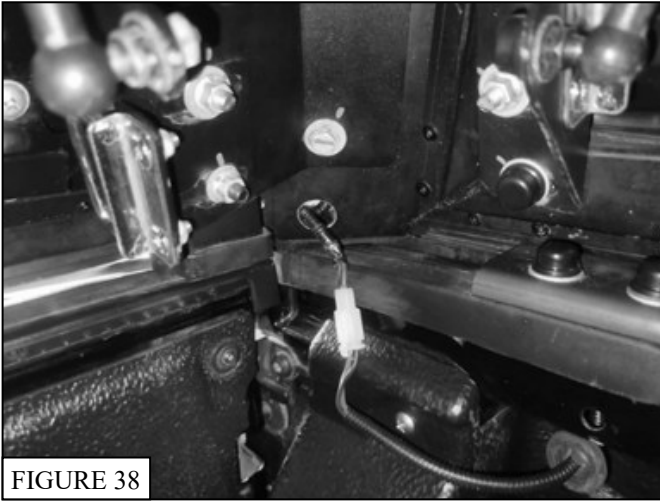


## LED INTERIOR LIGHT

30. Plug the provided Interior Light Harness (**Item 10**) at the connector coming from the rear driver side of the topper (**Fig 38**). Tuck the harness into the topper using the rubber grommet (**Fig 39**). The other end of the harness will need to go to the vehicle's battery. Route the harness underneath the vehicle, make sure to avoid any moving parts.

A key set is included in the topper packaging.

The installation of your Westin Automotive Bed Topper is complete!





## WARNING



Failure to follow these instructions could lead to death, personal injury, and / or property damage.

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### FASTENERS:

All Westin supplied fasteners must be utilized and installed in accordance with the installation instructions and apply torque to the specifications as defined. **DOUBLE CHECK ALL FASTENERS BEFORE INITIAL USE, AND PERIODICALLY IN THE FUTURE TO ENSURE PROPER FUNCTION AND SAFETY.**

### DRILLING:

Most Westin products do not require drilling for installation. If drilling is defined as required, use caution when drilling a vehicle. **FAILURE TO REVIEW AN AREA TO BE DRILLED MAY RESULT IN PERSONAL INJURY AND/OR INJURY TO OTHERS AS WELL AS VEHICLE DAMAGE.**

### EYE PROTECTION:

**ALWAYS WEAR SAFETY GLASSES OR GOGGLES DURING THE INSTALLATION PROCESS TO AVOID PERSONAL INJURY.**

### MAXIMUM TOWING/CARRYING CAPACITY: (if applicable)

The Westin Receiver Hitches will have a visible tow rating label affixed directly on the product. User should never exceed the vehicle manufacturers maximum tow and weight rating regardless of the capacity of the hitch. **FAILURE TO FOLLOW THESE GUIDELINES WILL VOID THE WESTIN WARRANTY AND MAY RESULT IN PERSONAL INJURY AND/OR INJURY TO OTHERS AS WELL AS VEHICLE DAMAGE.**

### FOR CALIFORNIA RESIDENTS ONLY-PROP 65 WARNING:

Some products may contain chemicals such as DEHP, which can cause cancer, birth defects or other reproductive harm. For more info go to [www.p65warnings.ca.gov](http://www.p65warnings.ca.gov)



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