

## INSTALLATION INSTRUCTIONS AND PARTS LIST

APPLICATION: MODEL **481031** (STAINLESS STEEL) SIDE ENTRY STEP BOARDS:  
**BODY MOUNT 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. WITH THE STEP BOARD BRACKETS ATTACHED TO THE VEHICLE, ON THE LEFT SIDE OF THE VEHICLE PLACE THE STEP BOARD (ITEM #1) ON THE BRACKETS AND CHECK THAT THE MOUNTING HOLES LINE UP. (THE LUVERNE STICKER SHOULD BE ON THE FRONT DRIVERS SIDE)
3. INSERT THE 10-24 X .75" CARRIAGE BOLTS (ITEM #3) INTO THE BLACK NEOPRENE WASHERS (ITEM #13).
4. USING FOUR (4) 10-24 X .75" CARRIAGE BOLTS (ITEM #3), AND FOUR (4) 10-24 FLANGE NUTS (ITEM #4) ATTACH THE STEP BOARD TO THE BRACKETS.
5. ADJUST STEP IN/OUT TO ALIGN STEP WITH THE CAB.
6. TIGHTEN THE STEP MOUNTING BOLTS.
7. REPEAT FOR RIGHT SIDE OF VEHICLE.

### SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	550160	1	STEP PLATE-SES, LH, 481032, QUAD CAB
2	550159	1	STEP PLATE-SES, RH, 481032, QUAD CAB
3	104258	8	BOLT – CARRIAGE – SST, 10-24 X .75"
4	104261	22	NUT – FLANGE, SST, 10-24
5	104250	2	END CAP – RH FRONT/LH REAR
6	104251	2	END CAP – LH FRONT/RH REAR
7	105500	2	STEP PAD, 5.50 X 20.00
8	104257	8	NUT – HEX, SINGLE THREAD
9	107958	4	SCR-PPH, #8-18 X .5", SST
10	107645	2	CLIP-U, .118-.185, BLK
11	107863	14	BOLT – CARRIAGE, 10-24 X .5", BZP
12	104256	2	TRIM – SEAL, EXTRUSION, 60.5"
13	104530	8	WASHER-NEOPRENE, .200 X .468 X .03



(A LUVERNE Company)

1200 E. Birch St.

Brandon, SD 57005

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## INSTALLATION INSTRUCTIONS AND PARTS LIST

APPLICATION: MODEL 571031/401031 SES/GRIP STEP BRACKETS ON:  
09-16 RAM REGULAR CAB PICKUPS



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. ASSEMBLE THE LOAD REACTION STUDS AND HARDWARE AS FOLLOWS.
  - 2.1. ON THE SHORT THREADED END OF THE LOAD REACTION STUD (ITEM #12), INSTALL A 3/8" SERRATED FLANGE NUT (ITEM #11) BACKWARDS TO THE BOTTTOM OF THE THREAD. THEN INSTALL A 3/8" FLAT WASHER (ITEM #10) AND RUBBER "CUSHION" WASHER (ITEM # 19) TIGHT UP AGAINST THE SERRATED FLANGE NUT. (THE END OF THE STUD MUST BE RECESSED IN THE RUBBER WASHER APPROX. 3/16").
  - 2.2. ON THE LONG THREADED END OF THE STUD, INSTALL A 3/8" SERRATED FLANGE NUT (ITEM # 11) BACKWARDS TO NEAR TO THE BOTTTOM OF THE THREADS
3. ATTACH THE LOAD REACTION STUD ASSEMBLIES TO THE MOUNTING BRACKETS AS SHOWN. INSERT THE STUD, FROM WHAT WILL BE THE INBOARD OR FRAME SIDE THRU THE LOWEST HOLE IN THE BENT FLANGE OF THE BRACKET THAT WILL ALLOW THE RUBBER WASHER TO SEAT FIRM AGAINST THE SIDE WALL OF THE FRAME. INSTALL A FLANGE NUT (ITEM #11) ON THE OUTBOARD END OF THE STUD (FINGER TIGHT ONLY).
4. ON THE RIGHT SIDE OF THE VEHICLE, REMOVE THE FACTORY FRONT, AND REAR BODY MOUNT BOLTS (ONE SIDE OF THE VEHICLE AT A TIME), THESE WILL NOT BE REUSED. INSTALL THE MOUNTING BRACKETS PER THE FOLLOWING INSTRUCTIONS:
  - 4.1. USING A M12 – 110MM BOLT (ITEM #7) AND A 2.0" WASHER (ITEM #8) INSTALL THE FRONT MOUNTING BRACKET (ITEM #1, 2) TO THE FRONT BODY MOUNT AS SHOWN (LEAVE THESE FASTENERS FINGER TIGHT).
  - 4.2. ON THE 1500 PICKUPS, IF THERE IS A CAST IRON DAMPENER ON THE REAR BODY MOUNT PLEASE REMOVE (THIS WILL NOT BE REUSED).
  - 4.3. USING A M12 – 110MM BOLT (ITEM #7) AND A 1/2" FLAT WASHER (ITEM #14) INSTALL THE REAR MOUNTING BRACKET (ITEM #3, 4) TO THE REAR BODY MOUNT AS SHOWN (LEAVE THESE FASTENERS FINGER TIGHT).
  - 4.4. ATTACH THE REAR OUTBOARD MOUNTING BRACKET (ITEM #5, 6) TO THE REAR INBOARD MOUNTING BRACKET (ITEM #3, 4) AS SHOWN, USING THREE 3/8-16 X 1.0 SCREW, 3/8" FLAT WASHERS AND 3/8" FLANGE NUTS. (ITEMS #13, 10, 11).

