

Part Number: PT738-48210

Kit Contents

Item #	Quantity Reqd.	Description
1	1	Crossbar Assembly - Front
2	1	Crossbar Assembly - Rear
3	2	Front Stanchion Covers
4	2	Rear Stanchion Covers
5	1	Hardware Kit

Recommended Sequence of Application

Item #	Accessory
1	Remove Covers on Vehicle Roof Side Rails
2	Install Cross Rails w/ Mounting Fasteners
3	Install Stanchion Covers

*Mandatory

Hardware Bag Contents

Item #	Quantity Reqd.	Description
1	4	M8 Button Head Mtg. Screw
2	4	M8 Paired Lock Washer
3	1	22Nm Torque Wrench
4	1	4 Pouch Poly Storage Bag
5	1	I Sheet (Care Card)

Additional Items Required For Installation

Item #	Quantity Reqd.	Description
1	1	Trim Removal Tool
2		
3		

Conflicts

None

Recommended Tools

Personal & Vehicle Protection	Notes
Safety Glasses	
Safety Gloves	
Vehicle Surface Protection	Vehicle Cover for Paint Protection Wrist & Belt Buckle Protection
Special Tools	Notes
Plastic Trim Removal Tool	Not Supplied in Kit
Installation Tools	Notes
22Nm T40 Torque Wrench	Supplied With Kit
Special Chemicals	Notes
None	

General Applicability

MY21 and newer Venza models (w/Side Rails)

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

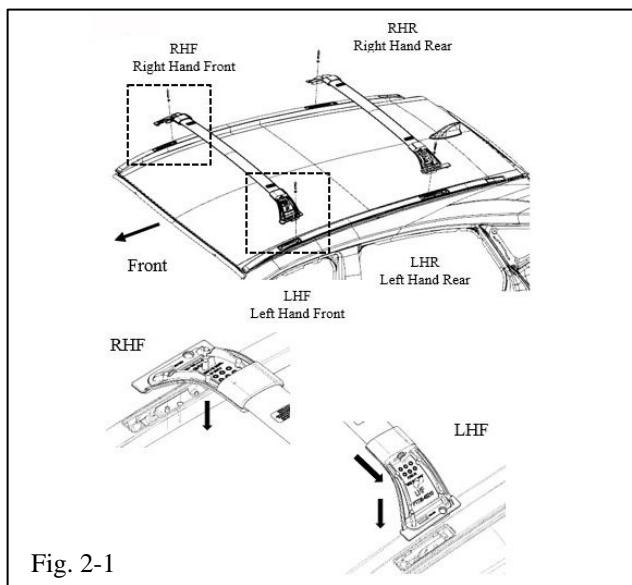
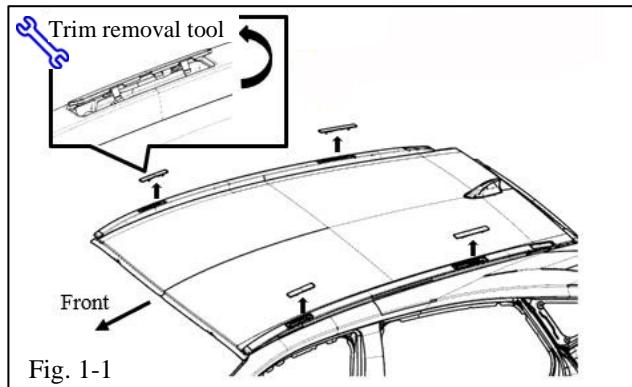
Care must be taken when installing this accessory to ensure damage does not occur to the vehicle. The installation of this accessory should follow approved guidelines to ensure a quality installation.

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. Remove the Vehicle Side Rail Covers

(a) Use plastic trim removal tool to pry up and remove side rail covers – 4 places (Fig. 1-1).

⚠ (b) Place covers in the 4 pouch sealable poly bag provided, to protect and store the covers for future use.

2. Install the Front / Rear Crossbars Assembly

⚠ (a) Ensure painted vehicle surfaces are protected during installation (Fig. 2-1).

(b) Lower the right hand front (RHF) stanchion into the passenger side front side rail opening ensuring the locating pin and mounting holes are aligned and the stanchion is fully seated.

(c) Pull the left hand front (LHF) stanchion outboard and lower it into the driver side front side rail opening ensuring the locating pin and mounting holes are aligned and the stanchion is fully seated.

