

Toyota**Tacoma****2017****Predator Pro Board**

Part Number: 00016-35168; D-Cab
00016-35188; D-Cab
00016-35069; C-Cab

**Code: RB5200, RB5210****Conflicts**

None

Kit Contents

Item #	Quantity Req'd.	Description
1	1	Left side step board
2	1	Right side step board
3	1	Hardware kit
4	1	Installation sheet

Hardware Bag Contents

Item #	Quantity Req'd.	Description
1	12	SEMS 8mm x 35mm Bolt

Additional Items Required For Installation

Item #	Quantity Req'd.	Description
1	1	Torque Audit Sheet, PIO Only
2		Note: For PIO Install Using Atlas Copco Torque Management Equipment, See Last Page.

Recommended Tools

Safety Tools	
Special Tools	
Installation Tools	
12mm Socket	Corresponding drive tool
Manual Torque Wrench	17 ft. lbs
Special Chemicals	

General Applicability

Access Cab, Double Cab

Recommended Sequence of Application

Item #	Accessory	
1	Drivers side	
2	Passenger side	
3		

*Mandatory

Vehicle Service Parts (may be required for reassembly)

Item #	Quantity	Description
00016-35068	1	D-Cab Driver Side Tube
00016-35188		
00016-35068	1	D-Cab Passenger Side Tube
00016-35188		
00016-35068	1	D-Cab Hardware Bolt Kit
00016-35188		
00016-35069	1	C-Cab Driver Side Tube
00016-35069	1	C-Cab Passenger Side Tube
00016-35069	1	C-Cab Hardware Bolt Kit

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.

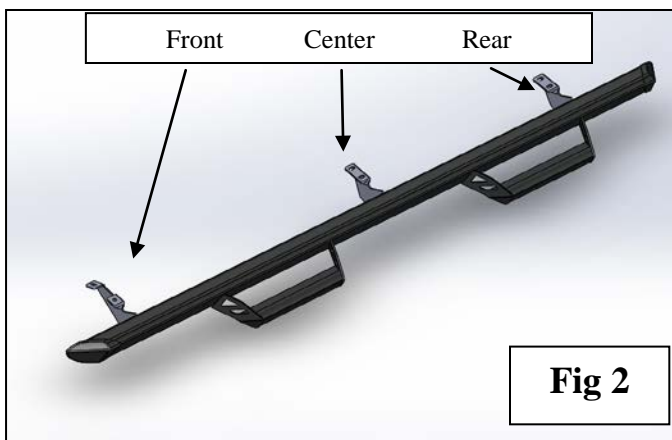
This document covers such items as:

- 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. Check Kit Contents.

- a. Open box and check kit for content and damage.





