

## INSTALLATION INSTRUCTIONS AND PARTS LIST

APPLICATION: MODEL **481032/33/36** (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 SIX (6) 10-24 X .75" CARRIAGE BOLTS (ITEM #3), AND SIX (6) 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
1	552162	1	STEP PLATE-SES, LH, 481033, CREW CAB
2	552161	1	STEP PLATE-SES, RH, 481033, CREW CAB
1	550171	1	STEP PLATE-SES, LH, 481036, MEGA CAB
2	550170	1	STEP PLATE-SES, RH, 481036, MEGA CAB
3	104258	12	BOLT – CARRIAGE – SST, 10-24 X .75"
4	104261	36	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	4	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	4	CLIP-U, .118-.185, BLK
11	107863	24	BOLT – CARRIAGE, 10-24 X .5", BZP
12	104255	2	TRIM – SEAL, EXTRUSION, 80.5", QUAD CAB
12	102502	2	TRIM-SEAL, EXTRUSION, 95", CREW/MEGA CABS
13	104530	12	WASHER-NEOPRENE, .200 X .468 X .03



## INSTALLATION INSTRUCTIONS AND PARTS LIST

APPLICATION: MODEL 571032/401032 SES/GRIP STEP BRACKETS ON:  
09-16 RAM CREW CAB, QUAD CAB, AND MEGA 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.

**NOTE: USE A 4" STUD (ITEM #16) FOR THE FRONT BRACKET AND A 3" STUD (ITEM #15) FOR THE REAR BRACKETS. HEAVY DUTY PICKUPS WITH THE DIESEL ENGINE WILL NOT USE THE CENTER LOAD REACTION STUD.**

- 2.1. ON THE SHORT THREADED END OF THE LOAD REACTION STUD (ITEM #15, 16, 19), INSTALL A 3/8" SERRATED FLANGE NUT (ITEM #14) BACKWARDS TO THE BOTTTOM OF THE THREAD. THEN INSTALL A 3/8" FLAT WASHER (ITEM #13) AND RUBBER "CUSHION" WASHER (ITEM # 12) 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 # 14) 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 #14) ON THE OUTBOARD END OF THE STUD (FINGER TIGHT ONLY).
  4. ON THE RIGHT SIDE OF THE VEHICLE, REMOVE THE FACTORY FRONT, CENTER, 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 #9) AND A 2.0" WASHER (ITEM #11) INSTALL THE FRONT MOUNTING BRACKET (ITEM #1, 2) TO THE FRONT BODY MOUNT AS SHOWN (LEAVE THESE FASTENERS FINGER TIGHT).
    - 4.2. USING A M12 – 110MM BOLT (ITEM #9) AND A 2.0" WASHER (ITEM #11) INSTALL THE CENTER MOUNTING BRACKET (ITEM #3, 4) TO THE CENTER BODY MOUNT AS SHOWN (LEAVE THESE FASTENERS FINGER TIGHT).
    - 4.3. FOR 1500 PICKUPS, IF THERE IS A CAST IRON DAMPENER ON THE REAR BODY MOUNT PLEASE REMOVE (THIS WILL NOT BE REUSED).
    - 4.4. USING A M12 – 110MM BOLT (ITEM #9) (**NOTE: IF INSTALLING ON A HEAVY DUTY PICKUP USE A M12-160MM BOLT (ITEM #10)**) AND A 1/2" FLAT WASHER (ITEM #18) INSTALL THE REAR MOUNTING BRACKET (ITEM #5, 6) TO THE REAR BODY MOUNT AS SHOWN (LEAVE THESE FASTENERS FINGER TIGHT). **NOTE: THE ORIENTATION OF THE REAR BRACKET WILL BE DIFFERENT BETWEEN THE QUAD/CREW CAB PICKUPS AND THE MEGA CAB PICKUPS. IF INSTALLING ON A QUAD/CREW CAB PICKUP REFER TO FIG. 2, IF INSTALLING ON A MEGA CAB PICKUP REFER TO FIG. 3.**
    - 4.5. ATTACH THE REAR OUTBOARD MOUNTING BRACKET (ITEM #7, 8) TO THE REAR INBOARD MOUNTING BRACKET (ITEM #5, 6), USING THREE 3/8-16 X 1.0 SCREW, 3/8" FLAT WASHERS AND 3/8" FLANGE NUTS. (ITEMS #17, 13, 14). **NOTE: IF INSTALLING ON A LIGHT DUTY PICKUP INSTALL IN THE LOWER HOLE LOCATIONS, IF INSTALLING ON A HD PICKUP INSTALL IN THE UPPER HOLE LOCATIONS. (FIG. 1)**



