



Southeast Toyota Distributors, LLC Accessory Installation Instructions

2020 Tacoma Predator Pro Board

Year & Model:	2020 Tacoma
Part Number:	00016-35188, 00016-35189
Accessory Code:	RB5200
PIO / DIO:	PIO / DIO
Business Partner:	J67

Conflicts

Note: None

General Applicability

Fits Models: 2020 Access Cab, Double Cab

Additional Items Required For Installation

Item#	Description:
1.	Torque Audit Sheet, PIO Only Note: For PIO Install Using Atlas Copco Torque Management Equipment , see Torque Procedures .

Sequence of Application

Item#	Accessory:
1.	Drivers Side
2.	Passenger Side

SPECIAL NOTE: Installation Sequences
After TMS & 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 & 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.

Recommended Tool

Safety Items	
Safety Glasses	
Special Tools	
Installation Tools	
12mm Socket	Corresponding Drive Tool
Manual Torque Wrench	17ft. lbs.
Special Chemicals	

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.
	REGULATORY MARK: This mark indicates that the component is related to regulatory compliance.
	VIDEO: This image indicates a video to show a installation procedure, PIO Only.

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Kit/Hardware Bag Contents:

Item #	Quantity	Description
1.	1	Left Side Step Board
2.	1	Right Side Step Board
3.	1	Hardware Kit
4.	1	Installation Sheet
5.	12	SEMS 8mm x 35mm Bolt

Parts for Installation:

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, re-checking torque procedure, etc.).
- Vehicle Disassembly/ Reassembly (panel removal, part storage, etc.).
- Electrical Component Disassembly/Reassembly (battery disconnection, connector removal, etc.).

Item #	Quantity	Description
1.	1	D-Cab / C-Cab Driver Side Step Board
2.	1	D-Cab / C-Cab Passenger Side Step Board
3.	12	SEMS 8mmx35mm Bolt



Used as an example for D & C-Cab Predator Pro Board

Service & Warranty Information:

Image Key	Parts information		Warranty Information	
	Part Number	Description	Warranty Time	Labor Op. Code
N/A	00016-35188	Tacoma Predator Pro Board D-Cab	N/A	N/A
N/A	00016-35189	Tacoma Predator Pro Board C-Cab	N/A	N/A
1	00016-35068-01	D-Cab Driver Board	0.5	ATR011
2	00016-35068-02	D-Cab Passenger Board	0.5	ATR011
1	00016-35069-01	C-Cab Driver Board	0.5	ATR011
2	00016-35069-02	C-Cab Passenger Board	0.5	ATR011
3	00016-35188-03	Bolt Kit/Nylon Patch	0.5	ATR021
3	00016-35189-03	Bolt Kit/Nylon Patch	0.5	ATR021
N/A	00016-89705-04	End Caps	0.2	ATR031
Note: Combo Code A applicable to ATR011 and ATR021 for additional 0.2 hours when replacing both sides. Combo Code A applicable to ATR031 for additional 0.1 hours when replacing both end caps.				

If you are a dealer located outside of the Southeast Region, please contact the SET Accessory Warranty Department at (888) 851-2722 or email Accessory.Warranty@SEToyota.com for claim payment instructions.

Image:



Figure 1

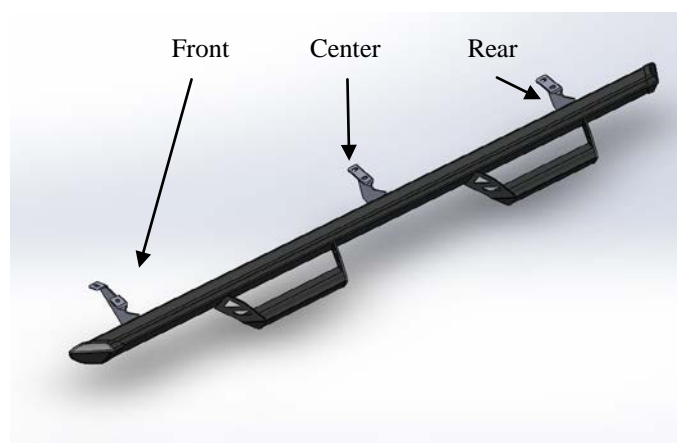


Figure 2

Vehicle Preparation

1. Open box and check kit for content and damage.
2. Using a flat screwdriver, remove and discard six (6) OE plastic bolts from underneath the vehicle. See Figure 1.

