

**Part Number: PT278-48140**

**Kit Contents**

Item #	Quantity Req.	Description
1	1	Crossbar Assembly Front
2	1	Crossbar Assembly Rear
3	2	RH Crossbar Covers
4	2	LH Crossbar Covers
5	1	Hardware Bag

**Hardware Bag Contents**

Item #	Quantity Req.	Description
1	1	Torque Tool
2	4	Tethers
3	4	Anti-Rotation Caps
4	1	Users Guide
5		
6		
7		

**Additional Items Required For Installation**

Item #	Quantity Req.	Description
1		
2		
3		

**Conflicts**

--

**Recommended Tools**

<b>Personal &amp; Vehicle Protection</b>	<b>Notes</b>
Safety Glasses	
Safety Gloves	
Vehicle Protection	Cloth
Wrist & Belt Buckle Protection	
<b>Special Tools</b>	<b>Notes</b>
Plastic trim removal tool	
<b>Installation Tools</b>	<b>Notes</b>
13mm Socket	
Torque Wrench	0-75 lbf-in
<b>Special Chemicals</b>	<b>Notes</b>

**General Applicability**

All models 2014-
------------------

**Recommended Sequence of Application**


Item #	Accessory
1	
2	
3	


\*Mandatory


**Vehicle Service Parts** (may be required for reassembly)


Item #	Quantity Req.	Description
1		
2		
3		


**Legend**


 **STOP:** Damage to the vehicle may occur. Do not proceed until process has been complied with.

 **OPERATOR SAFETY:** Use caution to avoid risk of injury.

 **CAUTION:** A process that must be carefully observed in order to reduce the risk of damage to the accessory/vehicle and to ensure a quality installation.

 **TOOLS & EQUIPMENT:** Used in Figures calls out the specific tools and equipment recommended for this process.

 **REVISION MARK:** This mark highlights a change in installation with respect to previous issue.

 **SAFETY TORQUE:** This mark indicates that torque is related to safety.

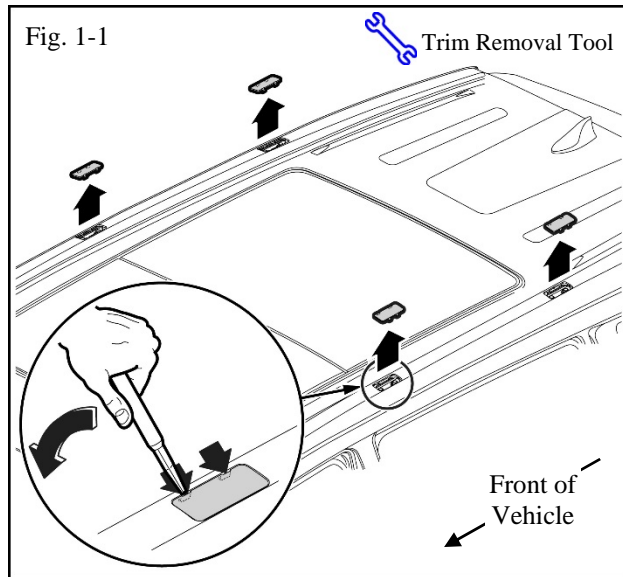
Care must be taken when installing this accessory to ensure damage does not occur to the vehicle. The installation of this accessory should follow approved guidelines to ensure a quality installation.

These guidelines can be found in the "Accessory Installation Practices" document.

This document covers such items as:-

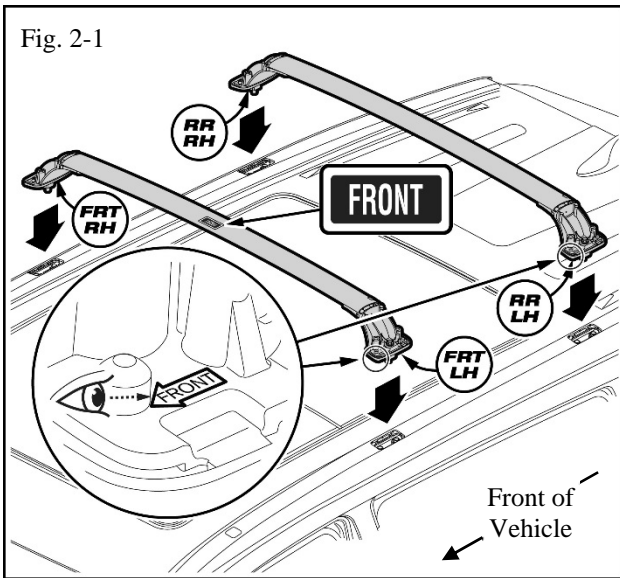
- Vehicle Protection (use of covers and blankets, cleaning chemicals, etc.).
- Safety (eye protection, rechecking torque procedure, etc.).
- Vehicle Disassembly/Reassembly (panel removal, part storage, etc.).
- Electrical Component Disassembly/Reassembly (battery disconnection, connector removal, etc.).

