

STEP BOARD KIT #27-1085 INSTALLATION INSTRUCTIONS

1999-2001 TOYOTA TACOMA X-CAB, CREW CAB

(USES 72" STEP BOARDS #27-0000 & 27-0005)

Instruction Sheet
No. 75-0273

NOTE: IT IS RECOMMENDED THAT YOU USE A PROFESSIONAL TO INSTALL THE WIRING HARNESS FOR THE LIGHTED VERSION.

**CAUTION!!
BEFORE BEGINNING
THIS INSTALLATION
PROCEDURE,
READ THROUGH
INSTRUCTIONS
CAREFULLY AND
COMPLETELY.**

HARDWARE KIT

| | | | |
|----|------------------|----|-------------------|
| 6 | Support Brackets | 18 | Nylock Nuts |
| 18 | 5/16" Washers | 12 | Square Head Bolts |
| 12 | TEK Screws | 6 | Hex Bolts |

Each Universal Running Board fitment has a specific Bracket Kit which coincides with specific vehicles. Make sure the kit you received coincides with your vehicle. Read all instructions thoroughly before you begin installing the running boards and brackets. Pre-fit all pieces and check the hardware list to be sure all the parts are included before beginning.

STEP 1: Lay out the bracket kit to make sure you have a complete hardware and bracket kit.

STEP 2: This installation utilizes the vehicle's body pinch weld located under the vehicle for installation. Starting at the pinch weld nearest the front tire and working toward the rear tire, measure and mark at 10 ½", 39" and 66 ½". See Figure 1. If installing on Tacoma Extra Cab the suggested measurements are as follows: 10 3/8", 34" and 58".



Figure 1

STEP 3: Drill a pilot hole on the three marks in the center of the pinch weld using 1/8" drill bit as shown in Figure 2.

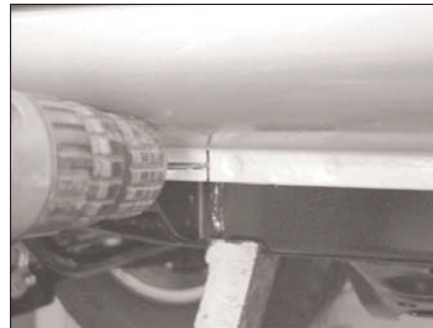


Figure 2

STEP 4: Drill out the 1/8" holes to 5/16" on all three holes. See Figure 3.



Figure 3

STEP 5: Use a hex bolt 5/16" with a washer and nylock nut to hang the brackets from the pinch weld of the truck. See Figure 4.



Figure 4

STEP 6: After hanging the brackets, tighten up the brackets at the pinch weld. Then take two tek screws in the backside of the bracket, you will find two slots to secure the bracket, use the two tek screws and run them in to both slots AND repeat this two more times.

STEP 7: Mount Step Boards to Brackets. Slide (6) six square head bolts into the two outside slots in the aluminum support plate. Note: Slide (3) three in the inner most slot and (3) in the the outer most slot. **Note:** Debur the aluminum channel if the square bolts cannot pass through the opening.

NOTE: If you have lights, run the wiring harness in the appropriate channel and make sure you run the longer harness on the passenger side. See Figure 5.



Figure 5

STEP 8: Use six nylock nuts and washers to attach the board to the brackets. Adjust the board to the appropriate location then tighten board down. Now repeat these steps to the other side of the vehicle. For lighted version, proceed to Step 9-16.

INSTALLING THE LIGHTS & WIRING HARNESS TO YOUR STEP BOARDS (FOR LIGHTED VERSION):

STEP 9: A three piece wiring harness is included with the Lighted Step Board. The harness includes four (4) light sockets and three plugs. Carefully plan a wire route from the right side Step Board to the left. Then choose a pass-through point (floor board to inner cab) for the wire harness. WESTIN RECOMMENDS YOU USE A PROFESSIONAL TO INSTALL THE WIRING HARNESS—SEE STEPS 15-20 BELOW.

STEP 10: Attach wire harness and lights. Be sure all rubber seals are in place before installation. The rubber grommets around the red and blue wires going into rear of sockets should be completely inserted and recessed about 1/4". **NOTE: Ensure the longevity of your lights by removing the bulb and placing a small amount of white grease into the sockets and replacing the bulb. Place a small amount of RTV Silicone where the lights go into the socket. This keeps the sockets dry and adds to longevity.** Screw lights into sockets and run conduit in center slot of aluminum base board. This will hold the harness in place.

STEP 11: GENERAL TIPS FOR WIRING HARNESS INSTALLATION. PLEASE NOTE: The light wiring harness installation requires splicing into your vehicle's electrical system. WESTIN HIGHLY RECOMMENDS THAT YOU USE A PROFESSIONAL TO INSTALL THE WIRING HARNESS FOR THE LIGHTED VERSION.

STEP 12: After choosing a pass through point follow this sequence: CAUTION: ALWAYS USE A FUSED (+) POSITIVE SUPPLY SOURCE AND UNDERCOAT SEAL FOR HARSH WEATHER. Route long lead harness to short lead harness and plug connector securely. Note: Avoid areas of excess heat, vibration, pinch or rotation when securing harness to vehicle.

STEP 13: Plug open-ended connection into unused connection. Note: Either connector on short lead board harness will work. Route open ended wire harness through truck cab. Note: Find the closest position to door light switch lead wire. Pass seal through hole. Use silicone or permanent sealer.

STEP 14: Connect positive and negative lead wires to vehicle sources (dome light or courtesy light under dash). Use vehicle door switch for ground lead source and appropriate positive lead for supply. ALWAYS USE A FUSED POSITIVE (+) POWER SOURCE.

STEP 15: Test circuit for proper function and connection before tape sealing all exposed wire.

STEP 16: Under-coat the Step Boards, Brackets and all electrical wires, connections and lenses for harsh weather conditions. INSTALLATION IS COMPLETE.

THANK YOU FOR CHOOSING WESTIN!

When it comes to quality side steps and nerf bars, Westin is the brand you can depend on.