3. Installation Procedures (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. See Figure 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.



NOTE: All fasteners using sealer or locite 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.

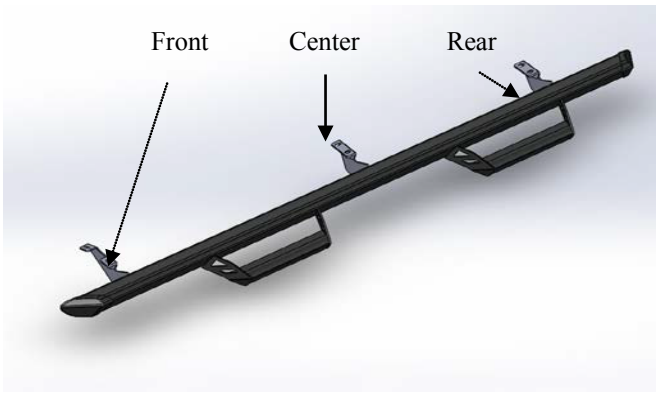


Figure 3

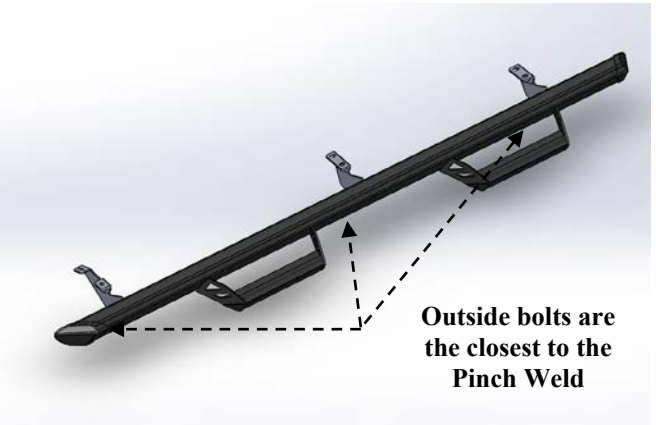


Figure 4

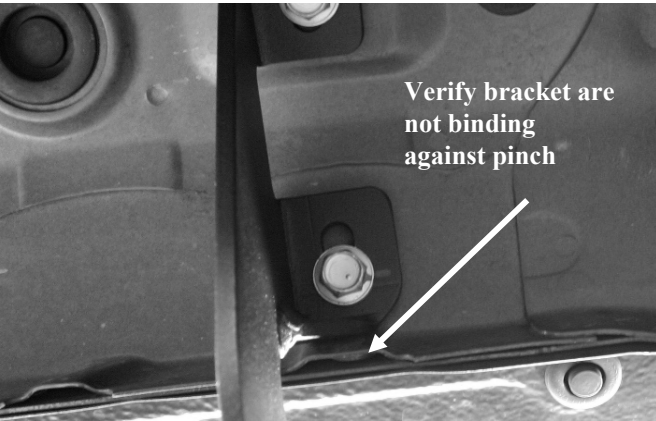
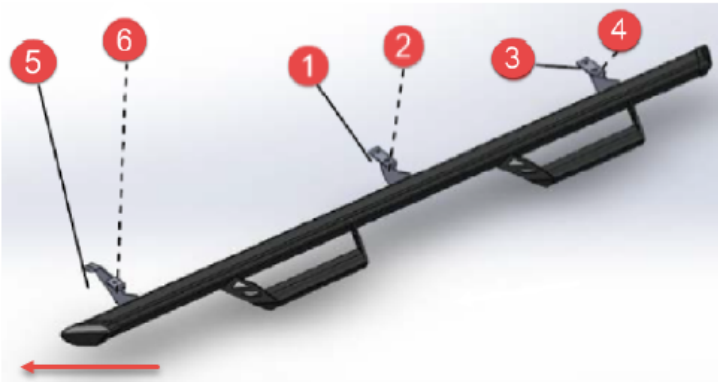


