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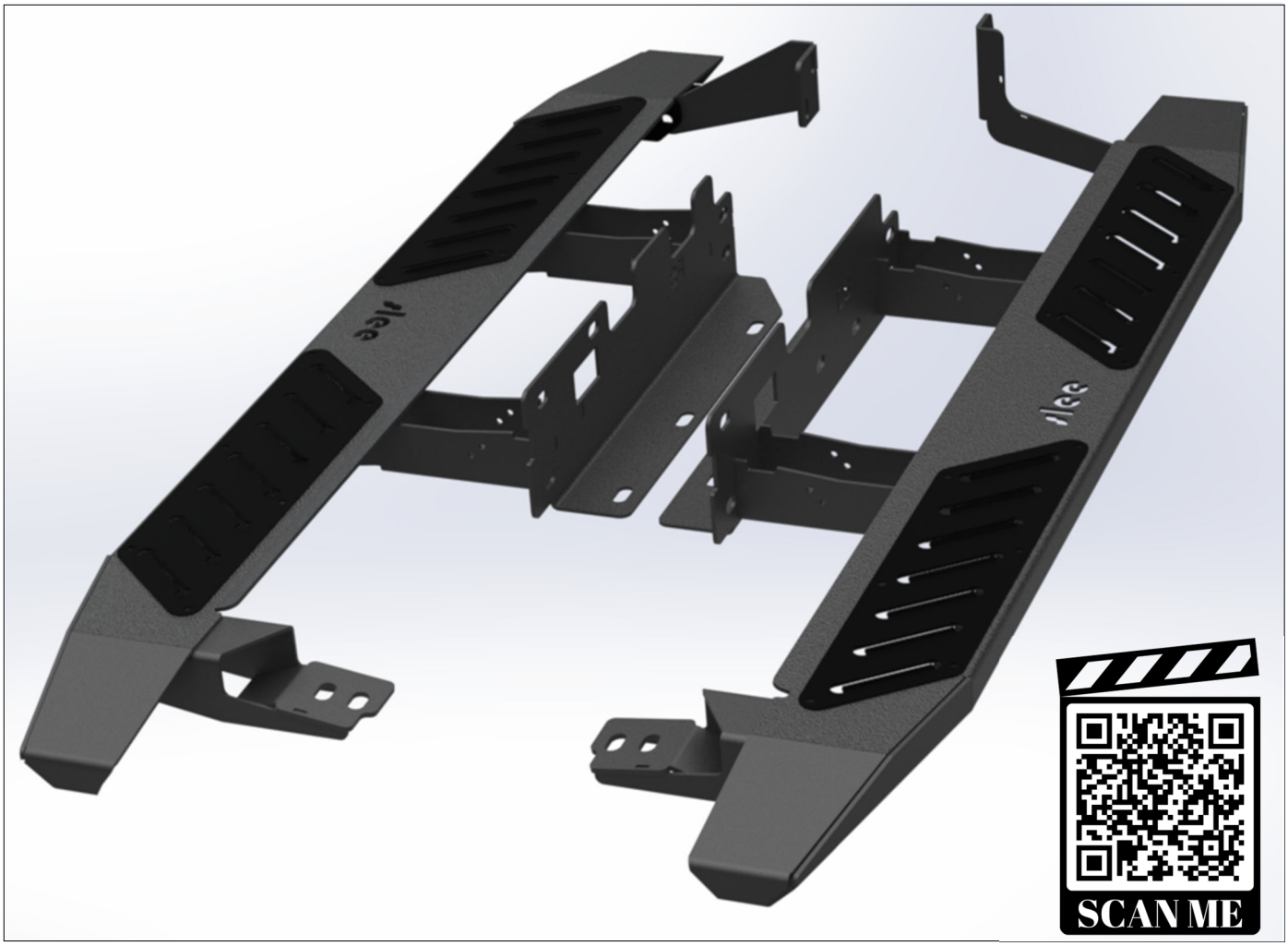
Land Cruiser 250/Lexus GX550 Sliders (SOK2102) – Installation instruction 1



For

[Land Cruiser LC250—Lexus GX550]

