

INSTALLATION INSTRUCTIONS AND PARTS LIST FOR MOUNTING 480829 SIDE ENTRY STEP BOX EXTENSIONS

1999-2007 FORD SUPER DUTY LONG BOX PICKUPS
2008 AND NEWER FORD SUPER DUTY LONG 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 TUBES (ITEM #10,11&13) TO THE UP POSITION. INSTALL THE 5/16 X 1.0 CARRIAGE BOLTS (ITEM #18), AND SERRATED FLANGE NUTS (ITEM #19) IN THE TAB MOUNTING HOLES OF THESE BRACES. (LEAVE THE FASTENERS FINGER TIGHT ONLY AT THIS TIME)
 - 2.2. ATTACH THE REMAINING BRACES FROM THE ACCESSORY PACKAGE (ITEM #12,14 &16) USING THE 5/16 X 1.0 CARRIAGE BOLTS (ITEM #18), AND SERRATED FLANGE NUTS.
 - 2.3. 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 #7&16) DOWN THRU THE STEP PLATE AND THE MOUNTING PATTERN ON THE BRACE WELDMENT AND TIGHTEN WITH #10-24 SERRATED FLANGE NUTS (ITEM #17). 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 #23) INTO THE RETAINER PLATES (ITEM #22 &24) 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 #20&21) THRU THE INBOARD FRONT AND REAR BRACES (ITEM #12 &13), AND INTO THE THREADED INSERTS.. HAND TIGHTEN ONLY. REPEAT THIS PROCESS FOR THE OUTBOARD FRONT AND REAR BRACES (ITEM #10 &11).
 - 3.3. **NOTE: ON THE 2011 DIESELS PASSENGER REAR OUTBOARD RETAINER HOLE WILL NEED TO HAVE A 1/2" HOLE DRILLED INTO THE OUTBOARD BOX STIFFENER.**
 - 3.4. **ON 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**



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3.5. 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 OBOUNDED 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.

3.6. CLAMP THE REAR BRACES (ITEM #14&15) 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 #25). TORQUE TO 9 LB. FT.

SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	549329	2	STEP PLATE-SES,RH/LH,FORD S.D.,LONG BOX
2	104250	2	END CAP-RH FRONT/LH REAR
3	104251	2	END CAP-LH FRONT/RH REAR
4	105500	2	PAD,SES,SPCL,5.50 X 20.00
5	104255	1	TRIM-SEAL,SES,EXTRUDED
6	104257	12	NUT-HEX,SGL SELF THD,CAP WASHER,1/4"
7	104530	8	WASHER-FLAT,NEOPRENE,.200SQ X .406 DIA
8	551327	1	BRACE WLDMT-TUBE,STEP MTG,RH,LB EXT
9	551326	1	BRACE WLDMT-TUBE,STEP MTG,LH,LB EXT
10	549338	2	BRACE-TUBE CENTER, RH/LH,OUTBOARD
11	551317	2	BRACE-TUBE,FRT,RH/LH,OUTBOARD
12	551318	2	BRACE-TUBE,FRT,RH/LH,BENT,INBOARD
13	551329	2	BRACE-TUBE CENTER, RH/LH,INBOARD
14	551322	1	BRACE-TUBE,REAR RH,480828
15	551323	1	BRACE-TUBE,REAR LH,480828
16	104258	8	BOLT-CARRIAGE,SST,#10-24 X 3/4"LG
17	104261	8	NUT-SERRATED FLANGE,HEX,SST,#10-24
18	100021	16	BLT-CRG,5/16-18 UNC X 1.00,STL,ZP
19	100178	16	NUT-SERR FLG,HEX,STL,5/16-18 UNC,ZP
20	100047	8	SCR-CAP,HEX HD,3/8-16 UNC X 1.25",ZP
21	100062	8	WSHR-PL,A,STL,3/8,.438 X 1.00 X .083,ZP
22	551316	2	PLATE-U-NUT RETAINER
23	104282	8	NUT-U,MULTI THD,STL,3/8-16 UNC,BLK
24	551328	2	PLATE-U-NUT RETAINER,FORMED
25	100004	4	SCR-HEX,TF,AB,1/4 X 3/4,ZP