Please see your Toyota dealer for a copy of this document.



**1. Remove the Side Rail Covers (Fig. 1-1).**

- ⚠ (a) Use a plastic trim removal tool to carefully remove the 4 trim covers by pressing the tabs and prying up (4 places).
- (b) Retain the covers for future use.



2. Install the Crossbars (Fig. 2-1).

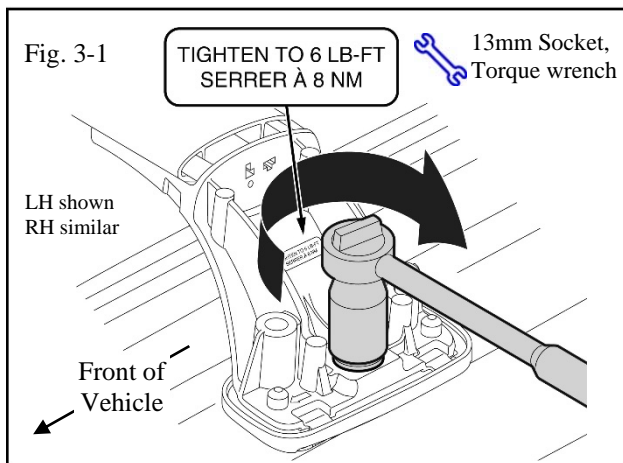
⚠ (a) Make sure the arrows on the crossbar end supports are pointing toward the front of the vehicle.

⚠ **NOTE: THE FRONT CROSSBAR HAS A “FRONT” LABEL.**

⚠ **NOTE: FRONT AND REAR, LH AND RH, ARE MOLDED INTO THE SUPPORT PAD BOTTOM.**

⚠ (b) **MAKE SURE THE RECTANGULAR SPACERS ARE ORIENTED PROPERLY.** The spacer should sit down into the recess (Fig. 2-2) and not above it (Fig. 2-3). Incorrect orientation will create a large space between the crossbar and the vehicle.



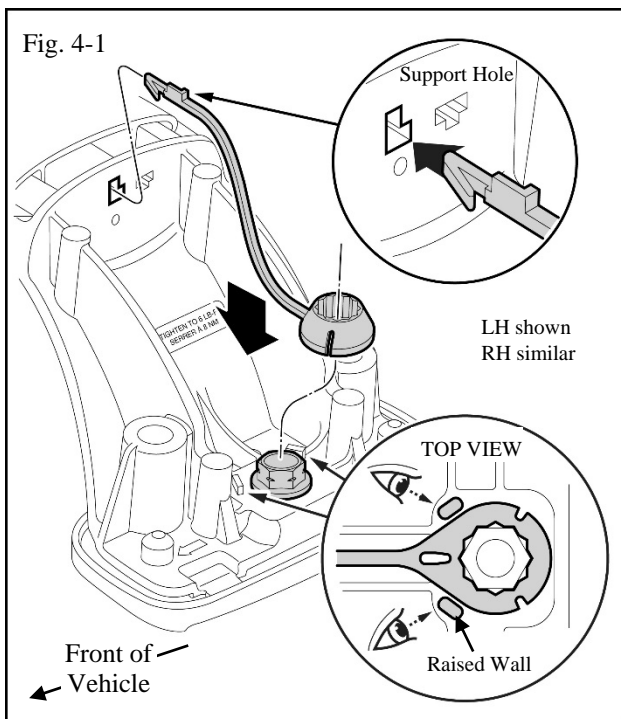


3. Secure the Crossbars (Fig. 3-1).

⚠ (a) Using a 13mm socket, tighten the bolt to 8 N-m (71 Lbf-in) (4 places).

