Part Number: PT974-48210

Kit Contents

Item #	Quantity Reqd.	Description
1	1	Activity Mount
2	1	Driver Side Plate
3	1	Passenger Side Plate
4	2	Mounting Plate
5	1	Hardware Kit
6	1	Customer Care Card

Hardware Bag Contents

Item #	Quantity Reqd.	Description
1	4	M12-1.25 x 55 Hex Bolt
2	8	M12-1.25 x 35 Hex Bolt
3	4	M12-1.25 Hex Nut
4	16	M12 Conical Toothed Washer

Additional Items Required For Installation

Item #	Quantity Reqd.	Description
1	1	C0325-99990, receiver plug
2		
3		

Conflicts

None

Recommended Tools

Personal & Vehicle Protection	**Notes**
Cut Resistant Gloves	For Cutting Heat Shield
Safety Glasses	
Special Tools	**Notes**
Snap-on Torque Wrench Adapters (or equivalent)	Closed ended: QXXM19A Open ended: QXOM19A
Snap-on 2” Torque Wrench Adapter (or equivalent)	FRDHM19
Exhaust Hanger Removal Pliers	
½” Drive Socket 17mm	For the tow hook
Installation Tools	Notes
Torque Wrench	0-100 lbf-ft
Crowfoot Wrench Adaptor	
Tin Snips	
½” drive socket wrench	
½” drive socket	**19mm**
19mm end wrench	
14mm socket	If removing tail exhaust
17mm socket	

General Applicability

MY21 and newer Venza models

Recommended Sequence of Application

Item #	Accessory

*Mandatory

Vehicle Service Parts (may be required for reassembly)

Item #	Quantity Reqd.	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

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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. Preparation for the Installation.

(a) Wear safety glasses.

(b) Verify the kit contents.

(c) Cover the exhaust pipe with a clean shop towel.

(d) Remove Tow Hook with 17mm socket (Fig. 1-1).

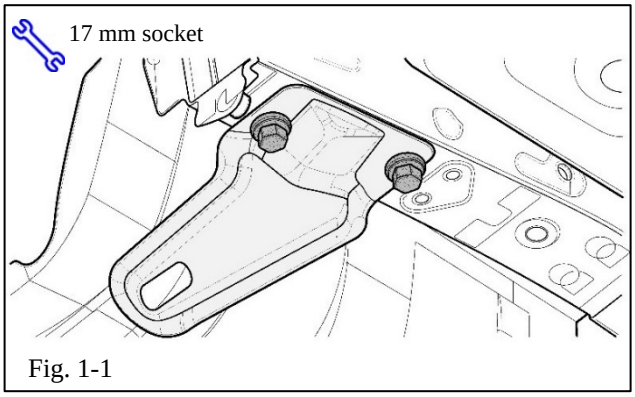


Fig. 1-1

(e) Reinstall bolts with 17mm socket. Torque to 66.6 Nm (49 ft-lbf) (Fig. 1-2).

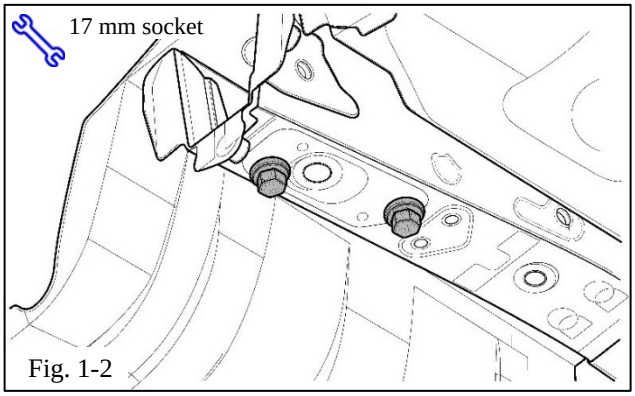


Fig. 1-2

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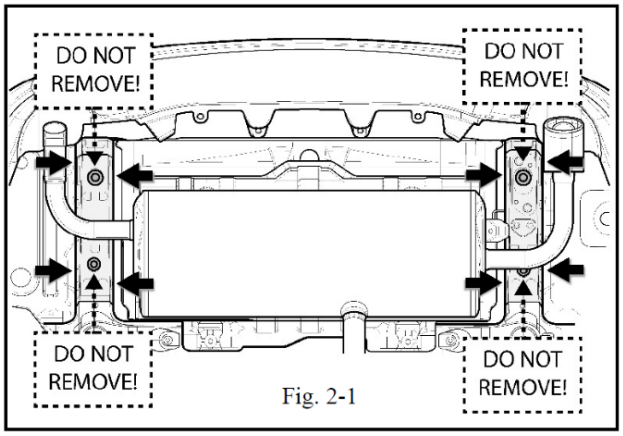


