

Part Number: PT278-08500**Kit Contents**

Item #	Quantity Req.	Description
1	1	Crossbar Assembly Front (long)
2	1	Crossbar Assembly Rear (short)
3	1	Hardware Bag

Hardware Bag Contents

Item #	Quantity Req.	Description
1	1	T30 Torque Wrench
2	8	M6 Shoulder Bolt
3	1	Care Card

Additional Items Required For Installation

Item #	Quantity Req.	Description

Conflicts

None

Recommended Tools

Personal & Vehicle Protection	Notes
Safety Glasses	
Safety Gloves	
Cloth	
Wrist & Belt Buckle Protection	
Special Tools	Notes
Installation Tools	Notes
Special Chemicals	Notes
Cleaner	Approved Cleaner

General Applicability

MY21 and newer Sienna models

Recommended Sequence of Application

Item #	Accessory
1	
2	
3	

*Mandatory

Vehicle Service Parts (may be required for reassembly)

Item #	Quantity Req.	Description
1		
2		
3		

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 the component is related to regulatory compliance

Procedure

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.

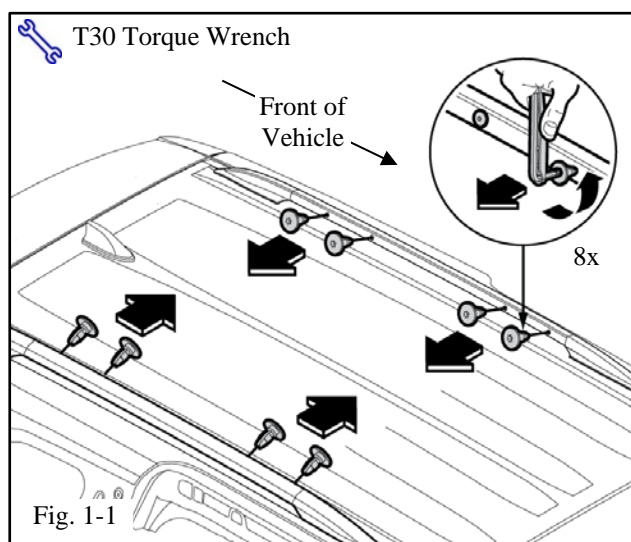
This document covers such items as: -

- 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 the Mating Parts

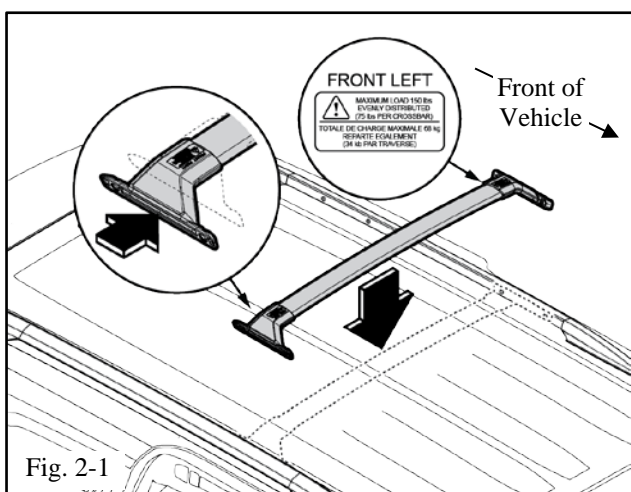
- Carefully open the hardware bag, remove content, and save the bag.
- Protect the roof with a blanket.
- Remove the plugs from the rivnuts on the inboard face of the left- and right-hand side rails with the T30 torque wrench (8pcs.). Save the plugs for Step 6 (Fig. 1-1).
- Ensure that the area inside each rivnut is clean and free of dirt and debris.

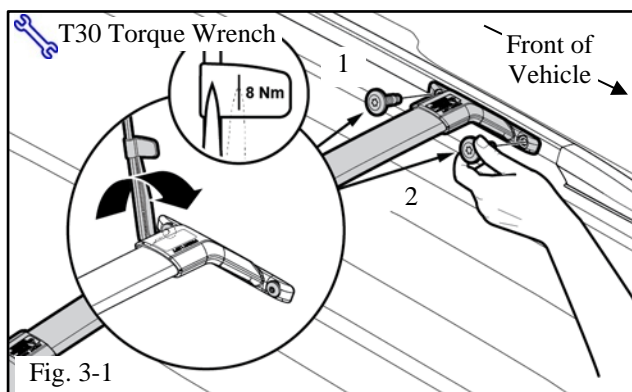


2. Align the Front Crossbar

NOTE: Make sure the crossbar is in the compressed state so that it fits easily between the side rails (Fig. 2-1).


- Ensure that the area around the attachment holes on the crossbar end supports is free of dirt and debris.
- Adjust the front crossbar between the side rails so that the position printed on each crossbar support is aligned with side rail rivnuts at that position (Fig. 2-1).





