

**INSTALLATION INSTRUCTIONS AND PARTS LIST  
FOR MOUNTING 480824 SIDE ENTRY STEP BOX EXTENSIONS  
1999-2007 FORD SUPER DUTY LONG BOX DUALY PICKUPS  
2008 AND NEWER FORD SUPER DUTY LONG BOX DUALY 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. PREPARE EACH SIDE OF THE VEHICLE FOR SIDE ENTRY STEP INSTALLATION:
  - 2.1 INSTALL THE MUD SHIELD (ITEM #29) ON THE TOP SURFACE OF THE BOX ROCKER PANEL. LOOSEN THE THREE EXISTING SCREWS THAT RETAIN THE BOTTOM OF THE FENDER FLARE AND SLIDE THE MUD SHIELD UNDER THE FLANGE NUTS.
  - 2.2 AT THE FRONT, INSTALL A TEK SCREW (ITEM #30) THRU THE BOX ROCKER PANEL AND MUD SHIELD.
3. ASSEMBLE THE STEP PLATES AND BRACE WELDMENTS AS FOLLOWS:
  - 3.1. LOOSEN THE FASTENERS AND ROTATE THE TUBES (ITEM #14) TO THE UP POSITION. INSTALL THE 5/16 X 1.0 CARRIAGE BOLTS (ITEM #17), AND SERRATED FLANGE NUTS (ITEM #18) IN THE TAB MOUNTING HOLES OF THESE BRACES. (LEAVE THE FASTENERS FINGER TIGHT ONLY AT THIS TIME).
  - 3.2. ATTACH THE REMAINING BRACES FROM THE ACCESSORY PACKAGE (ITEM #13, 15 &16) USING THE 5/16 X 1.0 CARRIAGE BOLTS (ITEM #17), AND SERRATED FLANGE NUTS. NOTE THAT BRACES #13 & 16 WILL USE THE SAME MOUNTING TAB, AND THAT #16 WILL ONLY USE THE UPPER HOLE.
  - 3.3. APPLY THE MUD GUARD TRIM (ITEM #25) TO THE OUTBOARD EDGE OF THE MUD GUARD (ITEM #24) AND TRIM OFF THE EXCESS. ATTACH THE MUD GUARD TO THE MOUNTING BRACE (ITEM #31) ON THE REAR OF THE STEP PLATE USING 10-24 X 3/4" CARRIAGE BOLTS AND SERRATED FLANGE NUTS (ITEM #9 &10). NOTE THAT THE MAXIMUM TORQUE ON THESE FASTENERS IS 4 LB. FT.
  - 3.4. POSITION THE STEP PLATE ASSEMBLY ON TOP OF THE BRACE WELDMENT AS SHOWN AND INSTALL #10-24 X 3/4" CARRIAGE BOLTS AND NEOPRENE WASHERS (ITEM #8&9) DOWN THRU THE STEP PLATE AND THE MOUNTING PATTERN ON THE BRACE WELDMENT AND TIGHTEN WITH #10-24 SERRATED FLANGE NUTS (ITEM #10). NOTE THAT THE MAXIMUM TORQUE ON THESE FASTENERS IS 4 LB. FT.
4. INSTALL THE SIDE ENTRY STEP ASSEMBLY AS FOLLOWS.
  - 4.1. POSITION AND CLAMP THE STEP PLATE/BRACE WELDMENT ASSEMBLY UP UNDER THE BOX ROCKER PANEL AS SHOWN. THE STEP MUST BE CENTERED FORE AND AFT ON THE BOTTOM OF THE ROCKER PANEL