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552859 SHEET 1 OF 5 20APR15

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	552852	1	BRKT-MTG, SES, CENTER, LH, BODY MOUNT
3	552864	1	BRKT-MTG, GRIP CENTER, LH, BODY MOUNT
4	552853	1	BRKT-MTG, SES, CENTER, RH, BODY MOUNT
4	552865	1	BRKT-MTG, GRIP, CENTER, RH, BODY MOUNT
5	552854	1	BRKT-MTG, REAR, LH, INBOARD, BODY MOUNT
6	552855	1	BRKT-MTG, REAR, RH, INBOARD, BODY MOUNT
7	552856	1	BRKT-MTG, SES, REAR, LH, OUTBOARD
7	552868	1	BRKT-MTG, GRIP, REAR, LH, OUTBOARD
8	552857	1	BRKT-MTG, SES, REAR, RH, OUTBOARD
8	552869	1	BRKT-MTG, GRIP, REAR, RH, OUTBOARD
9	103444	6	SCREW-HEX HEAD, M12 - 1.75 X 110MM, ZP
10	109451	2	SCREW-HEX HEAD, M12 - 1.75 X 160MM, BZP
11	105909	4	WSHR-FLAT, 2.0 X .509 X .179, ZP
12	102592	6	WSHR, RUBBER, .354 ID X 1.00 OD X .75 THK
13	100062	12	WSHR, FLAT, 3/8", .438 ID X 1.00 OD X .083" THK
14	100181	24	NUT, SERR FLG, HEX, 3/8-16 UNC, ZP
15	104697	4	STUD, STL, 3/8-16 X 3.00", ZP
16	104686	2	STUD, -DBL ENDED, STL, 3/8-16 X 4.00", ZP
17	100040	6	SCR-HEX HD, 3/8-16 X 1.0" UNC, ZP
18	100118	2	WASHER, FLAT, 1/2" ZP