**NOTE: 4.5 IS FOR GRIP STEPS ONLY.**

- 4.5. ATTACH THE SUPPORT BRACE (ITEM #15) TO THE LOWEST HOLE ON THE REAR OUTBOARD MOUNTING BRACKET (ITEM #5, 6). **NOTE: LEAVE SUPPORT BRACKET LOOSE UNTIL THE STEP BOARD IS ATTACHED. ONCE THE STEP BOARD IS ATTACHED HOLD THE SUPPORT BRACKET UP TO THE BOARD, MARK THE HOLE LOCATION THEN DRILL A 3/8" HOLE IN THE STEP BOARD. ATTACH THE SUPPORT BRACKET USING A 3/8-16 X 1.0" SCREW, 3/8" FLAT WASHER, AND A 3/8" FLANGE NUT (ITEMS #13, 10, 11).**



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5. ATTACH THE STEP PLATE PER THE INSTRUCTIONS INCLUDED WITH YOUR STEP PLATE ASSEMBLY.
6. POSITION THE LOAD REACTION STUD ASSY SO THAT THE RUBBER CUSHION IS SNUG UP AGAINST THE SIDE OF THE FRAME. TIGHTEN THE 3/8" FLANGE NUTS ON EITHER SIDE OF THE BRACKET TO 19LB. FT.

### SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	552850	1	BRKT-MTG, SES. FRONT, LH, BODY MOUNT
1	552862	1	BRKT-MTG, GRIP, FRONT, LH, BODY MOUNT
2	552851	1	BRKT-MTG, SES, FRONT, RH, BODY MOUNT
2	552863	1	BRKT-MTG, GRIP, FRONT, RH, BODY MOUNT
3	552854	1	BRKT-MTG, SES, REAR, LH, INBOARD,BODY MOUNT
4	552855	1	BRKT-MTG, SES, REAR, RH, INBOARD, BODY MOUNT
5	552856	1	BRKT-MTG, SES, REAR, LH, OUTBOARD
5	552868	1	BRKT-MTG, GRIP, REAR, LH, OUTBOARD
6	552857	1	BRKT-MTG, SES, REAR, RH, OUTBOARD
6	552869	1	BRKT-MTG, GRIP, REAR, RH, OUTBOARD
7	103444	4	SCREW-HEX HEAD, M12 - 1.75 X 110MM, ZP
8	105909	2	WSHR-FLAT, 2.0 X .509 X .179, ZP
9	102592	4	WSHR, RUBBER, .354 ID X 1.00 OD X .75 THK
10	100062	12	WSHR, FLAT, 3/8", .438 ID X 1.00 OD X .083" THK
11	100181	20	NUT, SERR FLG, HEX, 3/8-16 UNC, ZP
12	104686	4	STUD, -DBL ENDED, STL, 3/8-16 X 4.00", ZP
13	100040	8	SCR-HEX HD, 3/8-16 X 1.0" UNC, ZP
14	100118	2	WASHER, FLAT, 1/2" ZP
15	552876	2	BRKT-SUPPORT, RAM REG CAB



