Part Number: PT925-89180

Kit Contents

|  |  |  |
| --- | --- | --- |
| Item # | Quantity Reqd. | Description |
| 1 | 1 | Left Hand Step Tube |
| 2 | 1 | Right Hand Step Tube |
| 3 | 1 | Hardware Kit |
|  |  |  |

Hardware Bag Contents

|  |  |  |
| --- | --- | --- |
| Item # | Quantity Reqd. | Description |
| 1 | 12 | SEMS M8 x 30mm Bolt |
| 2 |  |  |
| 3 |  |  |
|  |  |  |

Additional Items Required For Installation

|  |  |  |
| --- | --- | --- |
| Item # | Quantity Reqd. | Description |
| 1 |  |  |
| 2 |  |  |
| 3 |  |  |
|  |  |  |

toolConflicts

|  |
| --- |
| Limited Models |

Recommended Tools

|  |  |
| --- | --- |
| Personal & Vehicle Protection | Notes |
|  |  |
|  |  |
|  |  |
| Special Tools | Notes |
|  |  |
|  |  |
|  |  |
| Installation Tools | Notes |
| Ratchet |  |
| Extension | 3” & 6” |
| Socket | 10mm, 12mm |
| Torque Wrench | 0-50 N-m (0-37 ft-lbf ) |
|  |  |
| Special Chemicals | Notes |
|  |  |
|  |  |
|  |  |

General Applicability

|  |
| --- |
| SR5 & PRO Models |

Recommended Sequence of Application

|  |  |
| --- | --- |
| Item # | Accessory |
| 1 |  |
| 2 |  |
|  |  |

\*Mandatory

Vehicle Service Parts (may be required for reassembly)

|  |  |  |
| --- | --- | --- |
| Item # | Quantity Reqd. | Description |
| 1 |  |  |
| 2 |  |  |
| 3 |  |  |
|  |  |  |

Legend

stop_2

**STOP:** Damage to the vehicle may occur. Do not proceed until process has been complied with.

**OPERATOR SAFETY:** Use caution to avoid risk of injury.

**CAUTION:** A process that must be carefully observed in order to reduce the risk of damage to the accessory/vehicle and to ensure a quality installation.

**TOOLS & EQUIPMENT:** Used in Figures calls out the specific tools and equipment recommended for this process.

**REVISION MARK:** This mark highlights a change in installation with respect to previous issue.  
  
**SAFETY TORQUE:** This mark indicates that torque is related to safety.

safety_2caution_2

Care must be taken when installing this accessory to ensure damage does not occur to the vehicle. The installation of this accessory should follow approved guidelines to ensure a quality installation.

These guidelines can be found in the "Accessory Installation Practices" document.

This document covers such items as:-

* Vehicle Protection (use of covers and blankets, cleaning chemicals, etc.).
* Safety (eye protection, rechecking torque procedure, etc.).
* Vehicle Disassembly/Reassembly (panel removal, part storage, etc.).
* Electrical Component Disassembly/Reassembly (battery disconnection, connector removal, etc.).

Please see your Toyota dealer for a copy of this document.

##### 1. Prepare for the Installation.

caution_2**NOTE:** Remove & dispose of the protective wrapping from the Tube Step prior to installation.

* 1. Verify and ensure all kit and hardware contents are present.
  2. stop_2Ensure all application areas are free from any dirt and debris that may damage the surface of the product or vehicle.

**Note:**

**Front bracket is different**

* 1. caution_2Use a 10mm socket to remove and discard the plastic wind deflector and bolts in front of the rear tire (Fig. 1-1).

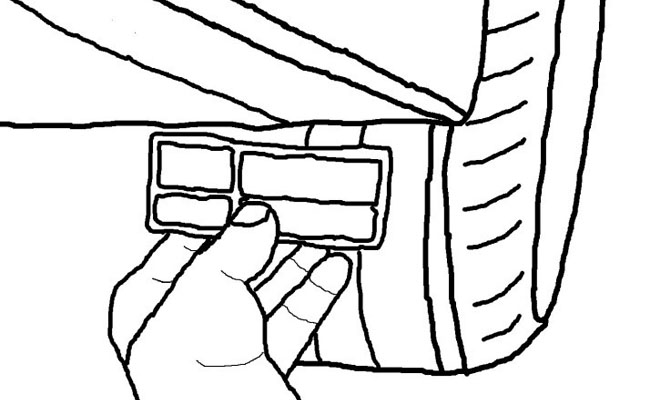


Fig. 1-1

10mm socket & ratchet



* 1. Use a 12mm socket to remove & discard six OE Hex bolts from underneath the vehicle (Fig. 1-2).

