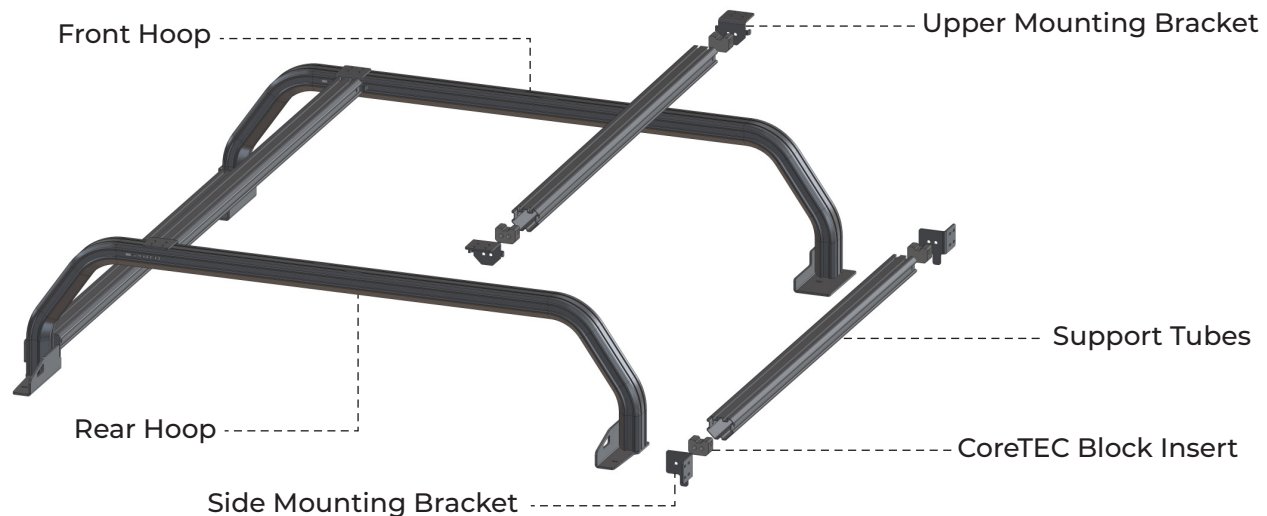


PUTCO® VENTURE TEC RACK™

INSTRUCTION GUIDE



Congratulations on your purchase of a high quality PUTCO® product. Should you need any application or technical assistance, feel free to call us at:

1-800-247-3974

Monday-Friday 8:00am - 5:00pm (Central Standard Time)
Contact your PUTCO® dealer for other quality accessories.



**PLEASE READ ALL INSTRUCTIONS BEFORE INSTALLATION
AND CHECK TO SEE THAT ALL PARTS ARE INCLUDED**

REQUIRED TOOLS

HEX KEYS OR SOCKETS
(sizes: 7/32", 3/16", 5/32")

X-ACTO / UTILITY KNIFE



WRENCH OR SOCKET (sizes: 9/16", 7/16")



CONTENT LIST

QTY

Rear Hoop (etched hoop)	1
Front Hoop	1
CoreTEC Block Inserts	8
Support Tubes	4
Vehicle Specific Hardware Mounting Kit	1
Upper Mounting Brackets	4
Side Mounting Brackets	4
Rack Hardware Kit	(Bag #185601) 1
Accessory Mounting Kit	(Bag #185602) 1
Universal Tent Bracket Kit	(Bag #185603) 1
Blue Loc Tite	1



NOTE: This rack is designed to interface with the in bed rail system equipped on Rubicon trim level Gladiators. To use this system with other trim levels, you will need to purchase Putco's Gladiator Sport Mounting Kit #184560.

1 Insert 4 of the threaded nut plates into the driver's side channel of the in-bed rail system. Slide two threaded plates towards the rear of the vehicle and keep two threaded plates near the front of the vehicle. Repeat this process on the passenger's side of the vehicle (Figure 1).



Figure 1: Inserting threaded nut plate into in-bed rail system

2 Place the front hoop of the Venture Tec Rack onto the vehicle. The edge of the rack should line up with the edge of the vehicle's plastic bed cap. Line up the threaded nut plate with the slot on the mounting feet of the rack. The Venture Tec alignment tool can be used to keep pressure on the nut plate while threading the bolt in (Figure 2). Loosely thread $3/8''-16 \times 5/8''$ bolt into the nut plate (Figure 3).