Fig. 2-1

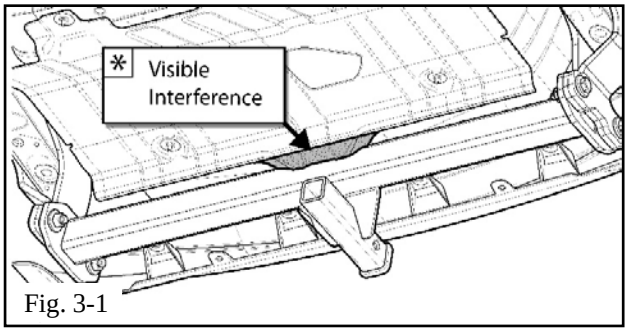
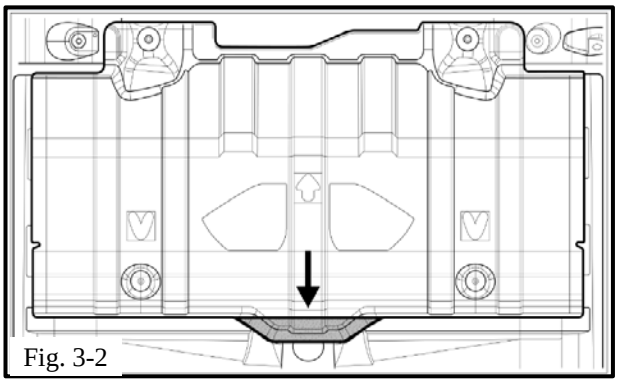


Fig. 3-1


Fig. 3-2

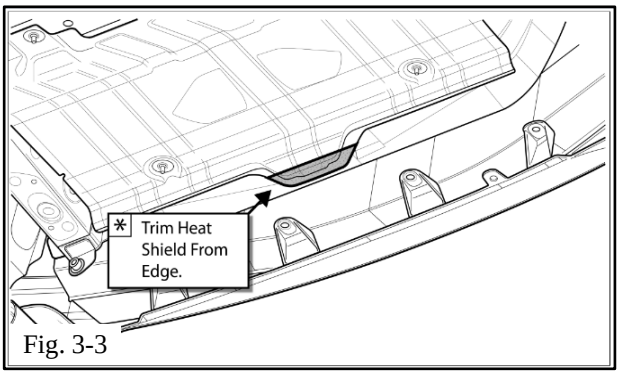


Fig. 3-3

2. Remove the Tape Plugs.

(a) Remove tape plugs located on side surfaces of frame rails. 8 total, 4 per side (2 inboard/ 2 outboard). Figure 2-1.

NOTE: Do NOT remove the bottom surface plugs (Fig. 2-1).

3. Locate Heat Shield.

NOTE: Heat shield edges are very sharp

(a) Interference will occur if heat shield is not trimmed Fig. 3-1 and Fig 3-2. Trimming must be made to clear any interferences.

(b) Taking tin snips, remove interference from heatsheild and activity mount by carefully trimming the heat shield back Fig 3-3.

4. Lowering of Exhaust

NOTE: Exhaust may be hot

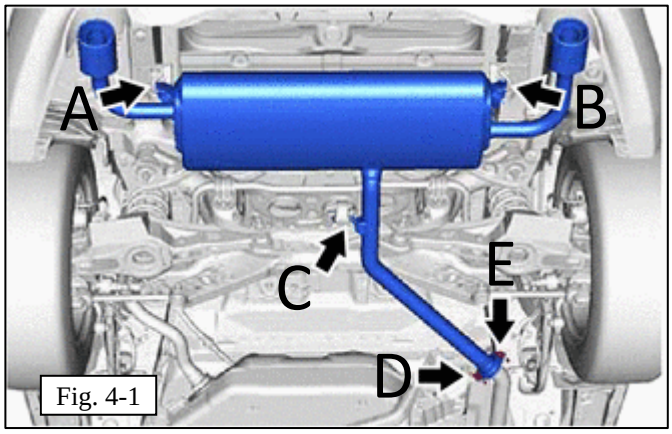


Fig. 4-1

(a) Exhaust needs to be released at 3 locations: A, B, C (Fig. 4-1) in order to reduce time for further instructions that follow.

(b) Prepare to detach the attachment points by adding soapy water as needed to the attachment points

(c) Release all attachment points at all 3 locations, Fig. 4-1, and support exhaust with stand.

(d) If preferred, installer may fully remove tail exhaust by removing forward 2 14mm bolts (D, E figure 4-1) and removing the assembly

5. Mounting Plate Attachment.

(a) With FWD arrow on label facing out on driver side outer mounting plate into position & attach to outer side of frail rail.