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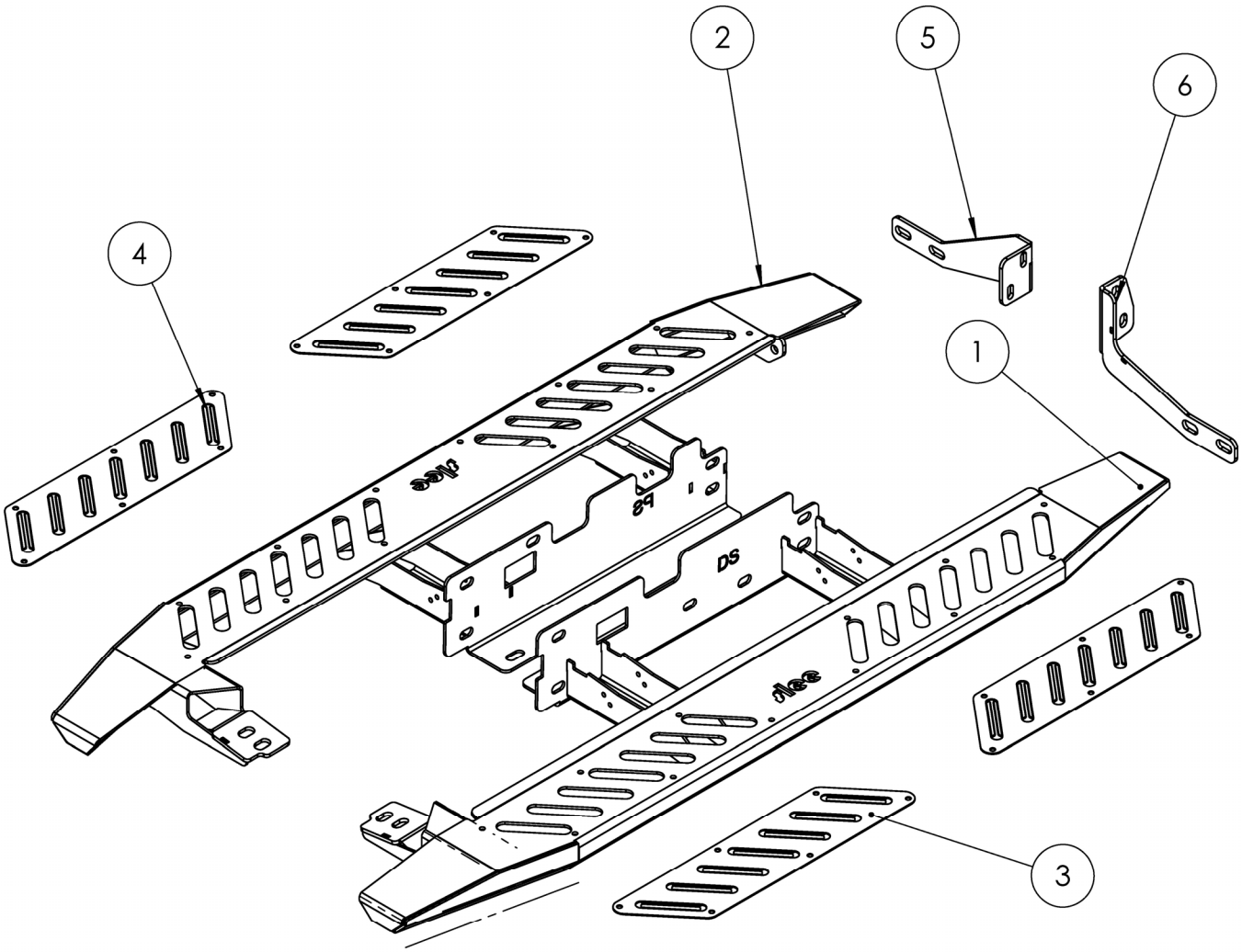
ITEM NO.	PART NAME	QTY.
1	DRIVER SIDE SLIDER	1
2	PASSGER SIDE SLIDER	1
3	STEP PLATE	2
4	STEP PLATE	2
5	PS REAR SUPPORT	1
6	DR REAR SUPPORT	1

NOTE:
GX550 PREMIUM and LUXURY models requires additional installation kit part numberL : SOK2102-GX



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DESCRIPTION: **BOLT ON SLIDERS**
PART NUMBER: **SOK2102**
PART NAME: **LC250-GX550**

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QTY	Parts Included	Torque Spec
1	Passenger Side Slider	
1	Driver Side Slider	
4	Step Plates	
1	Passenger Side Support	
1	Driver Side Support	
1	Z Bracket	
1	Wire Clamp	
16	M10 x 30mm - Flange Bolt - [1.25 pitch] class 10.9 zinc clear	30 ft.lb
16	M10 - Fender Washer OD 1.2" - thick (1/8") zinc clear	
1	M8 x 16mm - Flange Bolt - [1.25 pitch] zinc clear	21 ft.lb
1	M8—Flange Nut	
7	M8 x 30mm - Flange Bolt - [1.25 pitch] zinc clear	21 ft.lb
7	M8 - Fender Washer - thick (1/8") zinc clear	
4	1/2" x 1-1/2" - Hex Bolt - grade 8 zinc yellow	30 ft.lb
8	1/2" - Washer - USS grade 8 zinc yellow	
4	1/2" - Lock Washer - grade 8 zinc yellow	
4	1/2" - Nut - grade 8 zinc yellow	
2	3/8" x 1-1/4" - Hex Bolt - grade 8 zinc yellow	30 ft.lb
2	3/8" - Lock Washer - grade 8 zinc yellow	
2	3/8" - Washer - USS grade 8 zinc yellow	
2	3/8" stick nut - 12" length, stainless steel	
24	1/4" x 5/8" - Button Head Bolt - Black Oxide - Stainless Steel	
24	1/4" - Washer - Stainless Steel - Black Oxide	
24	1/4" - Flange Lock Nut - zinc clear	

Tools Required
Metric Tools
SAE Tools
Optional:
M10 x 1.25 Thread Chase Tool
M8 x 1.25 Thread Chase Tool

NOTE:

GX550 PREMIUM and LUXURY models requires additional installation kit SOK2102-GX

NOTES:

- Photographs were taken while installing the sliders on a Land Cruiser LC250. The steps are the same for the Lexus GX550 but some photos might not match exactly due to additional components present on the GX550.
- We suggest using a thread chase tools on all the captive nuts on the frame to ensure easier installation.
- Inspect welds on the bottom of the frame. If there are large “drips” or “blobs” we suggest grinding those down and treating with paint to ensure proper fitment of the frame flange.

IMPORTANT GX550 INSTALL NOTE

READ FIRST: Refer to Addendums A & B for more details on GX install.

For GX550 the support bracket shown in step 7 should be attached to the slider loosely before placing the slider against that frame. Use the 1/2” hardware as indicated in step 7. The bracket should be located on the backside (towards the rear of the vehicle) on the flange on the sliders.

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01 Make sure all parts for the kit are present. Start by uninstalling any factory running boards or sliders.
Remove the plastic rectangular and round plug from the frame rails for both DS and PS side.

On the DS unlclip the light tab and rotate out of the way for installation. The harness can be secured later with zip ties.

Install the tread plates on the sliders using the 1/4” hardware. Use the washer under the bolt head and tighten the bolt while holding the nut in place to prevent damage to powder coat.