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- 4.2. INSERT THE 3/8" MULTI THREAD U-NUTS (ITEM #22) INTO THE RETAINER PLATES (ITEM #21 &23) AS SHOWN. (THE THREADS OF THE INSERT MUST BE IN THE UP POSITION OF THE RETAINER PLATE. INSERT THE FLAT RETAINER ASSEMBLY INTO THE END OF THE FRONT BOX STIFFENER. INSTALL THE FORMED RETAINER ASSEMBLY INTO THE REAR BOX STIFFENER. INSTALL A 3/8"X 1.25" HEX HEAD CAP SCREW WITH FLAT WASHER (ITEM #19&20) THRU THE INBOARD FRONT AND REAR BRACES (ITEM #15 &16), AND INTO THE THREADED INSERTS.HAND TIGHTEN ONLY. REPEAT THIS PROCESS FOR THE OUTBOARD FRONT AND REAR BRACES (ITEM #13 &14).
- 4.3. **NOTE: ON THE 2011 DIESEL PASSENGER REAR OUTBOARD RETAINER HOLE WILL NEED TO HAVE A 1/2" HOLE DRILLED INTO THE OUTBOARD BOX STIFFENER.**
- 4.4. **ON THE DRIVERS SIDE REMOVE THE PLASTIC UREA HOSE HANGER BRACKET AND TRIM OFF A 1/2" OF THE BOTTOM. INSTALL RETAINER ASSEMBLY AND REPLACE UREA HANGER BRACKET, THIS WILL ALLOW RETAINER BRACKET TO BE USED WITH HANGER BRACKET. SEE FIG 2**
- 4.5. INSURE THAT THE STEP IS LEVEL AND PROPERLY LOCATED BY SLIDING THE STEP PLATE/BRACE ASSEMBLY IN OR OUT AND FORE AND AFT ON THE OBROUND HOLES OF THE BRACES. TIGHTEN ALL THE FASTENERS.
- 4.6. DRILL TWO 9/32" HOLES THRU THE CENTER OF THE STEEL WHEEL WELL FLANGE. THE WHEEL WELL LINER, AND THE MUD GUARD. THE TOP HOLE SHOULD BE APPROX. 3/4" DOWN FROM THE TOP OF THE MUD GUARD AND THE BOTTOM HOLE AS LOW ON THE STEEL WHEEL WELL FLANGE AS IS PRACTICAL. THIS SHOULD BE DRILLED FROM UNDER THE BOX AND BETWEEN THE FRAME AND THE ROCKER PANEL. BLOCKING THE MUD GUARD AGAINST THE TIRE MAY BE HELPFUL. FASTEN WITH TWO 1/4-20 X 1.0" HEX HEAD CAP SCREWS, 1/4" FLAT WASHER, AND 1/4-20 SERRATED FLANGE NUT. (ITEM #26,27,&28) AS SHOWN.

**FIG 2**



**LUPERNE**  
TRUCK EQUIPMENT

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## SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	549290	1	STEP PLATE-SES,RH,FORD S.D.,LONG BOX DUALLY
2	549292	1	STEP PLATE-SES, LH,FORD S.D.,LONG BOX DUALLY
3	104250	2	END CAP-RH FRONT/LH REAR
4	104251	2	END CAP-LH FRONT/RH REAR
5	105500	2	PAD,SES,SPCL,5.50 X 20.00
6	104255	1	TRIM-SEAL,SES,EXTRUDED
7	104257	12	NUT-HEX,SGL SELF THD,CAP WASHER,1/4"
8	104530	16	WASHER-FLAT,NEOPRENE,.200SQ X .406 DIA
9	104258	22	BOLT-CARRIAGE,SST,#10-24 X 3/4"LG
10	104261	22	NUT-SERRATED FLANGE,HEX,SST,#10-24
11	551335	1	BRACE WLDMT-TUBE,STEP MTG,RH,LB DUAL,EXT
12	551334	1	BRACE WLDMT-TUBE,STEP MTG,LH,LB DUAL,EXT
13	549338	2	BRACE-TUBE CENTER, RH/LH,OUTBOARD
14	551317	2	BRACE-TUBE,FRT,RH/LH,OUTBOARD
15	551318	2	BRACE-TUBE,FRT,RH/LH,BENT,INBOARD
16	551329	2	BRACE-TUBE CENTER, RH/LH,INBOARD
17	100021	12	BLT-CRG,5/16-18 UNC X 1.00,STL,ZP
18	100178	12	NUT-SERR FLG,HEX,STL,5/16-18 UNC,ZP
19	100047	8	SCR-CAP,HEX HD,3/8-16 UNC X 1.25",ZP
20	100062	8	WSHR-PL,A,STL,3/8,.438 X 1.00 X .083,ZP
21	551316	2	PLATE-U-NUT RETAINER
22	104282	8	NUT-U,MULTI THD,STL,3/8-16 UNC,BLK
23	551328	2	PLATE-U-NUT RETAINER,FORMED
24	549374	2	MUD GUARD-SST,RH/LH,SD,DUALLY, EXT
25	547319	2	TRIM GUARD,14.00" LONG
26	101381	4	SCREW-HEX HEAD,SST,1/4-20 X 1.00"
27	101369	4	WASHER FLAT,SST,1/4"
28	100012	4	NUT-SERR FLANGE,HEX,1/4-20,ZP
29	549372	2	SHIELD,MUD, BLACK
30	103435	2	SCREW-TEK, SEMS, #8 X 1.00"
31	549373	2	BRACE-SUPPORT,REAR,RH/LH,SD DUALLY, EXT.



