

Installation Instructions for IA20SIG5B

by APS Auto Parts Specialist Inc.

Application: For 2014-2019 Toyota Highlander

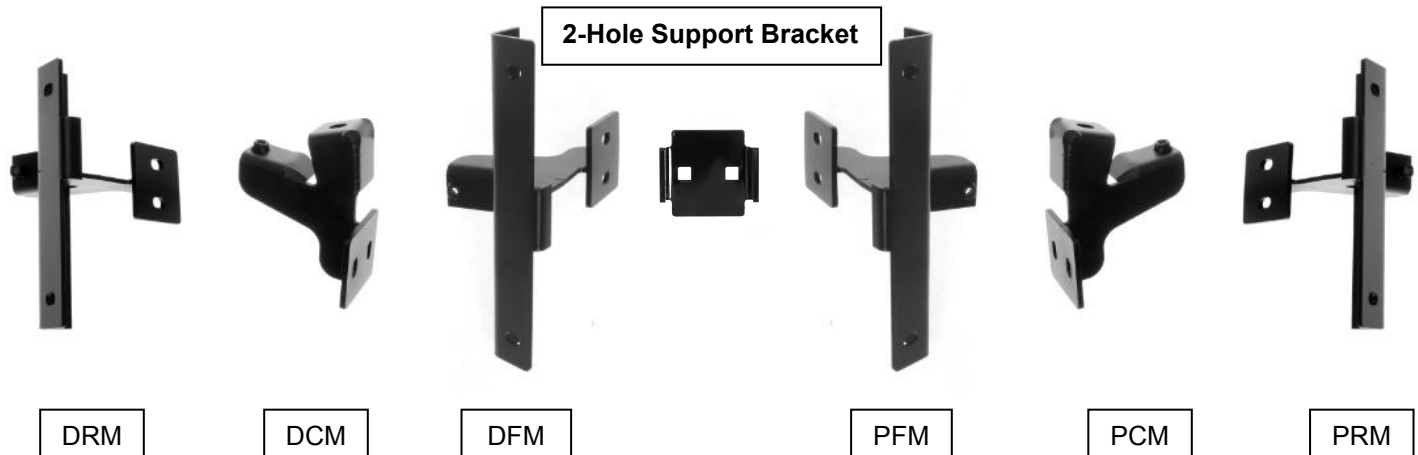
Estimated Time: 1 to 2 hours



The instruction here is for your reference only. We strongly recommend the professional installer for best result. We are not responsible for any damage caused by the installation. Thank you for choosing our product!

PARTS LIST:

Item	QTY	Description	Item	QTY	Description
#1	2	Driver/ Passenger Side Bar	#9	6	Backing Plates
#2	1	Driver Front Mounting Bracket (DFM)	#10	10	M10X30 Bolt Plates
#3	1	Passenger Front Mounting Bracket (PFM)	#11	6	M10X1.5-50 Hex Bolts
#4	1	Driver Center Mounting Bracket (DCM)	#12	16	10.5X30X2.5 mm Flat Washers
#5	1	Passenger Center Mounting Bracket (PCM)	#13	28	M10 Lock Washers
#6	1	Driver Rear Mounting Bracket (DRM)	#14	28	M10 Hex Nuts
#7	1	Passenger Rear Mounting Bracket (PRM)	#15	12	M10X1.5-75 Carriage Bolts
#8	6	2-Hole Support Bracket	#16	12	M10 Flat Washers

