

Toyota 4 RUNNER
Section I – Installation Preparation

2016

Step Board

Part Number: 00016-89040

Code: RB1300



Conflicts

Note: Air deflector near wheel may need to be removed if present. This board will not fit the 2016 Trail & SR5 models.

General Applicability

2016 4Runner Limited Models Only

Kit Contents

Item #	Quantity Req'd.	Description
1		Running Board Driver (L)
2		Running Board Passenger (R)
3		Hardware Kit
4		Installation Instructions
5	6	brackets

Hardware Bag Contents

Item #	Quantity Req'd.	Description
1	2	8mm x 20mm Hex Bolt
2	2	8mm x 30mm Hex Bolts
4	2	8mm flange nut
5	2	Flat washers
6	2	Lock Washers

Additional Items Required For Installation

Item #	Qty. 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	
Eye Protection	
Special Tools	
	Utility Knife
Installation Tools	
13mm Socket	Corresponding drive tool
Torque Wrench	10 ft. 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.

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.




Section II – Installation Procedure

A. Pre-installation Preparation

NOTE: Be sure to remove the protective wrapping from the Step Boards and dispose properly, prior to installation. (Fig 1)


1. Verify and ensure all Kit and Hardware Contents are present.

NOTE: Due to the generic nature of the hardware kit some "extra" hardware may be present. Please save this hardware for replacement of damaged or lost hardware on future installations.

2.  Wear eye protection.
3.  Ensure all application areas are free from any dirt and debris that may damage the surface of the product or vehicle.
4.  Separate and prepare the Bracket to Vehicle Hardware, 8mm x 30mm hex bolts, flat washers, and lock washers.

B. Running Board Installation

1. Using a 13mm socket, remove & discard OEM Hex bolts from all bracket positions underneath vehicle and plastic wind deflector in front of rear tire. (New bolts are provided) (Fig 2)

2.  **NOTE:** For each side of the vehicle, the different bracket goes toward the front. (Fig 3)

NOTE: Front Driver Side and Passenger Side Brackets are identical (ambidextrous). All referred instruction procedures represent instructions on one side of the vehicle.

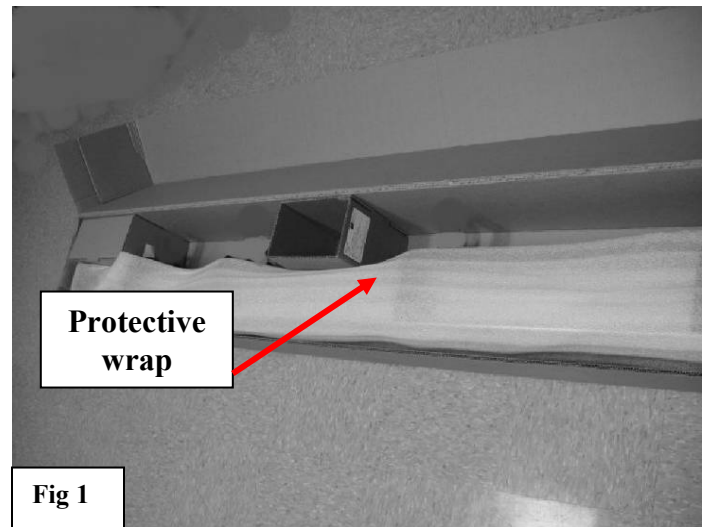


Fig 1

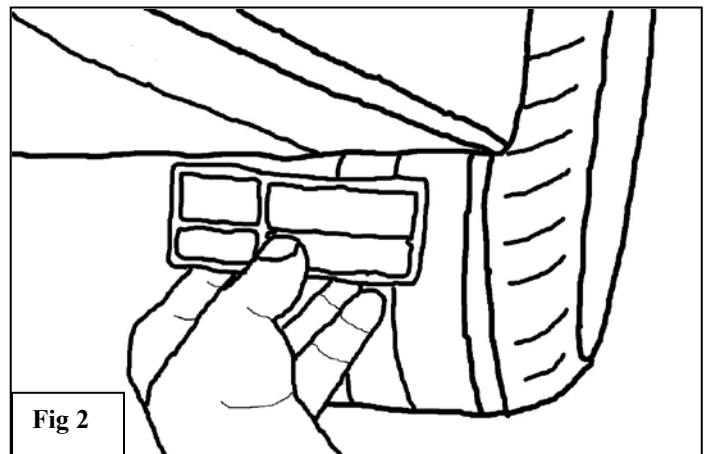


Fig 2

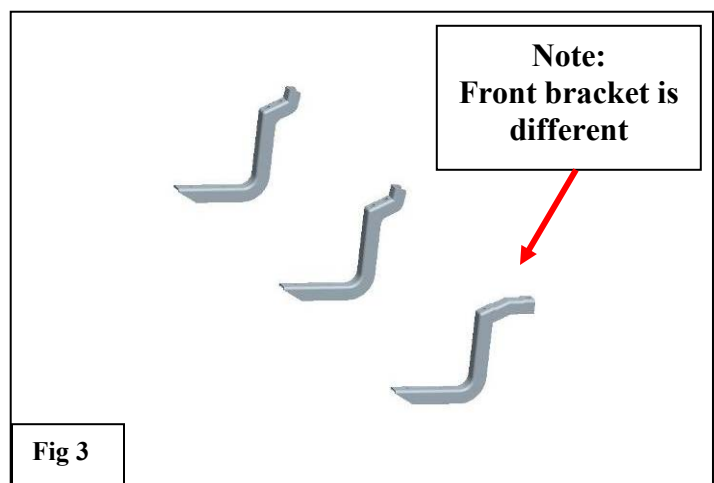





Fig 3


3. Locate the 8mm factory-threaded holes.
4. Position the Brackets onto the sidewall & align the Bracket holes to the factory holes (Fig 4).
5. Secure the Brackets using the 8mm x 30mm hex bolts, flat washer and lock washers.
6. Repeat Steps B.1-5 for the opposite side of the vehicle.