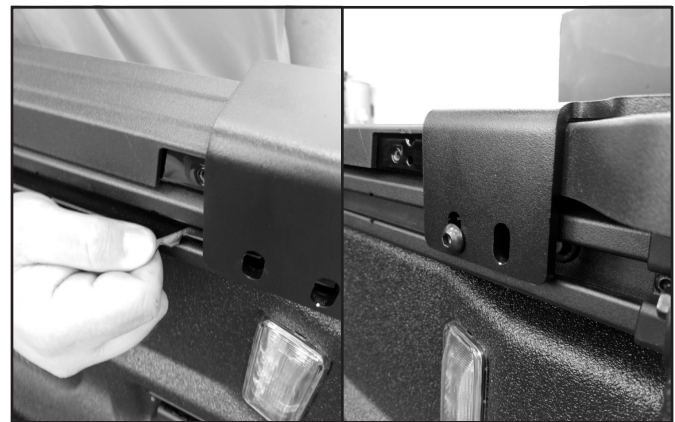


Figure 2 (Left): Using Venture Tec alignment tool to keep pressure on nut plate

Figure 3 (Right): Bolt loosely threaded into nut plate

3 Repeat this process on the remaining mounting bolts and on the rear hoop. Do not fully tighten bolts until rack is fully assembled, including cross rails. This will allow adjustment fore and aft, to match contours of bed cap.

4 Insert 8 square nuts into each channel of both racks. Slide square nuts down to the mounting plate, so that both sides of the hoop look like Figure 4. Position remaining square nuts in top channel near bend, as shown in Figure 5.

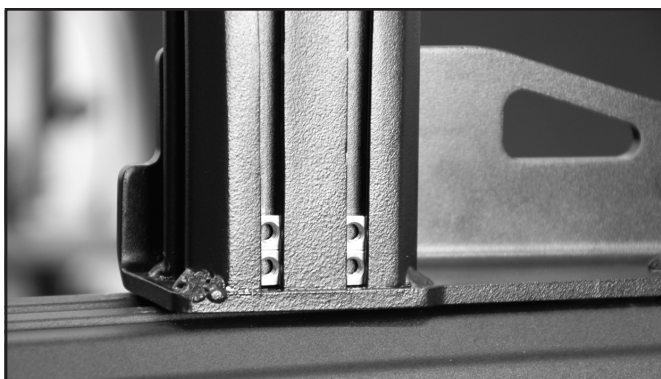


Figure 4: 4 square nuts slid towards the mounting plate

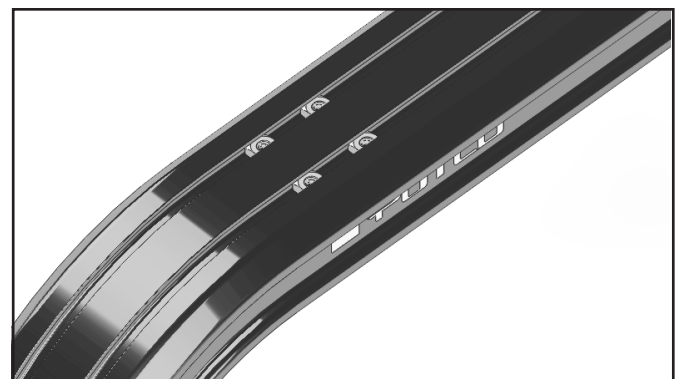


Figure 5: square nuts are slid towards the corner



5 Locate the four support tubes. Slide CoreTec threaded insert into tube. The offset threaded holes should be towards the inside of the rail (Figure 6). Fasten it into place using 3/8" x 5/8" bolts. When properly installed, the CoreTec insert should be flush with the end of the tube.