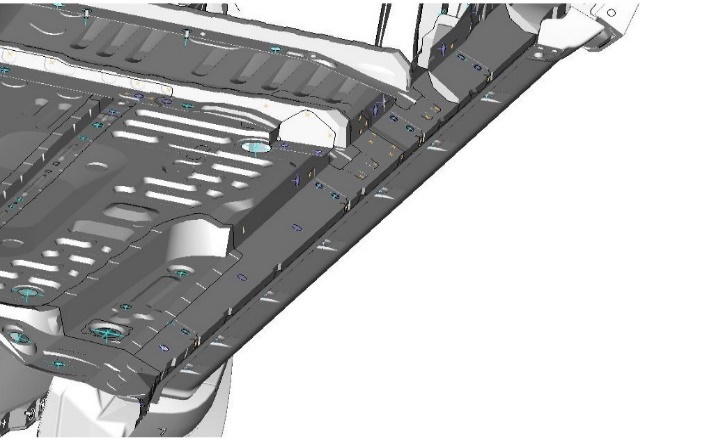


Fig. 1-2

Bracket positions

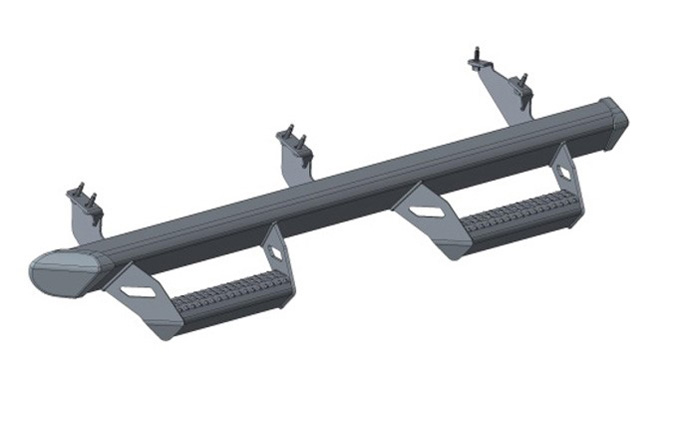
Front

12mm socket & ratchet



##### Install the Passenger Side Tube Step.

* 1. Position the tube step to the passenger side of the vehicle (Fig. 2-1).



Front

Center

Rear

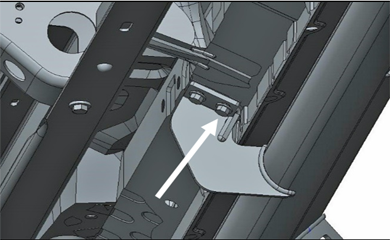
Fig. 2-1

Passenger side

caution_2**NOTE:** The long bracket goes to the front of the vehicle (Fig. 2-1).

caution_2**NOTE:** For the following steps, the use of a non-impacting type electric hand tool can be used to drive the bolts so long as the bolt does not reach or exceed the specified torque. **Leave all hardware loose at this time.**

* 1. Hand start one M8 bolt into the outside slotted hole in the center bracket (Fig. 2-2).



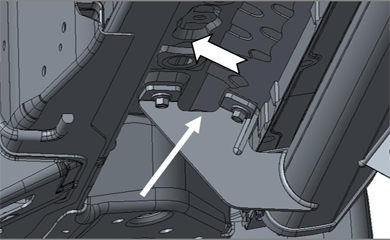
Push as the bolts are tightened

Center outside

Fig. 2-2

Passenger side

* 1. Hand start one M8 bolt into the outside slotted hole in the rear bracket (Fig. 2-2).
  2. Hand start one M8 bolt into the outside hole in the front bracket (Fig. 2-3).



Push as the bolts are tightened

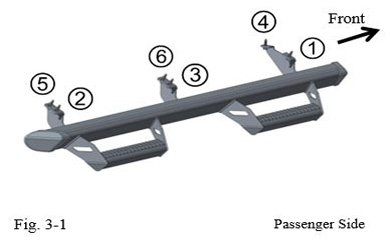
Fig. 2-3

Front outside

Passenger side

* 1. Hand start the remaining M8 bolts, starting with the front bracket working to the rear.

##### Tighten all of the Hardware.



Passenger side

Fig. 3-1

* 1. In numerical order, tighten (but do not torque) from the outside bolts (closest to the pinch weld) to the inside bolts (Fig 3-1).

caution_2**NOTE:** As the bolts closest to the pinch weld are tightened, push the bracket inward to maximize clearance to the pinch weld.

* 1. Tighten (but do not torque) the remaining bolts as indicated in Fig. 3-1.

##### Torque all Hardware.

* 1. Follow the tightening sequence in Fig. 3-1 to torque the “outside bolts” through .

**caution_2NOTE:** Make sure the bracket is seated to the body before torqueing.

##### Torque: 23 N-m (17 ft-lbf)

* 1. Follow the tightening sequence in Fig. 3-1 to torque the “inside bolts” through .

**Torque: 23 N-m (17 ft-lbf)**

##### Install the Driver Side Tube Step.

* 1. Repeat Steps 2 through 4 on the driver side.

##### Re-torque all Hardware.

* 1. Re-torque all twelve M8 Hex Bolts in the same order as Step 4.

##### Torque: 23 N-m (17 ft-lbf)

Accessory Function Checks

Step alignment

Inspect bolt torques

Vehicle Function Checks

No interference between step & vehicle

Tube Step is level and even to vehicle rocker.

Complete the torque audit sheet

Pinch weld contact

Vehicle Appearance Check

After accessory installation and removal of protective cover(s), perform a visual inspection.

Ensure no damage (including scuffs and scratches) was caused during the installation process.

(For PPO installations, refer to TMS Accessory Quality Shipping Standard.)