-  7. **IMPORTANT:** Position the Board on the brackets. Install (6) 8mm x 20mm bolts, three per track align with brackets **Fig 5**. Install 8mm serrated flange nuts.
8. Leave the Hardware loose at this time.

C. Torque sequence (Passenger/Driver side).


-  i. **IMPORTANT:** Prior to final Torque sequence, ensure that the bracket is positioned flush on the vehicle sidewall

-  **IMPORTANT:** Align front edge of rear end cap with the edge of rear bracket. Fig 6-7.

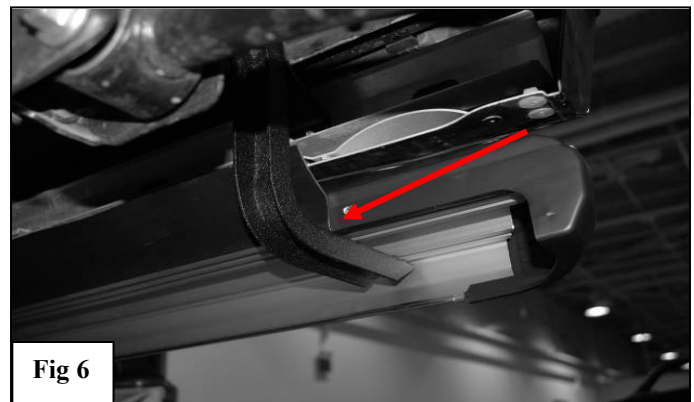
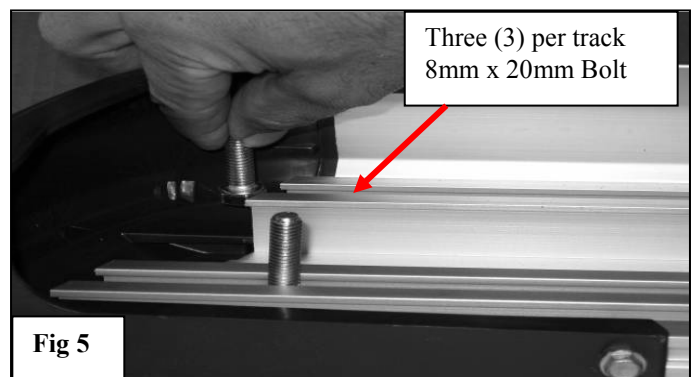
-  3. Torque all twelve 8mm Hex Bolts (Bracket to Vehicle) to **14nm (10ft/lbs)**.

-  4. Torque all twelve 8mm Flange nuts (Bracket to Running Board) to **14nm (10ft/lbs)**.

5. **Re-Torque both passenger & drivers sides after initial torque has been set.**

-  Re-Torque all twelve 8mm Hex Bolts (**Bracket to Vehicle**) to 10 ft./lbs.

 **Torque: 10ft./lbs**



Section IV: Process / Audit Criteria

Process

Audited during accessory installation

Audit



Audited on completed vehicle installation

Accessory Function Checks

Board alignment & tighten properly

All bolts are tightened to proper specifications.

No abnormal noise when weight is applied

Torque bolts to target:

8mm Hex Bolts (Bracket to Vehicle) to **(10ft/lbs)**. -/+25% 7.5~ 12.5ft . lbs

8mm Flange nuts (Bracket to Running Board)

Verify torque wrench is being used during installation .

Vehicle Function Checks

View alignment from front edge of rear end cap to rear edge of rear bracket.

Verify that there is no interference with side cladding.

Note: Range is provided by QA



FIG1

Front of Vehicle

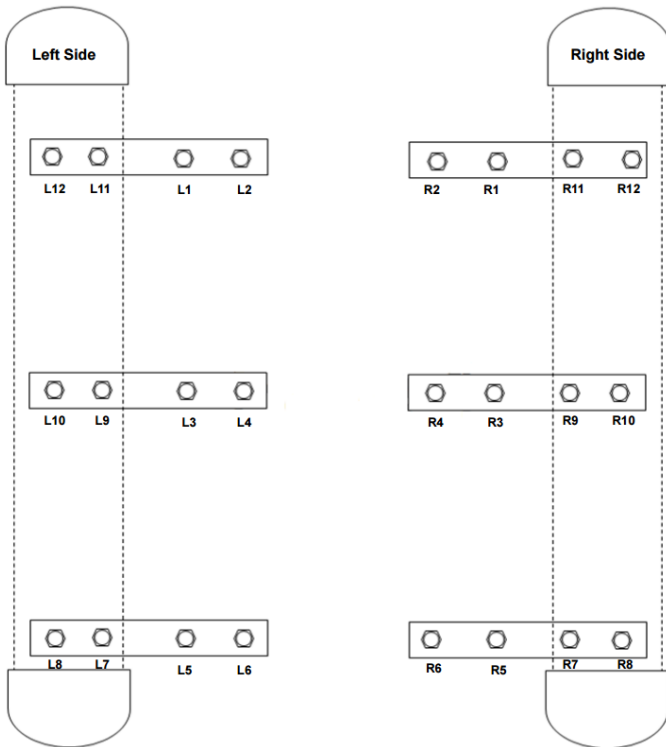


FIG 2

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 shown in **FIG 2**.
- 6) Once job is complete verify on controller.

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