



# STEP BOARD KIT #27-1085 INSTALLATION INSTRUCTIONS

APPLICATION: 2001 TOYOTA TACOMA 4 DOOR  
1999- TACOMA X- CAB

## AUTOMOTIVE PRODUCTS, INC.

**CAUTION:**  
**BEFORE BEGINNING**  
**THIS INSTALLATION**  
**PROCEDURE,**  
**READ THOUGH**  
**INSTRUCTIONS**  
**CAREFULLY AND**  
**COMPLETELY**

### HARDWARE KIT

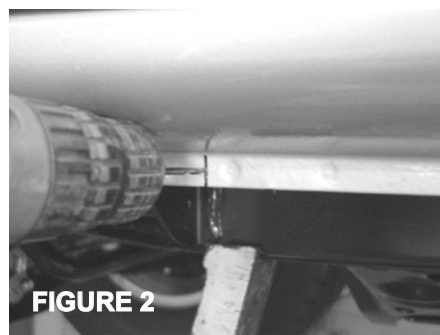
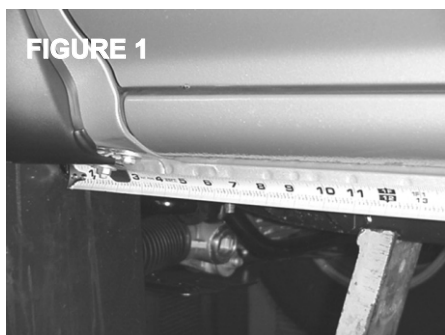
16	SQUARE HEAD BOLT	8	5/16" HEX HEAD BOLT
24	5/16" SAE WASHER	24	5/16" NYLOCK NUT
16	TEK SCREW	8	MOUNT BRACKET

STEP 1. Remove the contents from the box and check for any damage. Verify all parts against the parts list. Read and understand instructions before beginning installation.

STEP 2. Measure from the front of the pinch weld towards the rear of the truck and mark your measurements. **SEE FIGURE 1.**

**NOTE:** When installing step boards to the Tacoma E-Cab, the suggested measurements are 10", 28", 43" and 59". When installing on the Tacoma 4 Door, the suggested measurements are 10", 33", 52 1/2" and 71".

STEP 3. Drill a pilot hole on the four marks in the center of the pinch weld using 1/8" drill bit. **SEE FIGURE 2.**



STEP 4. Drill the 1/8" holes to 5/16" on all four holes locations.

STEP 5. Use a 5/16" hex head bolt, washer and nylock nut to fasten mount brackets to the pinch weld of the vehicle. **SEE FIGURE 3.**



STEP 6. After hanging the brackets, tighten up the brackets at the pinch weld. Locate the two slots on the backside of the bracket. Install one tek screw in each slot and tighten. Repeat for remaining brackets.

STEP 7. Insert eight square head bolts into the appropriate slots in the aluminum base of the step board, four bolts in each slot. **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 4.**

STEP 8. Use eight nylock nuts and washers to attach the step board to the brackets. Adjust the board to appropriate location then tighten board down. Repeat these steps to the other side of the vehicle.

NOTE: For lighted version, proceed to Steps 9-16.

STEP 9. A three piece wiring harness is included with the Lighted Step Board. The harness includes four light sockets and three plugs. Carefully plan a wire route from the right side of the step bar 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 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 sockets and replacing the bulb. Place a small amount of RTV Silicone where 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. **NOTE:** The light wiring harness installation required splicing into your vehicle's electrical system. WESTIN HIGHLY RECOMMENDS THAT YOU USE A PROFESSIONAL TO INSTALL WIRING HARNESS FOR THE LIGHT 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 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 supply. **ALWAYS USE A FUSED POSITIVE (+) POWER SOURCE.**

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

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

Finish protection - Westin 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 (pure carnauba, for example) on a regular basis. The use of cleaner wax or any compound which contains an abrasive is detrimental, as the compounds scratch the finish and open it to corrosion.



Westin Automotive Products, Inc.  
5200 N. Irwindale Ave. Suite 220  
Irwindale, Ca. 91706

Thank You for choosing Westin products  
For additional installation assistance please call  
Customer service (800) 793-7846 or (507) 375-3559