



51-718 / 41-718 Double Cab
 51-720 / 41-720 Crew Max
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 IRON CROSS AUTOMOTIVE INC. 2007

TUBE STEP INSTALLATION SHEET

STEP 1 REMOVE ALL CONTENTS FROM THE BRACKET BOX AND CHECK FOR CORRECT QUANTITY AND ANY DAMAGED PARTS

STEP 2 INSTALL FRONT BRACKETS

1) REMOVE FRONT NUT AND FLAT WASHER FROM FRONT BODY MOUNT BOLT AND INSTALL FRONT BRACKET. **(FIG 1)** INSTALL 1/2" LOCK WASHER, 1/2" FLAT WASHER, FRONT BRACKET AND FACTORY BODY MOUNT FLAT WASHER ONTO BODY MOUNT BOLT. HAND TIGHTEN ALLOWING FOR FINAL ADJUSTMENTS.

STEP 3 INSTALL REAR BRACKETS

1) INSTALL REAR BRACKETS USING FACTORY SUPPLIED SELF THREADING 8MM BOLTS TO THE LAST 2 HOLES TOWARDS REAR OF BODY PANEL. **(FIG 2)** HAND TIGHTEN ALLOWING FOR FINAL ADJUSTMENT.

STEP 4 BOLT THE TUBE AND SUPPLIED O-RING FOR FRONT TUBE LEG TO THE BRACKETS USING THE 1/2" X 1-3/4" HEX BOLTS, 1/2" FLAT WASHERS AND 1/2" LOCK WASHERS. HAND TIGHTEN THE BOLTS. NEXT, ALIGN THE TUBE WITH THE TRUCK AND TIGHTEN THE TUBE STEP BOLTS TO 65 FT/LBS. FINALLY, TIGHTEN THE FRONT BRACKET BOLTS TO 35 FT./LBS. **(FIG 3)**

STEP 5 REPEAT STEPS 2 THROUGH 4 FOR INSTALLATION OF DRIVERS SIDE.

QTY	718 KIT PARTS LIST
2	526 Front Bracket
2	718 REAR BRACKET
6	1/2" FLAT WASHER
6	1/2" LOCK WASHER
4	1/2" – 13 x 1-3/4" Hex Bolt

QTY	720 KIT PARTS LIST
2	520 Rear Bracket (use for front)
2	720 REAR BRACKET
6	1/2" FLAT WASHER
6	1/2" LOCK WASHER
4	1/2" – 13 x 1-3/4" Hex Bolt

MAINTENANCE AND CARE

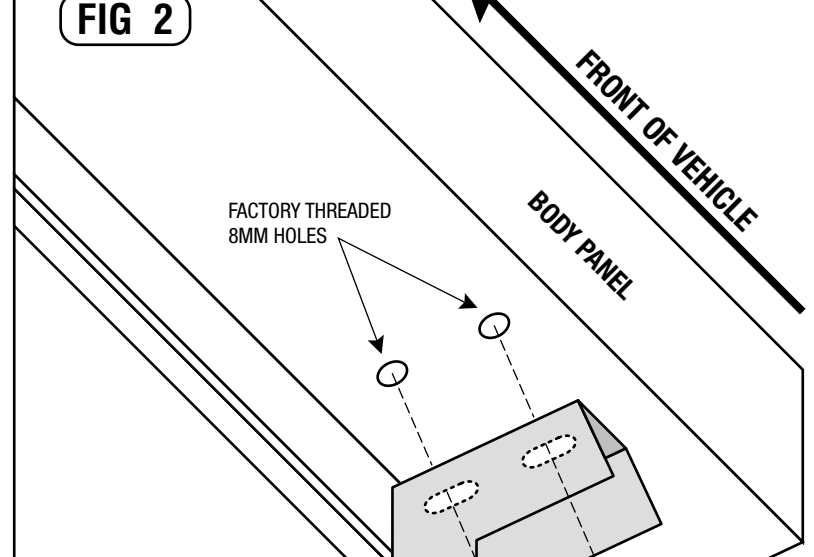
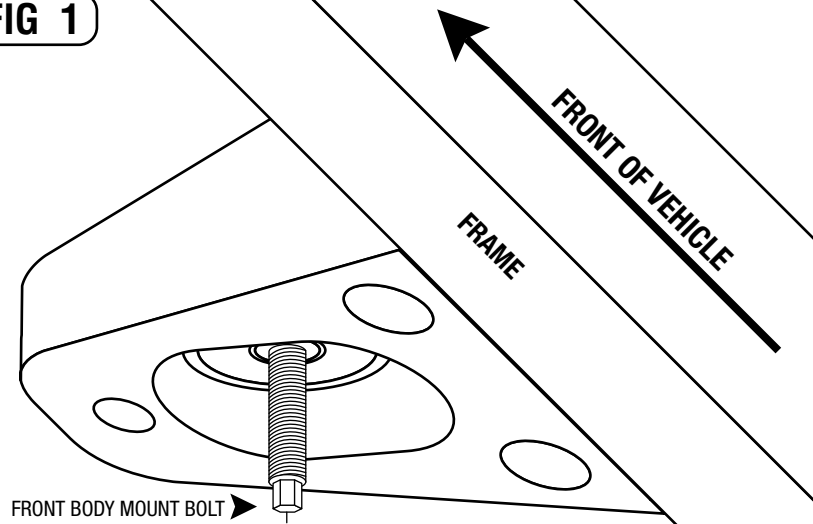
Only use mild soap for regular cleaning. For heavy build up, a solution of ammonia and water can be used. Never use abrasive material, i.e. steel wool, for cleaning purposes. Use terry cloth towels wiping in the direction of the tube at all times.

FRONT SIDE PASSENGER

REAR SIDE PASSENGER

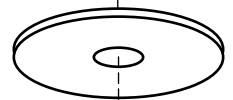
FIG 1

FIG 2

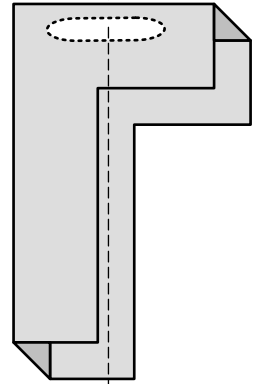


FRONT BODY MOUNT BOLT

FACTORY BODY MOUNT FLAT WASHER



FRONT BRACKET



FLAT WASHER

LOCK WASHER

BODY MOUNT BOLT NUT



TUBESTEP TO BRACKET

Plastic tube rings available on 3" tube steps only.

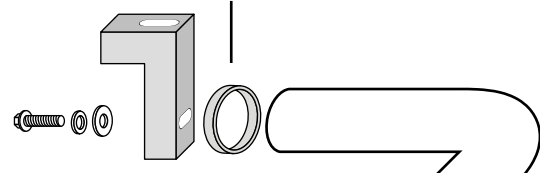
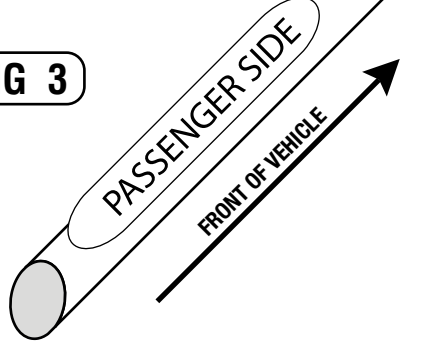


FIG 3



REAR BRACKET

FACTORY THREADED 8MM HOLES

FACTORY 8MM SELF THREADING BOLTS

2007 TOYOTA TUNDRA
DOUBLE CAB / CREWMAX