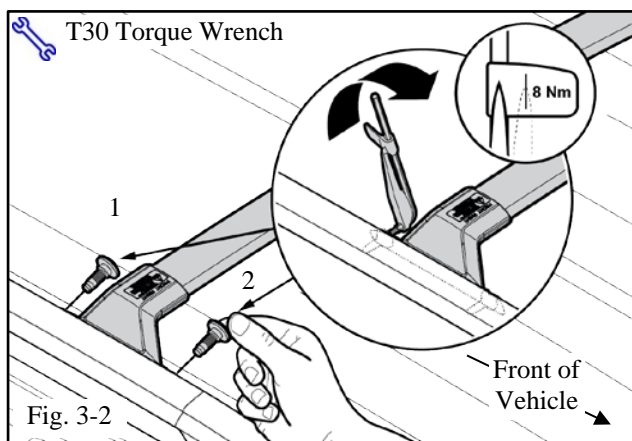
3. Install the Front Crossbar


- (a) Align the holes in the front left crossbar support to the corresponding mounting holes on the left-hand side rail (Fig. 3-1).
- (b) Starting with the rear fastener, hand-start both shoulder bolts (2pcs.) on the left-hand side front crossbar support until fastened. Handle of torque tool can be used to fasten bolts.


 (c) Adjust the length of the crossbar by pulling or pushing on the right-hand side support until it fits flush against the inside surface of the right-hand side rail.

- (d) Align the holes in the front crossbar right-hand support to the corresponding mounting holes on the right-hand side rail.

- (e) Starting with the rear, hand-start both shoulder bolts (2pcs.) on the right-hand side front crossbar support until fastened. Handle of torque tool can be used to fasten bolts (Fig. 3-2).



 **NOTE: Do not torque until confirming that the support is properly aligned to the rivnut holes and seated against the face of the side rail**

-  (f) Torque shoulder bolts (4pcs.) on the front crossbar supports to 8 N·m (71 in·lb). (Fig. 3-1) (Fig. 3-2).

Torque 8 N·m (71 in·lb)

4. Install the Rear Crossbar

- (a) Repeat steps 2 through 3 for the rear cross bar installation.

5. Retorque All Fasteners



- (a) Re-torque all shoulder bolts (8pcs.) to 8N·m (71in·lb) (Fig. 5-1).

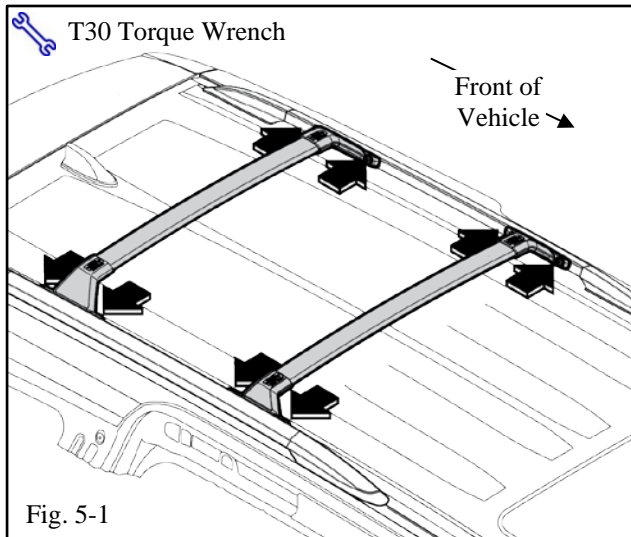


Fig. 5-1

6. Complete the Installation

- (a) Place plugs, torque wrench, and care card into the bag.
- (b) Place bag with content into vehicle's glove box (Fig. 6-1).

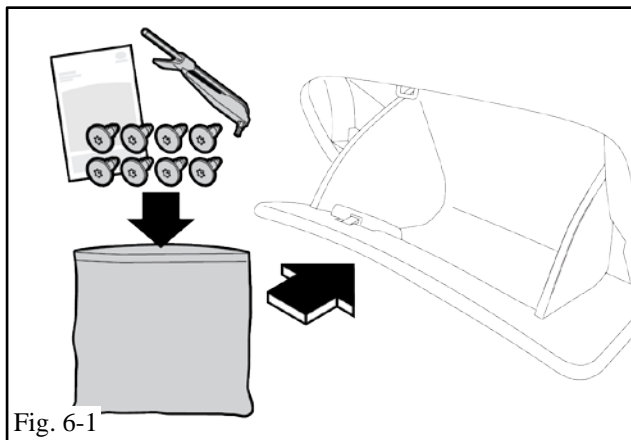


Fig. 6-1

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

<u>Check:</u>	<u>Look For:</u>
<u>Accessory Function Checks</u> <input type="checkbox"/> Ensure crossbars are secure and in correct orientation <input type="checkbox"/> Care card & torque wrench <input type="checkbox"/> Crossbar security	 Ensure the corner position printed on each crossbar support is on the corresponding corner of the vehicle. Care card, T-30 torque wrench and plastic plugs inside vehicle glove box. Ensure crossbars are fully tightened to the side rails (8 N·m (71 in·lb)).
<u>Vehicle Function Checks</u> <input type="checkbox"/> <input type="checkbox"/>	
<u>Vehicle Appearance Check</u> <input type="checkbox"/> After accessory installation perform a visual inspection.	 Ensure no damage (including scuffs and scratches) was caused during the installation process. (For PPO installations, refer to TMNA Accessory Quality Shipping Standard.)