

# INSTALLATION INSTRUCTIONS

## R5Wheel to Wheel Nerf Step Bars

**APPLICATION:****F-250/350/450/550 Crew Cab 1999-2016 (6.75 ft. Bed)****PART NUMBER:****28-534010, 28-534015****CONTENT**

ITEM	QUANTITY	DESCRIPTION	TOOLS NEEDED
1	2	STEP BAR ASSEMBLY FRONT SECTION (1 DRIVER, 1 PASSENGER)	18MM SOCKET
2	2	STEP BAR ASSEMBLY REAR SECTION (1 DRIVER, 1 PASSENGER)	18MM WRENCH
3	2	STEP PAD	16MM SOCKET
4	2	LINK BRACKET (1 DRIVER, 1 PASSENGER)	16MM WRENCH
5	2	LINK PLATE	13MM WRENCH
6	2	TALL REINFORCEMENT LINK	10MM WRENCH
7	2	SHORT REINFORCEMENT LINK	10MM SOCKET
8	4	MOUNTING BRACKET	RATCHET
9	2	TOP ISOLATOR BRACKET (1 DRIVER, 1 PASSENGER)	
10	2	BOTTOM ISOLATOR BRACKET	
11	2	ISOLATOR KIT	
12	6	PLATE ADAPTER	
13	8	BRACKET COVER	
14	2	FRONT SPACER PLATE	
15	4	M12 BOLT PLATE	
16	4	M12 HEX NUT	
17	4	M12 SPLIT LOCK WASHER	
18	4	M12 FLAT WASHER	
19	4	M10 HEX HEAD FLANGE BOLT	
20	10	M8 HEX HEAD CAP SCREW	
21	34	M8 SPLIT LOCK WASHER (12 black zinc)	
22	46	M8 FLAT WASHER (12 black zinc)	
23	24	M8 HEX NUT (12 black zinc)	
24	12	M8 BUTTON HEAD BOLT	
25	10	M8 U-CLIPS	
26	28	M6 HEX HEAD CAP SCREW (12 black zinc)	
27	44	M6 FLAT WASHER (12 black zinc)	
28	16	M6 NYLOCK NUT	
29	12	M6 SPLIT LOCK WASHER	
30	4	M12 FISH WIRE	
31	16	SELF THREADING NUTS	

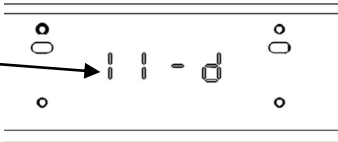
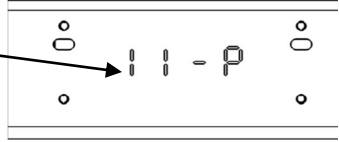
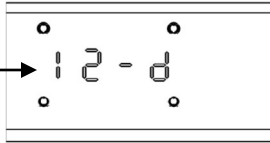
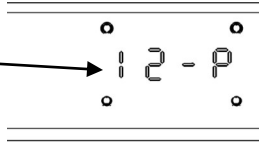
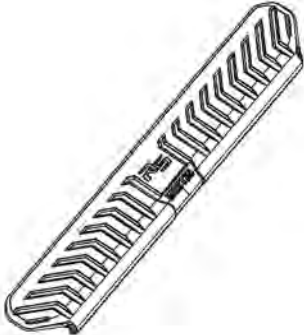
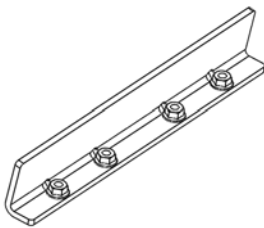
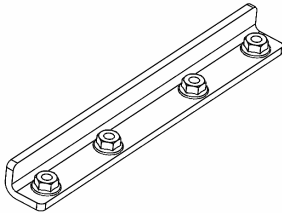
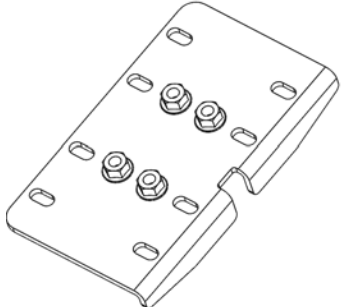
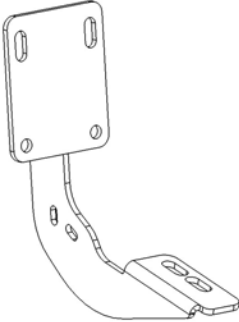
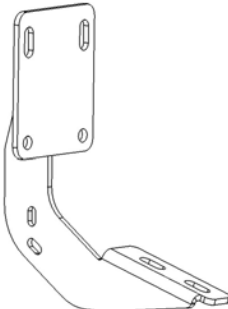
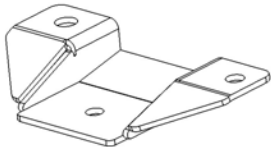
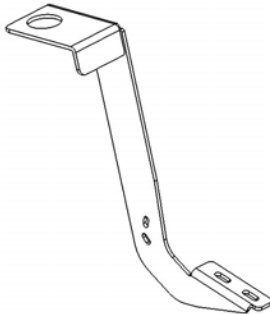