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SERVICE PARTS LIST

MODEL NO. - 480824

2011 DIESELS DRILL 1/2" HOLE  
PASSENGER SIDE ONLY

CENTER BOX  
STIFFENER

FRONT BOX  
STIFFENER

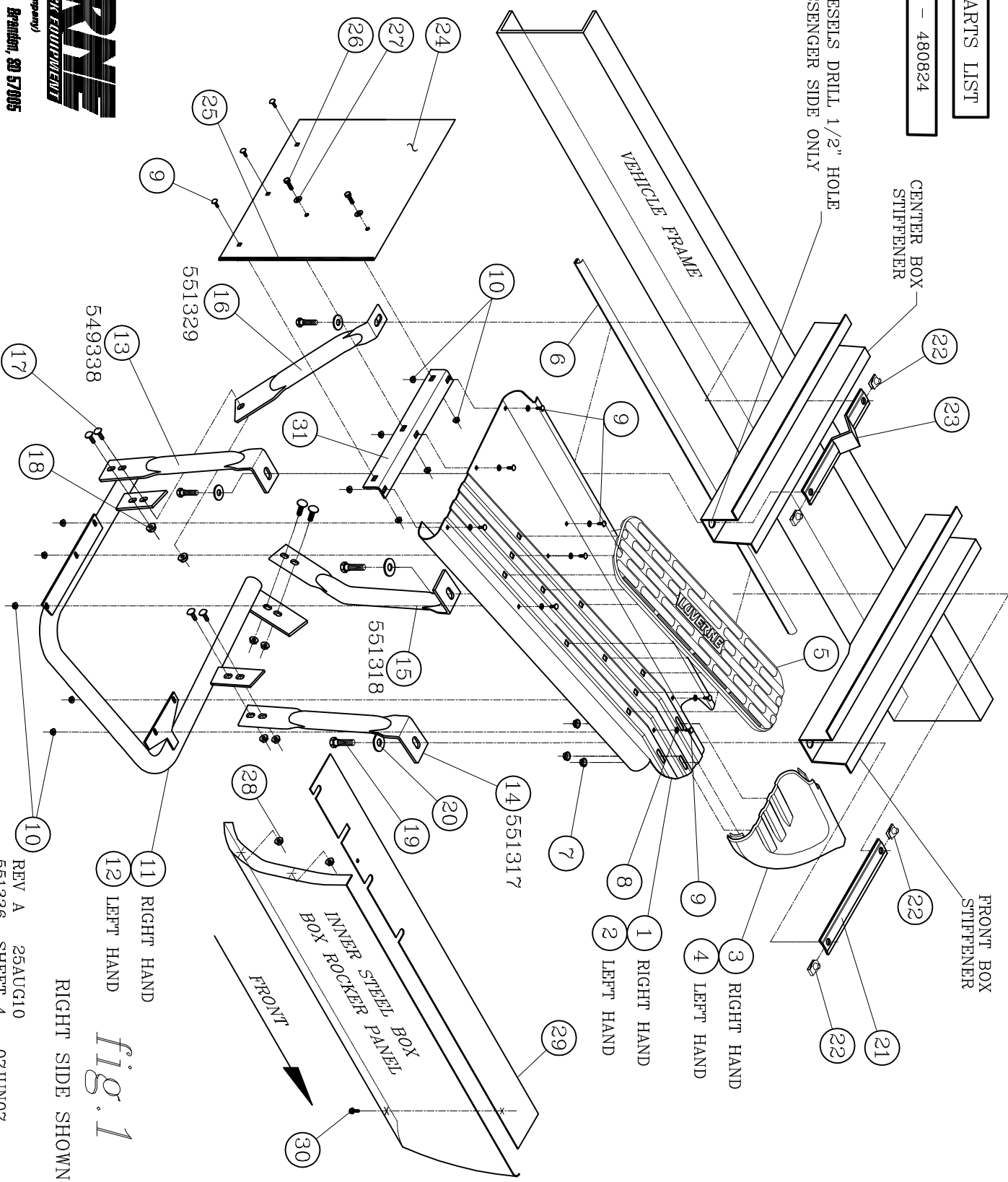


fig. 1

RIGHT SIDE SHOWN

11 RIGHT HAND  
12 LEFT HAND

1 RIGHT HAND  
2 LEFT HAND

3 RIGHT HAND  
4 LEFT HAND