

Step Bar Installation Instructions: Part Numbers 37-6320 and 37-6350, 204035

1967-72 Chevrolet and GMC 2 Wheel Drive 1/2Ton Pickups

Content List: (Qty)

(1) LH step Bar – long end of bar to rear of vehicle	(4) 3/8 x 1-1/4" hex head bolts
(1) RH step Bar – long end of bar to rear of vehicle	(4) 3/8" hex nuts
(1) LH front step bar mounting bracket	(8) 3/8" flat washers
(1) LH front support bracket	(4) 3/8" lock washers
(1) RH front step bar mounting bracket	(2) 7/16 x 5-1/2" hex head bolts
(1) RH front support bracket	(4) 7/16" flat washers
(2) Rear step bar mounting brackets	(2) Rear support brackets
(4) 3/16" thick spacer washers	(2) 9/16 x 6" hex head bolt
(2) 9/16" torque lock nuts	(4) 9/16" flat washers
(4) 12mm x 1.75 x 50mm hex head bolts	(4) 1/2mm lock washers
(8) 12mm flat washers	

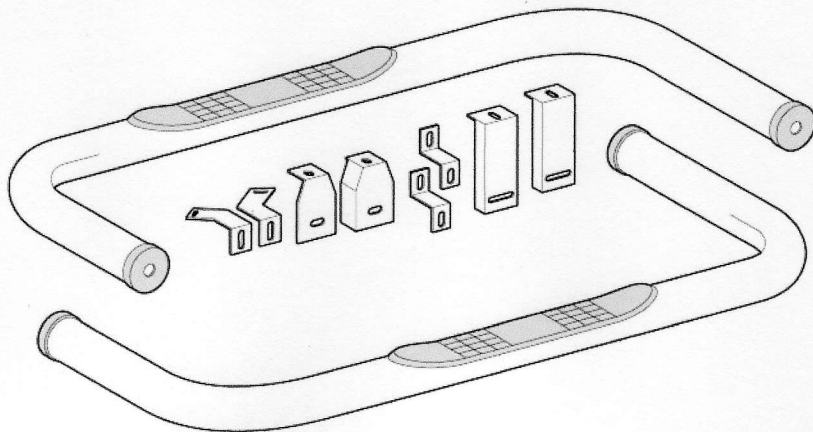
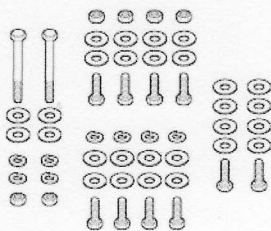
Instructions:

1. Read instructions completely before proceeding with installation.
2. To help identify the LH and RH step bar, notice the difference in length of the step bar mounting legs. When installed, the long leg is positioned to the rear of the vehicle.
3. Remove the nut from the front cab mount bolt. Depending on its condition, you may be able to reuse your existing bolt. To remove the front cab bolt you will need to access the interior side of the cab floor and then install the 9/16 x 6" bolt with flat washer. Install the front step bar mounting bracket to the front cab mount bolt. Install flat washer and lock nut and hand tighten.
4. Remove rear cab mount bolt. Install rear step bar mounting bracket. Note the order of assembly - flat washer, bracket, flat washer and 7/16 x 5-1/2" bolt. Install rear cab mount bolt and hand tighten.
5. Install step bar to front and rear brackets using the 12mm x 1.75 x 50mm bolts, lock washers and flat washers. With the bar bolted to front and rear brackets, check for proper clearance between step bar and rocker panel. If additional clearance is necessary, use the 3/16" spacer washers, as required, between the flat washer on the bottom side of cab bushings and step bar mounting brackets.
6. With proper clearance established, the front support bracket can be installed. The end of the front support bracket with the 90° bend mounts to the step bar mounting bracket and is held in place with the 1/2 x 2" step bar mounting bolt. Remove the step bar mounting bolt. Position the step bar support bracket so the

flat horizontal surface of the support contacts the underside of the frame rail. Reinstall step bar mounting bolt and hand tighten. With the support bracket positioned correctly, the hole in the bracket will line up with an existing hole in the frame rail. Install a 3/8 x 1-1/4" bolt and corresponding lock washer, flat washer and hex nut. Hand tighten.

7. The rear support bracket will require drilling one 3/8" mounting hole per side in the face of the frame rail. It will be bolted to the frame using the 3/8 x 1-1/4" bolt and is secured to the step bar mounting bracket with the step bar mounting bolt. Remove step bar mounting bolt and position rear support bracket between the step bar mounting bracket and frame of vehicle. Install step bar mounting bolt and hand tighten. Mark location on frame for mounting hole to be drilled. To allow room for drilling operation, remove step bar mounting bolt, rear support bracket and the step bar mounting bracket. With hole drilled, reinstall the step bar mounting bracket, rear support bracket and step bar mounting bolt. Secure the rear support bracket to frame with 3/8 x 1-1/4" bolt and corresponding lock washer, flat washer and lock nut.
8. Check alignment of step bar. Make any final adjustments and then tighten all bolts.
9. Repeat procedure for the opposite side.
10. Check fasteners periodically. Re-tighten as necessary.

Contents



Assembly

