

INSTALLATION INSTRUCTIONS AND PARTS LIST

STAINLESS STEEL BAJA STEPS:

431431 2009 AND NEWER DODGE RAM REG CAB
431432 2009 AND NEWER DODGE RAM QUAD CAB
431433 2009 AND NEWER DODGE RAM CREW CAB
491432 2009 AND NEWER DODGE RAM QUAD CAB, SST
491433 2009 AND NEWER DODGE RAM CREW CAB, SST



NO DRILL INSTALLATION

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 BAJA STEPS AND BRACKETS.
 - 2.1. PLACE BAJA STEPS ON A FLAT SURFACE AND ATTACH THE MOUNTING BRACKETS (ITEM #3, & 4) AS SHOWN IN FIG 1, & 2. **NOTE: THE LUVERNE SERIAL NUMBER DECAL GOES ON THE FRONT LEFT HAND (DRIVERS) SIDE.**
 - 2.2. LEAVE 1/2" BOLTS (ITEM #5) FINGER TIGHT UNTIL STEPS ARE MOUNTED ON THE VEHICLE, THEN THE 1/2" BOLTS MUST BE TORQUED TO 65 LB FT.
3. ASSEMBLE THE DOUBLE ENDED STUD & FASTENERS TO THE FRONT & REAR BRACES AS FOLLOWS,
 - 3.1. INSTALL 3/8" SERRATED FLANGE NUTS (ITEM #11) **BACKWARDS**, TO THE END OF THE THREAD, ON EACH END OF THE DOUBLE ENDED STUD (ITEM #9).
 - 3.2. ON THE SHORT THREADED END OF THE STUD, INSTALL A 3/8" FLAT WASHER (ITEM #12). THEN, PUSH THE 3/4" THICK RUBBER WASHER (ITEM #10) & FLAT WASHER TIGHT UP AGAINST THE SERRATED FLANGE NUT. (THE END OF THE DOUBLE ENDED STUD SHOULD BE RECESSED BACK IN THE HOLE OF THE RUBBER WASHER APPROXIMATELY 3/16").
 - 3.3. INSTALL THE LONG THREADED END OF THE STUD ASSEMBLY THRU THE HOLE IN THE MOUNTING BRACKET (JUST ABOVE THE NERF BAR TUBE) AND INSTALL A 3/8" SERRATED FLANGE NUT AS SHOWN. (FINGER TIGHT ONLY).
4. REMOVE THE FOUR (4) APPLICABLE M12-1.75 BODY MOUNT BOLTS FROM THE VEHICLE. **(THE FRONT BOLTS AND WASHERS ARE NOT REUSED).**
5. POSITION THE BAJA STEP ASSEMBLY UP UNDER THE BODY MOUNT METAL BUSHING:
 - 5.1. ON THE FRONT BODY MOUNTS, INSTALL M12-1.75 X 110mm (APPROX. 4-3/8" LONG) HEX HEAD BOLTS (ITEM #6), 1/2" LOCK WASHERS (ITEM #7) AND 1/2" FLAT WASHERS (ITEM #8) UP THRU THE HOLE IN THE BAJA STEP MOUNTING BRACKET AND THE BODY MOUNTING BUSHING AS SHOWN.
 - 5.2. **2013-** ON THE REAR BODY MOUNT IF THERE IS CAST IRON DAMPENER PLEASE REMOVE (THIS IS NOT REUSED). PLACE FACTORY BODY MOUNT BOLT AND WASHER THROUGH BAJA-STEP BRACKET AND THE BODY MOUNT BUSHING AS SHOWN IN **FIG.1**.
 - 5.3. **2009 TO 2012-** ON THE REAR BODY MOUNT INSTALL THE FACTORY BOLT AND WASHER THRU THE HOLE IN THE BAJA STEP MOUNTING BRACKET AND BODY MOUNT BUSHING AS SHOWN IN **FIG. 2**.
 - 5.4. TORQUE ALL M12-1.75 BODY MOUNTING BOLTS TO 45 LB. FT.
 - 5.5. POSITION THE STUD ASSEMBLIES SO THAT THE RUBBER WASHER IS SNUG UP AGAINST THE FRAME. TIGHTEN THE 3/8" SERRATED FLANGE NUTS ON EITHER SIDE OF THE REAR BRACKET TO LOCK THE STUD ASSEMBLY IN POSITION.