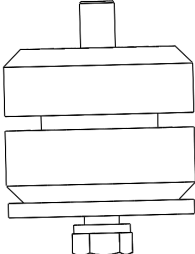
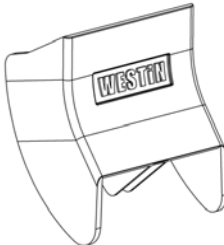
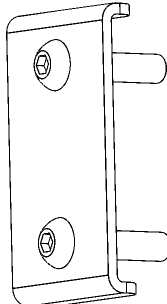


Westin Automotive Products, Inc.  
320 W. Covina Blvd  
San Dimas, Ca. 91773

Thank you for choosing Westin products  
for additional installation assistance please call  
Customer Service (800) 793-7846

[www.westinautomotive.com](http://www.westinautomotive.com)

DATE: 09/21/18

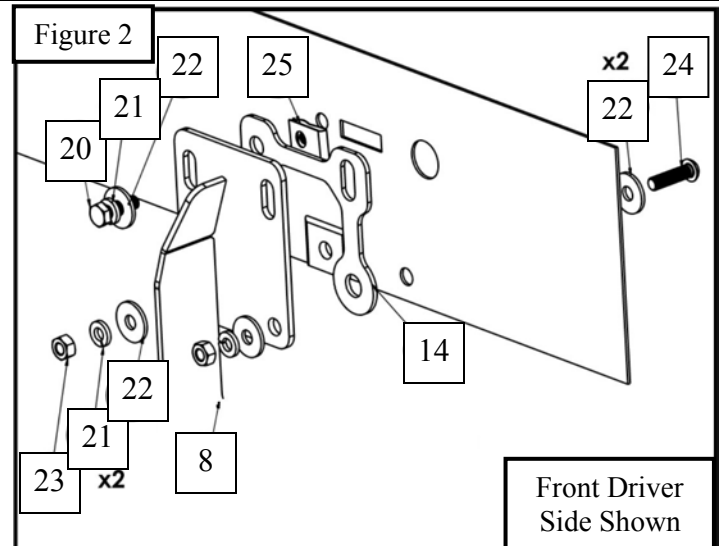
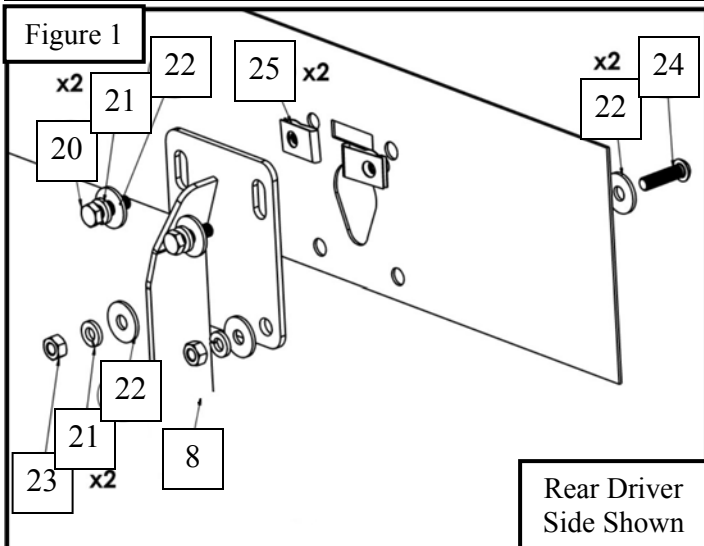
ITEM 1	<div>Driver Side Front Marking</div> 		<div>Passenger Side Front Marking</div> 	
ITEM 2	<div>Driver Side Rear Marking</div> 		<div>Passenger Side Rear Marking</div> 	
<div><div></div><div></div><div></div><div></div></div>				
ITEM 3	ITEM 6	ITEM 7	ITEM 5	
<div><div></div><div></div><div></div><div></div></div>				
ITEM 4	ITEM 8	ITEM 9	ITEM 10	
<div><div></div><div></div><div></div><div></div></div>				
ITEM 14	ITEM 11	ITEM 13	ITEM 12	