Figure 5



Front of vehicle

Figure 6

4. Bracket Installation

- Starting with one of the Center bracket, Start one 8mm bolt into the factory threaded holes. See Figure 3.
- Start second bolt into other Center bracket.
Note: Leave hardware loose at this time.
- 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). See Figure 4.
- Snug the remaining bolts.



IMPORTANT: make sure front bracket is pushed fully inward with bolt at the end of the slotted hole. See Figure 5.

5. Final position and Torque



- Following the tightening sequence. Torque the “Outside bolts” to 17 ft/lbs. See Figure 6.



- Following the tightening sequence. Torque the “Inside bolts” to 17 ft/lbs. See Figure 6.

6. Installation Procedures (Passenger Side)

- Repeat installation procedure steps 1-5.

- Print Warranty Statement and place in glove box, DIO Only.

Procedure

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.



Warranty Statement.

Place Warranty Statement in glove
box, DIO Only.

Range provided by QA



Step Board Torque Procedure

- 1) Hand start all fasteners to the factory threaded cavities.
 - a) Note: The bracket should be to the front with the flange facing forward, reference FIG 1
- 2) Prior to final torque sequence, ensure that the brackets positioned flush on the vehicles sidewall per the installation guide.
- 3) Scan the identifiers in the following order and visually confirm correct job is running on the controller and the stacklight is flashing red.
 - a) Part Number
 - b) VIN (Door Jam Only)
- 4) Use the Atlas Copco STB nutrunner shown in FIG 2, torque all twelve fasteners starting with the inside and working to the outside per the installation guide.
- 5) Once the job is finished verify the batch count is complete and the Green Light is on.



