

TOYOTA TACOMA D-CAB

2016

STEALTH STEP BOARD

Part Number: Stainless 00016-35037 Black 00016-35036

Code: RB1210 / RB1110



Conflicts

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Kit Content

Item #	Quantity Req'd.	Description
1	2	Front Brackets with Clip
2	4	Rear Brackets with Clip
3	1	Stealth Board (L)
4	1	Stealth Board (R)
5	1	Hardware Bag
6	1	Installation Instructions

Hardware Bag Contents

Item #	Quantity Req'd.	Description
1	12	8mm Hex Bolt
2	12	8mm Lock Washer
3	12	8mm Flat Washer

Additional Items Required For Installation

Item #	Qty. Req'd.	Description
1	1	Wiping Cloth, Non-Scratch
2	1	Torque Audit Sheet, PIO Only
3		Note: For PIO Install Using Atlas Copco Torque Management Equipment, See Last Page.

Recommended Tools

Personal & Vehicle Protection	Notes
Eye Protection	
Special Tools	Notes
Utility Knife	
Installation Tools	Notes
Screwdriver/Pry Tool	
13mm deep socket	Corresponding drive tool
Torque Wrench	18 ft. lbs
Special Chemicals	Notes

General Applicability

Applicable to all Tacoma D-Cab with out factory running board

Recommended Sequence of Application

1.	LED Illumination
2.	Step / Running Board

Legend

**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.

SPECIAL NOTE: Installation Sequences

After TMS and Safety mandated preparatory steps have been taken, the installation sequence is the suggested method for completing the accessory installation. In some instances the suggested sequence is written for one associate to install and in others the sequence is given as part of a team accessory installation. Unless otherwise stated in the document, the associates may perform the installation steps in any order to make the installation as efficient as possible while maintaining consistent quality.

Note: All fasteners using sealer or loctite on threads must be checked within five minutes of installation to prevent compromising sealer or loctite. Fasteners using nylon or crimped locking nuts must be checked within five minutes of installation to prevent compromising the nylon or crimp locking mechanism.

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.)

1. Pre-Installation Preparation

- (a) Remove the protective wrapping from both ends of the Step Boards prior to installation.
- (b) Verify Kit and Hardware Bag quality and contents

NOTE: Due to the generic nature of hardware kits, some “extra” hardware may be present. Please save this hardware for future use in case of loss or damage



- (c) Wear eye protection



- (d) Ensure all application areas are free from any dirt and debris that may damage the surface of the product or vehicle



- (e) Using a flathead screwdriver / pry tool remove and discard six (6) OE plastic bolts from underneath vehicle.



Fig 1



Fig 2



Fig 3



Fig 4

2. Front Mounting Bracket Installation

- (a) The Front Brackets are longer than the other Brackets and can be installed on either side of the vehicle. **Fig 2**
- (b) Align the Front Bracket holes to the (2) 8mm threaded factory sidewall holes. **Fig 3**
- (c) Secure each Front Bracket to the vehicle side wall using (2) Bolts, (2) Lock Washers, and (2) Flat Washers.
- (d) Tighten the front brackets to the vehicle, making sure that the brackets mount flush to the vehicle side wall. **Fig 4**
- (e) Repeat on opposite side of the vehicle.



Fig 5



Fig 6



Fig 7



Fig 8

3. Rear Mounting Bracket Installation

- (a) The Rear Brackets are universal and can be installed at any location
- (b) Align the Rear Bracket holes to the threaded factory sidewall holes.
- (c) Loosely install the (2) bolts, (2) lock washers, and (2) flat washers to the factory-threaded hole. **Fig 5**
- (d) Tighten the rear bracket to the vehicle, making sure that the bracket mounts flush to the vehicle side wall.
- (e) Repeat for the (1) remaining Rear Bracket
- (f) Repeat on the opposite side of the vehicle

4. Step Board Installation

- (a) Lift and rotate the Pinch Clips 90 degrees so that they are perpendicular to the Brackets. **Fig 6**
- (b) Position the appropriate Step Board over the Mounting Brackets.
 - (1) Left (Driver Side) Board has the large step pad towards the front of the vehicle.



- (d) Lift and rotate the Pinch Clips 90 degrees so they are parallel with the Brackets. **Fig 7**



- (1) Make sure that the tabs on the Pinch Clip drop into the slots in the Bracket
- (2) Make sure all (4) Pinch Clips are correctly engaged to their respective Brackets



- (e) Position the Step Board all the way inboard. **Fig 8**



Fig 9

- (f) Position the Step Board centered (front to rear) over the Brackets **Fig 9**



- (g) Torque the Bracket to Vehicle hardware to 18 lbs-ft.



- (h) Re-check the Step Board position, tighten the Step Board to Bracket hardware and torque to 18 lbs-ft.

5. Clean and Check



- (a.) The Step Board should not contact any vehicle painted surfaces. If necessary, loosen all bolts, adjust the Brackets as required and re-tighten the bolts to specified torque values.
- (b.) Clean any fingerprints or dirt with a damp non-scratch cloth.

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Checklist - these points **MUST** be checked to ensure a quality installation.




Check:

Look For:

Accessory Function Checks

- ☐ Board alignment
- ☐ Board tightened properly

Verify board aligned straight and even

Torque specifications followed : 

Torque the “Bracket to Vehicle” hardware to
18lbs -ft. (13.5 lbs -ft min. / 27 lbs -ft max.) (-25% / +50%)

Torque the “Step Board to Bracket”-verify correct torque
18 ft ft. lbs is used during installation.

Note: Range provided by QA



FIG 1

Step Board Torque Procedure

- 1) Loosely install the bolts, and flat washers to the factory- threaded hole.
- 2) Position the Step Board all the way inboard.
- 3) Scan identifiers in the following order and visually confirm correct entries in controller.
 - a) IDP Number
 - b) VIN Number
 - c) Accessory Code
 - d) Job

Note: If an incorrect barcode is scanned, complete the scan procedure then repeat until correct identifiers have been received.

- 4) Use Atlas Copco STB nutrunner shown in **FIG 1** to torque fasteners.
- 5) Torque fasteners in order as shown in **FIG 2**.
- 6) Once job is complete verify on controller

Front of Vehicle

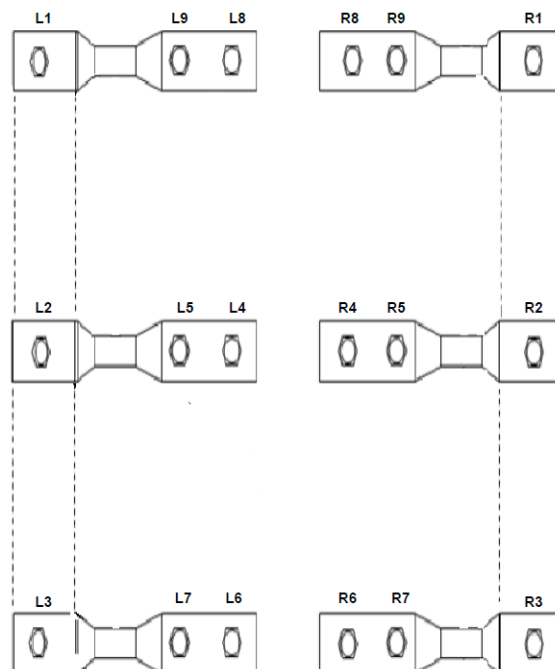


FIG 2