DRIVER SIDE ITEMS SHOWN

## PROCEDURE

1. Remove contents from box, verify if all parts listed are present and free from damage.  
Carefully read and understand all instructions before attempting installation.  
**Failure to identify damage before installation could lead to a rejection of any claim.**

2. Start installation on driver's side. On the rocker panel find locations with open holes and insert in the top open holes (2) M8 nut clips (Item 25). **NOTE: ON SOME VEHICLES THE MOUNTING HOLES DO NOT LINE UP FROM THE FACTORY IF THIS IS THE CASE DRILL OUT THE HOLES USING A 7/16" DRILL BIT**
3. Then loosely install M8 hardware to previously installed Nut Clip; (2) M8 hex head bolts, (2) M8 flat washers, (2) M8 split lock washers. For installing to bottom open holes of the rocker panel, loosely install, (2) M8 button head bolts, (4) M8 flat washers, (2) M8 split lock washers, (2) M8 hex nuts. Repeat the same procedure for all other mounting locations. **See Figure 1.**
4. Note: For 2010– up model years place (1) front mounting bracket spacer (Item 14) in between the rocker panel and the front mounting bracket before installing. **See Figure 2**

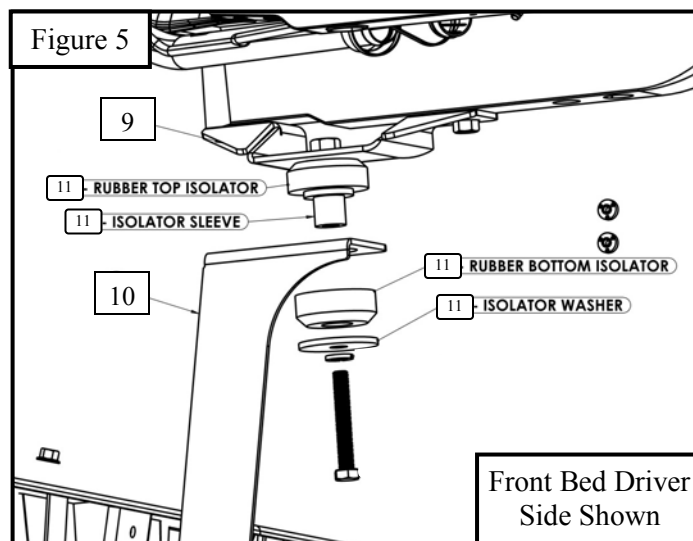
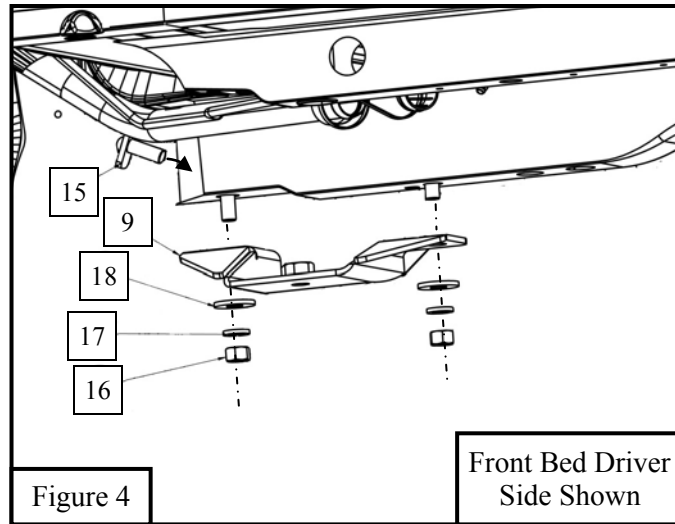
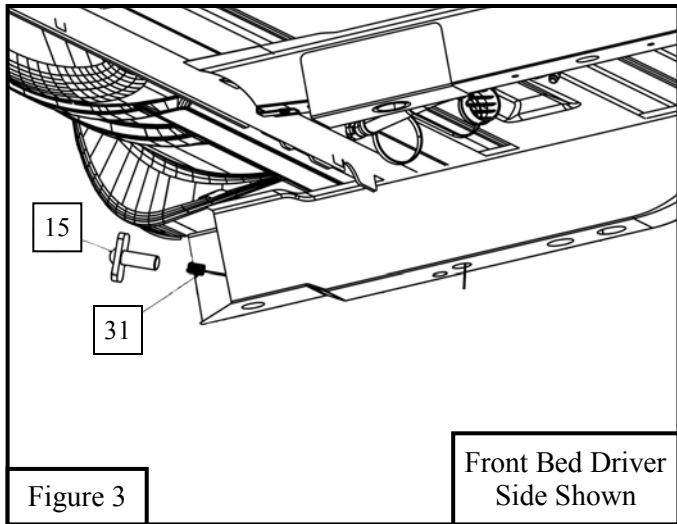


5. Locate the supplied M12 bolt plate (item 15) and M12 fish wire (item 31), and guide the bolt plate through the specified holes on the bed rail located underneath the truck closest to the front of the bed. **See Figure 3**
6. Once bolt plates are through the specified holes locate the top isolator bracket (item 9). Loosely install the bracket with supplied M12 hardware. **See Figure 4**
7. Continue by locating the isolator kit (item 11) and the isolator bracket (item 9). Loosely install the brackets with the supplied M12 hardware. **See Figure 5**

*Go to page 7 for supplementary bracket configuration diagram.*

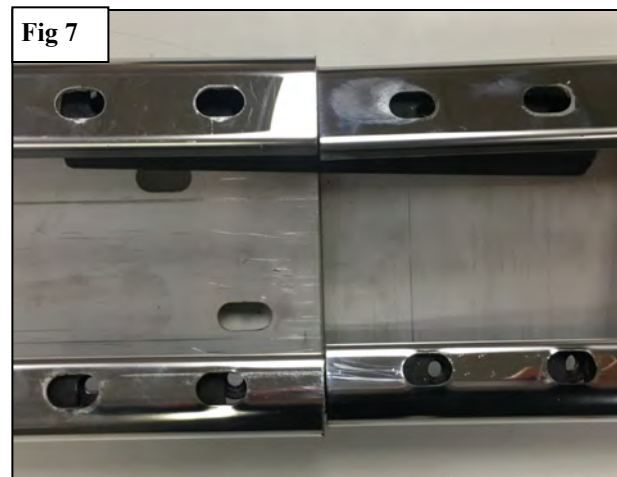


Westin Automotive Products, Inc.  
320 W. Covina Blvd  
San Dimas, Ca. 91773



8. Obtain both sections of the Step Bar Assembly (1 or 2). Slide the Reinforcement Links (6 & 7) into both sides of the step bar sections. **See Figure 6.**