1200 E. Birch St.

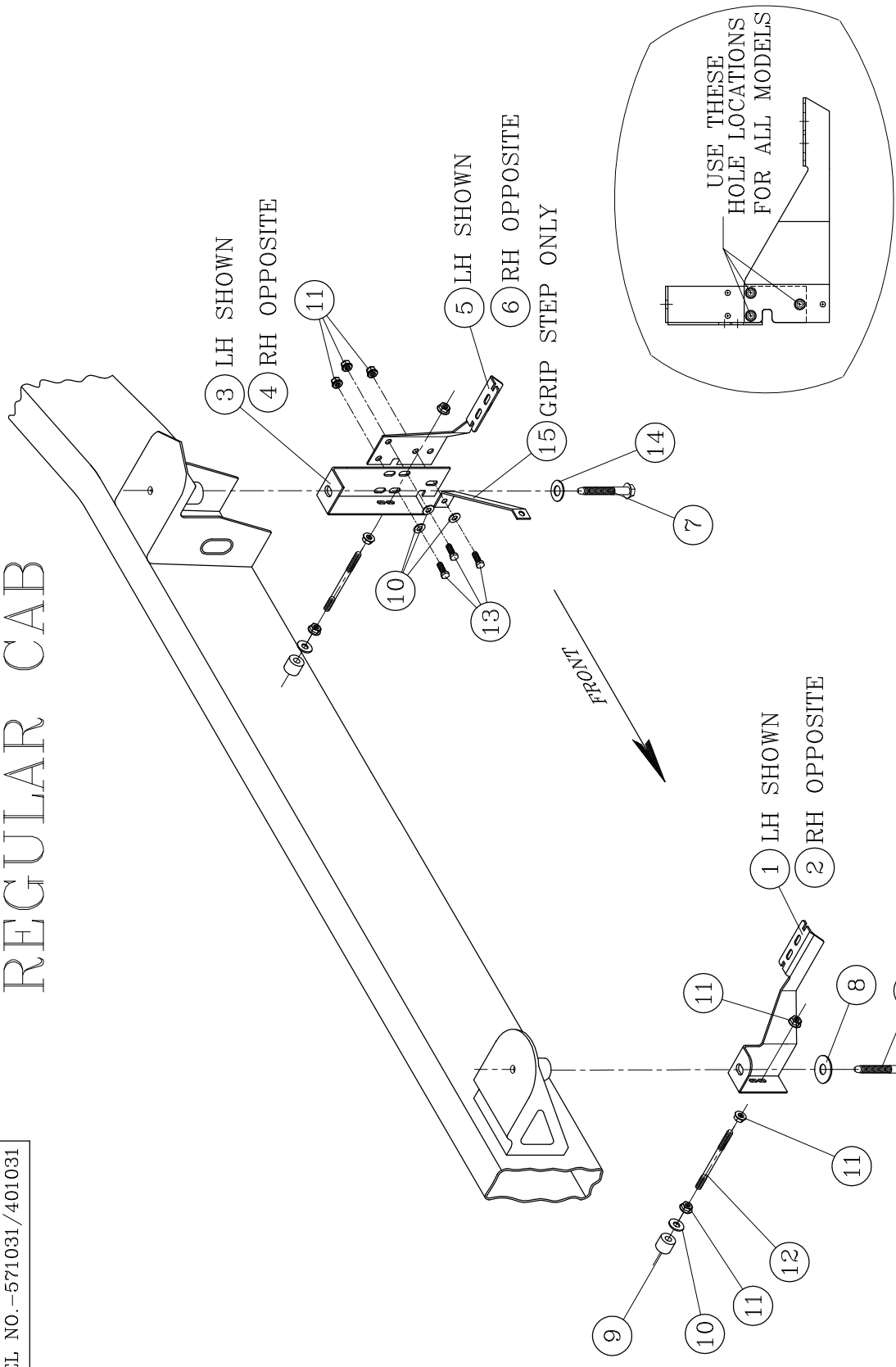
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SERVICE PARTS LIST