FIG. 1

Front of Vehicle

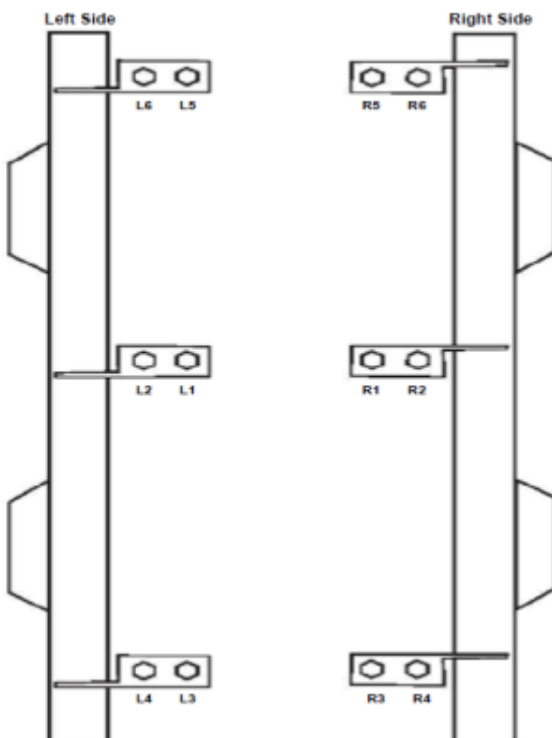


FIG. 2

Part Number: 00016-35188





Step Board Torque Procedure



FIG 1

Front of Vehicle

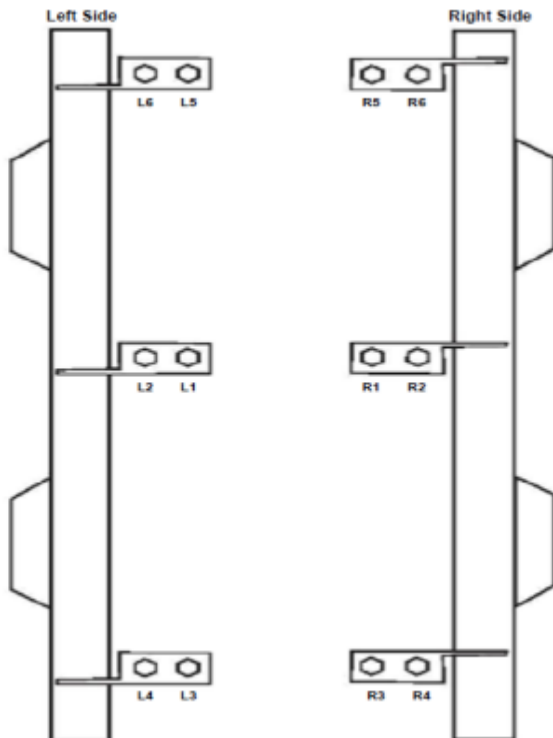


FIG 2

- 1) Hand start all fasteners to the factory threaded cavities.
 - a) Note: The bracket should be to the front with the flange facing forward, reference FIG 2
- 2) Prior to final torque sequence, ensure that the brackets positioned flush on the vehicles sidewall per the installation guide.
- 3) Scan the identifiers in the following order and visually confirm correct job is running on the controller and the stacklight is flashing red.
 - b) Part Number
 - c) VIN (Door Jam Only)
- 4) Use the Atlas Copco STB nutrunner shown in **FIG 1**, torque all twelve fasteners starting with the inside and working to the outside per the installation guide.
- 5) Once the job is finished verify the batch count is complete and the Green Light is on.

Part Number: 00016-35189



LIMITED WARRANTY – SOUTHEAST TOYOTA

SOUTHEAST TOYOTA DISTRIBUTORS, LLC ("we," "our" and "us") provides the following limited warranty on our accessories, excluding tires, ("Accessories" or "Accessory") installed on a Toyota. This limited warranty is not provided by and does not bind or provide benefit to the vehicle dealer, the manufacturer, or Toyota Motor Sales, U.S.A., Inc. This limited warranty does not apply to tires; please consult the tire manufacturer and/or its materials accompanying the vehicle for any warranty terms concerning tires. This limited warranty also does not apply to ToyoGuard Exterior Paint Sealant and ToyoGuard Interior Protector; please consult the ToyoGuard Limited Warranty Certificate for the warranty terms concerning those products.

SCOPE OF LIMITED WARRANTY:

A. Protection:

- i. **Accessories Installed by Southeast Toyota Distributors, LLC on a new Toyota vehicle.** We warrant that, for a period of 36 months or 36,000 miles, whichever occurs first, we will repair or replace (includes labor), free of charge, any defect in such an Accessory due to faulty material or workmanship, or, at our option, provide a full refund of the purchase price of the Accessory. The warranty period begins on the vehicle's In-Service Date, which is the first date the new vehicle is either delivered to an ultimate purchaser, leased, or used as a company car or demonstrator. Accessories installed by Southeast Toyota Distributors, LLC are identified on the vehicle's window sticker (Monroney Label).
- ii. **Accessories Installed by a Toyota Dealer on a Toyota vehicle.** We warrant that, for 12 months, regardless of mileage, from the date such an Accessory was installed on the vehicle or the remainder of the Toyota new vehicle warranty, whichever is longer, we will repair or replace (includes labor), free of charge, any defect in the Accessory due to faulty material or workmanship, or, at our option, provide a full refund of the purchase price of the Accessory. For a new vehicle, the warranty period begins on the vehicle's In-Service Date, which is the first date the new vehicle is either delivered to an ultimate purchaser, leased, or used as a company car or demonstrator.
- iii. **Accessories purchased from a Toyota Dealer but not installed by the Toyota Dealer.** We warrant that, for a period of 12 months, regardless of mileage, from the date the accessory was purchased, we will repair or replace (does not include labor), free of charge, any defect in the Accessory due to faulty material or workmanship, or, at our option, provide a full refund of the purchase price of the Accessory.

