Part Number: PT925-35170 (D-Cab)
PT925-35172 (C-Cab)

Kit Contents

Item #	Quantity Reqd.	Description
1	1	Left Hand Step Tube
2	1	Right Hand Step Tube
3	1	Hardware Kit

Hardware Bag Contents

Item #	Quantity Reqd.	Description
1	12	SEMS 8mm x 30mm Bolt
2		
3		

Additional Items Required For Installation

Item #	Quantity Reqd.	Description
1		
2		
3		

Conflicts

Regular/Access Cab Models

Recommended Tools

Personal & Vehicle Protection	**Notes**
Special Tools	**Notes**
Installation Tools	**Notes**
12mm Socket	
Ratchet	
Torque Wrench	0-50 N-m (0-37 ft-lbf)
Panel Pry Tool	Toyota SST 00002-06001-01
Special Chemicals	**Notes**

General Applicability

MY16 and newer D-Cab & C-Cab Models

Recommended Sequence of Application

Item #	Accessory
1	
2	

*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.



Issue: B 02/02/2022

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 Install.

(a) Open the box and check the kit for complete contents and any damage.

(b) Use a panel pry tool to remove and discard the twelve (12) OE plastic plug bolts from underneath the vehicle, 6 per side (Fig. 1-1).

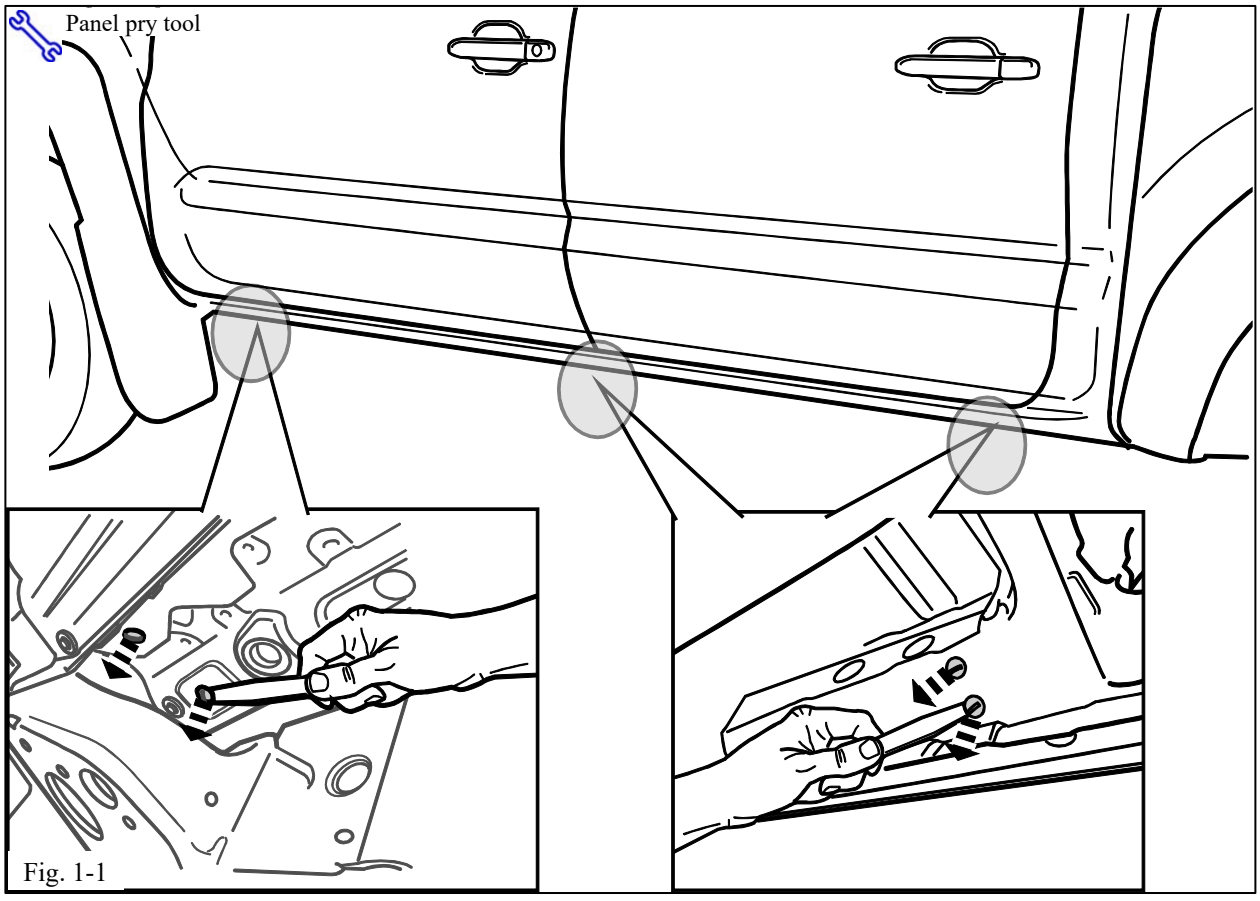


Fig. 1-1

Issue: B 02/02/2022

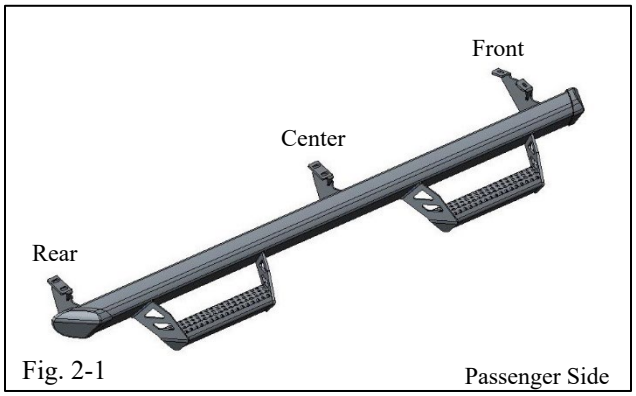


Fig. 2-1

2. Install the Passenger Side Tube Step.

(a) Position the tube step to the passenger side of the vehicle.