1200 E. Birch St.

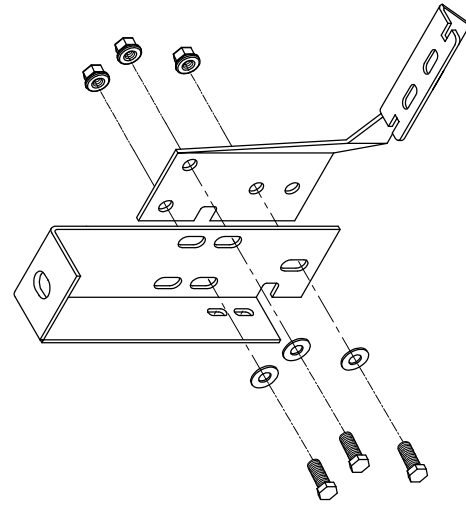
Brandon, SD 57005

# FIG. 1 REAR BRACKET ASSEMBLIES

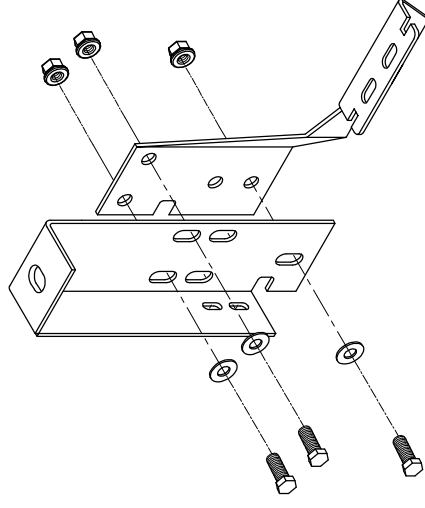
SERVICE PARTS LIST

MODEL NO. -571032/401032

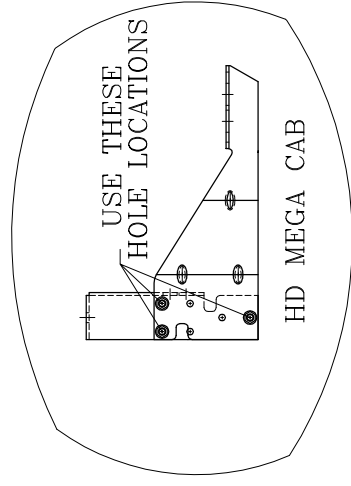
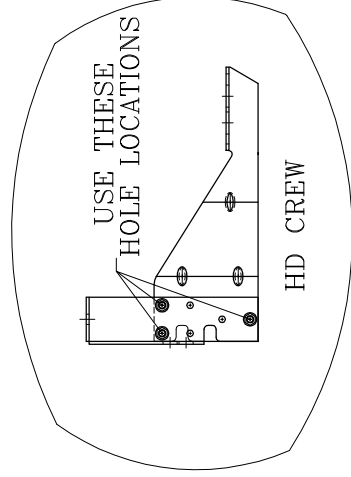
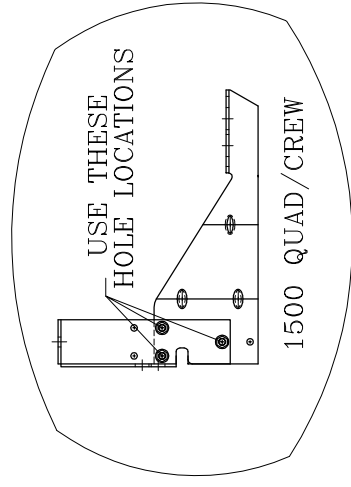
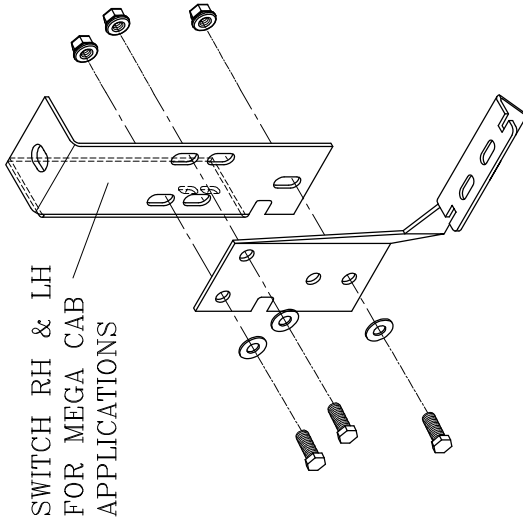
1500 QUAD/CREW CABS



