



INSTALLATION INSTRUCTIONS

01-06 TOYOTA HIGHLANDER TUBULAR SIDE STEPS PART 202005/202005-2

COMPONENTS

(2) Front Brackets (DS & PS)	(8) 1/2 x 1 1/2" Hex Head Bolts
(2) Front Support Brackets (DS & PS)	(10) 1/2" Nylock Nuts
(2) Rear Brackets (DS & PS)	(18) 1/2" SAE Washers
(2) 1/2 x 2" Special Bolts	(4) 3/8" Nylock Nuts
(2) 3/8 x 1 1/2" Short Special Bolts	(4) 3/8" USS Washers
(2) 3/8 x 1 1/2" Long Special Bolts	

NOTE: Driver Side (DS); Passenger Side (PS)

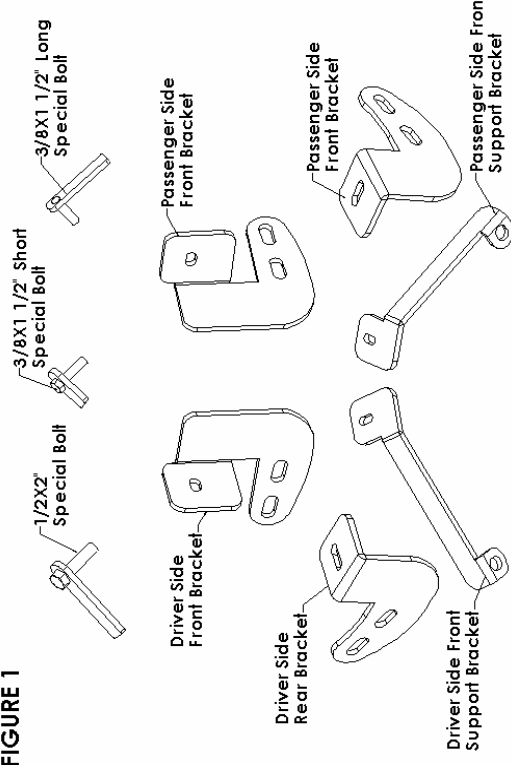
INSTALLATION

1. Before you start the installation, make sure that you have all the components listed above.
2. Refer to Figure 1 to identify the driver and passenger side mounting brackets.
3. The front mounting brackets mount to the factory locations on the body panel underneath the vehicle using the 3/8 x 1 1/2" special bolts as shown in Figures 2 & 3.
4. Insert the 3/8 x 1 1/2" long special bolt through the large opening on the body panel and then fasten (Hand tighten) the mounting bracket as shown in Figure 2 & 3.
5. The rear bracket also mounts to the body panel, fasten (Hand tight) the rear-mounting bracket using the 1/2 x 2" special bolt as shown in Figure 4.
6. Align the driver side tube step to the brackets and fasten (Hand tight) using the 1/2 x 1 1/2" hex head bolts with their

corresponding Nylock nuts and washers as shown in the Figures.

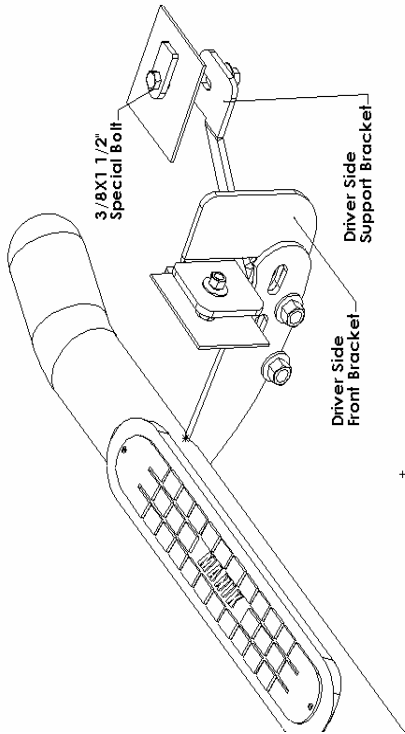
7. Align the driver side front support bracket to the mounting bracket as shown in Figure 3, locate and insert the 3/8 x 1 1/2" short special bolt through the opening that lines up with the support bracket. Fasten (Hand tight only) that end of the support bracket using the 3/8" Nylock nuts and washers supplied.
8. Fasten the other end of the front support bracket the hole on the mounting bracket as shown in Figure 3, using the same 1/2 x 1 1/2" hex head bolt.
9. Finally align the tube step to the desired position and tighten all of the hardware.
10. Repeat steps 3 – 9 to install the passenger side tube step.
11. **IMPORTANT:** PLEASE MAKE SURE TO PERIODICALLY CHECK THAT ALL HARDWARE IS TIGHT.

