

Part Number: PT925-89180

Kit Contents

Item #	Quantity Req'd.	Description
1	1	Left Hand Step Tube
2	1	Right Hand Step Tube
3	1	Hardware Kit

Hardware Bag Contents

Item #	Quantity Req'd.	Description
1	12	SEMS M8 x 30mm Bolt
2		
3		

Additional Items Required For Installation

Item #	Quantity Req'd.	Description
1		
2		
3		

Conflicts

Limited Models

Recommended Tools

Personal & Vehicle Protection	Notes
Special Tools	Notes
Installation Tools	Notes
Ratchet	
Extension	3" & 6"
Socket	10mm, 12mm
Torque Wrench	0-50 N-m (0-37 ft-lbf)
Special Chemicals	Notes

General Applicability

MY17 and newer SR5 & PRO Models

Recommended Sequence of Application


Item #	Accessory
1	
2	


*Mandatory


Vehicle Service Parts (may be required for reassembly)


Item #	Quantity Req'd.	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.



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 for the Installation.

⚠ NOTE: Remove & dispose of the protective wrapping from the Tube Step prior to installation.

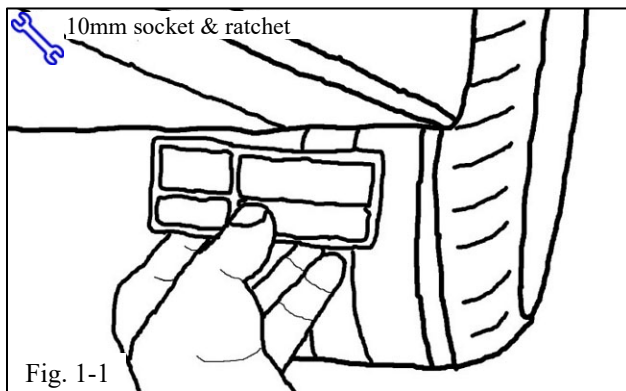
(a) Verify and ensure all kit and hardware contents are present.



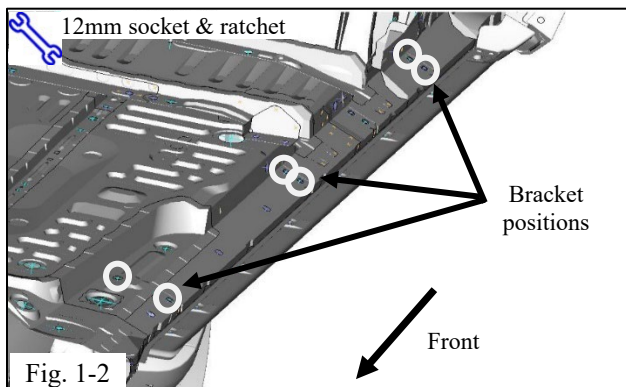
(b) Ensure all application areas are free from any dirt and debris that may damage the surface of the product or vehicle.

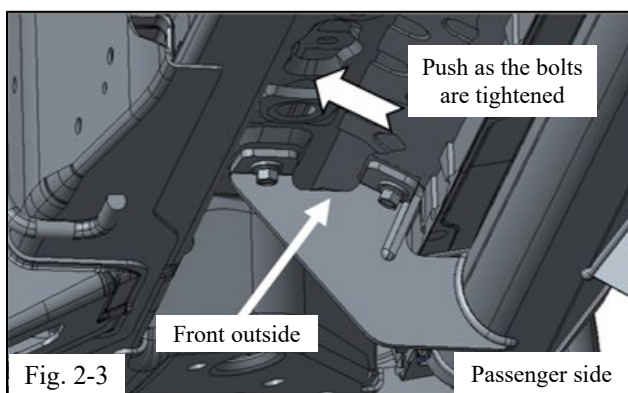
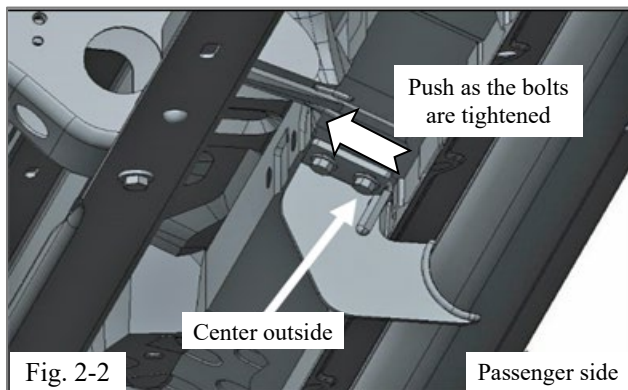
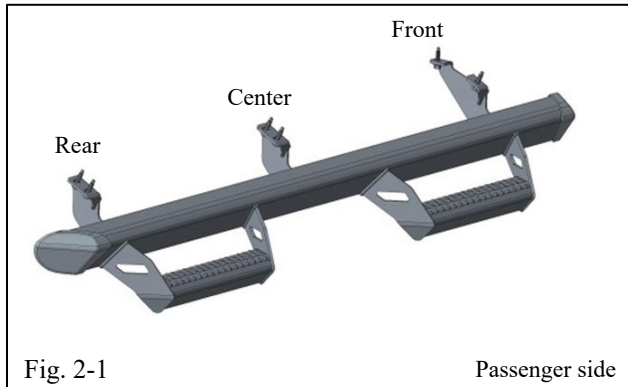


