Part Number: PT392-34140

Kit Contents

<table>
<thead>
<tr>
<th>Item #</th>
<th>Quantity</th>
<th>Reqd.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td></td>
<td>Linkage Assembly</td>
</tr>
<tr>
<td>2</td>
<td>1</td>
<td></td>
<td>Mounting Bracket</td>
</tr>
<tr>
<td>3</td>
<td>1</td>
<td></td>
<td>Step Pad</td>
</tr>
<tr>
<td>4</td>
<td>1</td>
<td></td>
<td>Hardware Bag</td>
</tr>
<tr>
<td>5</td>
<td>1</td>
<td></td>
<td>Bumper Support Bracket</td>
</tr>
<tr>
<td>6</td>
<td>1</td>
<td></td>
<td>Bumper Re-enforcement Bracket</td>
</tr>
</tbody>
</table>

Hardware Bag Contents

<table>
<thead>
<tr>
<th>Item #</th>
<th>Quantity</th>
<th>Reqd.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>2</td>
<td></td>
<td>M10 Hex Head Bolt</td>
</tr>
<tr>
<td>2</td>
<td>3</td>
<td></td>
<td>¼-20 x 1” SHCS</td>
</tr>
<tr>
<td>3</td>
<td>3</td>
<td></td>
<td>¼-20 Nut Plate</td>
</tr>
<tr>
<td>4</td>
<td>5</td>
<td></td>
<td>M8 Nut</td>
</tr>
<tr>
<td>5</td>
<td>1</td>
<td></td>
<td>½” Spacer</td>
</tr>
</tbody>
</table>

Additional Items Required For Installation

<table>
<thead>
<tr>
<th>Item #</th>
<th>Quantity</th>
<th>Reqd.</th>
<th>Description</th>
</tr>
</thead>
</table>

Conflicts

Accessory Hitch (Factory Hitch okay)

Recommended Tools

**Personal & Vehicle Protection**

Safety Glasses

**Special Tools**

None

**Installation Tools**

Ratchet Wrench
3” Extension
19mm Socket
15mm Socket
13 mm Socket & Wrench
12 mm Socket & Wrench
Large & Regular Flat Blade Screwdriver
Phillips Screwdriver
3/16 Allen Wrench
Torque Wrench 0-150 ft-lbf

**Special Chemicals**

General Applicability

Recommended Sequence of Application

<table>
<thead>
<tr>
<th>Item #</th>
<th>Accessory</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Bumper Step Assist</td>
</tr>
<tr>
<td>2</td>
<td>TRD Exhaust</td>
</tr>
</tbody>
</table>

*Mandatory

Vehicle Service Parts (may be required for reassembly)

<table>
<thead>
<tr>
<th>Item #</th>
<th>Quantity</th>
<th>Description</th>
</tr>
</thead>
</table>

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.
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. **Assemble linkage to mounting bracket.**

   (a) With the linkage assembly secure in a vice at the points indicated by the arrows, bolt the linkage assembly to the mounting bracket with the spacer and reinforcement bracket (Fig. 1-1). Tighten but do not torque.

   (1) Keep the linkage assembly in the closed (or stowed) position.

   (2) Protect (cover) the part with cloth when placed in the vice to prevent paint damage.

2. **Remove bumper cap.**

   (a) Add protective tape to the body above the bumper cap and tailgate on the driver’s side of the vehicle. From the underside of the bumper, press the tabs holding the bumper outer cap in place. Use a large flat blade screwdriver to press the tabs inward (Fig. 2-1). Use caution when removing tabs.

   (b) Remove the license plate light (Fig. 2-2a). Remove the trailer hitch plug from the socket by pressing the metal tabs. Plug removal is not required (Fig. 2-2b).
(c) Remove the plastic plug holding the bumper cap onto the lower portion of the bumper (Fig. 2-3a). Remove the plug behind the license plate in the center of the bumper using a Philips screwdriver to remove the plastic pin (Fig. 2-3b).