B. Limitation of Warranty. This limited warranty does not apply to, and we will not repair, replace, or reimburse you for: (1) wheel balancing and wheel alignments, except for one wheel balancing or alignment during the first 12 months or 12,000 miles, whichever occurs first, from the vehicle's In-Service Date, as defined above, (2) abrasions or dents, whatever their cause, and any failure or damage resulting directly or indirectly from accidents, collisions, impacts from foreign objects, fire, theft, larceny, explosion, malicious mischief, vandalism, civil commotion, riots, war, or any other similar causes, (3) any failure or damage resulting directly or indirectly from lightning, windstorms, hail, water, floods, subfreezing temperatures, airborne chemicals, tree sap, dust, salt, and any other environmental conditions or similar causes, (4) any failure or damage caused by: (a) a failure of any part, other than the Accessory, (b) any misuse, abuse, improper towing, negligence or lack of maintenance of the vehicle or Accessory, (c) the alteration, modification or repair of the Accessory by anyone other than persons expressly authorized by us to perform such alteration, modification or repair, or (d) the use of the vehicle for commercial purposes, competitive driving or racing, (5) any failure or damage, if the Accessory has not been installed according to instructions, (6) any failure or damage occurring outside of Canada, the United States of America, its territories or possessions, (7) except to the extent required by the state whose laws govern this limited warranty, any consequential, secondary, or unreasonable costs that may be suffered as a result of the need to repair or replace the Accessory, including without limitation any loss of use of the vehicle, road service, towing, storage charges, inconvenience, loss of wages and/or income, additional expense incurred, loss of transportation, rental car expense, or any derivative damage to persons or things other than the Accessory, including other parts of the vehicle, or (8) liability for damage to property or for injury to or death of any person, arising out of the operation, maintenance or use of your vehicle whether or not related to the covered Accessory.

C. Exclusive Remedy. If there is a valid claim under this limited warranty for a defect due to faulty material or workmanship in the Accessory, we will, at our option, either: (i) repair, (ii) replace or (iii) provide a full refund of the purchase price of the Accessory. We have no other obligations under this limited warranty. Refunds will be made to the vehicle owner. If the vehicle is leased, the refund will be made to the leasing company.

HOW TO MAKE A CLAIM: In the event of a warranty claim, please contact the nearest Toyota dealer to arrange for repairs. The dealership must receive our prior authorization before making repairs covered by this limited warranty. The dealer will contact Southeast Toyota Distributors, LLC at 1-888-851-2722, select option #5 (Warranty Department), then option #4 (Repairs), for instructions on processing a warranty claim, if they are not already familiar with the process. If you have any questions or concerns regarding repairs covered by this limited warranty, please contact our **Customer Assistance Hotline at 1-800-301-6859**.

