



# FITTING INSTRUCTIONS

## **ARB TOYOTA HJ100 2002 IFS, SIDE STEP AND FRONT RAIL**

**PRODUCT No. FRONT RAIL 4413250 or 4413270**  
**SIDE STEP 4413260**

**FITTING KIT 6171750**

<b>USE</b>	<b>QTY</b>	<b>DESCRIPTION</b>	
SIDE STEP TO CHASSIS REAR	2	BOLT 'U' M12 x 1.75 x 175mm x 100mm	
	4	1/2" SPRING WASHERS	
	4	1/2" FLAT WASHERS	
	4	M12 NUTS	
	1	FOAM TAPE	
	4	SMALL SPACER	
SIDE STEP TO CHASSIS MIDDLE	2	BOLT 'U' M12 x 1.75 x 175mm x 100mm	
	4	1/2" FLAT WASHERS	
	4	1/2" SPRING WASHERS	
	4	M12 NUTS	
	2	SPACER	
SIDE STEP TO CHASSIS FRONT	2	BOLT 'U' M12 x 1.75 x 175mm x 100mm	
	4	1/2" FLAT WASHERS	
	4	1/2" SPRING WASHERS	
	4	M12 NUTS	
	2	SPACER	
RAIL TO STEP LOCKING BOLT	4	M8 BOLT x 20mm	
	4	M8 FLAT WASHER	
	4	M8 FLANGE NUT	
SIDE RAIL TO BULLBAR	4	SIDE RAIL CLAMP	
	6	M8 BOLT X 70mm DOME HEAD BLKZP	
	6	M8 NYLOC NUT BLACK	
	6	M8 FLAT WASHER X 17mm OD BLACK	
	4	SIDE/RAIL RUBBER PLUG	
CHECKER TOP TO STEP	1	CHECKER TOP PLATE LHS	
	1	CHECKER TOP PLATE RHS	
	14	M6 BOLT x 25 mm DOME HEAD	
	14	M6 FLANGE NUT	
	14	M6 FLAT WASHER	
	2	ARB DECAL	

### **Tools Required**

Basic Metric Spanner and Socket set, "G" Clamp, 3.0mm, 8.5mm and 10mm drill bit, electric drill, Stanley knife and a tube of neutral cure Silicon.

## ASSEMBLY SEQUENCE FOR SIDE RAIL AND STEP.



1. Lay the side step next to the vehicle in position to see the approximate location of the “U” bolts on the chassis. Fit the “U” bolts to the chassis as shown.

### WARNING

When fitting the “U” bolts to the chassis on the left hand side of the vehicle, make sure the “U” bolts fit under all cables and steel brake lines giving plenty of clearance. Fit protective foam tape to back of ‘U’ bolt to protect brake and fuel lines.

### DO NOT CRUSH PIPING OR WIRING.

2. Fit the rubber plugs into the ends of the side steps and also into the end of the front rail that meets the bull bar.



3. With help, support the front of the step. Bolt the rear bracket loosely into position using ½” flat washer, spring washer and M12 nut. Finger tighten only.
4. Repeat this for both the front bracket and center bracket. Once all brackets are attached align the side rail to the vehicle and tighten firmly.



**NOTE:-** Due to chassis variations the step may need to be fitted with a spacer on one side, to maintain a consistent gap from the left hand to right hand side. These are supplied in the kit, depending on the gap one or two spacers per bracket will be used. The spacer is placed between the chassis rail and the side step bracket.

The front and center bracket use the long spacer (319 3721) the rear bracket uses the smaller type similar to the ones welded to the rear bracket, and locate in the same position.



5. Fit the rear of the front rail into the front step. Using the M8 hardware, bolt the front rail to the side step (finger tight at this stage).
6. “G” clamp the bull bar clamps to the front of the side rail and bull bar. Once the rail is aligned to the front guard of the vehicle, tighten the M8 bolt in the lower bracket then drill and pin through the side step bracket to lock the front rail into position using the M8 bolt and hardware supplied.

**The mud flaps may need to be removed to drill and pin the bracket, the wheel will also need to be turned outboard to provide sufficient access.**

Ensure the side step and front rail tubes are butted together firmly with no gap before fastening tightly.

7. Drill through the side rail and rail clamps using a 8.5 mm drill bit and fasten with the black M8 coach bolts and hardware supplied.



8. Run a bead of silicone along the top of the step to eliminate vibration of the checker top against the side rail step.
9. Fit and align the checker top using the M6 dome head bolts, washers and nuts and tighten securely.

