



STEP BOARD KIT #27-1155

INSTALLATION INSTRUCTIONS

APPLICATION: 1999+ TUNDRA EXTENDED CAB, 4 DOOR
 USES 70" STEP BOARD #27-0000 & 27-0005

Instruction Sheet
No. 75-0279

NOTE: WESTIN RECOMMENDS 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																
	<table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 15%; text-align: right;">2</td> <td style="width: 45%;">Front Brackets</td> <td style="width: 15%; text-align: right;">16</td> <td style="width: 25%;">#14 Hex Head TEK Screws</td> </tr> <tr> <td style="text-align: right;">6</td> <td>Rear Brackets</td> <td style="text-align: right;">24</td> <td>5/16" SAE Washers</td> </tr> <tr> <td style="text-align: right;">10</td> <td>5/16" Hex Head Bolts</td> <td style="text-align: right;">24</td> <td>5/16 Nylock Nuts</td> </tr> <tr> <td style="text-align: right;">16</td> <td>5/16" Square Head Bolts</td> <td></td> <td></td> </tr> </table>	2	Front Brackets	16	#14 Hex Head TEK Screws	6	Rear Brackets	24	5/16" SAE Washers	10	5/16" Hex Head Bolts	24	5/16 Nylock Nuts	16	5/16" Square Head Bolts		
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STEP 1: Remove all the Brackets from the wrappers and check the hardware list to be sure all the parts are included. Read the instructions thoroughly before beginning installation.

STEP 2: Using the Bracket Chart below, lay out and, with a pencil, clearly mark the mounting locations for the final Bracket positions.

STEP 3: Drill the 5/16" pinch weld holes in all pre marked locations in the pinch weld. Note: Drill each hole in the pinch weld so that it is evenly placed relative to the bottom of the pinch.

BRACKET CHART: 99+ TUNDRA EXTENDED CAB, 4 DOOR			
SUGGESTED LOCATIONS FROM FRONT FENDER WELL, BOTH SIDES			
Front Bracket	11"	Middle Bracket (Rear)	45"
Middle Bracket (Front)	28"	Rear Bracket	64"

STEP 4: Using the 5/16" Hex Head Bolts, SAE Washers and Nylocks, attach the Main Brackets to the previously drilled Pinch Weld holes from Step 3 (eight brackets). Install the #14 TEK screws through the Main Brackets and into the frame rail (two per bracket).



Front Bracket



Front Bracket



Middle Brackets

STEP 5: Carefully remove the Step Boards from the box and place them face down on a soft clean surface. For the unlighted version, skip to STEP 8.

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

STEP 6: 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 12-16 BELOW.

STEP 7: Attach wire harness and lights. Be sure all rubber seals are in place before installation. The rubber grommet 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 wires go into the socket. This keeps the sockets dry and adds to longevity.** Screw lights into each end of the board and run conduit in center slot of aluminum base board. This will hold the harness in place.

STEP 8: Mount Step Boards to Brackets by sliding (4) four of the 5/16" x 3/4" Square Head Bolts into the two outside slots in the aluminum support plate and (4) four in the inner most slot.

STEP 9: Position the Square Headed Bolts on the aluminum support plate so that there are (2) two Bolts over each Bracket location. Place the Step Board over the Brackets and pass the Bolts through the Brackets.

STEP 10: Start the Nylock Nuts and the SAE Washers on the Square Headed Bolts. Leave loose at this time.

STEP 11: Center the Step Boards from wheel well to wheel well and position for height. Set all final positions for height, depth and center. Tighten all the remaining hardware and test the Step Boards for attachment. This concludes the installation procedure for the Step Boards without lights. For the Lighted version, proceed to STEP 12.

STEP 12: 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 13: After choosing a a pass through point for the cab harness (STEP 6), follow this sequence: Route long lead harness to short lead harness and plug connectors securely. Note: Avoid areas of excess heat, vibration, pinch or rotation when securing harness to vehicle.

STEP 14: 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. Seal pass-through hole. Use silicone or permanent sealer.

STEP 15: 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 16: Test circuit for proper function and connection before tape sealing all exposed wire.

INSTALLATION IS COMPLETE. **THANK YOU FOR CHOOSING WESTIN!**