



FITTING INSTRUCTIONS

Part Number: **4423040**
Product **SUMMIT SIDE STEP SECT SUIT TACOMA MY24**
Description:
Suited to **TOYOTA TACOMA 2024 ONWARDS**
vehicle/s:

WARNING

NOTE THE FOLLOWING:

- ◆ This product must be installed exactly as per these instructions using only the hardware supplied.
- ◆ In the event of damage to any Side Step and Side Rail component, contact your nearest authorised ARB stockist. Repairs or modifications to the impact absorption system must not be attempted.
- ◆ Do not use this product for any vehicle make or model, other than those specified by ARB.
- ◆ This product or its fixing must not be modified in any way.
- ◆ The installation of this product may require the use of specialized tools and/or techniques.
- ◆ It is recommended that this product is only installed by trained personnel.
- ◆ These instructions are correct as at the publication date. ARB Corporation Ltd. cannot be held responsible for the impact of any changes subsequently made by the vehicle manufacturer.
- ◆ During installation, it is the duty of the installer to check correct operation/clearances of all components.
- ◆ Work safely at all times.
- ◆ Unless otherwise instructed, tighten fasteners to specified torque.

ARB 4x4 ACCESSORIES

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GENERAL CARE AND MAINTENANCE

By choosing an ARB Side Step and Side Rail, you have bought a product that is one of the most sought after 4WD products in the world. Your step and rail is a properly engineered, reliable, quality accessory that represents excellent value. To keep your step and rail in original condition it is important to care and maintain it following these recommendations:

- Prior to exposure to the weather your step and rail should be treated to a Carnauba based polish on all exposed surfaces. It is recommended that this is performed on a six monthly basis or following exposure to salt, mud, sand or other contaminants.



As part of any Pre Trip Preparation, or on an annual basis, it is recommended that a thorough visual inspection of the step and rail and surrounding components is carried out, making sure that all bolts are torqued to the correct specification. Also check that nearby wiring and plumbing are free of damage. Replace any components as necessary. This service can be performed by your local authorized ARB Stockist.

FITTING REQUIREMENTS

REQUIRED TOOLS FOR FITMENT OF PRODUCT:

Basic tool kit	Silicon
Axle stands (optional)	Torque Wrench/Wrenches - (5Nm TO 100Nm)

HAVE AVAILABLE THESE SAFETY ITEMS WHEN FITTING PRODUCT:

Protective eyewear		Hearing protection	
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NOTE: 'WARNING' notes in the fitting procedure relate to OHS situations, where to avoid a potentially hazardous situation it is suggested that protective safety gear be worn or a safe work procedure be employed. If these notes and warnings are not heeded, injury may result.

FASTENER TORQUE SETTINGS:

SIZE	Torque Nm	Torque lb/ft
M6	9Nm	7lbft
M8	22Nm	16lbft
M10	44Nm	32lbft
M12	77Nm	57lbft

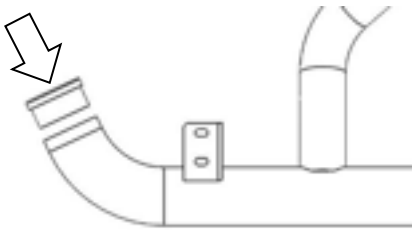
PARTS LISTING			
APPLICATION.	PART NO.	QTY	DESCRIPTION
SIDE STEPS TO VEHICLE	6562930R	1	WELD ASY RH S/STEP SUIT TACOMA
	6562930L	1	WELD ASY LH S/STEP SUIT TACOMA
	3194639R	2	PLATE NUT FRNT UPR RH AMAROK
	4581072	16	WASHER FLAT M6x20x1.6 TZP
	4584305	8	WASHER FLAT 10.2ID X 25OD X 10 ZP
	4654084	2	NUT PLATE M10X1.5
	6151128	16	NUT FLANGE M6x1.0 ZP SERRATED
	6151478	4	NUT FLANGE M10x1.25 TZP FINE PITCH SERRATED
	6151717	10	SCREW HXHD FL M10x1.25x40 PC8.8 TZP480
	6151786	4	BOLT HXHD FL M10x1.25x135 PC10.9
	6151897	4	BOLT HXHD FL M10x1.5x30 PC8.8 ZNN480
	6500002	4	PLUG RUBBER 60.3 TUBE BLANKING PLUG
	215637	2	STKR DECAL ARB SMALL