⚠ **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.**

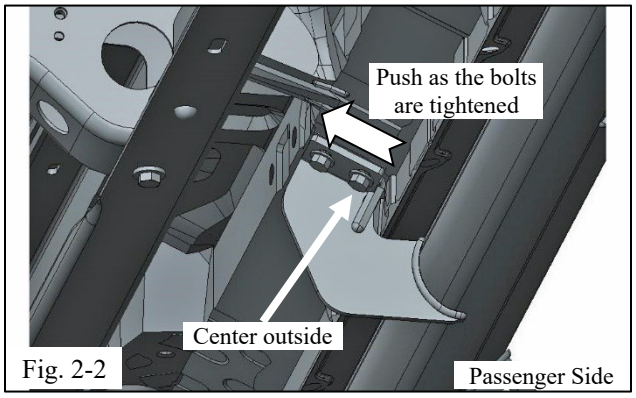


Fig. 2-2

(b) Start one 8mm bolt into the outside slotted hole in the center bracket (Fig. 2-2).

(c) Start one 8mm bolt into the outside slotted hole in the rear bracket.

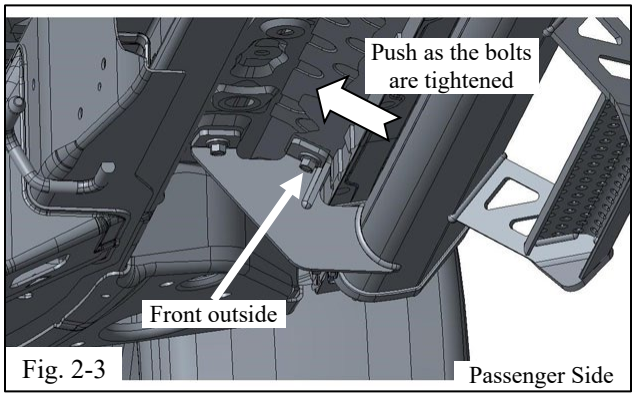


Fig. 2-3

(d) Start one 8mm bolt into the “outside” hole in the front bracket (Fig. 2-3).

(e) Start the remaining 8mm bolts, starting with the front bracket working to the rear.

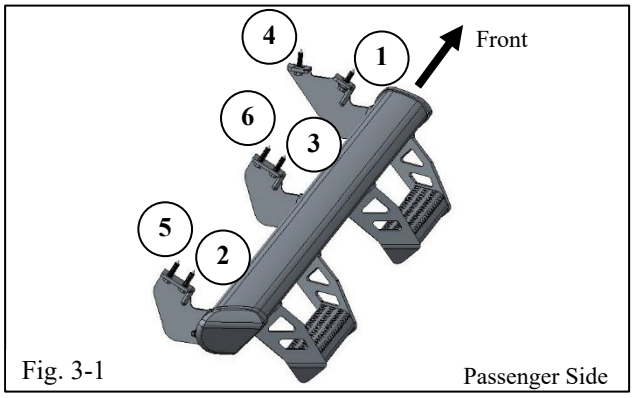


Fig. 3-1

3. Tighten all Hardware.

(a) Tighten (but do not torque) the front outside bolt (1), then the rear outside bolt (2), and finally the center outside bolt (3) (closest to the pinch weld) (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).

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 8mm Hex Bolts in the same order as Step 4.

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

Issue: B 02/02/2022

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

Check:	Look For:
Accessory Function Checks	
☐ Step alignment & torque	Torque: 23 N-m (17 ft-lbf)
☐	
☐	
☐	
Vehicle Function Checks	
☐ No interference between step & vehicle	Pinch weld contact
☐	
☐	
Vehicle Appearance Check	
☐ 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. (For PPO installations, refer to TMNA Accessory Quality Shipping Standard.)

Issue: B 02/02/2022