(d) Repeat steps b) and c) for the Rear Crossbar Assembly.

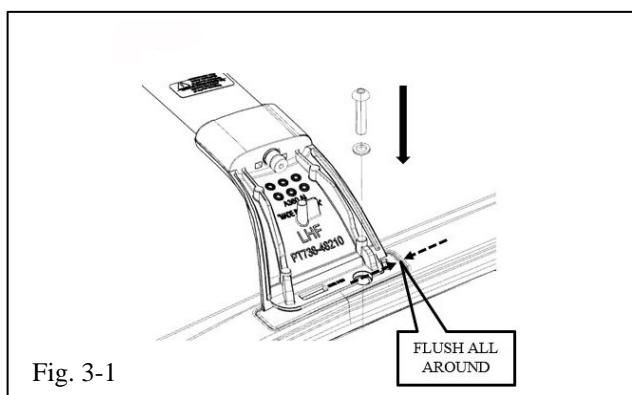


Fig. 3-1

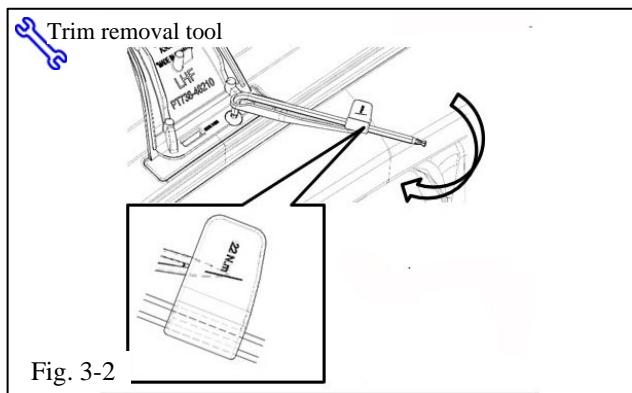


Fig. 3-2

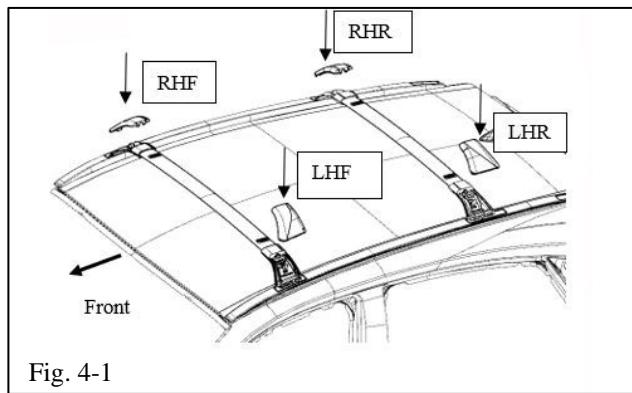


Fig. 4-1

3. Secure the Crossbars

(a) Insert T-40 button head bolt and washer into left hand and right hand stanchion mounting holes and start threads by hand (Fig. 3-1).

! (b) Before torqueing mounting fasteners, ensure stanchion are flush to side rail surface all around (Fig. 3-1).

(c) Use the T-40 torque wrench provided and tighten screw to 22N·m rotating wrench clockwise (Fig. 3-2).

Torque: 22N·M (16 ft-lb) (195 in-lb)

(d) Install and torque all stanchion mounting screws in the same manner.

4. Install the Cross Bar Covers

! (a) Before attaching covers to stanchions, ensure covers are matched to the associated stanchion (Fig. 4-1).

