

# INSTALLATION INSTRUCTIONS AND PARTS LIST

APPLICATION:

## MODEL 400922 STEP BRACKETS:

2004 FORD F-150 SUPER CAB / SUPERCREW CAB PICKUPS

1. READ INSTRUCTIONS COMPLETELY AND CHECK TO MAKE SURE THAT ALL REQUIRED PARTS (LISTED ON THE SERVICE PARTS LIST) ARE ON HAND BEFORE STARTING THE INSTALLATION.
2. INSTALL 5/16" MULTI THREAD U-NUTS (ITEM #5) IN THE TOP REAR HOLE OF THE SECOND PATTERN FROM THE FRONT AND IN THE TOP FRONT HOLE OF THE THIRD PATTERN FROM THE FRONT AS SHOWN. INSTALL THESE U-NUTS SO THAT THE THREADS ARE TO THE INSIDE OF THE ROCKER PANEL. (THIS IS DONE BY INSERTING THE THREADED HALF OF THE U-NUT THRU THE LARGE ACCESS HOLES AND SLIDING THE U-NUT TOWARDS THE ROUND HOLE UNTIL IT SEATS IN THE ROUND HOLE).
3. **FRONT AND REAR BRACKET:** [SEE FIG 1] THESE BRACKETS WILL NEED TO BE APPROXIMATELY 6" FROM THE BACK OF THE CAB AND 6" FROM THE FRONT OF THE CAB AND WILL REQUIRE SOME DRILLING.
  - 3.1. CLAMP THE BRACKETS INTO POSITION. DRILL A (11/32") HOLE IN THE PINCH WELD AREA TO LINE UP WITH THE BOTTOM HOLE IN THE BRACKET.
  - 3.2. ATTACH THE BOTTOM OF THE BRACKET TO THE PINCH WELD WITH A 5/16" X 1.00" BLACK PLATED HEX HEAD CAP SCREW (ITEM #2), 5/16" BLACK PLATED FLAT WASHER (ITEM #3) AND 5/16" SERRATED FLANGE NUT (ITEM #4). LEVEL THE BRACKETS AND TIGHTEN THE BOLTS.
  - 3.3. DRILL A (7/32") HOLE INTO THE TOP OF THE ROCKER PANEL. INSTALL A SELF TAPPING SCREW (ITEM #9) INTO THE SMALL HOLE AND TIGHTEN, BE CAREFUL NOT TO OVER TIGHTEN.

### SUPER CAB

4. ATTACH THE CENTER TWO MOUNTING BRACKETS (ITEM #1) TO THE VEHICLE.
  - 4.1. POSITION THE (2) BRACKETS ON THE VEHICLE SO THAT THE TOP HOLE LINES UP WITH THE MULTI THREAD U-NUT AND THE HOLE IN THE OFFSET LINES UP WITH THE HOLE IN THE PINCH WELD. ATTACH THE TOP OF THE BRACKET WITH A 5/16" X 1.00" ZINC PLATED HEX HEAD CAP SCREW (ITEM #7) AND 5/16" ZINC PLATED FLAT WASHER (ITEM #8). ATTACH THE BOTTOM OF THE BRACKET TO THE PINCH WELD WITH A 5/16" X 1.00" BLACK PLATED HEX HEAD CAP SCREW (ITEM #2), 5/16" BLACK PLATED FLAT WASHER (ITEM #3) AND 5/16" SERRATED FLANGE NUT (ITEM #4). LEVEL THE BRACKETS AND TIGHTEN THE FASTENERS.

### SUPERCREW ONLY

5. ATTACH THE SECOND FROM THE FRONT MOUNTING BRACKET (ITEM #1) TO THE VEHICLE.
  - 5.1. ATTACH ANGLE BRACKET (ITEM #6) TO MOUNTING BRACKET (ITEM #1) WITH A 5/16" X 1.00" ZINC PLATED HEX HEAD CAP SCREW (ITEM #7) AND 5/16" ZINC PLATED FLAT WASHER (ITEM #8). AND A 5/16" SERRATED FLANGE NUT (ITEM #4) TOGETHER WITH THE ANGLE TOWARDS THE MULTI THREAD U-NUT IN THE HOLE THAT IS OFFSET FROM THE PINCH WELD HOLE. REPEAT STEP 4.1 USING ANGLE BRKT.
6. ATTACHING THE STEP ASSEMBLY:  
PLEASE REVIEW THE INSTALLATION INSTRUCTIONS THAT ARE INCLUDED IN YOUR STEP ASSEMBLY FOR SPECIFIC DETAILS.

TORQUE ALL 5/16" FASTENERS TO 19 LB FT.



