

INSTALLATION INSTRUCTIONS AND PARTS LIST FOR MOUNTING 480828 SIDE ENTRY STEP BOX EXTENSIONS

1999-2007 FORD SUPER DUTY SHORT BOX PICKUPS
2008 AND NEWER FORD SUPER DUTY SHORT BOX 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 STEP PLATES AND BRACE WELDMENTS AS FOLLOWS:
 - 2.1. LOOSEN THE FASTENERS AND ROTATE THE FRONT TUBES (ITEM #9&12) AND THE REAR TUBE BRACES (ITEM #10&11) TO THE UP POSITION. INSTALL THE 5/16 X 1.0 CARRIAGE BOLTS (ITEM #15), AND SERRATED FLANGE NUTS (ITEM #16) IN THE TAB MOUNTING HOLES OF THESE BRACES. (LEAVE THE FASTENERS FINGER TIGHT ONLY AT THIS TIME)
 - 2.2. 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 #13&22) DOWN THRU THE STEP PLATE AND THE MOUNTING PATTERN ON THE BRACE WELDMENT AND TIGHTEN WITH #10-24 SERRATED FLANGE NUTS (ITEM #14). NOTE THAT THE MAXIMUM TORQUE ON THESE FASTENERS IS 4 LB. FT.
3. INSTALL THE SIDE ENTRY STEP ASSEMBLY AS FOLLOWS:
 - 3.1. POSITION AND CLAMP THE STEP PLATE/BRACE WELDMENT ASSEMBLY UP UNDER THE BOX ROCKER PANEL AS SHOWN. THE TRIM SEAL (ITEM #5) MUST BE OUTBOARD OF THE BOX ROCKER PANEL PINCH WELD. THE STEP MUST BE CENTERED FORE AND AFT ON THE BOTTOM OF THE ROCKER PANEL AND THE UPPER FLAT SWAGE OF THE REAR BRACES MUST BE ON THE OUTBOARD SIDE OF THE BOX PINCH WELD.
 - 3.2. INSERT THE 3/8" MULTI THREAD U-NUTS (ITEM #17) INTO THE RETAINER PLATE (ITEM #18) AS SHOWN. (THE THREADS OF THE INSERT MUST BE IN THE UP POSITION OF THE RETAINER PLATE. INSERT THE RETAINER ASSEMBLY INTO THE END OF THE BOX STIFFENER. INSTALL A 3/8"X 1.25" HEX HEAD CAP SCREW WITH FLAT WASHER (ITEM #19&20) THRU THE INBOARD FRONT BENT BRACE (ITEM #12), AND INTO THE THREADED INSERT. HAND TIGHTEN ONLY. REPEAT THIS PROCESS FOR THE OUTBOARD FRONT BRACE (ITEM #9).
 - 3.3. 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 OBOUND HOLES OF THE BRACES. TIGHTEN THE 5/16" SERRATED FLANGE NUTS TO 19 LB. FT., AND THE 3/8" HEX HEAD BOLTS TO 45 LB. FT.
 - 3.4. CLAMP THE REAR BRACES (ITEM #10&11) TO THE BOX PINCH WELD AS SHOWN. USING THE (2) HOLES IN THE REAR MOUNTING BRACE AS PILOT HOLES, DRILL A 5/32" DIA. HOLE THROUGH THE PINCH WELD AND INSTALL 1/4" X 3/4" HEX HEAD THREAD FORMING SCREW (ITEM #21). TORQUE TO 9 LB. FT.



1200 E. Birch St.

Brandon, SD 57005

551320 SHEET 1 23MAY07

SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	549305	2	STEP PLATE-SES,RH/LH,FORD S.D.,SHORT BOX
2	104250	2	END CAP-RH FRONT/LH REAR
3	104251	2	END CAP-LH FRONT/RH REAR
4	105501	2	PAD,SES,SPCL,5.50 X 5.50
5	104255	.5	TRIM-SEAL,SES,EXTRUDED
6	104257	16	NUT-HEX,SGL SELF THD,CAP WASHER,1/4"
7	551315	1	BRACE WLDMT-TUBE,STEP MTG,RH,SB EXT
8	551314	1	BRACE WLDMT-TUBE,STEP MTG,LH,SB EXT
9	551317	2	BRACE-TUBE,FRT,RH/LH,OUTBOARD
10	551322	1	BRACE-TUBE,REAR RH,480828
11	551323	1	BRACE-TUBE,REAR LH,480828
12	551318	2	BRACE-TUBE,FRT,RH/LH,BENT,INBOARD
13	104258	8	BOLT-CARRIAGE,SST,#10-24 X 3/4"LG
14	104261	8	NUT-SERRATED FLANGE,HEX,SST,#10-24
15	100021	12	BLT-CRG,5/16-18 UNC X 1.00,STL,ZP
16	100178	12	NUT-SERR FLG,HEX,STL,5/16-18 UNC,ZP
17	104282	4	NUT-U,MULTI THD,STL,3/8-16 UNC,BLK
18	551316	2	PLATE-U-NUT RETAINER
19	100047	4	SCR-CAP,HEX HD,3/8-16 UNC X 1.25",ZP
20	100062	4	WSHR-PL,A,STL,3/8,.438 X 1.00 X .083,ZP
21	100004	4	SCR-HEX,TF,AB,1/4 X 3/4,ZP
22	104530	8	WASHER-FLAT,NEOPRENE,,200SQ X .406 DIA