Hardware:
24- 1/4"x 5/8" Button Head Bolt, Black SS
24 - 1/4" - Washer Black SS
24 - 1/4" - Flange Lock Nut - zinc clear

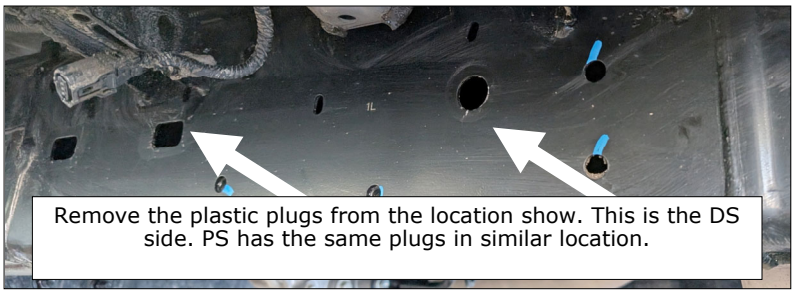
02 **Driver Side Slider Install:** With a helper position the slider against the frame rail and align the slot openings on the slider with the holes in the frame. Support the slider in position.

Installi the M10 and M8 bolts on the frame flange portion of the slider. Use hardware as shown on diagram. Bolts thread into existing holes with captured nuts. Hand Tighten.

Hardware:
4 - M10x30mm Flange Bolts
4 - M10 Fender Washers
3 - M8x 30mm Flange Bolts
3 - M8 Fender Washers

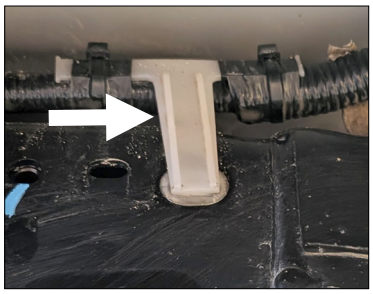
03 The 3/8” hardware installs with stick nuts. **Stick nuts are installed through two rectangular holes in the frame. Remove the plastic plug from the rectangular holes that are used, one on the inner side of the frame rail and one outside.**
Rearmost 3/8” bolt position. Bend the stick nut as shown and insert the nut end into frame via the rectangular hole on inner side of the frame. Line up nut with the hole on the bottom of the frame. Adjust bends as needed and thread 3/8” bolt with washer into stick nut. Hand tighten.

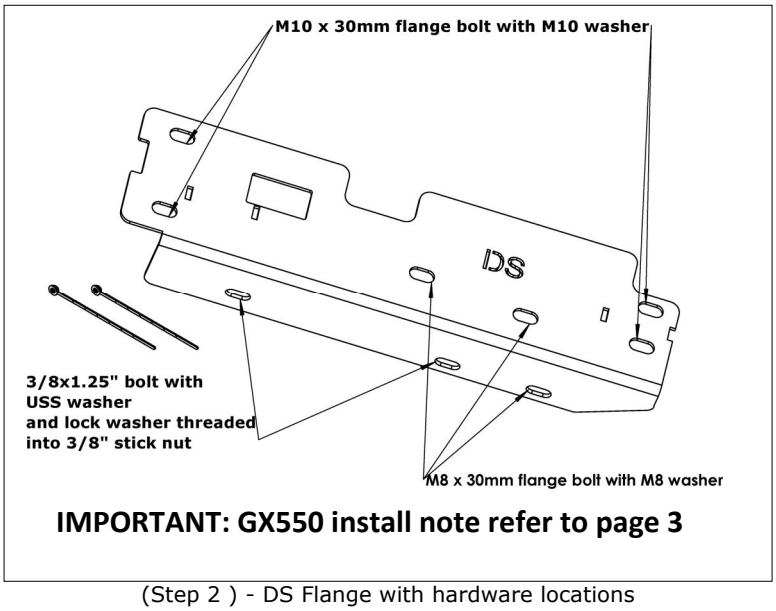
Hardware:
1 - 3/8” x 1 1/4” Hex Bolts
1 - 3/8” Lock Washers
1 - 3/8” USS Washer
1 - 3/8” Stick Nut



(Step 1)- Plastic Plug Locatons (Driver Side)

(Step 1)- Tread plate hardware


(Step 1)- Unclip Light Tab



(Step 2) - DS Flange with hardware locations

(Step 3) - Initial bend on stick nut. Installed through the rectangular hole from inner side of the frame rail.

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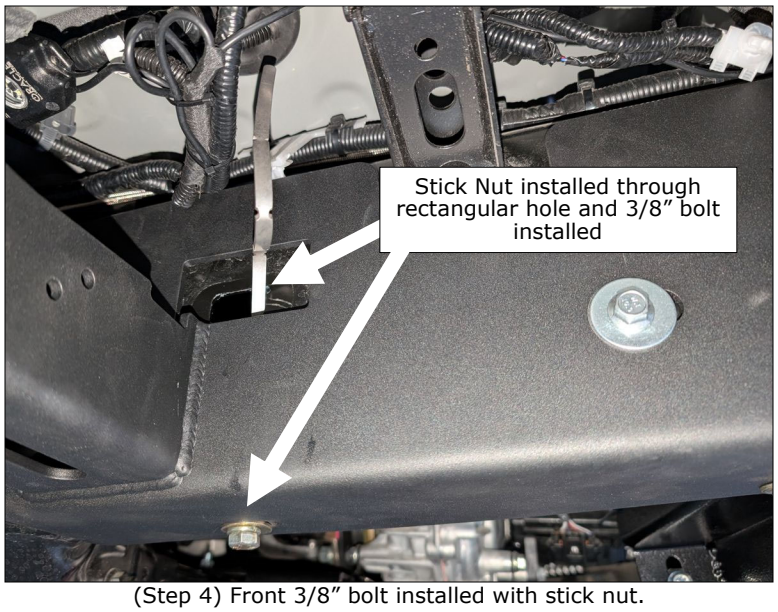
04 **Forward 3/8” bolt position.** Bend the stick until the nut is viewable from the hole on the bottom of the frame. Adjust bends as needed and thread 3/8” bolt with washer into stick nut. Hand tighten.