OUR DISPUTE RESOLUTION PROGRAM: Your satisfaction is our highest priority. In keeping with that focus, in the event that an issue arises related to this Limited Warranty, we invite you to call our Customer Assistance Hotline at 1-800-301-6859 to discuss it. In most cases, we expect that a satisfactory resolution of your issue can be reached through engagement with that Department. If our Customer Loyalty Department is unable to resolve your issue to your satisfaction, we offer a dispute resolution program administered by the National Center for Dispute Settlement (NCDS) ("the Program"). The purpose of the Program is to resolve disputes in an informal setting before an impartial arbitrator. The Program is free of charge to you (although you must bear the cost of any expert witness or attorney you elect to employ). You are required to complete the Program before exercising rights or seeking remedies under the federal Magnuson-Moss Warranty Act, 15 U.S.C. § 2301 et seq. ("the Act"). If you choose to seek remedies that are not created by the Act, you are not required to use the Program before pursuing such remedies – although the Program is still available to you to resolve the dispute. When utilizing the Program, you will need to provide (a) the vehicle identification number of your vehicle, (b) the identity of your selling and servicing dealerships, (c) the mileage on your vehicle at relevant times, (d) the date and nature of any relevant repairs, (e) legible copies of repair orders and other relevant documents, (f) a summary of the unresolved issue and the requested action, and (g) your contact information. In most cases, the dispute resolution process under the Program will be completed within forty (40) days of your submission of your request and will consist of steps such as an initial eligibility determination, an opportunity for you and us to submit information in writing relating to your claim, an oral hearing, and a decision from the arbitrator. A decision will be binding on you only if you choose to accept it. You may submit a request to NCDS by telephone at their toll free number: (877)-276-8848 or in writing at P.O. Box 463196, Mt. Clemens, MI 48046. You may obtain additional information regarding the Program at www.ncdsusa.org. In the event that the NCDS does not exist or no longer handles disputes for us at the time that you seek to submit a request, you may contact our **Customer Assistance Hotline at 1-800-301-6859** to obtain current information about our dispute resolution programs.

GENERAL LIMITATION OF WARRANTY: THIS LIMITED WARRANTY IS IN LIEU OF ALL OTHER EXPRESS WARRANTIES OR LIABILITIES. IN NO EVENT SHALL WE BE LIABLE FOR ANY CONSEQUENTIAL OR INCIDENTAL DAMAGES FOR BREACH OF THIS OR ANY OTHER WARRANTY. SOME STATES DO NOT ALLOW THE EXCLUSIONS OR LIMITATIONS OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE INFORMATION OR EXCLUSION MAY NOT APPLY. NO EXPRESS WARRANTY OF FITNESS OR MERCHANTABILITY IS GRANTED BY THIS LIMITED WARRANTY. THERE ARE NO WARRANTIES WHICH EXTEND BEYOND THOSE DESCRIBED IN THIS DOCUMENT. ANY IMPLIED WARRANTIES, INCLUDING THE IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE, WHICH MAY BE APPLICABLE BY OPERATION OF LAW SHALL BE LIMITED TO THE PERIOD OF THIS WRITTEN LIMITED WARRANTY. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATIONS MAY NOT APPLY. THIS LIMITED WARRANTY PROVIDES SPECIFIC LEGAL RIGHTS, AND THERE MAY BE OTHER RIGHTS WHICH VARY FROM STATE TO STATE. ANY ACTION FOR BREACH OF ANY WARRANTY HEREUNDER, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY, MUST BE BROUGHT WITHIN A PERIOD NOT EXCEEDING 12 MONTHS AFTER EXPIRATION OF THIS LIMITED WARRANTY. THE REMEDIES SPECIFIED HEREIN AND THOSE SPECIFIED BY APPLICABLE LAW ARE THE ONLY REMEDIES AVAILABLE. WE ASSUME NO OTHER OBLIGATION OR RESPONSIBILITY WITH REGARD TO THE ACCESSORY. WE NEITHER ASSUME, NOR AUTHORIZE ANYONE TO ASSUME FOR US, ANY ADDITIONAL LIABILITY IN CONNECTION HERewith.

GENERAL: This limited warranty describes the complete and exclusive rights that result from the purchase of Accessories. No oral representations or statements may be relied upon. This limited warranty may not be amended or modified, and additional rights may not be granted, unless in a written statement signed by one of our officers. This limited warranty shall be governed by the laws of the state where the vehicle is purchased, excluding laws concerning conflicts of law. We may delegate the performance of our duties and obligations and assign our rights and benefits hereunder. For inquiries regarding this limited warranty, we can be contacted directly at **Customer Assistance Hotline at 1-800-301-6859**, or by mail to: **Southeast Toyota Distributors, LLC, Attention: Customer Loyalty Department, 100 Jim Moran Boulevard, Deerfield Beach, Florida 33442.**