HD CREW CABS



HD MEGA CABS

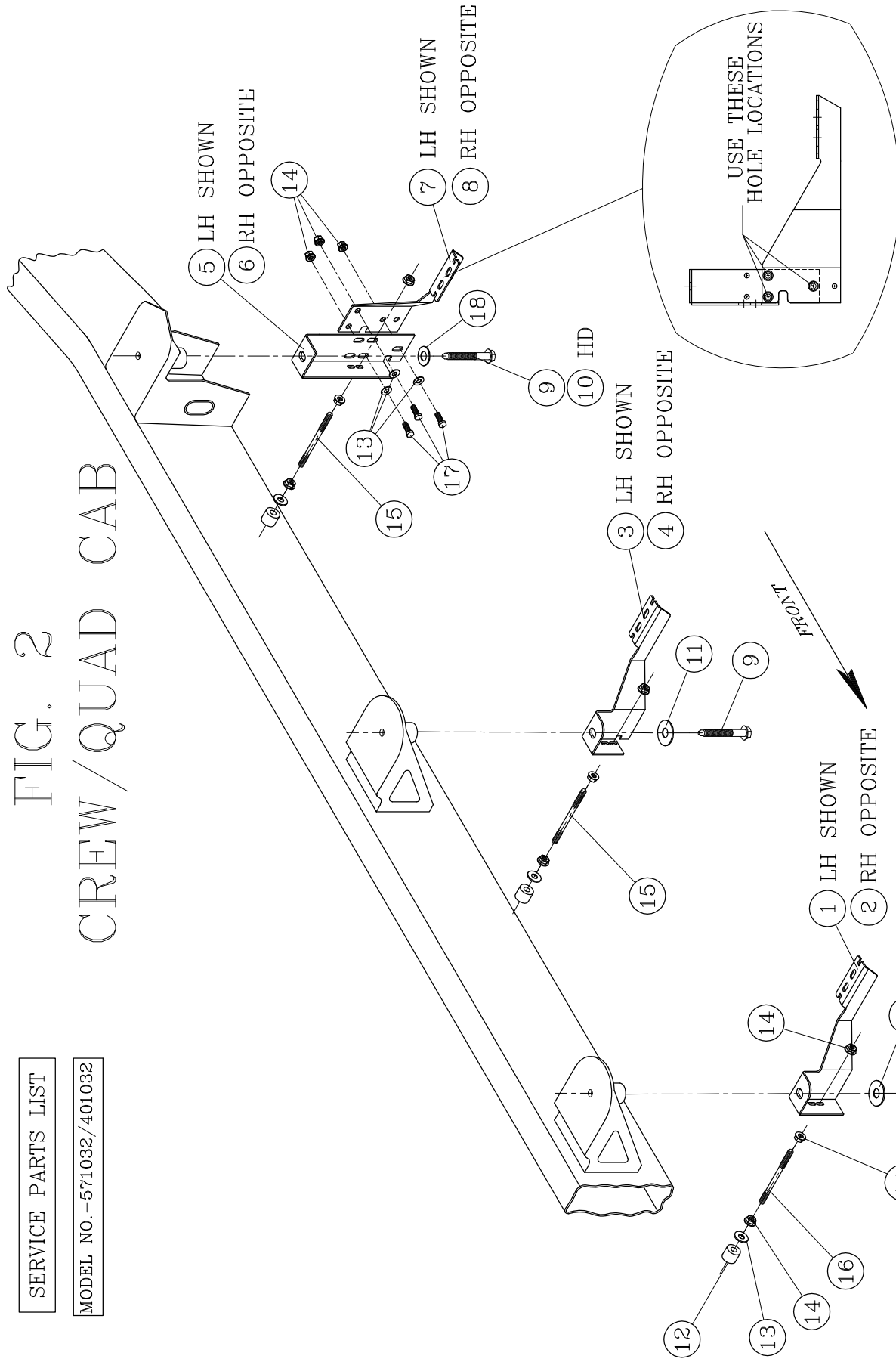


LEFT (DRIVER) SIDE SHOWN  
-RIGHT (PASSENGER) SIDE OPPOSITE-

# FIG. 2 CREW / QUAD CAB

SERVICE PARTS LIST

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LEFT (DRIVER) SIDE SHOWN