Hardware:

1 - 3/8” x 1 1/4” Hex Bolts
1 - 3/8” Lock Washers
1 - 3/8” USS Washer
1 - 3/8” Stick Nuts

Note:

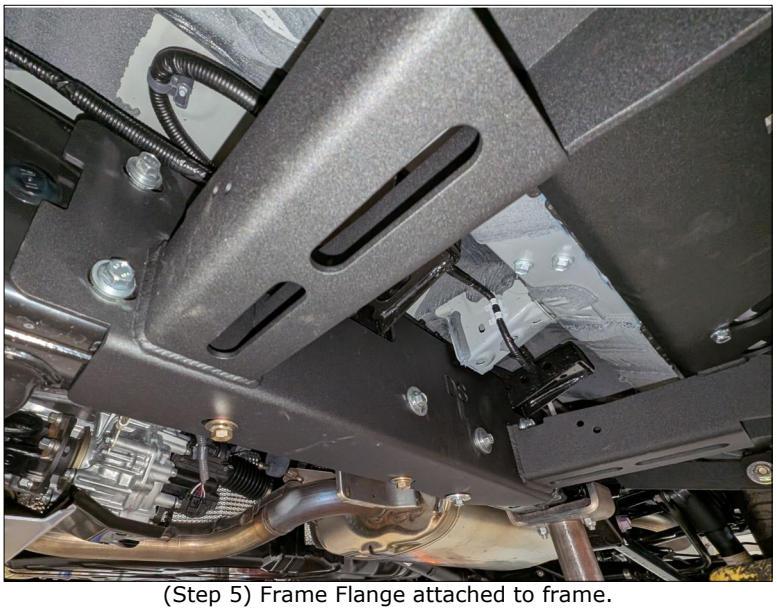
Once installation is complete the stick nut tails can be trimmed for a cleaner install.



(Step 4) Front 3/8” bolt installed with stick nut.

05 Photo on the right shows frame flange attached.

Hint: Leave hardware hand tightened. It might be needed to move sliders forwards or backwards to get the bolts to line up on the front frame bracket.


(Step 5) Frame Flange attached to frame.

06 Attach the frontmost support leg to the frame by threading the M10 bolts with washers into the captive nuts located in the body mount bracket. Hand tighten.

Hint: Move the slider forward or backward to line up holes as needed

Hardware:

2 - M10 x 30mm Flange Bolts
2 - M10 Fender Washers

(Step)

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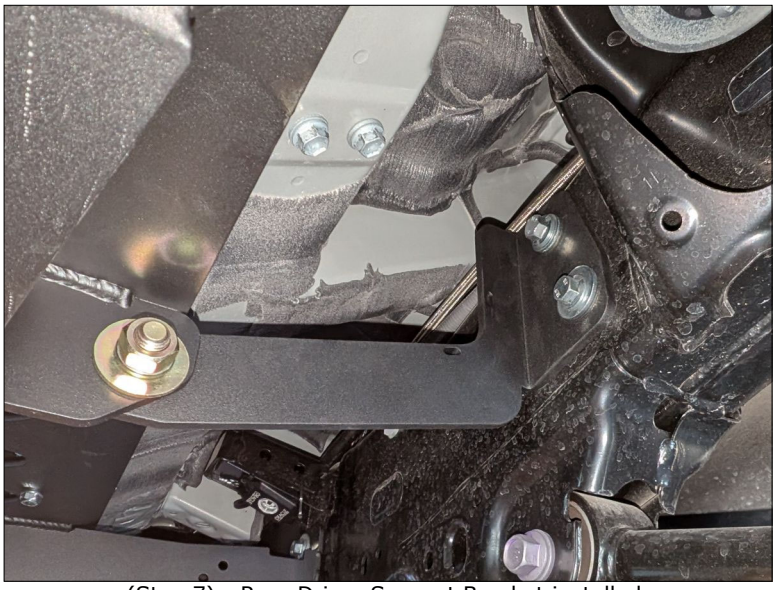
07 Install the **Driver Side Support** bracket with M10 hardware into the captive nuts on the frame.

If there is a plastic round plug on the frame, remove the plug.

Attach to the slider with 1/2” hardware. Hand Tighten.

Hardware:

2 - M10 x 30mm Flange Bolts
2 - M10 Fender Washers
2 - 1/2”x1 1/2” Hex Bolts
2 - 1/2” Nuts
2 - 1/2” Lock Washers
4 - 1/2” USS Washers

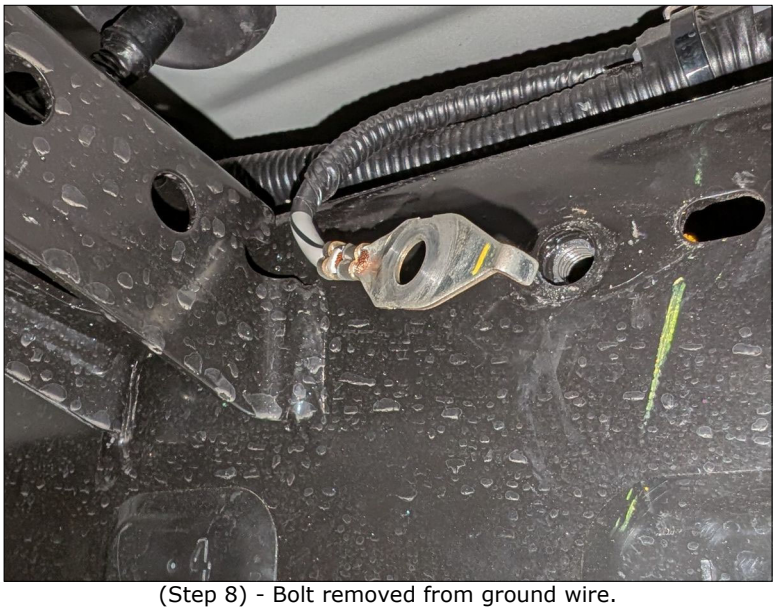


(Step 7) - Rear Driver Support Bracket installed.