⚠ Torque: 8 N•m (71 in•lbs)

⚠ (b) Verify all supports are snug and properly fitted to the side rail (4 places).



4. Attach the Anti-rotation Caps to the Crossbars (4 Places) (Fig. 4-1).

(a) Install the tether end of the anti-rotation cap into the crossbar support.

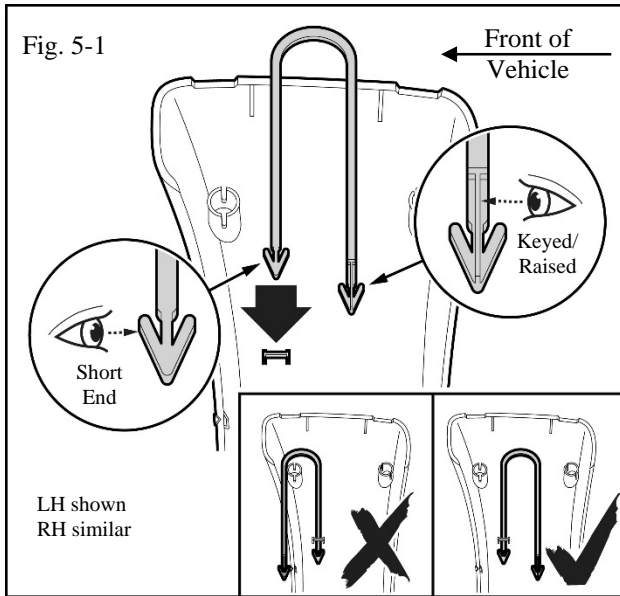
(b) Install a cap over the crossbar bolt.

⚠ NOTE: Verify the proper orientation of the tether into the hole specified in Fig. 4-1.

⚠ NOTE: Verify the tether is fully engaged and locked into the support.

⚠ NOTE: Verify the caps are fully engaged over the bolt.

⚠ NOTE: Verify the caps are centered between the 2 small raised walls on the support.

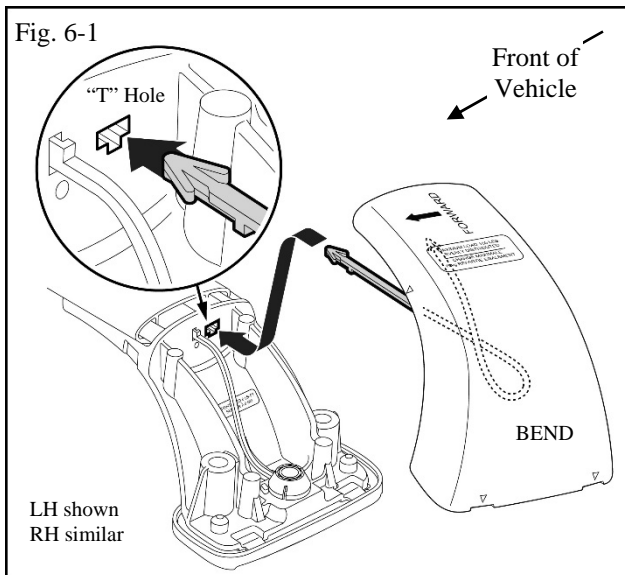


**5. Attach the Tethers to the Crossbar Covers.**

- (a) Install the 4 tethers on the covers (2 RH, 2 LH) (Fig. 5-1). Install the short end of the tether through the loop on the cover.