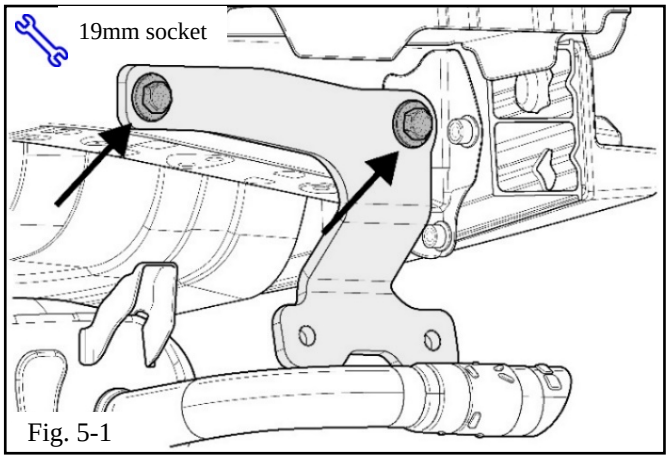


Fig. 5-1

(b) Loosely install two M12 x 35mm hex bolts with two M12 conical washers with teeth facing mounting plate (Fig. 5-1).

NOTE: Be sure conical washer teeth are against mounting plate



(c) Lift inner flat mounting plate into position and attach to inner side of the driver side frame rail.

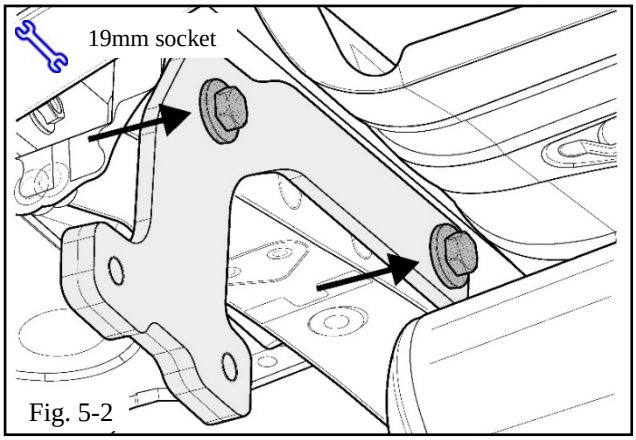


Fig. 5-2

(d) Loosely install two M12 x 35mm hex bolts with two M12 conical washers using a ½" drive socket wrench with 19mm socket (Fig. 5-2).

⚠ **NOTE: Be sure conical washer teeth are against mounting plate**

6. Repeat Steps on Passenger Side.

(a) Repeat step 4 (a) – (d) on the passenger side frame rail.

7. Inner Side Flat Mounting Plate Attachment.

(a) Lift center weldment assembly into position & attach to inner side flat mounting plates.

(b) Loosely install two M12 x 55mm hex bolts with two M12 conical washers (Fig 7-1).

(c) Loosely install two M12 hex nuts with two M12 conical washers (Fig 7-1).



½" drive socket wrench with 19mm socket & 19mm end wrench.