08 **Passenger Side Slider Install.**

Start by removing the bolt from the ground wire that is located ahead of the impact bracket on the frame. Use pliers to flatten the “alignment tab” on the ground terminal.

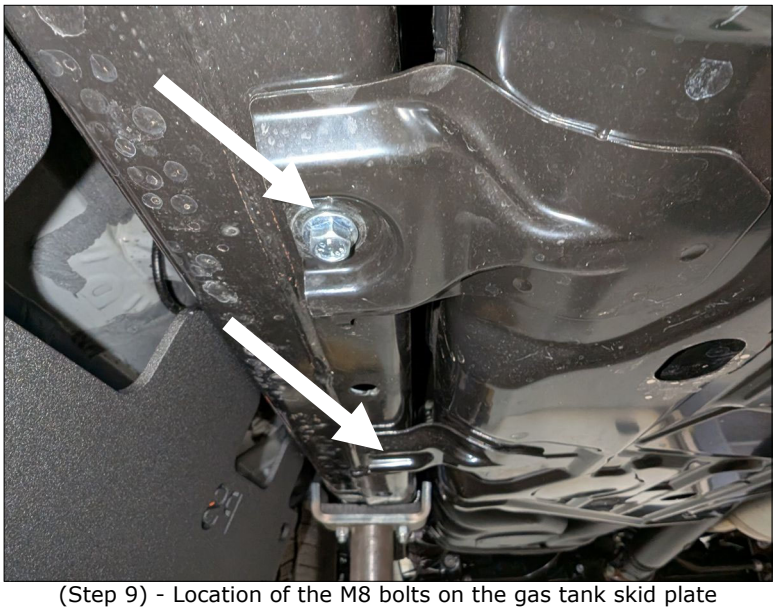
Make sure terminal is out of the way to prevent damage. Terminal will be reattached after slider installation on the outside of the frame flange.



(Step 8) - Bolt removed from ground wire.

09 Remove the two M8 bolts that attach the tabs of the gas tank skid plate to the frame.

Hint: The strap and brackets keep the skid plate in place. The frame flange of the PS slider will install between these tabs and lower frame.



(Step 9) - Location of the M8 bolts on the gas tank skid plate

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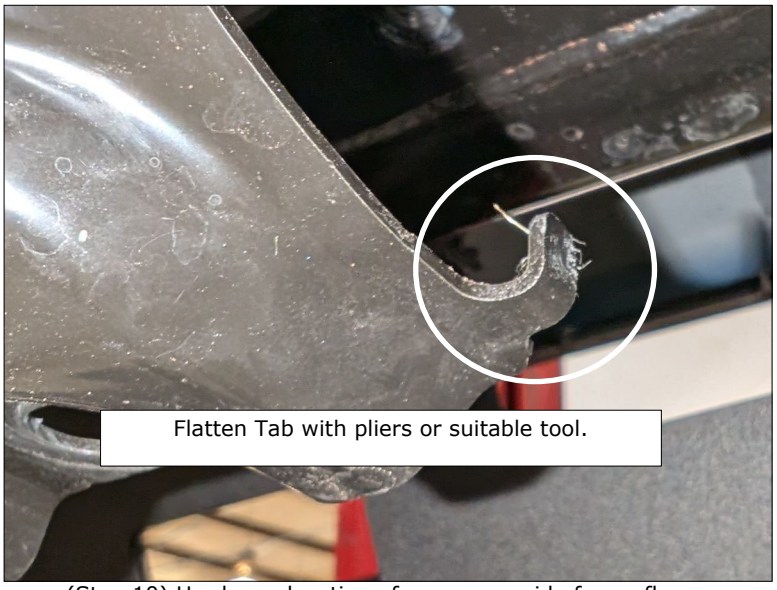
10 Use pliers or a suitable tool and flatten the locating tab on the gas tank skid plate tabs.



(Step 10) Hardware location of passenger side frame flange

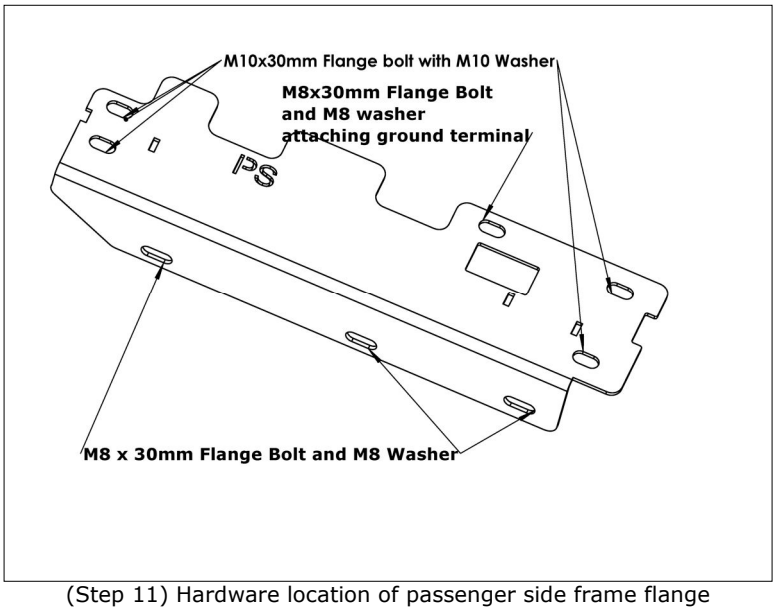
11 Position the slider against the frame rail. The horizontal flange of the slider installs between the gas tank skid plate tabs and lower frame

Attach with the M10 and M8 hardware as shown on the diagram on the right.