(c) Use a 10mm socket to remove and discard the plastic wind deflector and bolts in front of the rear tire (Fig. 1-1).



(d) Use a 12mm socket to remove & discard six OE Hex bolts from underneath the vehicle (Fig. 1-2).





2. Install the Passenger Side Tube Step.

- (a) Position the tube step to the passenger side of the vehicle (Fig. 2-1).

⚠ NOTE: The long bracket goes to the front of the vehicle (Fig. 2-1).

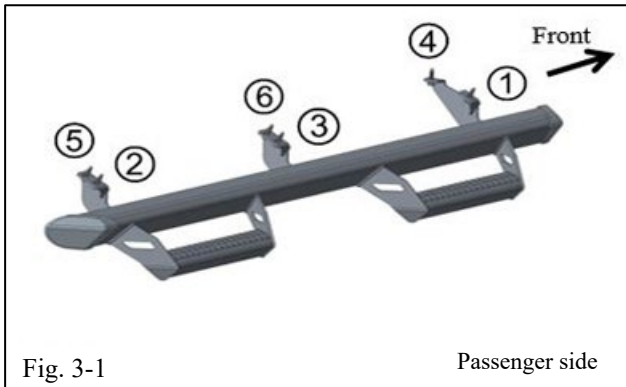
⚠ NOTE: For the following steps, the use of a non-impacting type electric hand tool can be used to drive the bolts so long as the bolt does not reach or exceed the specified torque. **Leave all hardware loose at this time.**

- (b) Hand start one M8 bolt into the outside slotted hole in the center bracket (Fig. 2-2).

- (c) Hand start one M8 bolt into the outside slotted hole in the rear bracket (Fig. 2-2).

- (d) Hand start one M8 bolt into the outside hole in the front bracket (Fig. 2-3).

- (e) Hand start the remaining M8 bolts, starting with the front bracket working to the rear.



3. Tighten all of the Hardware.

- (a) In numerical order, tighten (but do not torque) from the outside bolts (closest to the pinch weld) to the inside bolts (Fig 3-1).

⚠ NOTE: As the bolts closest to the pinch weld are tightened, push the bracket inward to maximize clearance to the pinch weld.

- (b) Tighten (but do not torque) the remaining bolts as indicated in Fig. 3-1.

4. Torque all Hardware.

- (a) Follow the tightening sequence in Fig. 3-1 to torque the “outside bolts” ① through ③ .

⚠ NOTE: Make sure the bracket is seated to the body before torquing.

Torque: 23 N-m (17 ft-lbf)

- (b) Follow the tightening sequence in Fig. 3-1 to torque the “inside bolts” ④ through ⑥ .

Torque: 23 N-m (17 ft-lbf)

5. Install the Driver Side Tube Step.

- (a) Repeat Steps 2 through 4 on the driver side.

6. Re-torque all Hardware.

- (a) Re-torque all twelve M8 Hex Bolts in the same order as Step 4.

Torque: 23 N-m (17 ft-lbf)

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

<u>Check:</u>	<u>Look For:</u>
<p><u>Accessory Function Checks</u></p> <p><input type="checkbox"/> Step alignment</p> <p><input type="checkbox"/></p> <p><input type="checkbox"/></p>	<p>Tube Step is level and even to vehicle rocker.</p>
<p><u>Vehicle Function Checks</u></p> <p><input type="checkbox"/> No interference between step & vehicle</p> <p><input type="checkbox"/></p> <p><input type="checkbox"/></p>	<p>Pinch weld contact</p>
<p><u>Vehicle Appearance Check</u></p> <p><input type="checkbox"/> After accessory installation and removal of protective cover(s), perform a visual inspection.</p>	<p>Ensure no damage (including scuffs and scratches) was caused during the installation process. (For PPO installations, refer to TMNA Accessory Quality Shipping Standard.)</p>