9. Line up the holes on the Step Bar sections with the holes on the Reinforcement Links (6 & 7). **See Figure 7.**



10. Place the supplied step pad (3) into the holes to connect the two Step Bar sections (1 & 2). Place the supplied thread cutting nut on each of the plastic stems. Tighten until nut reaches metal and feels firm in place. **See Figures 8 & 9.**

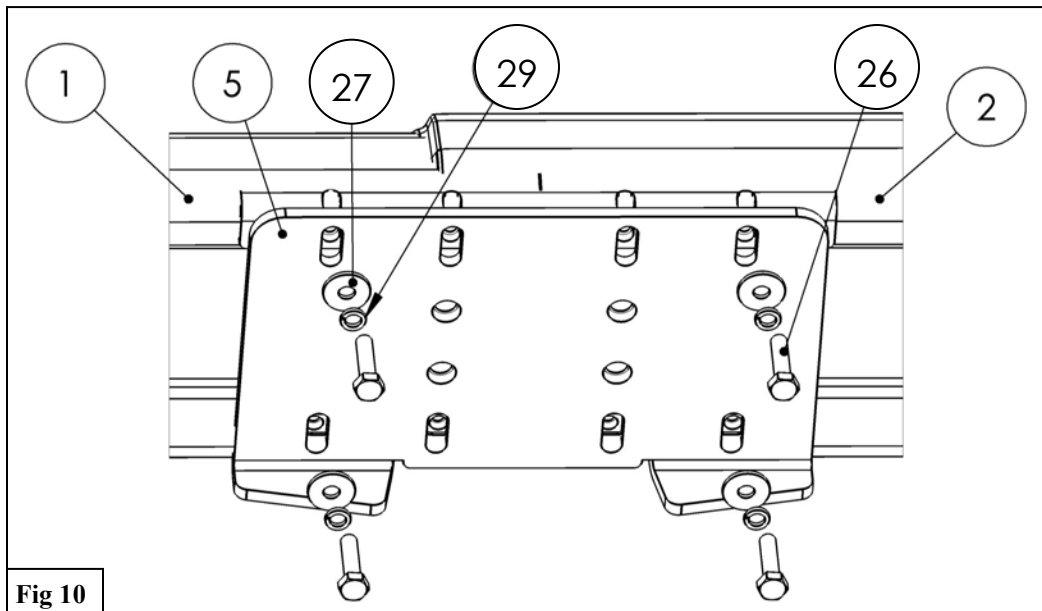
**Fig 8**



**Fig 9**



11. Obtain the Link Plate (5) and secure it to the Step Bar Assembly (1 & 2) using the supplied black M6 Hardware. **See Figure 10.**