(d) Lightly pull up on the bumper inner cap and from the underside of the bumper, press the tabs holding the cap in place. Use a large flat blade screwdriver when pressing the tabs inward (Fig. 2-4).

3. **Remove factory bumper support bracket.**

   (a) Unbolt the three lower screws holding the bracket in place (Fig. 3-1).
(b) Pull the bumper inner cap away from the bumper and remove the two upper mounting screws holding the bracket in place (Fig. 3-2).

4. **Install the provided reinforcement bracket.**
   - (a) Install the provided bracket in place of the factory bracket. Reuse the factory bolts and use the provided M8 nuts to secure it. Leave the forward-most lower bolt out until the linkage assembly is in place. Torque the hex bolts to 27 N·m (20 ft-lbs) (Fig. 4-1).

   **Torque: 27 N·m (20 ft-lbf)**

   (1) Replace the bumper components removed in Step 2.

5. **Locate and prepare the mounting point.**
   - (a) Locate the rear bumper attachment point on the driver’s side (Fig. 5-1).

   - (b) Remove the two bumper fasteners with a ratchet wrench and 19mm socket (Fig. 5-1).
6. **Install the bumper step assist to the mounting point.**

   (a) Rotate the bumper step assist assembly into position and install the mounting bracket using the factory fasteners. Align the bumper support bracket to the mounting hole in the reinforcement bracket.

   1. Keep the linkage assembly in the lowered position (Fig. 6-1).

   2. Torque the fasteners to 152 N·m (112 ft-lbs).

   **Torque: 152 N·m (112 ft-lbf)**

   3. Torque the fasteners from Step 1 to 44 N·m (33 ft-lbs).

   **Torque: 44 N·m (33 ft-lbf)**

   4. Torque the remaining M8 hardware from Step 4 to 27 N·m (20 ft-lbs).

   **Torque: 27 N·m (20 ft-lbf)**

7. **Prepare for step pad installation.**

   (a) Push the linkage assembly into the lowered position.

   (b) Insert the three nut plates into the designated slots (Fig. 7-1).

   1. The raised lip of the nut plate faces upward.

   2. Use the first, second and forth slots only.

8. **Install the step pad.**

   (a) Locate the step pad onto the mount of the linkage assembly.
(1) The step pad interface allows two positions. Use the position that extends the step pad most outboard (Fig. 8-1).

(2) This arrangement allows foot access for deploying the step (Fig. 8-2).

(b) Insert the cap screws into the corresponding holes (first, second and forth) and torque to 8 N·m (6 ft-lbs) (Fig. 8-1).

**Torque: 8 N·m (6 ft-lbf, 71 in-lbf)**
Checklist - these points **MUST** be checked to ensure a quality installation.

<table>
<thead>
<tr>
<th>Check: Accessory Function Checks</th>
<th>Look For:</th>
</tr>
</thead>
<tbody>
<tr>
<td>☐ Torque adjustment of linkage to mounting bracket bolts</td>
<td>Linkage to mounting bracket bolts must be tightened to <strong>44 N-m (33 ft-lbs)</strong></td>
</tr>
<tr>
<td>☐ Torque adjustment of brackets / linkage assembly bolts</td>
<td>Brackets / linkage assembly bolts must be tightened to <strong>152 N-m (112 ft-lbs)</strong></td>
</tr>
<tr>
<td>☐ Torque adjustment of step pad screws</td>
<td>M8 hardware must be tightened to <strong>27 N-m (20 ft-lbs)</strong></td>
</tr>
<tr>
<td>Process check: An auditor will confirm the torque wrench setting and observe the installer performing the process.</td>
<td>Step pad screws must be tightened to <strong>8 N-m (6 ft-lbs, 71 in-lbf)</strong></td>
</tr>
</tbody>
</table>

Note: The bolts may loosen 1ft-lb over the first 24 hour period. This is very common with plastic components and is commonly referred to as “creep” in the plastic industry. THIS IS NOT A SAFETY ISSUE.

☐ Step pad position

Ensure foot access for deployment. Step deploys with downward force to left leading corner (indication by raised grip section).