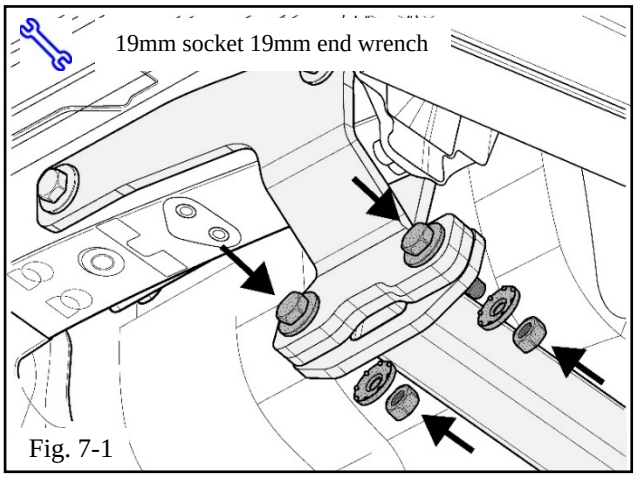


Fig. 7-1

⚠ **NOTE: Be sure conical washer teeth are against mounting plate.**

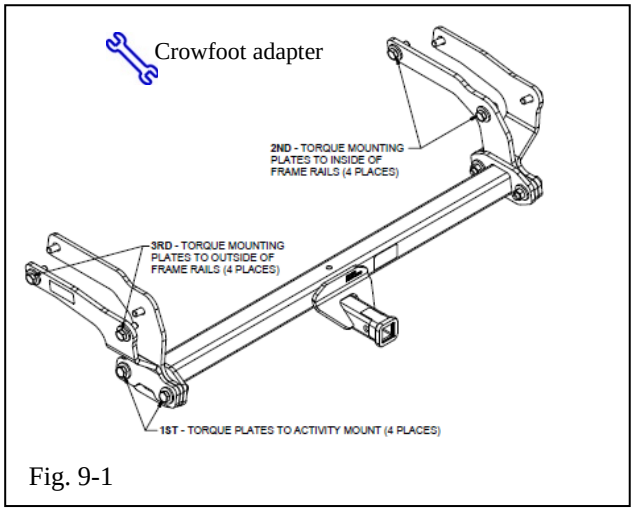


Fig. 9-1

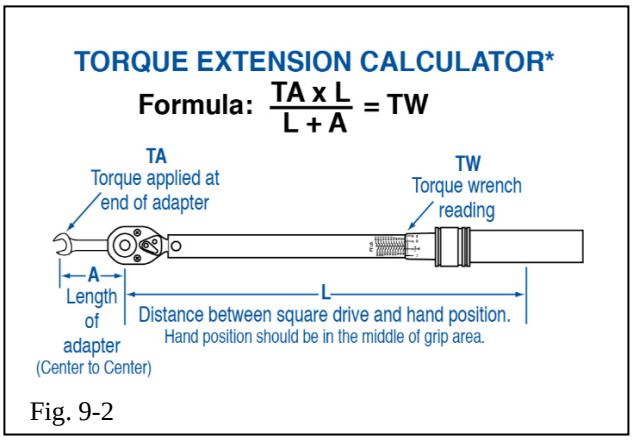


Fig. 9-2

8. Repeat Steps on Passenger Side.

(a) Repeat on steps 5a, 5b & 5c on driver side.

9. Torque all 12 Bolts.

NOTE: Torque is to be applied to the nut

(a) 1st Torque plates to activity mount main tube with assembly M12 fasteners to 100 Nm (74 ft-lbf) Fig 9-1. See Fig. 9-2 for bolts that need crowfoot adaptor to apply proper torque.

(b) 2nd Tighten all inner mount plates to inside of frame rails with M12 fasteners to 100 Nm (74 ft-lbf) Fig 9-1. See Fig. 9-2 for bolts that need crowfoot adaptor to apply proper torque.

(c) 3rd Tighten all outer plate M12 fasteners to outside of frame rails 100 Nm (74 ft-lbf) Fig 9-1. See Fig 9-2 for bolts that need crowfoot adaptor to apply proper torque.



Crowfoot wrench with 19mm socket.

Torque: 100 Nm (74 ft-lbf.)

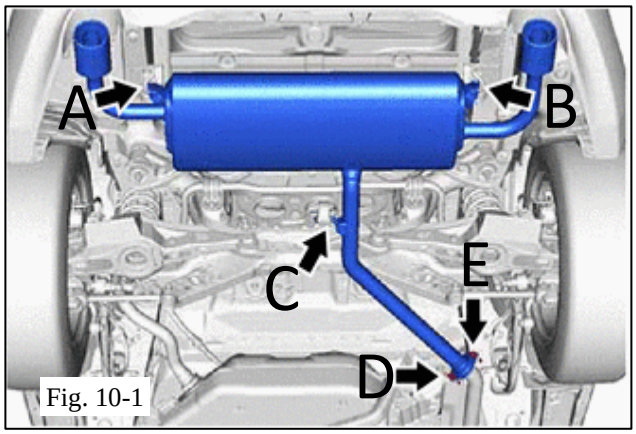


Fig. 10-1

10. Re-Attaching Exhaust

(a) After torqueing all bolts, reattach exhaust to all three attachment points (Fig. 10-1).

(b) If exhaust previously removed, install gasket to front exhaust assembly and attach tail exhaust using previously removed bolts (D,E). Torque bolts to 43Nm (32 ft-lbf.).

⚠**NOTE: install a new gasket for dealer installs**

11. Care Card Placement.

(a) Locate care card provided in package.

(b) Place care card in glove box.

12. Complete the installation.

(a) Remove vehicle protection.

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

Check:	Look For:
Accessory Function Checks ☐ Bolt Torque	Confirm all bolts are tightened to the correct torque of_ 100 Nm (74 ft-lbf)
Vehicle Function Check ☐ Warning Label ☐ Part Label ☐ Customer Care Card ☐ Receiver Plug	Two labels are on activity mount (already applied by supplier). Customer Care card placed into glove box. Receiver Plug placed on passenger floor
Vehicle Appearance Check ☐ After accessory installation and removal of protective cover(s) on exhaust pipe. Perform visual appearance check.	Ensure no damage (including scuffs and scratches) was caused during the installation process. (For PPO installations, refer to TMNA Accessory Quality Shipping Standard.)

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