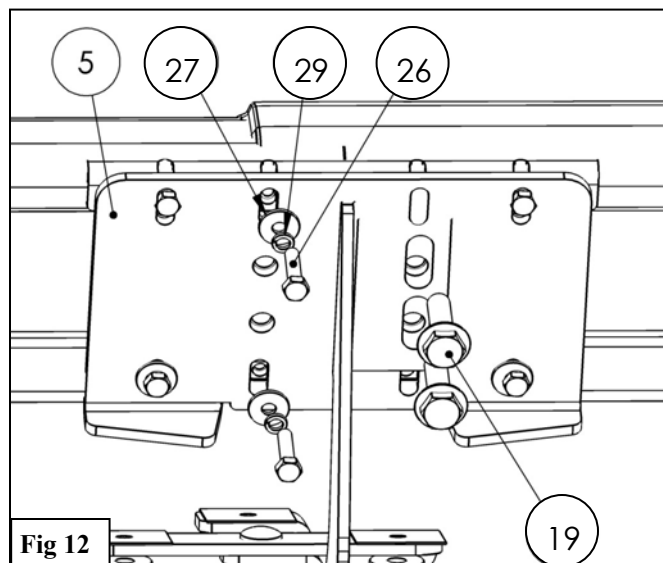
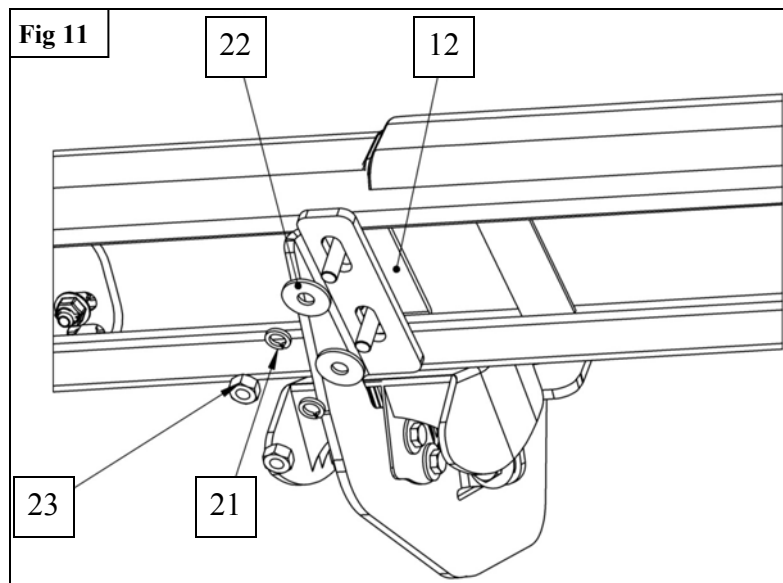


**Fig 10**



12. Installation of the step boards will utilize the supplied black M8 hardware with Plate Adapters (12) for all brackets excluding the Link Brackets (4). The Link Brackets (4) will use the supplied black M10 hardware. **See Figures 11 & 12.**

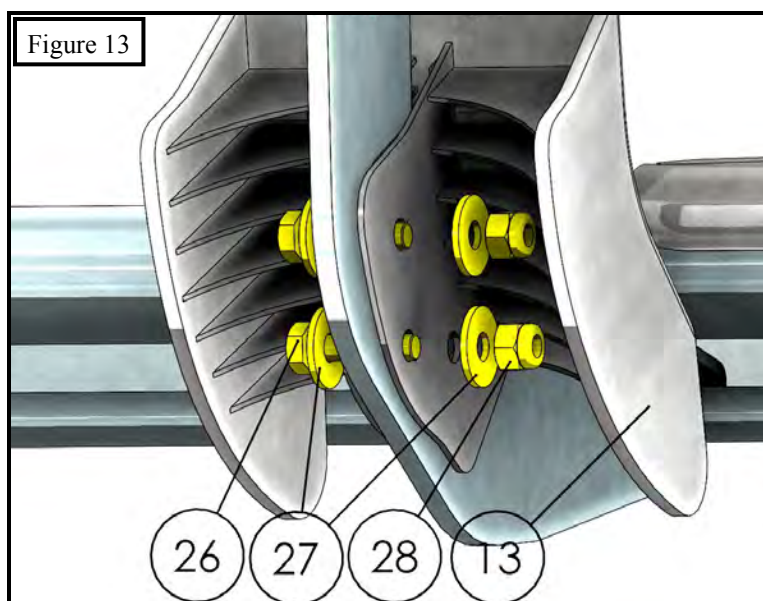
13. Align and adjust the step bars and brackets as needed, then fully tighten all hardware: M8 to 15-18 ft-lbs, M10 to 32-38 ft-lbs, and M12 to 52-60 ft-lbs.