2. Vehicle Preparation

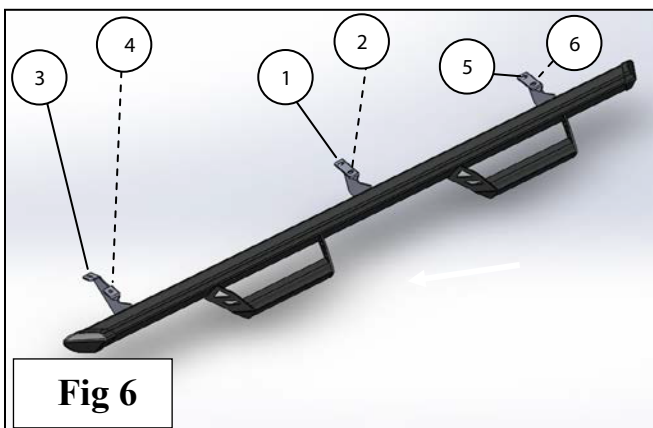
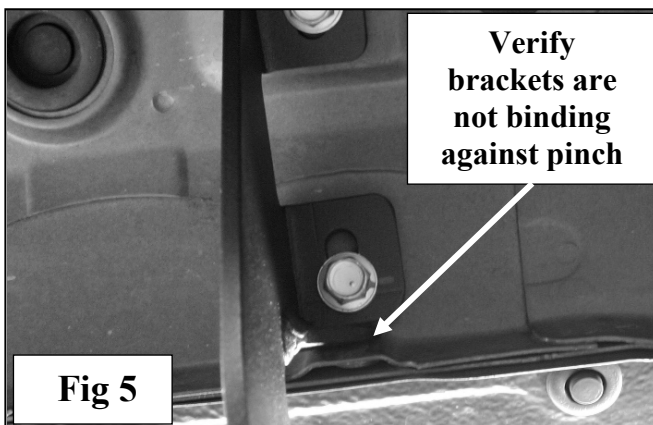
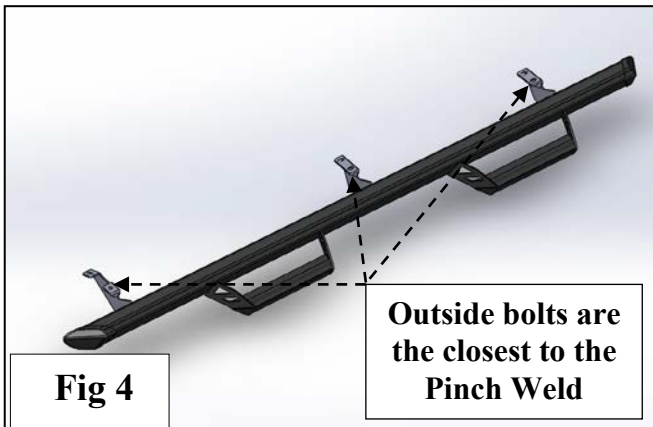
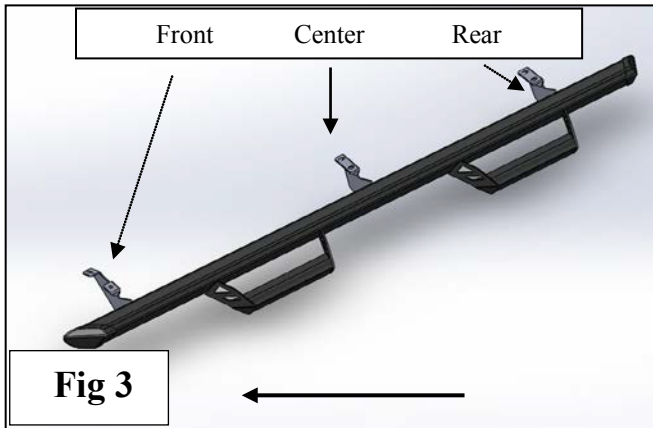
- a. Using a flat screwdriver, remove and discard six (6) OE plastic bolts from underneath the vehicle (Fig 1).

3. Step board Installation (Drivers Side)

- a. Position the step board to the driver side of the vehicle.

 **Note:** The long bracket should be to the front with flange facing forward. (Fig 2).

 **NOTE:** The use of a non-impacting type electric hand tool can be used to drive the bolts in so long as the bolt does not reach or exceed the specified torque.



4.Bracket Installation.

- Starting with one of the Center bracket, Start one 8mm bolt into the factory threaded holes. (Fig. 3)
- Start second bolt into other Center bracket.
- Start all remaining 8 mm bolts at each bracket.
- Snug the Front and Rear bracket bolts starting with “Outside bolts” first (closest to the pinch weld). (Fig 4).
- Snug the remaining bolts.



Note: Leave hardware loose at this time.



IMPORTANT: make sure front bracket is pushed fully inward with bolt at the end of the slotted hole as shown in (Fig. 5).

5. Final position and Torque.



- Following the tightening sequence (Fig 6), Torque the “Outside bolts”to 17 ft/lbs. to 17 ft/lbs.



- Following the tightening sequence (Fig 6), Torque the “Inside bolts” to 17 ft/lbs.