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

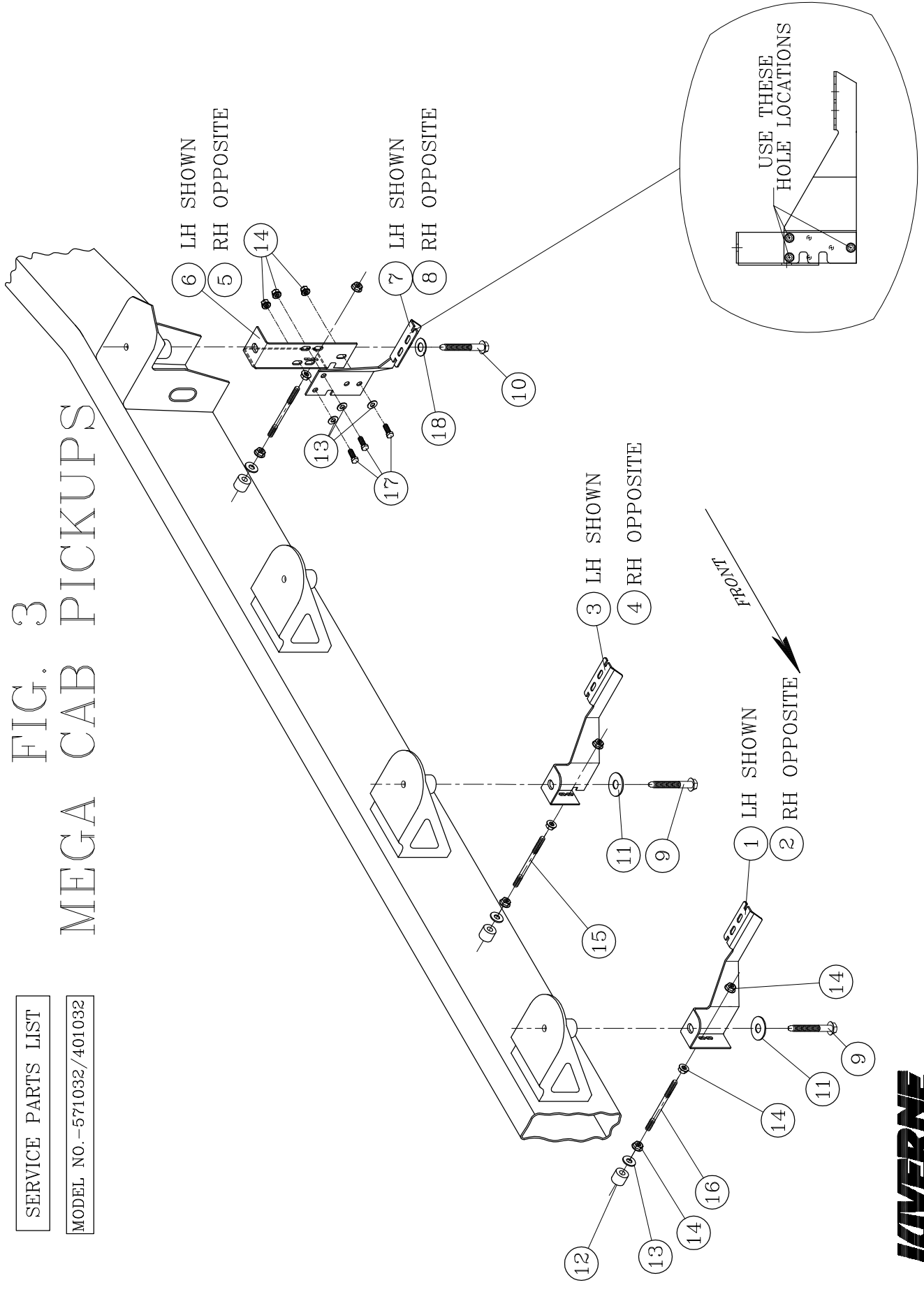
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# FIG. 3 MEGA CAB PICKUPS



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



SERVICE PARTS LIST

- MODEL NO. - 481032  
 - 481033  
 - 481036