**⚠ NOTE: Verify the tether is centered in the cover.**

**⚠ NOTE: Verify the tether is fully engaged and locked into the cover.**

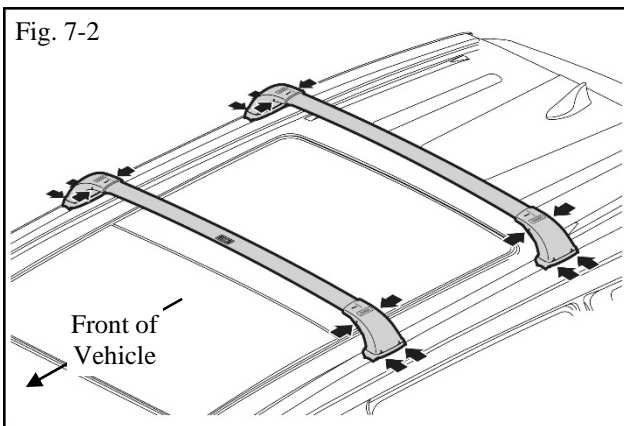
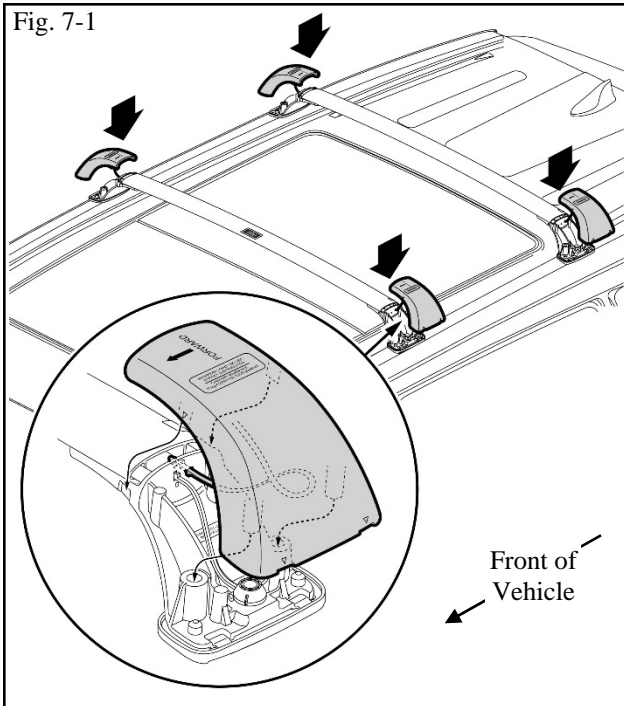


**6. Attach the Tethers to the Crossbars (Fig. 6-1).**

- (a) Install the 4 tethers (2 RH, 2 LH) with covers on to the crossbar supports. The tether is flat and must be bent during installation (Fig. 6-1).

**⚠ NOTE: Verify the proper orientation of the keyed/raised end of the tether when inserting into the "T" shape hole in the crossbar support (Fig. 6-1).**

**⚠ NOTE: Verify the tether is fully engaged and locked into the support.**



**7. Install the Crossbar Covers.**

- (a) Install the crossbar covers (4 places) (Fig. 7-1). Line up the cover posts with the holes in the supports. Press down firmly (Fig. 7-1).

**NOTE:** Make sure the covers are fully engaged at each location marked with a triangle (16 places) (Fig. 7-2).

**8. Complete the Installation.**

- STOP** (a) Place the side rail covers removed in Step 1(b) and the crossbar users guide and torque tool in the polybag.
- (b) Place the polybag with the side rail covers, crossbar users guide and torque tool in the glove box.

Checklist - these points **MUST** be checked to ensure a quality installation.

<u>Check:</u>	<u>Look For:</u>
<p><u>Accessory Function Checks</u></p> <ul style="list-style-type: none"><li><input type="checkbox"/> Inspect bolt torque</li><li><input type="checkbox"/> Ensure crossbars are secure and in correct position</li><li><input type="checkbox"/> Side rail covers, crossbar users guide and torque tool</li><li><input type="checkbox"/> Crossbar cover engagement</li></ul>	<p>Crossbar support bolt: <b>8 N•m (71 in•lbf)</b></p> <p>Front crossbar has “FRONT” label.</p> <p>Side rail covers, users guide and torque tool inside vehicle glove box</p> <p>Ensure crossbar covers are fully engaged.</p>
<p><u>Vehicle Function Checks</u></p> <ul style="list-style-type: none"><li><input type="checkbox"/></li></ul>	
<p><u>Vehicle Appearance Check</u></p> <ul style="list-style-type: none"><li><input type="checkbox"/> After accessory installation, perform a visual inspection.</li></ul>	<p>Ensure no damage (including scuffs and scratches) was caused during the installation process. (For PPO installations, refer to TMS Accessory Quality Shipping Standard.)</p>