(A LUVERNE Company)

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SERVICE PARTS LIST

MODEL NO. - 480828

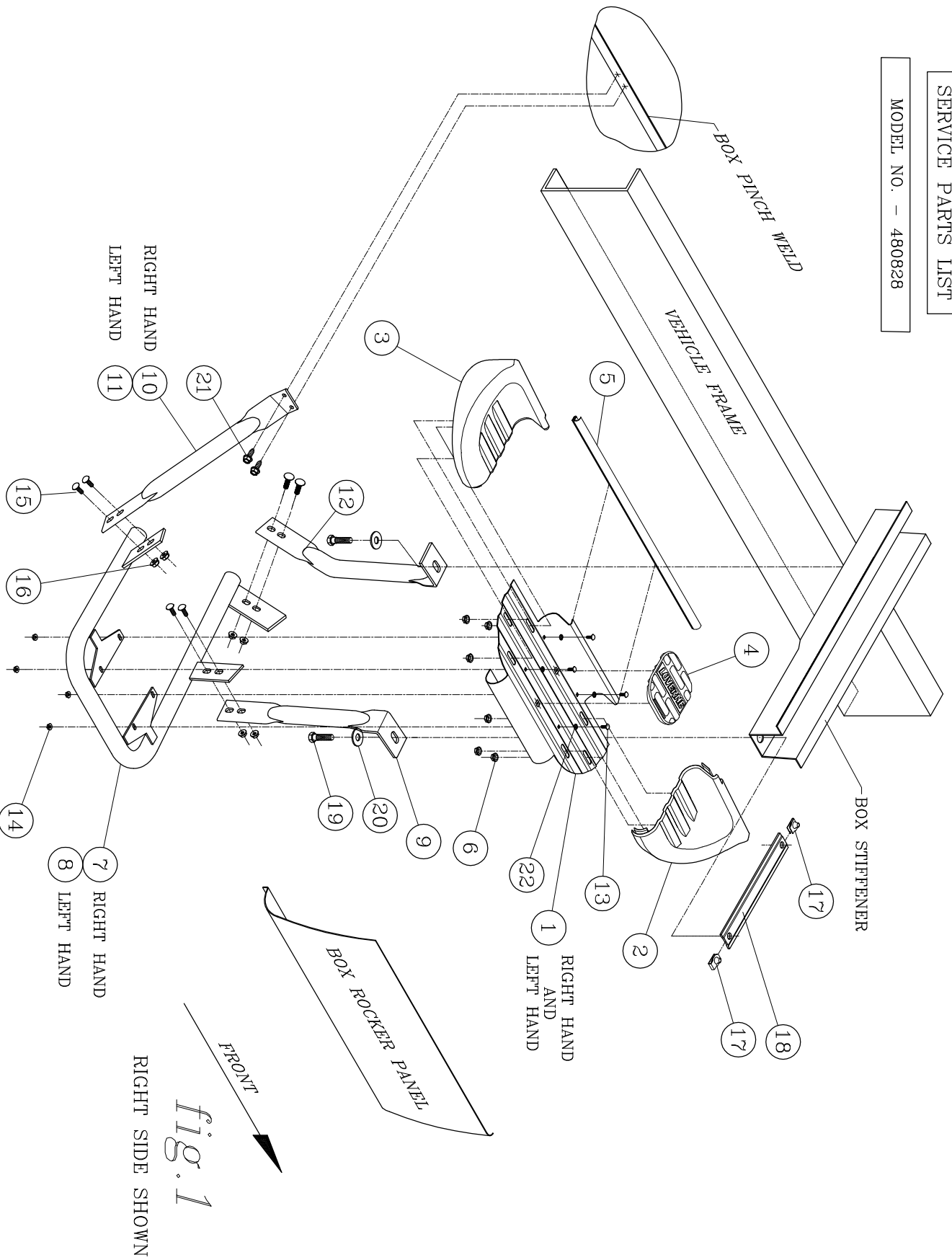


fig. 1

RIGHT SIDE SHOWN