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FIG 2



*TRIM A 1/2" OFF BOTTOM
OF PLASTIC HANGER
BRACKET*

SERVICE PARTS LIST

MODEL NO. - 480829

2011 DIESELS DRILL 1/2" HOLE
PASSENGER SIDE ONLY

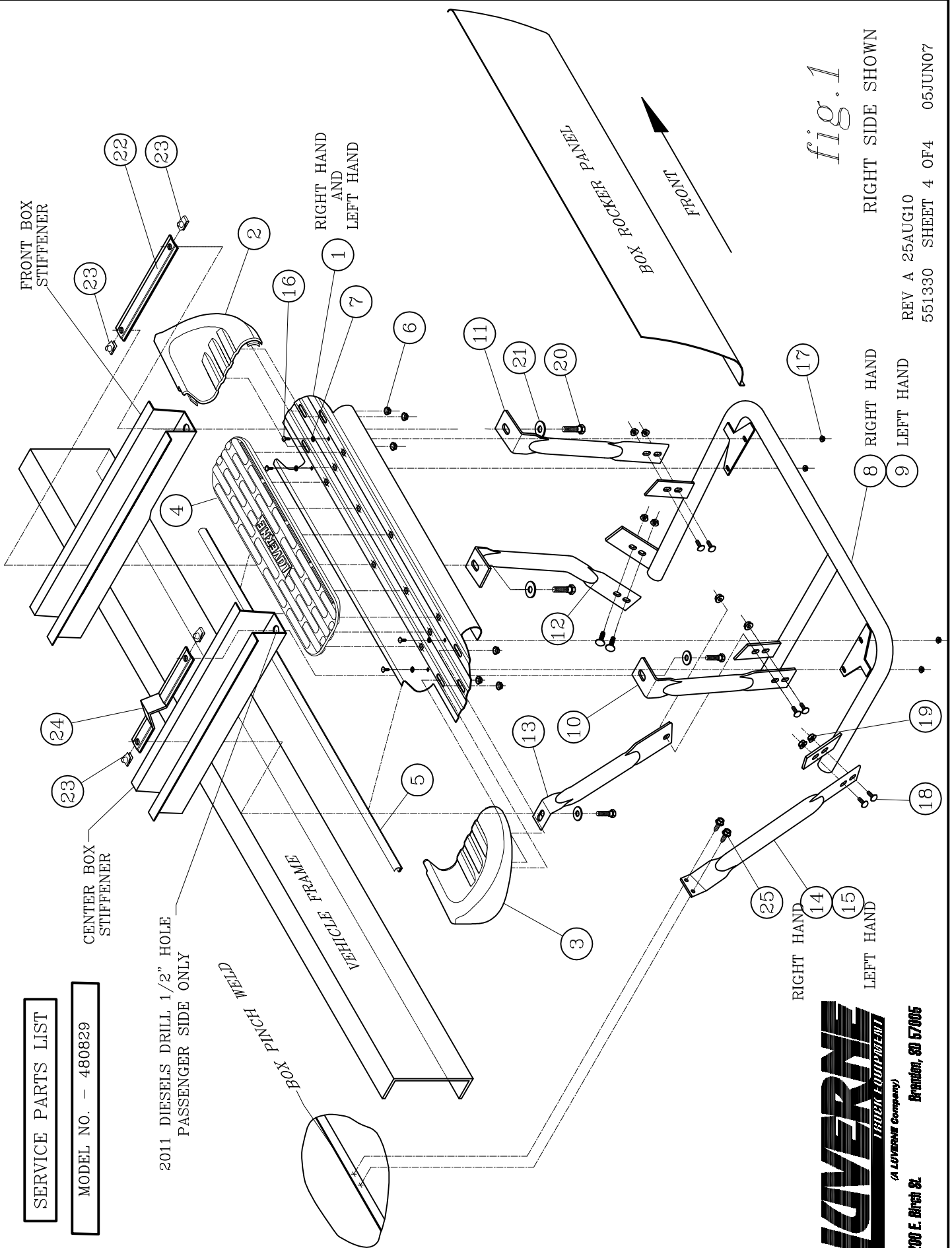


fig. 1

RIGHT SIDE SHOWN

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8 RIGHT HAND
9 LEFT HAND

14 RIGHT HAND
15 LEFT HAND



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