Hand tighten.

Hardware:

4 - M10 x 30mm Flange Bolts
4 - M10 Fender Washers
4 - M8 x 30mm Flange Bolts
4 - M8 Fender Washers



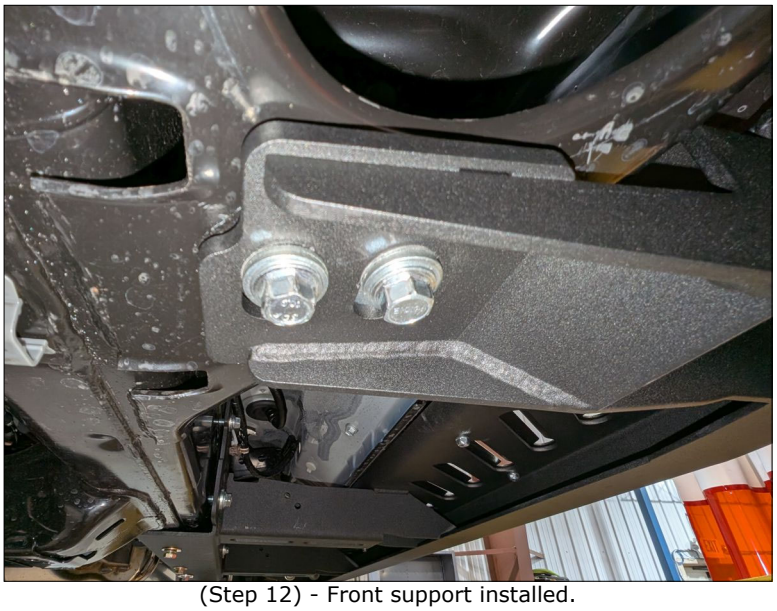
(Step 11) Hardware location of passenger side frame flange

12 Attach the frontmost support leg to the frame by threading the M10 bolts with washers into the captive nuts located in the body mount bracket. Hand tighten.

Hint: Move the slider forward or backward to line up holes as needed.

Hardware:

2 - M10 x 30mm Flange Bolts
2 - M10 Fender Washers



(Step 12) - Front support installed.

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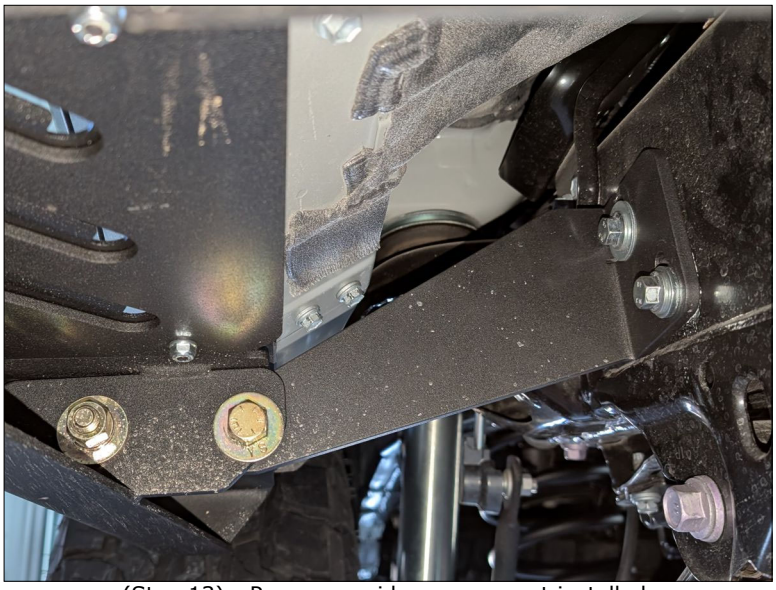
13 Install the **Passenger Side Support** bracket with M10 hardware into the captive nuts on the frame.

If there is a plastic round plug on the frame, remove the plug.

Attach to the slider with 1/2” hardware. Hand tighten.

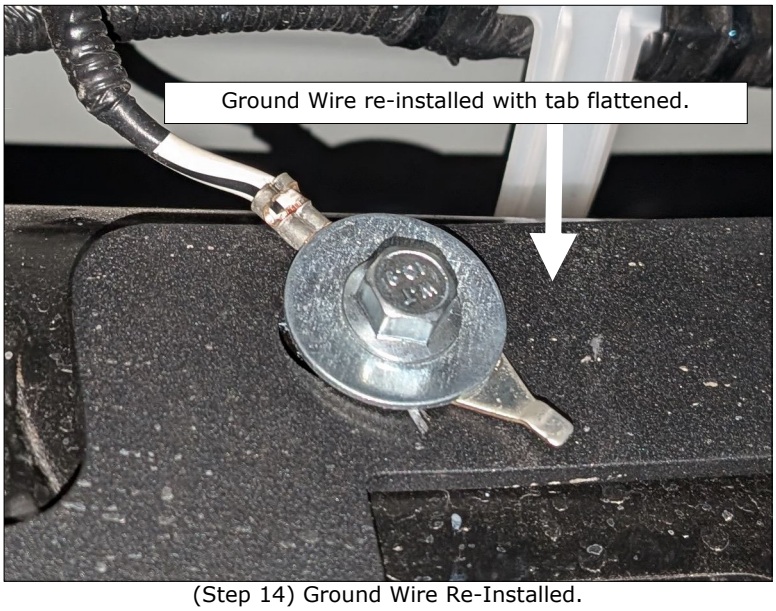
Hardware:

2 - M10 x 30mm Flange Bolts
2 - M10 Fender Washers
2 - 1/2”x1 1/2” Hex Bolts
2 - 1/2” Nuts
2 - 1/2” Lock Washers
4 - 1/2” USS Washers



(Step 13) - Passenger side rear support installed.