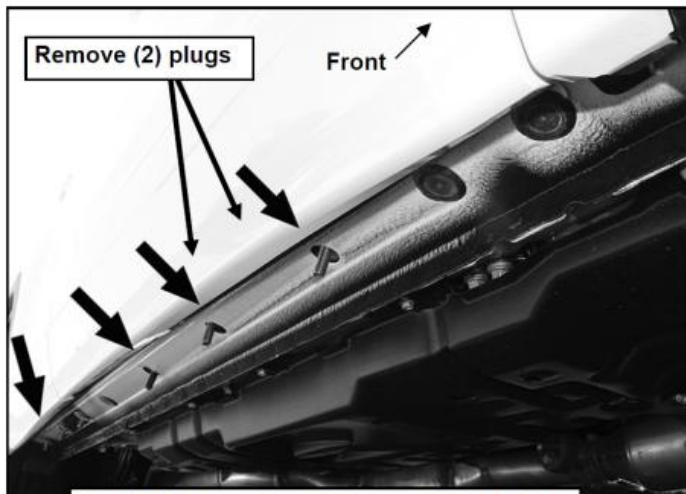
**PROCEDURE:**

- 1. REMOVE CONTENTS FROM BOX. VERIFY ALL PARTS ARE PRESENT. READ INSTRUCTIONS CAREFULLY BEFORE STARTING INSTALLATION.**
- Start on the passenger side of the vehicle, locate the (9) rubber plugs along the lower body panel. From the front, remove the 3rd and 4th round plugs (**Figure 1**). Select (2) Bolt plates, (**Figure 2**). Check the location for body sealant and scrape away excess as necessary, (**Figure 3**). Insert each Bolt Plate into the factory hole with the long end of the plates facing each other, (**Figure 1&3**). Hold a Front Bracket over the Bolt Plates and line up the (2) mounting holes, (**Figure 4**). Secure the Bracket to the Bolt Plates with (2) 10mm Flat Washer, (2) 10mm Lock Washer and (2) 10mm Hex Nuts, (**Figure 4**). Snug but do not tighten hardware at this time.
- Next, select (1) Support Plate, (1) 10mm Hex Nut and (1) 10mm Hex Bolt, (**Figure 5**). Thread the 10mm Hex Nut all the way down the long Hex Bolt. Screw the Hex Bolt and Nut a few threads into and through the Nut welded onto the back tab on the front Bracket. Insert the Support Plate with the welded socket facing down, into the space between the Front Bracket and the floor panel behind the pinch weld, (**Figure 4 5 &12**). Tighten the Hex Bolt into the socket on the Support Plate until the Plate is close to but not touching the floor panel. Do not tighten hardware at this time.
- Next, remove the rubber plug in the 5th (next) hole along the body panel. Repeat **Steps 2-3** to install the center Bracket, (**Figure 6&7**).
- Continue along the body to the 7th and 8th rubber plugs, (**Figure 6**). Repeat **Step 2-3** to install the passenger side rear Bracket, (**Figure 8&9**). **NOTE:** Rear Brackets are offset towards the rear of the vehicle, (**Figure 8**).

6. Select the Passenger Side Bar. Slip (2) M10X1.5-75 Carriage Bolts into each 2-Hole Support Brackets ,and insert the 2-Hole support bracket into the Driver Side Bar.(**Fig 10**). Carefully position the Bar onto the (3) Mounting Brackets. **IMPORTANT:** Do not slide the Bar on the Brackets or damage to the finish may result. Attach the Driver Side Bar to the Mounting Brackets with (2) M10 Hex Nuts,(2)10mm lock washers and (2)10mm flat washers, (**Fig 11**). Do not tighten hardware.
7. Level and adjust the Bar properly and tighten all hardware. **NOTE: Torque all M10 X1.5-75 Carriage Bolts to 22~25 lb-ft. Don't over tighten,or the aluminum square bars will be damaged by the brackets.**
8. Repeat Step 2-7 for the other side installation. Installation completed!!! (**Fig 12**)
9. Do periodic inspections to the installation to make sure that all hardware is secure and tight.

Products have a high quality finish that must be cared for like any other exposed finish on the vehicle. Protect the finish with a non-abrasive automotive wax, (e.g.Pure Carnauba) on a regular basis. The use of any soap, polish or wax that contains an abrasive is detrimental, as the compounds scratch the finish and open it to corrosion.