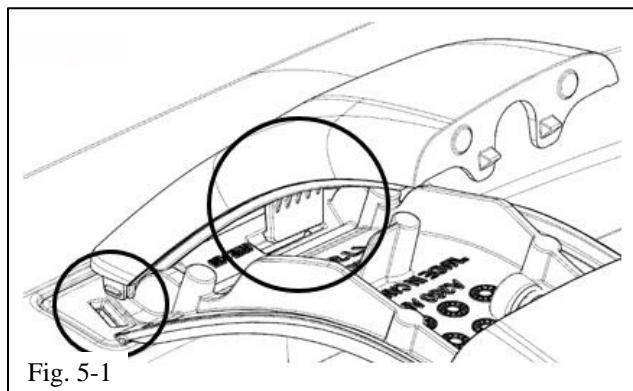
! **NOTE:**

**LHF COVER TO LHF STANCHION
(Cover ID #1)**

**RHF COVER TO RHF STANCHION
(Cover ID #2)**

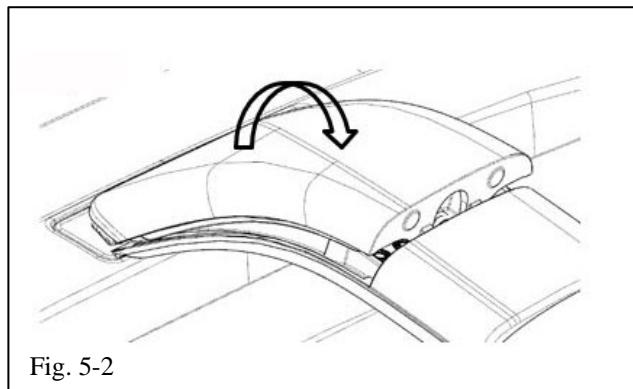
**LHR COVER TO LHR STANCHION
(Cover ID #3)**

**RHR COVER TO RHR STANCHION
(Cover ID #4)**

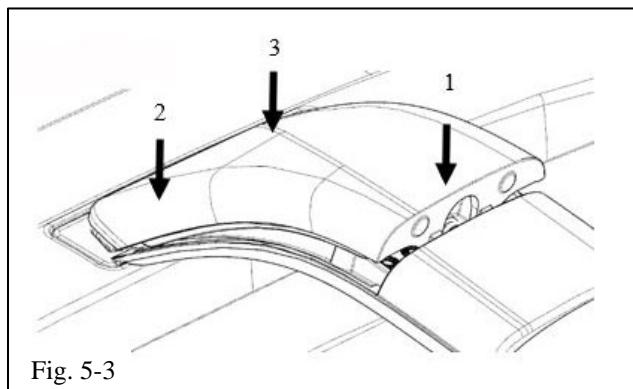


5. Install the Cross Bar Covers

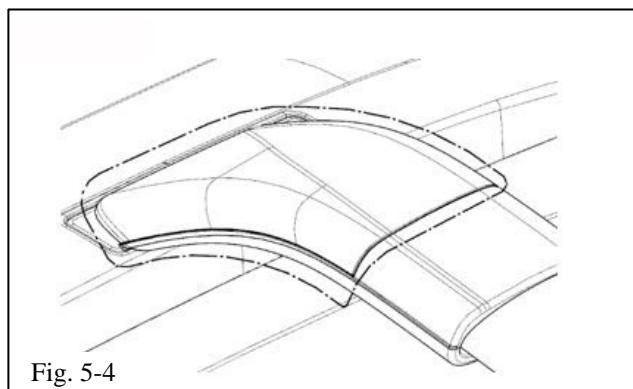
(a) Lower the cover down over the stanchion ensuring the large and small clips are seated in their respective stanchion openings (Fig. 5-1).



(b) Rotate the cover until the top over the cover and top of the stanchion touch (Fig. 5-2).



(c) Using the palm of your hand (or a soft rubber mallet), snap the cover down to engage the clips into the stanchion in the order indicated: 1) upper cover clips 2) lower small clip 3) lower large clip (Fig. 5-3).



(d) Ensure the cover is fully seated around the entire interface of the cover and stanchion. (Fig. 5-4).

(e) Repeat this process on all other stanchions.

6. Complete the Installation

- || (a) Place the torque wrench, user's manual, and poly bag with covers saved from step 1(b) in the glove box or center console.
- || (b) Installation is complete.

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

Check:	Look For:
<u>Accessory Function Checks</u>	
<input type="checkbox"/> Ensure the crossbars are secure and in the correct position.	Stanchion base is flush to side rail surface.
<input type="checkbox"/> Side rail covers, torque tool and users guide	Indicated items are stored in the glove box for future use.
<input type="checkbox"/> Crossbar cover engagement	Ensure covers are fully seated on stanchions
<input type="checkbox"/> Load labels	Ensure load labels are legible (both sides). Max. indicated load is 165lbs. (75kg).
<u>Vehicle Function Checks</u>	
<input type="checkbox"/>	
<input type="checkbox"/>	
<u>Vehicle Appearance Check</u>	
<input type="checkbox"/> After accessory installation and removal of protective cover(s), perform a visual inspection.	Ensure no damage (including scuffs and scratches) was caused during the installation process.
	Ensure no damage has occurred to cross rails during the installation process. (For PPO installations, refer to TMNA Accessory Quality Shipping Standard.)