



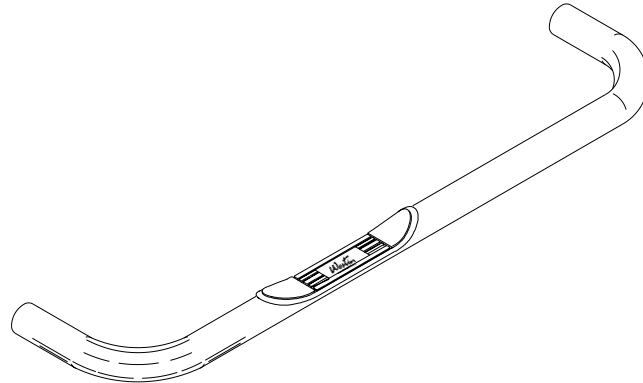
INSTALLATION INSTRUCTIONS

APPLICATION: 1980-96 F-SERIES SUPERCAB
 1980-96 F-SERIES REGULAR CAB
 1980-96 FULL SIZE BRONCO

AUTOMOTIVE PRODUCTS, INC.

STEP BAR ASSEMBLIES

- 25-0530
- 25-0535
- 25-0620
- 25-0625
- 25-1580



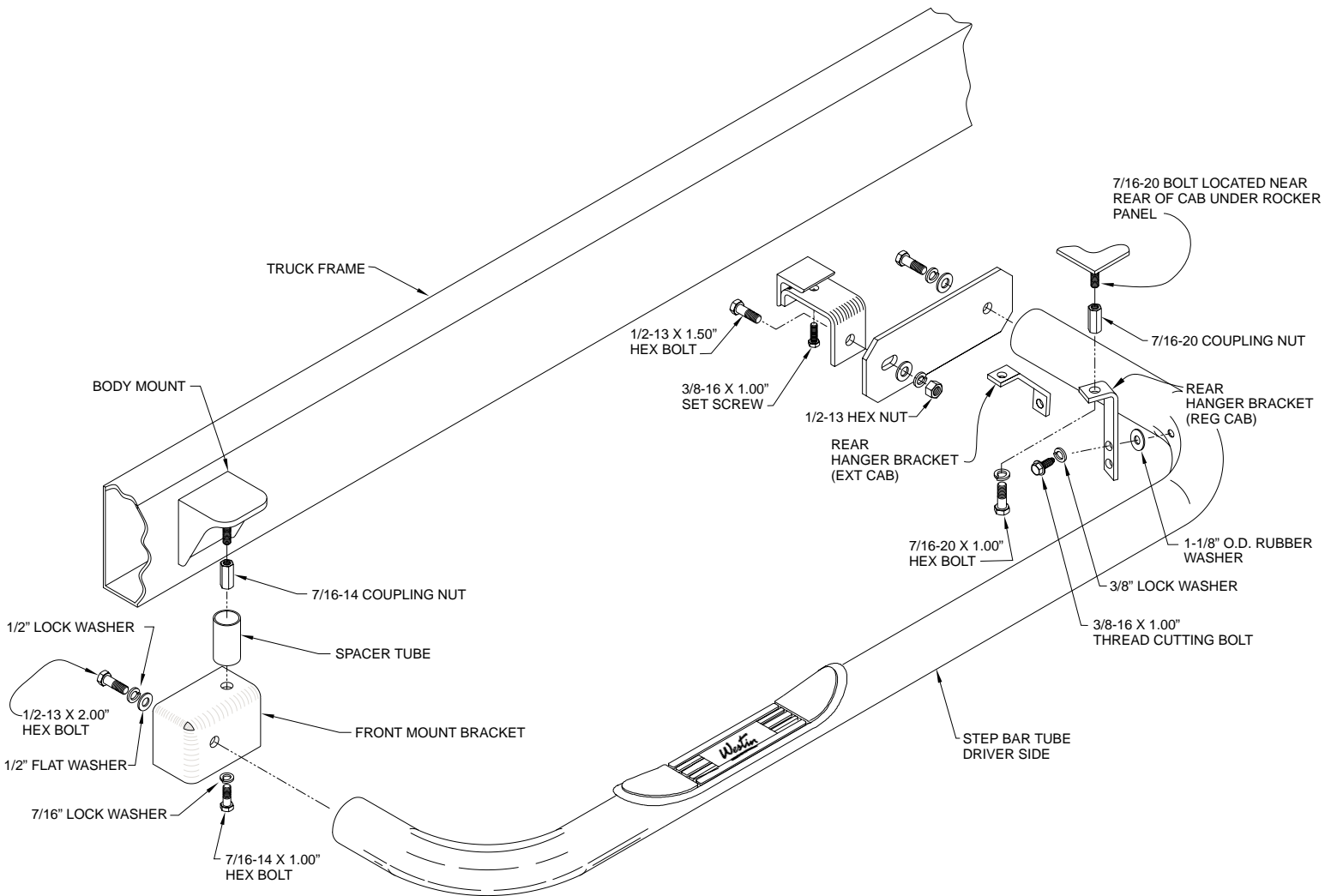
QTY	PARTS KIT CONTENTS DESCRIPTION	TOOLS REQUIRED
1	STEP BAR with PLASTIC STEP PAD - DRIVER SIDE	11/16" SOCKET
1	STEP BAR with PLASTIC STEP PAD - PASSENGER SIDE	11/16" WRENCH
1	DRIVER FRONT MOUNT BRACKET	3/4" SOCKET
1	PASSENGER FRONT MOUNT BRACKET	3/4" WRENCH
2	REAR MOUNT BRACKET	ADJUSTABLE WRENCH
2	REAR SWING BRACKET	RATCHET
2	REAR HANGER	TORQUE WRENCH
2	SPACER TUBE	
2	7/16-14 X 1.75" COUPLING NUTS	
2	7/16-20 X 1.75" COUPLING NUTS	
2	7/16-14 X 1.00" HEX HEAD BOLTS, GRADE 5	
2	7/16-20 X 1.00" HEX HEAD BOLTS, GRADE 5	
4	7/16" SPLIT LOCK WASHER	
2	3/8" SPLIT LOCK WASHER	
2	1/2-13 X 1.50" HEX HEAD BOLT, GRADE 5	
2	1/2-13 HEX NUT	
4	1/2-13 X 2.00" HEX HEAD BOLT	
6	1/2" FLAT WASHER	
6	1/2" SPLIT LOCK WASHER	
2	3/8-16 X 1.00" SQUARE HEAD, CUP POINT, SET SCREW	

