INSTALLATION INSTRUCTIONS AND PARTS LIST

MODEL: 415254
54" GRIP STEP
UNIVERSAL APPLICATION

1. READ INSTRUCTIONS COMPLETELY AND CHECK TO MAKE SURE THAT ALL REQUIRED PARTS (LISTED ON SERVICE PARTS LIST) ARE ON HAND BEFORE STARTING THE INSTALLATION.

2. FOLLOW THE INSTRUCTIONS INCLUDED WITH THE SPECIFIC BRACKET PACKAGE THAT YOU ARE USING, TO MOUNT THE BRACKETS TO YOUR VEHICLE.

3. ATTACHING THE STEP TO THE BRACKETS.
   3.1 SLIDE THE END CAP (ITEM #5) OVER THE ENDS OF THE STEP (ITEM #1). USING THE SUPPLIED #8 X 1/2" SELF DRILLING TEK SCREW (ITEM #6). SCREW THE END CAPS TO THE BOTTOM OF THE STEP.
   3.2 SET THE STEP ON THE MOUNTING BRACKETS AND SLIDE THE (2) SUPPORT BRACES (ITEM #3) INSIDE THE CHANNEL OF THE STEP AND ATTACH THE FLAT SPACER (ITEM #2) TO THE BOTTOM OF THE STEP, ABOVE THE TOP OF THE BRACKET.
   3.3 USING THE SUPPLIED 5/16-18 X 1.0 CARRIAGE BOLT, WASHER, NUT (ITEMS # 4, 7, 8), ATTACH THE STEP ASSEMBLY, SUPPORT BRACKET, SPACER PLATE TO THE MOUNTING BRACKET.
   3.4 SET THE STEP INTO A LEVEL POSITION AND TIGHTEN ALL FASTENERS.

SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	551954	1	GRIP STEP BOARD, 54", BLK
2	551298	2	SPACER PLATE, FLAT, GALV.
3	551296	2	SUPPORT BRACE, GALV.
4	108683	4	BOLT-CARRAIGE, 5/6-18 X 1.00,SST
5	551394	2	END CAP, GRIP STEP, BLACK
6	107958	4	SCREW-TEK, #8X1/2, SST,BLK
7	101369	4	WASHER-FLAT, 5/16, SST
8	102680	4	NUT SERR FLG,SST,5/16"

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(A LUVERNE Company)
TRUCK EQUIPMENT

1200 E. Birch St.
Brandon, SD 57005

FIG. 1

INSTALLATION MANUAL

Parts List	
2	Middle Mounting Bracket
1	Rear Mounting Bracket
1	T-Bolt M8
2	U-Bolt 3.75"
4	Spacer
6	Bolt Retainer
6	Lock Washer, 5/16
5	Flange Nut M8
6	Hex Bolt, M8
6	Clip Nut M8

Level of Difficulty
Easy

Product Image

Middle Monting
Bracket
(553196)

Rear Mounting
Bracket
(553199)

Notes and Maintenance

Before you begin installation, read all instructions thoroughly.

Make sure all required parts are on hand before starting the installation.