FITTING PROCEDURE – PREPARATION TO VEHICLE



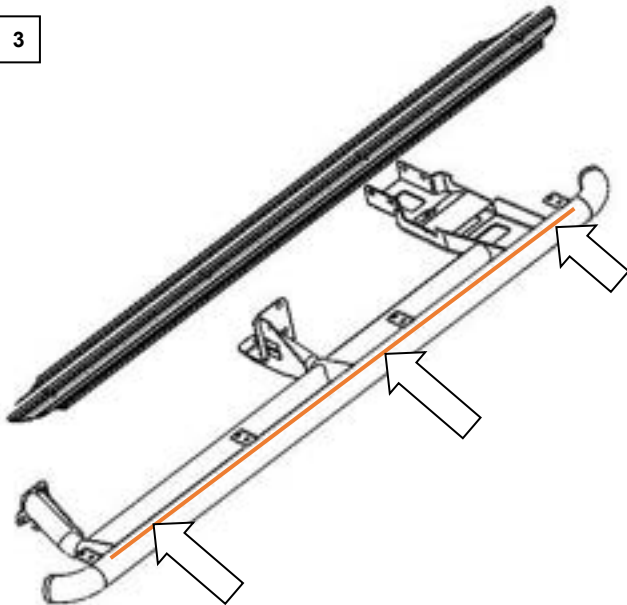
1. If fitted, remove the factory side steps.

SIDE STEP FITMENT TO VEHICLE



2. Fit the Rubber Plugs into the ends of the Side Steps.

3



3. Run a bead of silicon along the top of the side step where the Tread Plate will sit.
4. Fit the tread plates to the rails using M6 flange nuts and M6 panel washers as shown.
5. Align tread plate so it is even at both ends and torque nuts.

Note: Over tightening of bolts may result in damage to the Tread Plates.

Torque to specification.



M6 - 5Nm (CRITICAL)

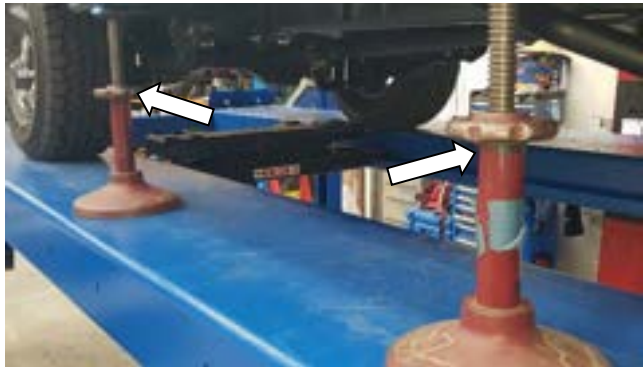


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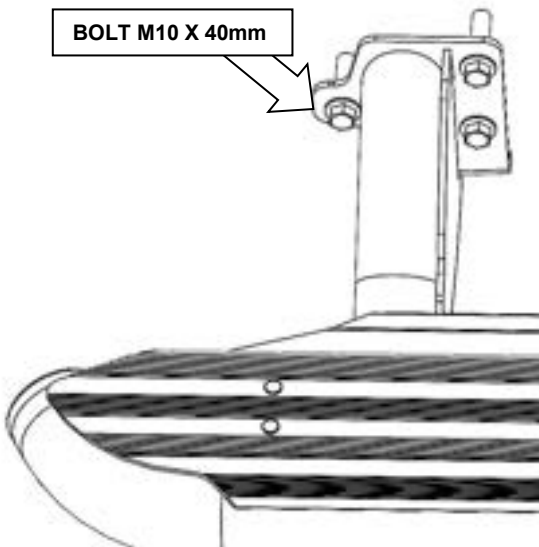


6. Support the gearbox crossmember. Remove Two M10 nuts and bolts on the R/H side only
7. Only remove one side at a time



8. Place the RHS Step against the chassis Use adjustable axle stands or a second person to hold the rails in place.

BOLT M10 X 40mm



9. Assemble M10x40 bolts through rear step mount and into the factory chassis threads (6151717).

Leave loose at this stage.



10. On the chassis in line with the middle rail mount, remove the plastic plug to expose the hole.



11. Insert the M10 nut plate and bend stick to align with the hole in the bottom of the chassis rail below. (4654084)

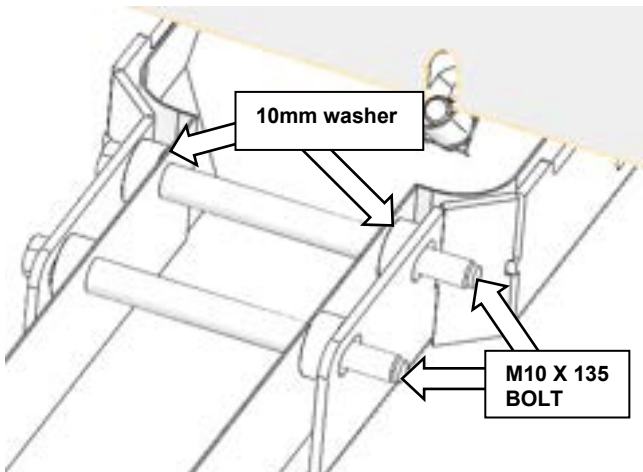


Leave loose at this stage.