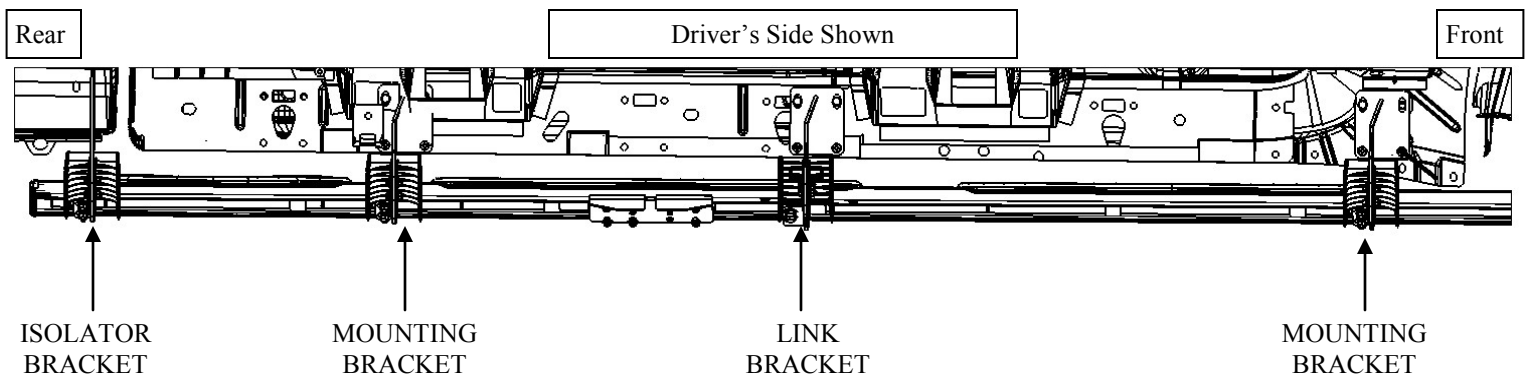
FOR LINK BRACKETS ONLY

#### Plastic Cover Installation:

1. Locate (1) plastic bracket cover (Item 13) and loosely secure it to the brackets using the provided hardware: (2) M6 hex head cap screws, (4) M6 flat washers, and (2) M6 nylock nuts. Repeat for every bracket. **See Figure 13.**



INSTALLATION COMPLETE



**WESTIN** Westin Automotive Products, Inc.  
320 W. Covina Blvd  
San Dimas, Ca. 91773

P.N.: 75-2853401-RevB

ECO #: W18-0125

7

Thank you for choosing Westin products  
for additional installation assistance please call  
Customer Service (800) 793-7846

[www.westinautomotive.com](http://www.westinautomotive.com)

DATE: 09/21/18



## WARNING



Failure to follow these instructions could lead to death, personal injury, and / or property damage.

Failure to follow these instructions could lead to death, personal injury, and / or property damage.

### FASTENERS:

All Westin supplied fasteners must be utilized and installed in accordance with the installation instructions and apply torque to the specifications as defined. **DOUBLE CHECK ALL FASTENERS BEFORE INITIAL USE, AND PERIODICALLY IN THE FUTURE TO ENSURE PROPER FUNCTION AND SAFETY.**

### DRILLING:

Most Westin products do not require drilling for installation. If drilling is defined as required, use caution when drilling a vehicle. **FAILURE TO REVIEW AN AREA TO BE DRILLED MAY RESULT IN PERSONAL INJURY AND/OR INJURY TO OTHERS AS WELL AS VEHICLE DAMAGE.**

### EYE PROTECTION:

**ALWAYS WEAR SAFETY GLASSES OR GOGGLES DURING THE INSTALLATION PROCESS TO AVOID PERSONAL INJURY.**

### MAXIMUM TOWING/CARRYING CAPACITY:

The Westin Receiver Hitches will have a visible tow rating label affixed directly on the product. User should never exceed the vehicle manufacturers maximum tow and weight rating regardless of the capacity of the hitch. **FAILURE TO FOLLOW THESE GUIDELINES WILL VOID THE WESTIN WARRANTY AND MAY RESULT IN PERSONAL INJURY AND/OR INJURY TO OTHERS AS WELL AS VEHICLE DAMAGE.**



Westin Automotive Products, Inc.  
320 W. Covina Blvd  
San Dimas, Ca. 91773