FIGURE 1



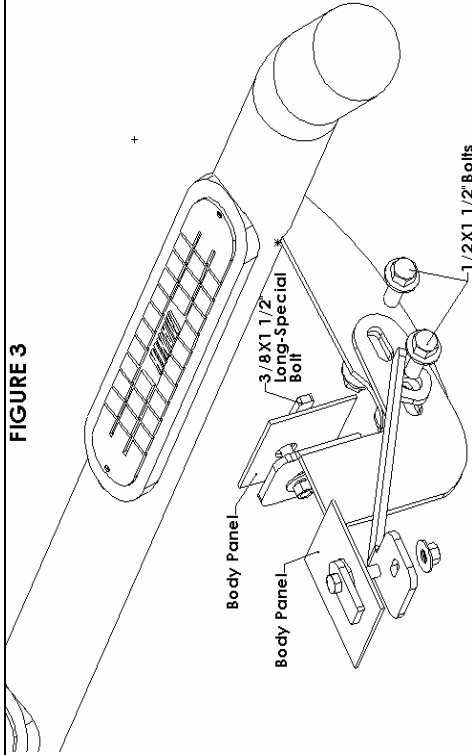
PART# 925254T
MOUNTING BRACKETS

FIGURE 2



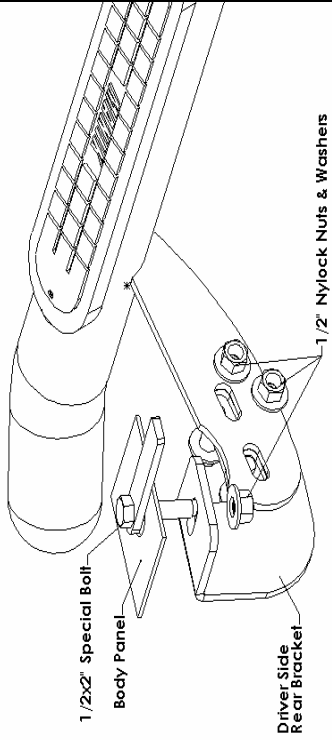
PART# 925254T
DRIVER SIDE FRONT BRACKET ASSEMBLY

FIGURE 3



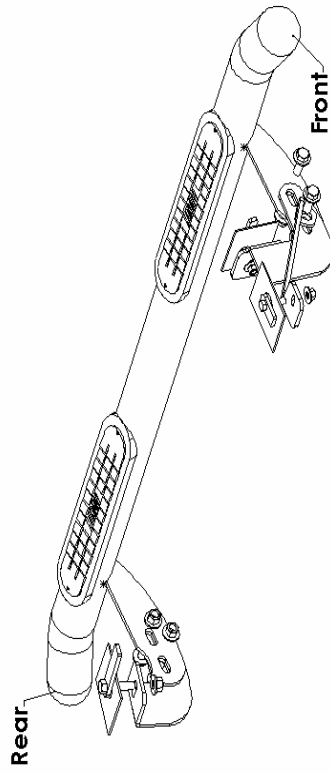
PART# 925254T
DRIVER SIDE FRONT BRACKET ASSEMBLY

FIGURE 4



PART# 925254T
DRIVER SIDE REAR BRACKET ASSEMBLY

FIGURE 5



PART# 925254T
DRIVER SIDE TUBE STEP ASSEMBLY