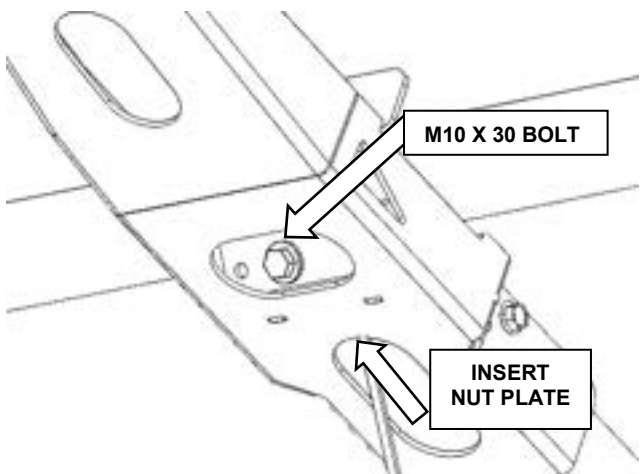


12. Assemble M10x40 bolts through rear step mount and into the chassis side threads
13. On bottom flange shape nut stick as shown ,to line up with factory chassis hole.
14. Assemble M10x30 bolt through into nut plate.

Leave loose at this stage.

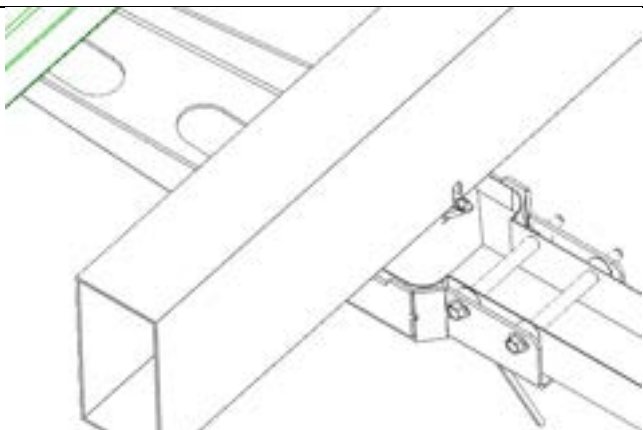
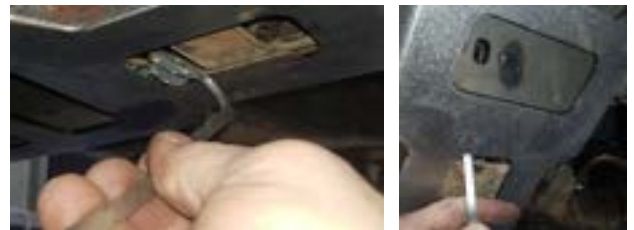


15. At the front mount use the M10x135 bolts and 10mm thick washers. Insert the washer as the bolt is passed through the cross member

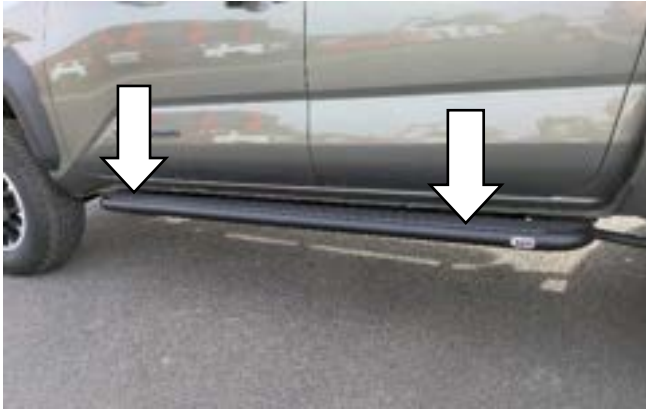


16. Attach the front mount to the chassis at the side using an M10 x 30 bolt and M10 nut plate.

(3194639R)



17. Break the exposed nut plate tails or alternatively push the nut plate tails inside the chassis rail.
18. Repeat Steps 1 to 17 on the LH side of vehicle



19. Adjust the rail so that it is level with the vehicle and tighten all fasteners to specified torque.
20. Repeat for both sides.

Torque to specification.



M10 - 44Nm



M10 - 54Nm Cross Member Bolts

FITTED PRODUCT