Driver/Passenger Side Installation Pictured



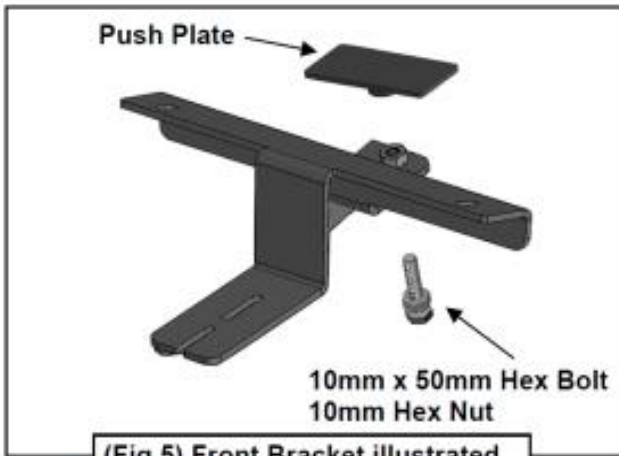
(Fig 1) Use the 3rd and 4th mounting hole from the front fender opening for passenger front Mounting Bracket location



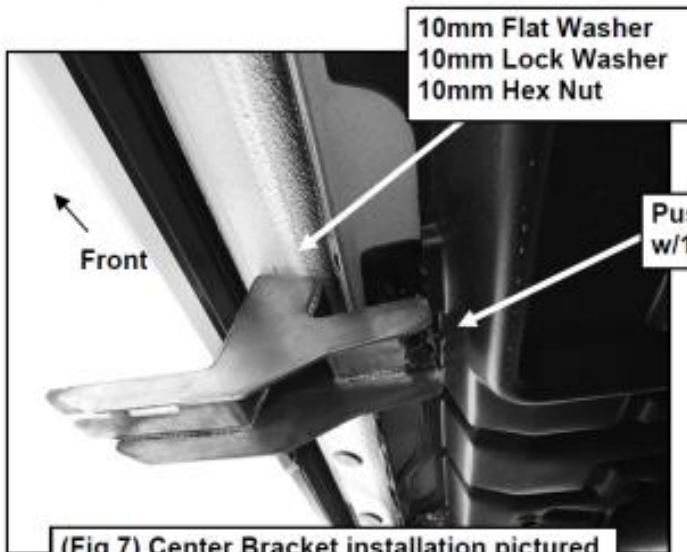
(Fig 2) 10mm Bolt Plate



from all locations before installing Brackets



(Fig 5) Front Bracket illustrated



(Fig 7) Center Bracket installation pictured

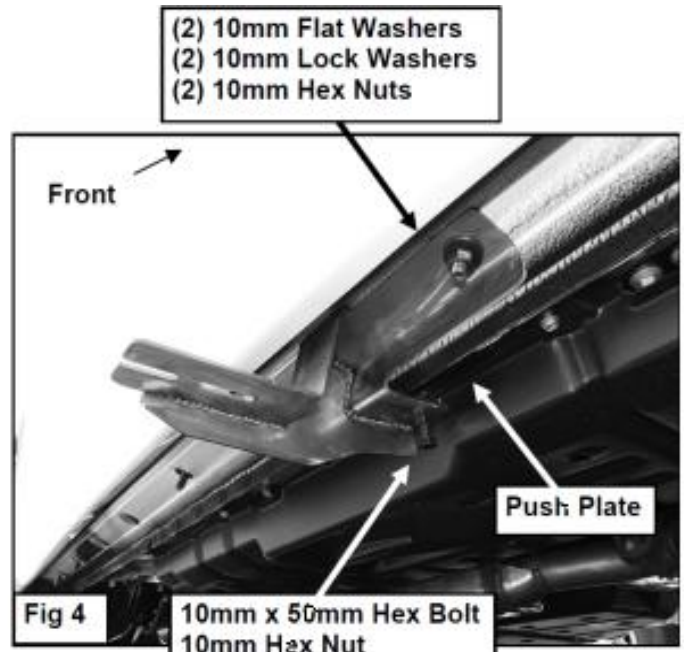


Fig 4

Mounting location for Rear Bracket
(use last 2 holes along body)