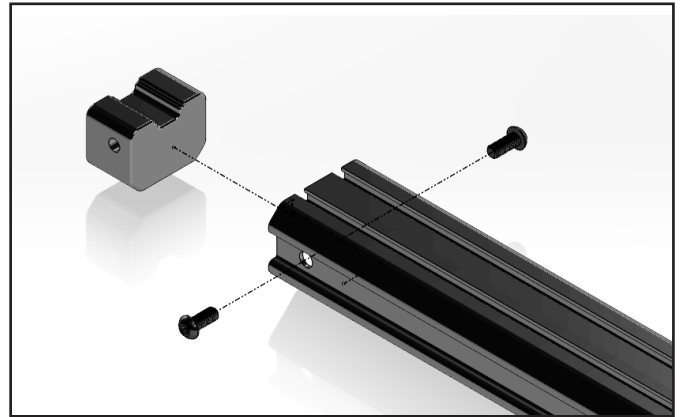


Figure 6: Diagram showing proper threaded insert installation

6 Locate the rail mounting brackets for the rack. Position the rail mounting brackets as shown in Figures 7 and 8. Figure 7 shows the correct setup for the brackets that mount on the side of the hoops, and Figure 8 shows the correct setup for brackets that mount on the top of the hoops.

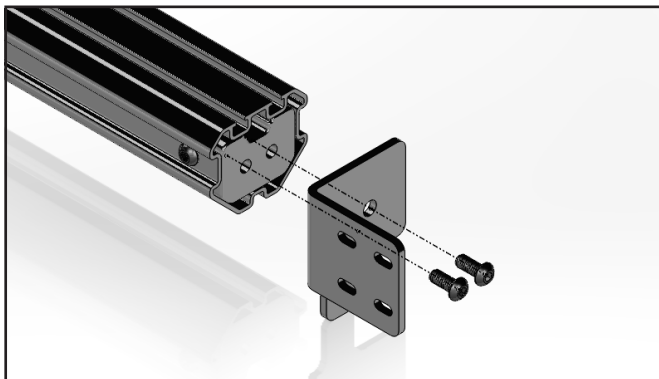


Figure 7: Proper side mounting bracket installation

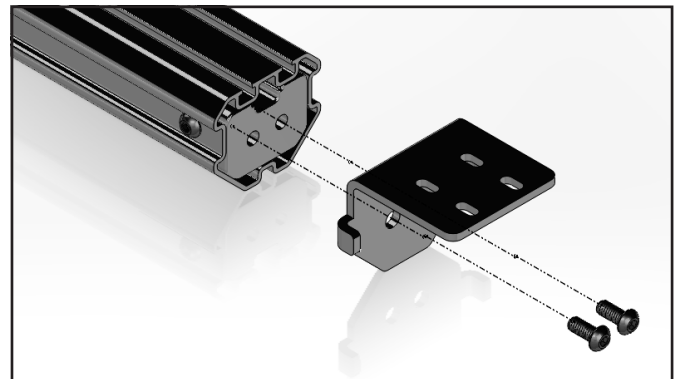


Figure 8: Proper top mounting bracket installation

7 Locate the tubes that will sit at the top of the rack. Position the bracket so that the outside edge of the bracket sits at the start of the bent edge of the hoop as shown in Figure 9. The easiest way to get the tubes into place is to get one side in and then insert the other side diagonally so that the tabs on the bracket fit into the channel of the hoop as shown in Figure 10. Slide the square nuts under the mounting holes in the bracket, and thread in the 1/4"-20 x 1/2" bolts. Repeat the process for the other tube.