6.Step board Installation (Passenger Side)

- Repeat installation procedure steps 1-5

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

Check:

Look For:

Accessory Function Checks

☐ Board alignment & tighten properly

☐ Torque bolts to target of 17 ft/lbs
(-25% / +50%) 12.75 min / 25.5 max

Vehicle Function Checks

☐ Verify that there is no interference
between step bar and vehicle.

☐ Pinch Weld contact

Range provided by QA



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. Visually confirm correct entries in controller and flashing red light turns on.
 - a) VIN Number
 - b) Part Number

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 and green light is on.

Part Number: 00016-35068

Part Number: 00016-35188



FIG 1

Front of Vehicle

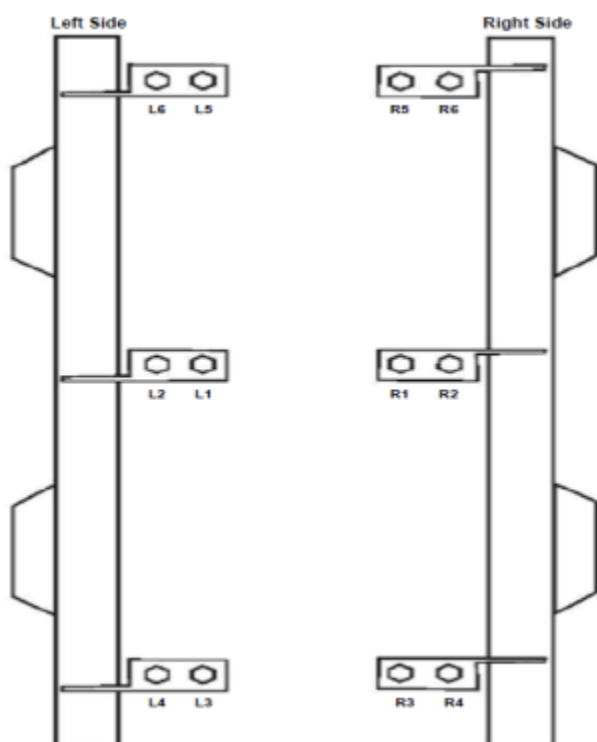


FIG 2



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. Visually confirm correct entries in controller and flashing red light turns on.
 - a) VIN Number
 - b) Part Number

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 completed verify on controller and green light on.

Part Number: 00016-35069



FIG 1

Front of Vehicle

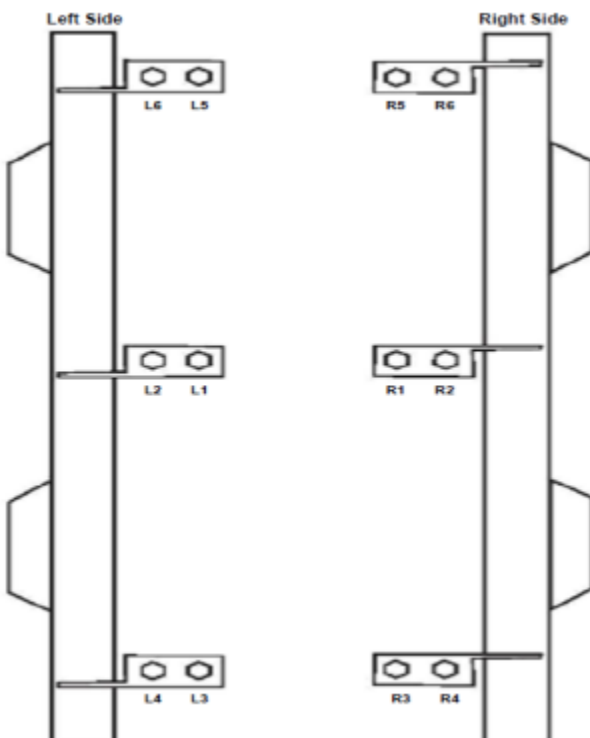


FIG 2