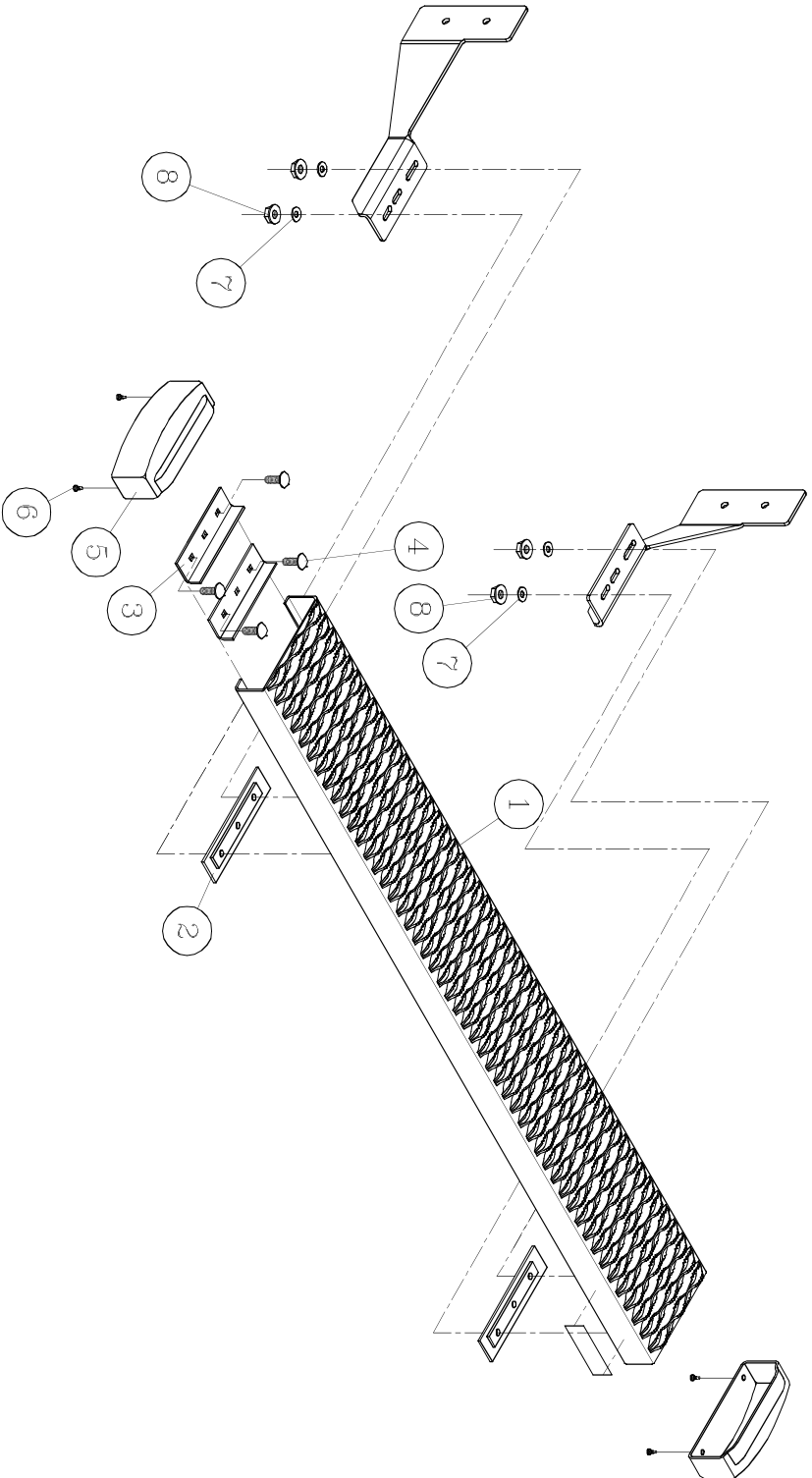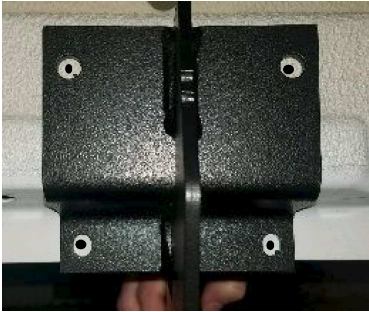| Tools Required	
Socket, 1/2"	Ratchet
Wrench, 1/2"	Drill
Flat Screwdriver	Drill Bit, 3/8"
Marker	Drill Bit, 3/32
Putty Knife	

Step 1

Starting on the Passanger side, locate mounting locations as shown in Fig 1 and Fig 3.

Hold each bracket in its mounting locations and mark each hole on the rocker and pinch weld.

Step 2

From the under side of the plastic rocker molding use a flat head screw drive to release the bottom push pins.

NOTE: Do not remove plastic trim all the way only release the bottom push pins.

Step 3

Move to the 3rd & 4th mounting brackets, **models with factory studs** will use those as monting locations. **Models with out factory studs** will have holes pre drilled in the rocker panel and will use the 3.75" U-Bolts with the plastic bolt retainer.
Repeat steps 3&4 for the bottom mounting Holes.

Continue along the side of the vehicle to the 5th mounting bracket repeat steps 3, 4 for the lower mounting holes.

Insert the 8mm T-bolt weldment with a plastic retainer clip to secure it in place.

Slide the rear mounting bracket on the T-Bolts and secure with (1) 8mm nuts and (2) 8mm bolts.

NOTE: Leave all brackets loose until the end

Step 7

Leave ALL brackets Loose at this time. Please Review the installation instructions that are included in your step assembly for specific details. Place step board on brackets tighten all brackets so the board is level.