MODEL NO. -571031/401031

# FIG. 1 REGULAR CAB



LEFT (DRIVER) SIDE SHOWN

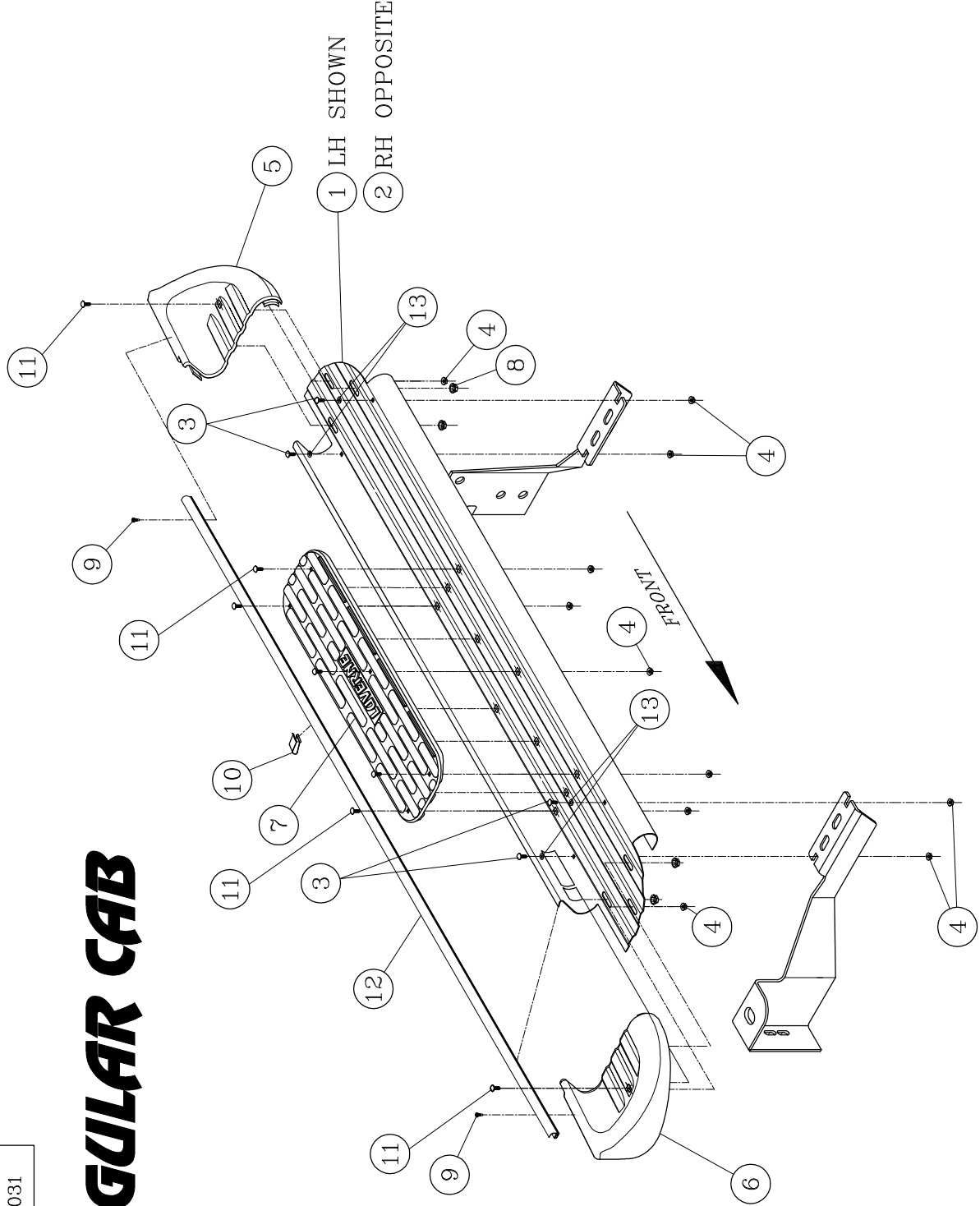
LEFT (DRIVER) SIDE SHOWN  
-RIGHT (PASSENGER) SIDE OPPOSITE-



SERVICE PARTS LIST

MODEL NO. - 481031

# RAM REGULAR CAB



1200 E. Birch St.  
Evansville, IN 47605