14 Make sure the ground wire that was detached in step 8 is reattached.



(Step 14) Ground Wire Re-Installed.

15 Torque bolts to specs listed on BOM located on page 3. Tighten hardware on bottom of frame first. Add upward or downward pressure to rear of slider to align with bottom of vehicle. Tighten the rear mounting brackets and finally the front most brackets.

This concludes the installation of the sliders.

(Step 15) Sliders Installed

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ADDENDUM A

The **GX Overtrail and Overtail Plus** has a KDSS line that runs along the passenger side frame rail. During the install the line needs to be unclipped from the frame and the slider flange installed between the line and frame.

When installing the topmost bolt in front on the crash bar use the Z bracket and Wire Clamp to secure the line as shown on the right. Use the M8 x 16 bolt and Flange nut to attach to the clamp to the Z bracket.

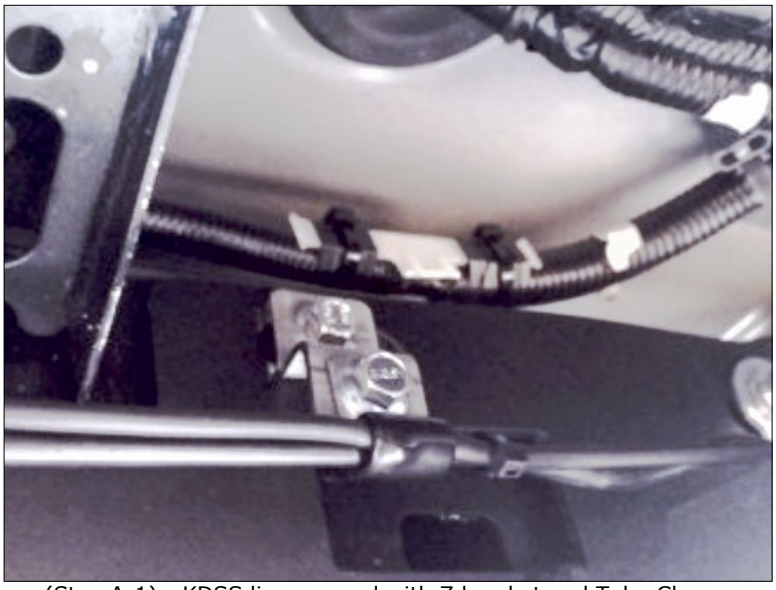
The photo on the right also has a harness attached to the tube. This will not be present.

Hardware:

1 - Z Bracket
1 - Wire Clamp

1 - M8 x 16 Flange Bolt

1 - M8 Flange Nut



(Step A-1) - KDSS line secured with Z bracket and Tube Clamp.

ADDENDUM B

For the **GX550 PREMIUM and LUXURY** models, certain captive nuts are not welded in the frame. For those vehicles the **SOK2102-GX additional hardware kit** is required. The kit consist of additional longer 3/8" bolts and stick nuts. The stick nuts are routed through openings in the frame and then the 3/8 bolts are used to attach the siider.

These stick nuts and bolts will be used where M8 bolts are referred to in the instructions. Use the supplied washers from the slider install kit where applicable.

There are enough captive nuts per side to be able to get the slider in position and then install the stick nuts. Refer to the diagrams for the locations where the stick nuts will be used.

Access to insert the captive nuts are through the rectangular holes in the frame. The holes are plugged with a plastic insert. Remove insert to install the stick nuts. The stick nuts are bent to enable the nut to line up with the relevant holes.

Hardware:

12 - 3/8" stick nuts—12" long

12 - 3/8" x 1.5" Bolts

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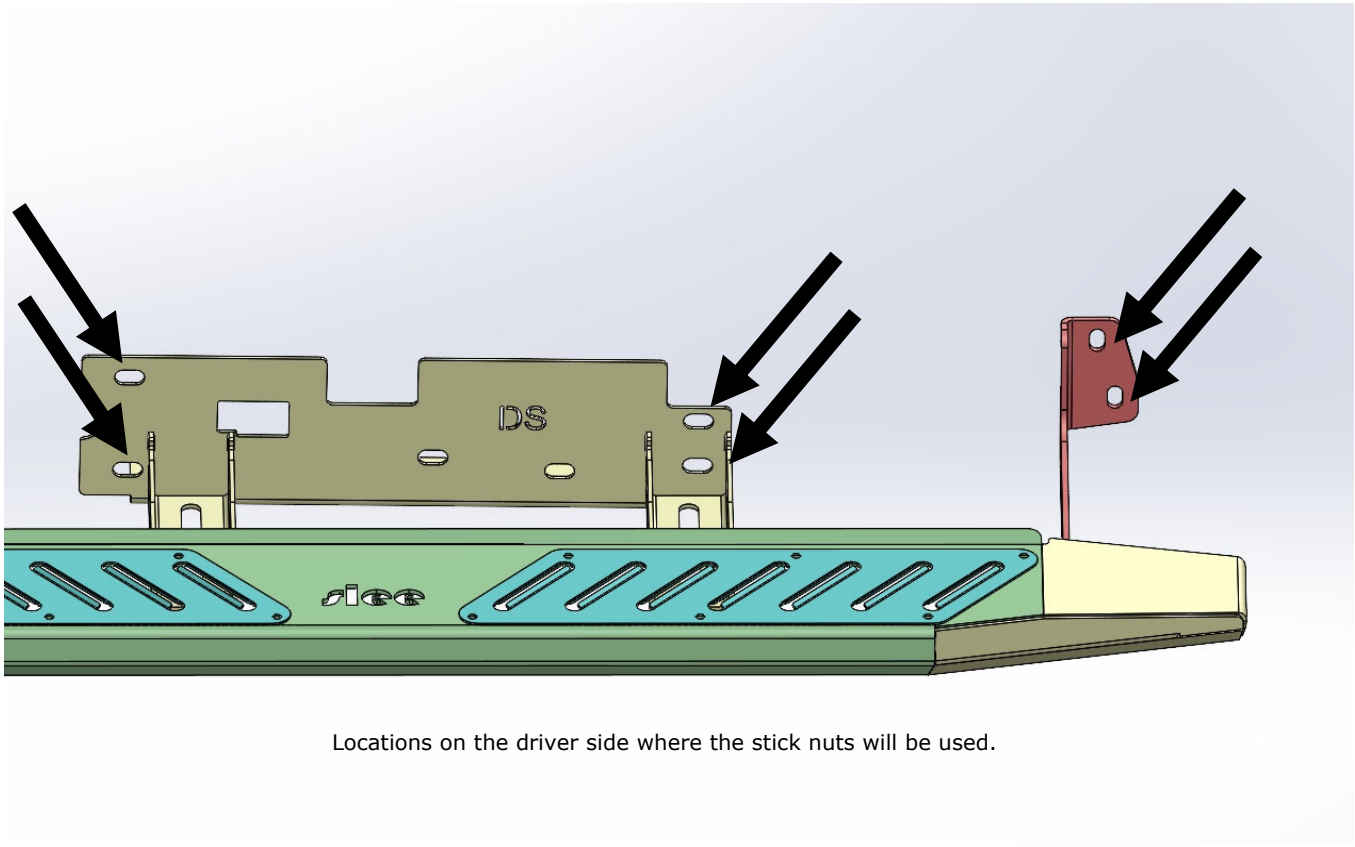

Locations on the driver side where the stick nuts will be used.

Stick Nuts installed before trimming excess.

Stick Nuts installed before trimming excess.

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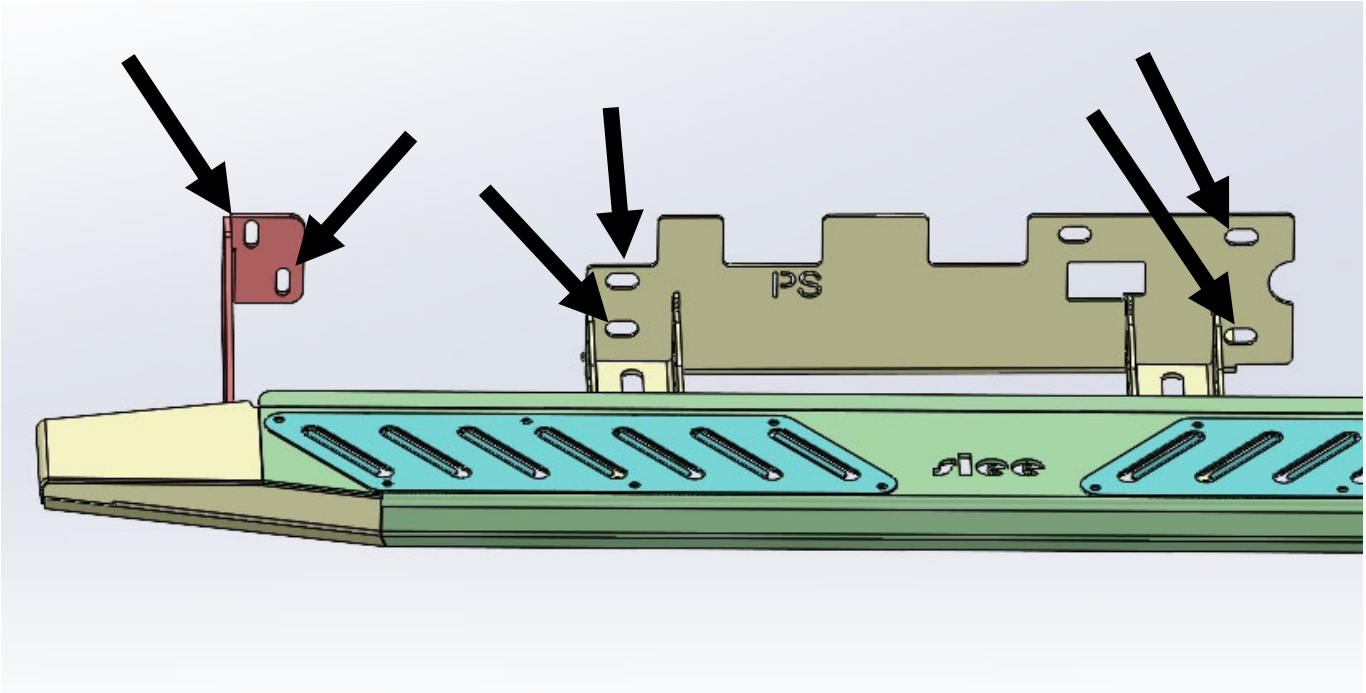

Locations on the passenger side where the stick nuts will be used.

Stick Nuts installed before trimming excess.

Stick Nuts installed before trimming excess.

Stick Nuts can be trimmed with a bolt cutter, cutoff wheel or any suitable tool.

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