PARTS LIST
FOR MOUNTING 401727 MEGA STEP BRACKETS
2015 AND NEWER FORD TRANSIT VAN

SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	553196	2	MIDDLE MOUNTING BRACKET
2	553199	1	REAR MOUNTING BRACKET
3	101796	2	U-BOLT 3.75
4	107182	4	WSHR-SPCR, NYL, BLK
5	101572	5	BOLT RETAINER
6	100030	6	5/16 LOCK WASHER
7	105859	5	M8 FLANGE NUT
8	102549	6	M8 HEX BOLT
9	101566	6	M8 CLIP NUT
10	553221	1	T-BOLT WLDMNT

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FIG. 1

IDENTIFICATION NOTCHES
IN BRACKET(S) #553199

IDENTIFICATION NOTCHES
IN BRACKET(S) #553196

FRONT
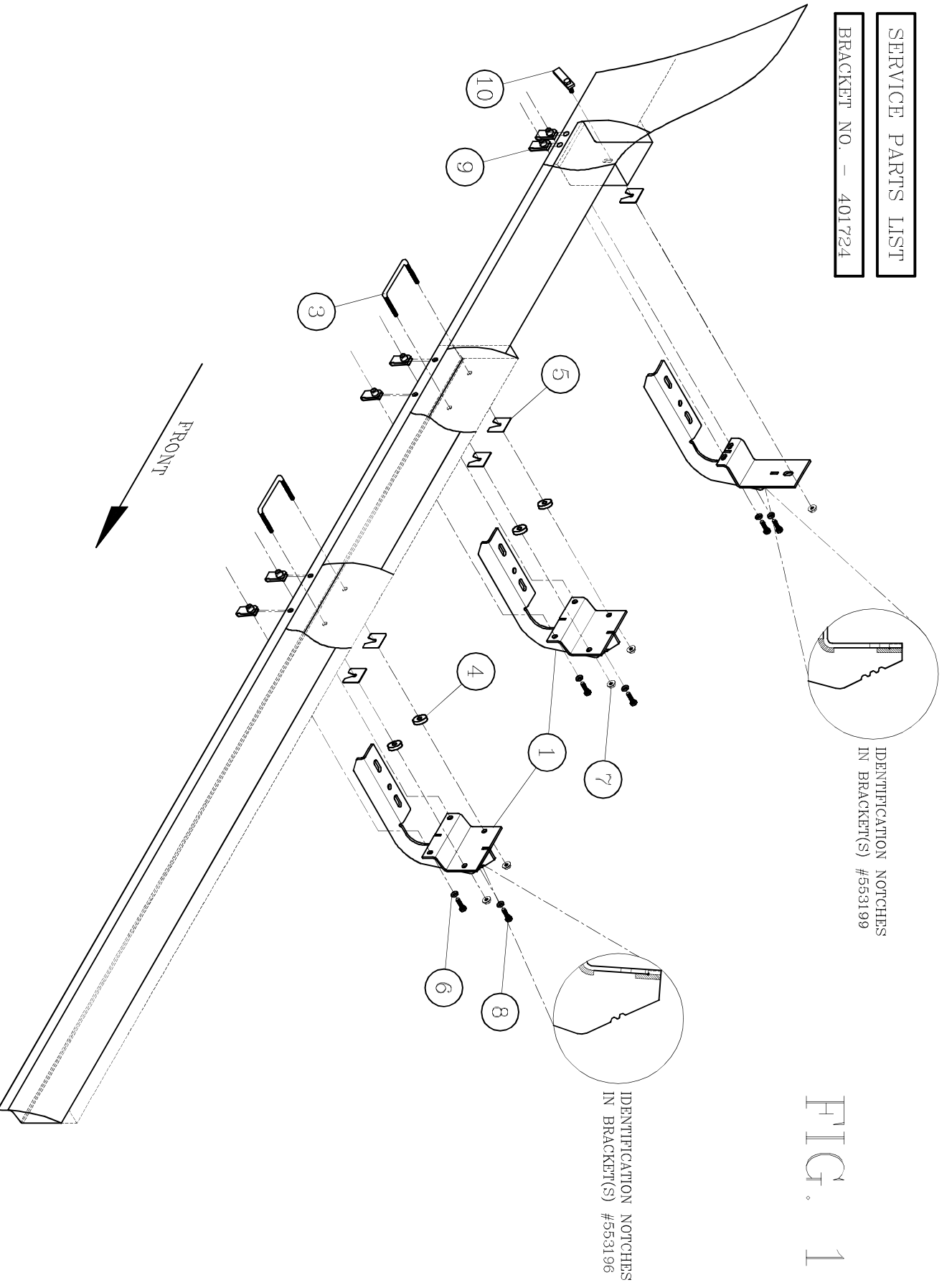
–RIGHT (PASSENGER) SIDE SHOWN–

553219 SHEET 5 OF 6 18MAY17

FIG. 2

–RIGHT (PASSENGER) SIDE SHOWN–

NOTE:
THESE DIMENSIONS MAY NEED TO BE ADJUSTED FORWARD, OR BACKWARD
TO AVOID DRILLING THROUGH SPOT WELDS IN THE PINCH SEAM.

FRONT

$9\frac{3}{8}$

68

$42\frac{1}{2}$

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