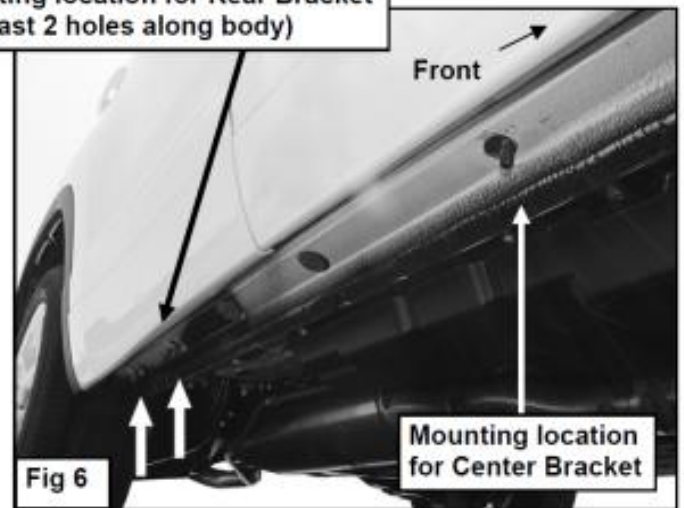
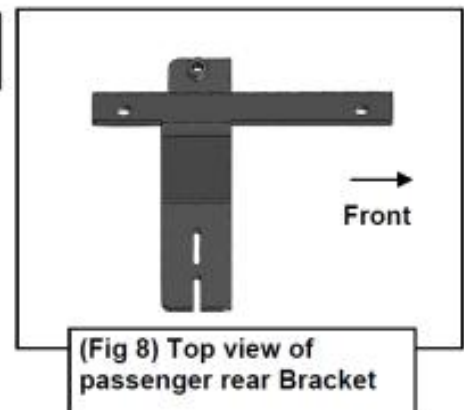
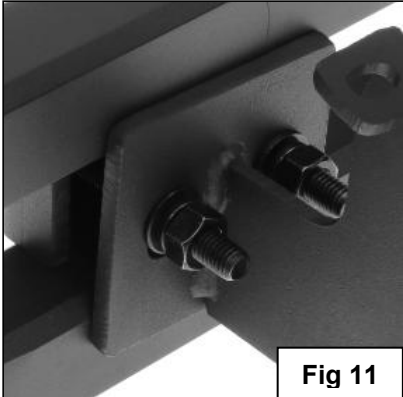
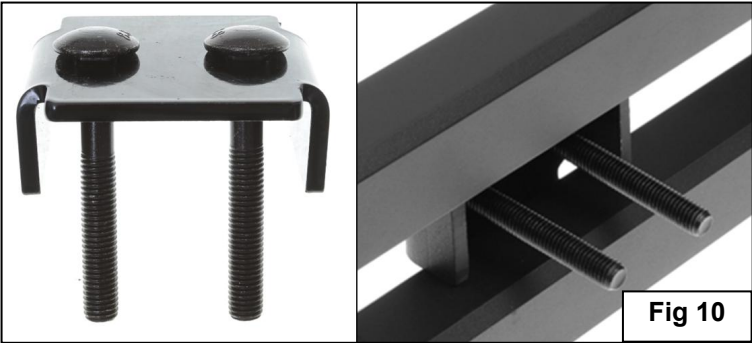
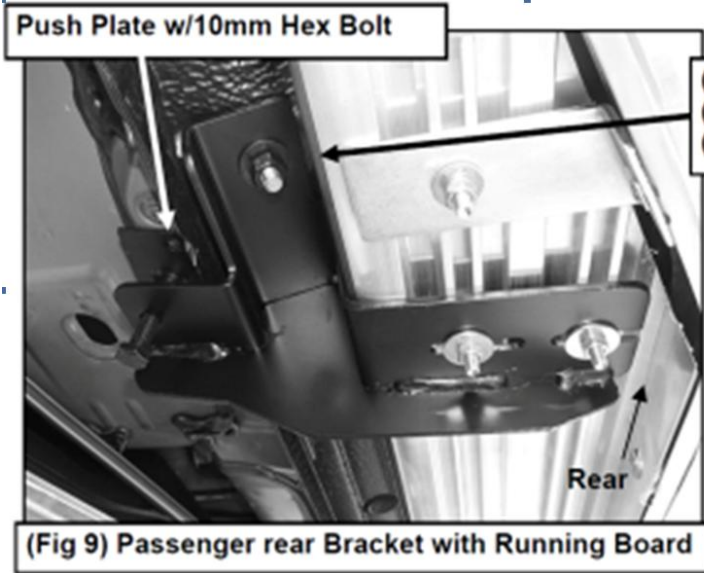


Fig 6



(Fig 8) Top view of
passenger rear Bracket



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