- STEP 1. REMOVE THE CONTENTS FROM THE BOX AND CHECK FOR ANY DAMAGE. VERIFY ALL PARTS AGAINST PARTS LIST.
- STEP 2. READ AND UNDERSTAND INSTRUCTIONS COMPLETELY BEFORE BEGINNING INSTALLATION.
- STEP 3. SCREW 7/16-14 COUPLING NUT ONTO FRONT BODY MOUNT AND TORQUE TO 40 FT. LBS. MOUNT BRACKET TO BODY MOUNT AS SHOWN BELOW (DO NOT TIGHTEN AT THIS TIME). BOLT THE SHORT END OF STEP BAR TO FRONT MOUNT.

STEP 4. HOOK REAR MOUNT ONTO BOTTOM FLANGE OF TRUCK FRAME AND BOLT SWING BRACKET TO REAR MOUNT AS SHOWN. DO NOT TIGHTEN. BOLT REAR LEG OF TUBE TO SWING BRACKET AS SHOWN. ADJUST TUBE AND BRACKETS UNTIL THE REAR LEG OF TUBE IS LEVEL WITH THE FRONT END OF STEP BAR. TIGHTEN SWING BRACKET TO REAR MOUNT AND SECURE REAR MOUNT TO FRAME WITH THE 3/8" SET SCREW. TORQUE SET SCREW TO 60 INCH LBS.

STEP 5. SCREW 7/16-20 COUPLING NUT ONTO BOLT ABOVE THE HOLE IN STEP BAR TUBE. TORQUE TO 40 FT. LBS. BOLT HANGER BRACKET TO COUPLING NUT AS SHOWN IN THE POSITION TO LINE UP WITH THE HOLE IN TUBE. SIGHT LEVEL TUBE AND BOLT HANGER BRACKET TO TUBE USING ONE OF THE TWO HOLES IN HANGER BRACKET AND PLACING A 1-1/8" OD. RUBBER WASHER BETWEEN HANGER BRACKET AND STEP BAR TUBE. TORQUE THREAD CUTTING BOLT TO 20 FT. LBS.

NOTE: TORQUE ALL 7/16" BOLTS TO 40 FT. LBS & TORQUE ALL 1/2" BOLTS TO 65 FT. LBS.



ASSEMBLY AND INSTALLATION VIEW OF DRIVER SIDE - PASSENGER SIDE OPPOSITE

Finish protection - Westin products have a high quality finish that must be cared for like any other exposed finish on the vehicle. Protect the finish with a non-abrasive automotive wax (pure carnauba, for example) on a regular basis. The use of cleaner wax or any compound which contains an abrasive is detrimental, as the compound scratches the finish and opens it to corrosion.



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Thank You for choosing Westin products
 For additional installation assistance please call
 Customer service (800) 793-7846 or (507) 375-3559