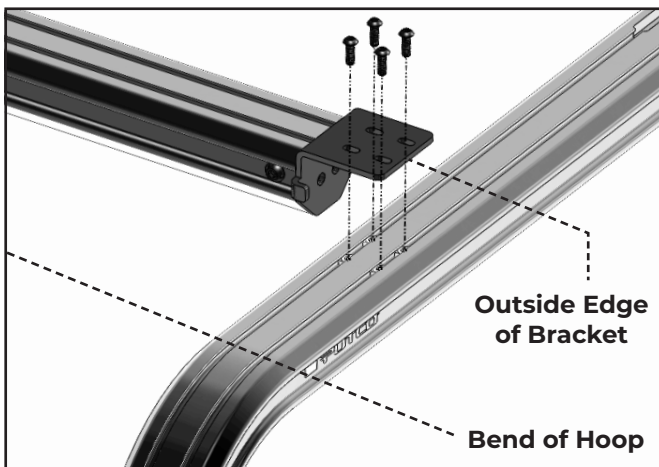


Figure 9: Diagram showing top tube installation

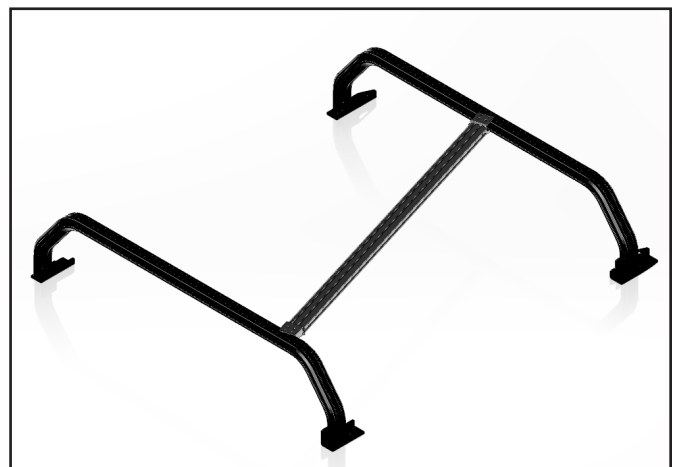


Figure 10: Diagram showing one side inserted and the other side inserted diagonally.



8 Locate the two side tubes. Starting with the top mounting holes, use the alignment tool to push square nuts into position by pressing the lip of the tool against the bottom edge of mounting bracket and the tip of the tool against the square nut (Fig 11a). The long leg is used to align the top mounting locations, and the shorter leg is used to align the lower mounting locations. Fasten 1/4"-20 bolts into square nuts, as shown in Figure 11b.

9 Adjust rack fore or aft to line up mounting feet with the vehicle's bed caps, then proceed with final torque of mounting bolt. Double check to make sure all other hardware is tight.

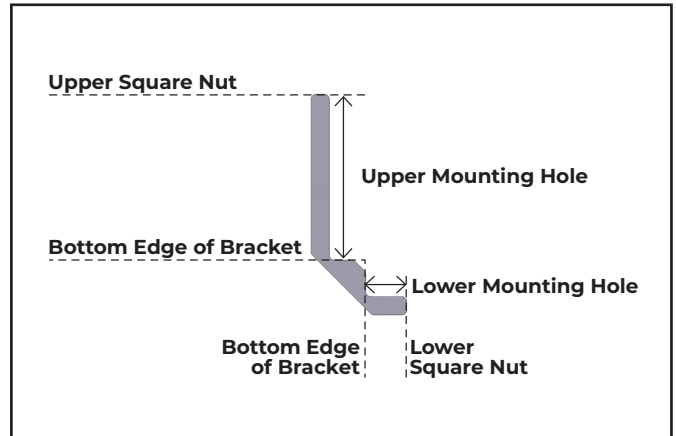


Figure 11a: Diagram showing the alignment tool

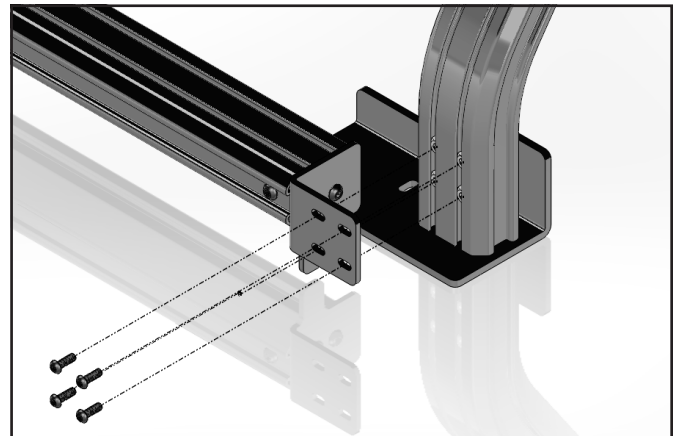


Figure 11b: Diagram showing the correct side tube mounting

Your new Venture TEC Rack is now successfully installed on your vehicle! Let the adventures begin!

WARNING:

- Make sure to periodically check that bolts are tight.
- Ensure that all accessories are securely mounted.
- Do not exceed maximum load recommended by vehicle manufacturer.
- Do not exceed maximum load rating of tent manufacturer, if applicable.
- Be aware of reduced clearance when accessories are mounted on top of the rack.