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SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	552221	1	BAJA STEP WLDMNT-LH,BLK
2	552222	1	BAJA STEP WLDMNT-RH,BLK
1	552191	1	BAJA STEP WLDMNT – LH, BLK
2	552192	1	BAJA STEP WLDMNT – RH, BLK
1	552236	1	BAJA STEP WLDMNT – LH, SST
2	552237	1	BAJA STEP WLDMNT – RH, SST
1	552193	2	BAJA STEP WLDMNT - LH/RH, BLK
1	552187	2	BAJA STEP WLDMNT - LH/RH, SST
3	551468	2	MOUNTING BRACKET FRONT, LH/RH
4	552280	2	MOUNTING BRACKET REAR, LH/RH
5	104249	4	SCREW-HEX HEAD, SER FLNG,1/2-13 X 2.0, ZP
6	103444	2	BOLT-HEX HD CAP,M12-1.75 X 110mm(4-3/8”),ZP
7	100121	2	WASHER-LOCK,1/2”,ZP
8	100118	2	WASHER-FLAT,1/2”,ZP
9	108448	4	STUD-DOUBLE ENDED,STL,3/8-16 UNC X 6.00”,ZP
10	102592	4	WASHER-RUBBER,.354 ID X 1.00 OD X .75 THK
11	100181	12	NUT-SERRATED FLANGE,HEX,3/8-16 UNC,ZP
12	100062	4	WASHER-FLAT,3/8”,ZP



(A LUVERNE Company)