(A LIVERNE Company)

1200 E. Birch St.

Brandon, SD 57005

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# INSTALLATION INSTRUCTIONS AND PARTS LIST

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## SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
<b>PARTS INCLUDED IN THE BRACKET PACKAGE</b>			
1	551851	8	MOUNTING BRACKET, BLK, F150, GRIP STEP
2	106997	8	SCREW- HEX HEAD CAP, 5/16_18 UNC X 1.00", SST, BZP
3	106998	8	WSHR-PL, A, SST, 5/16,.375 ID X .875 OD X .083 THK, BZP
4	102680	10	NUT-SERR FLG,HX,SST,WX,5/16-18
5	104264	4	U-NUT- MULTI THREAD, 5/16-18 UNC, STL, BLK
6	551559	2	BRKT-MTG,ANGLE, 09 F-150
7	100647	6	SCREW- HEX HEAD CAP, 5/16_18 UNC X 1.00".ZP
8	100034	6	WSHR-PL, A, STL, 5/16,.375 ID X .875 OD X .083 THK, ZP
9	104267	4	5/16"X3/4" SELF TAPPING SCREW



(A LUVERNE Company)

1200 E. Birch St.

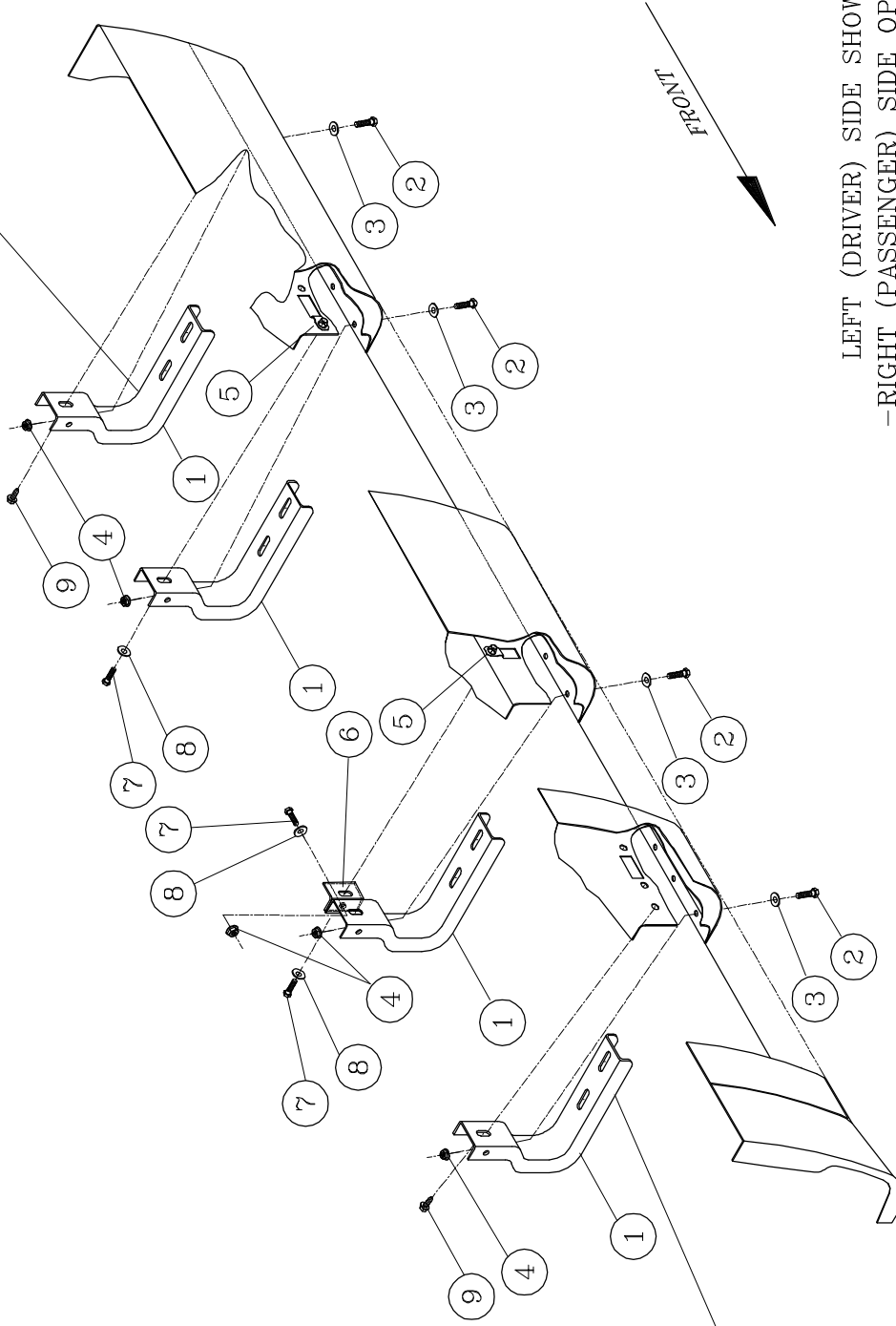
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SERVICE PARTS LIST

MODEL NO. - 400922

ADDITIONAL  
REAR BRACKET



MOVE FRONT  
BRACKET FORWARD

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

FIG. 1



1200 E. Birch St.  
A LOVERNE Company  
Beverly, OH 45705