1200 E. Birch St.

Brandon, SD 57005

REV B 21OCT13

REV A 09JAN13

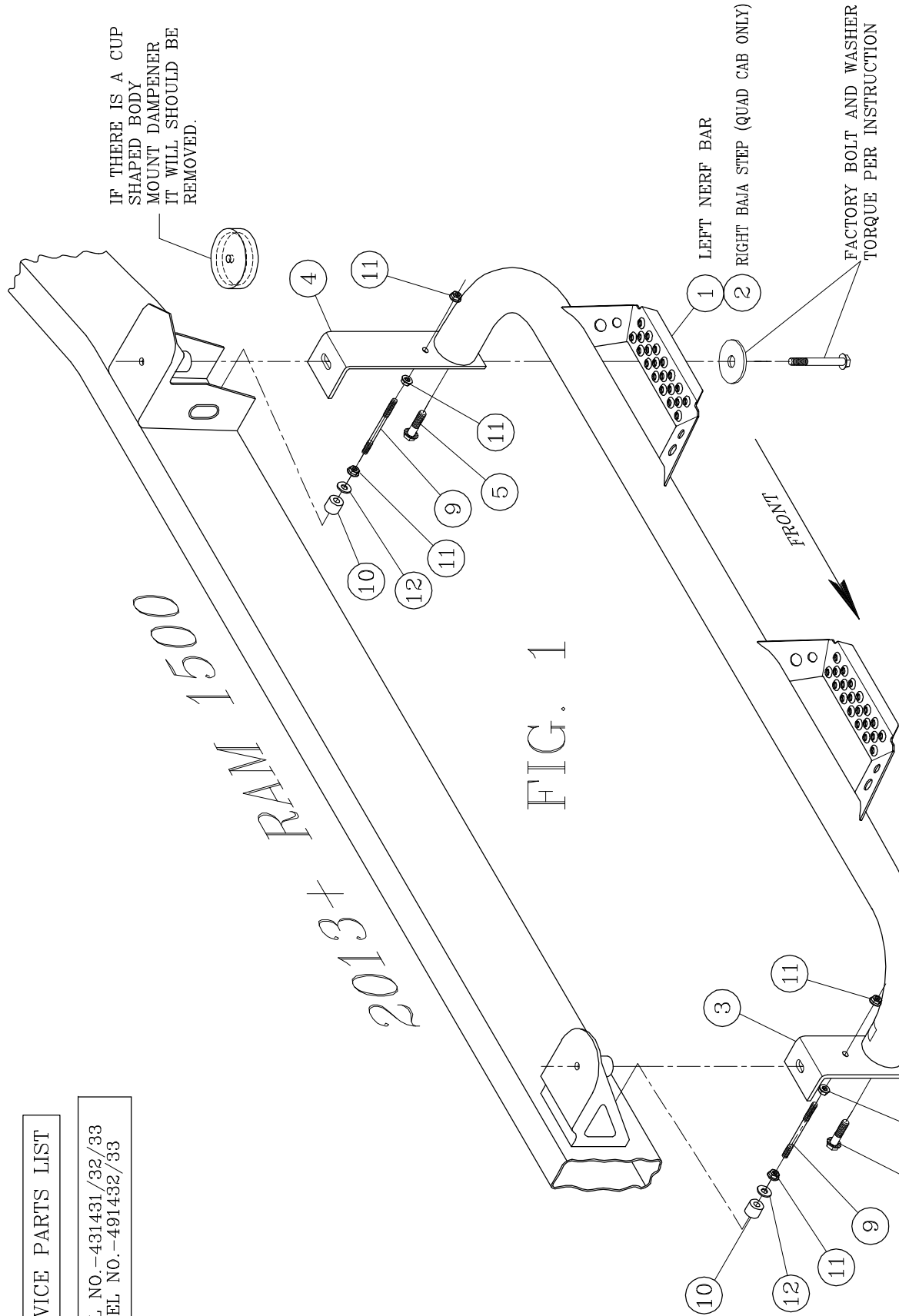
552195 SHEET 2 OF 4 31DEC12

SERVICE PARTS LIST

MODEL NO.-431431/32/33
MODEL NO.-491432/33

2013+ RAM 1500

FIG. 1



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

LUVERNE
TRUCK EQUIPMENT
(A LUVERNE COMPANY)

12800 E. Birch St
Denver, CO 80231

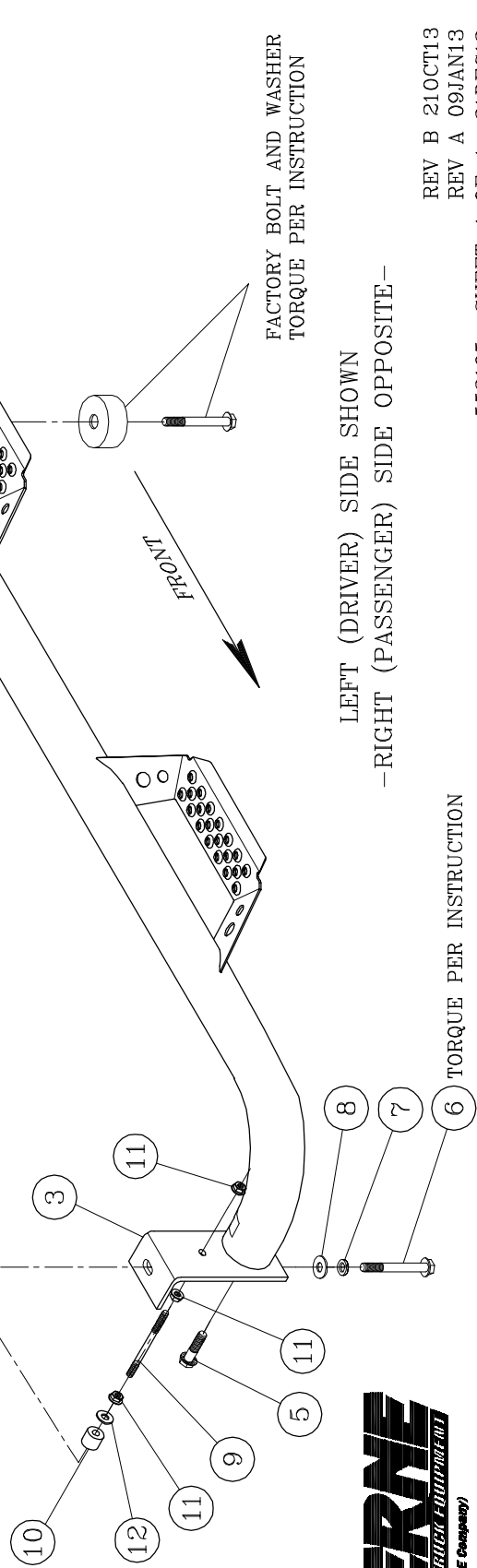
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552195 SHEET 3 OF 4 31DEC12

SERVICE PARTS LIST

MODEL NO.-431431/32/33
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2009-2012 RAM 1500

FIG. 2



LUVERNE
TRUCK EQUIPMENT
(A LUVERNE COMPANY)

12800 E. Birch St
Denver, CO 80231

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