

# INSTALLATION INSTRUCTIONS AND PARTS LIST

VEHICLE APPLICATION: **MODEL 480412 SIDE ENTRY STEPS ON:**

2004 AND NEWER CHEVROLET COLORADO & GMC CANYON EXTENDED & CREW CAB 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. PEEL AWAY THE PROTECTIVE VINYL COVERING AND CLEAN THE TOP OF EACH STEP PLATE TO REMOVE ANY VINYL COVERING RESIDUE. (A GOOD GLASS CLEANER IS SUGGESTED).
3. INSTALL THE REAR DOOR AND BOX STEP PADS ON THE STEP PLATES: (THE BOX STEP PAD IS NOT REQUIRED ON THE CREW CAB). (**TEMPERATURE OF THE STEP PLATES (ITEM #1 & #2) AND THE STEP PAD ASSEMBLIES (ITEM #6 & #15) MUST BE AT OR ABOVE 45 DEGREES F.**)
  - 3.1. PAD LOCATION FROM THE REAR EDGE OF THE FRONT END CAP (ITEM #3 & #4) TO THE FRONT OF THE STEP PADS SHOULD BE AS FOLLOWS: ON THE REAR DOOR PADS, 38.00" FOR THE EXTENDED CAB TRUCKS, 46.00" FOR THE CREW CAB TRUCKS AND APPROX. 67.00" ON THE EXTENDED CAB BOX PAD.
  - 3.2. CLEAN THE AREA WHERE THE STEP PADS WILL BE LOCATED WITH ALCOHOL, REMOVE THE BACKING FROM THE TAPE AND INSTALL THE PADS. (**NOTE THAT THE STEP PAD MUST BE LOCATED ON THE SAME RIBS AND IN LINE WITH THE FRONT STEP PADS.**)
4. PREPARE THE VEHICLE AND STEP PLATE ASSEMBLY FOR MOUNTING: THERE ARE SEVEN (7) SLOTTED HOLES ALONG THE OUTBOARD SIDEWALL OF THE FRAME FROM THE FRONT BODY MOUNT TOWARD THE REAR. SOME OF THESE HOLES WILL BE USED FOR THIS INSTALLATION PER THE FOLLOWING INSTRUCTIONS.
  - 4.1. ON THE FIRST (1), FOURTH (4), SIXTH (6) AND SEVENTH (7) HOLES, MAKE A LINE FROM NEAR THE CENTER OF EACH HOLE DOWN TOWARDS THE BOTTOM OF THE FRAME. (THESE LINES WILL BE USED TO LOCATE THE BRACE FASTENERS).
  - 4.2. ASSEMBLE A POLYETHYLENE "FOAM" WASHER (ITEM #18) AND SINGLE THREAD LOCKING PALNUT (ITEM #19), WITH THE FLAT SURFACE TOWARD THE FOAM WASHER, ON THE 5/8-11 UNC X 2.00" CLIPPED HEAD CARRIAGE BOLT (ITEM #16). (HAND TIGHTEN THE PALNUT).
  - 4.3. INSERT THE CLIPPED HEAD OF THE CARRIAGE BOLT THRU THE FRAME HOLES INDICATED ABOVE. PUSH IN AND TURN THE BOLT 90 DEGREES TO LOCK THE BOLTS INTO THE HOLES. LOCATE THE BOLTS ON THE CENTERLINE OF THE FRAME HOLES.
  - 4.4. THE FRONT MOUNTING BRACE ON EACH STEP HAS BEEN ROTATED TO MEET PACKAGING REQUIREMENTS. REMOVE THE INBOARD SET OF BRACE FASTENERS, ROTATE THE BRACE TO THE PROPER MOUNTING POSITION AND REINSTALL & TIGHTEN THE BRACE FASTENERS.
5. ON THE LEFT HAND (DRIVERS) SIDE OF THE FRAME, THE VEHICLE BRAKE CABLE IS LOCATED NEAR THE #4 MOUNTING HOLE. ACCOMMODATE THIS CABLE AS FOLLOWS.
  - 5.1. REMOVE THE SECOND MOUNTING BRACE (ITEM #8) FROM THE FRONT ON THE LEFT HAND STEP ASSEMBLY. THIS BRACE IS REMOVED BY REMOVING THE #10-24 X 3/4" CARRIAGE BOLTS (ITEM #12) AND SERRATED FLANGE NUTS (ITEM #14).
  - 5.2. INSTALL THIS BRACE ON THE 5/8" CARRIAGE BOLT IN THE #4 HOLE ON THE SIDE OF THE FRAME AS SHOWN. (LEAVE THE FASTENERS FINGER TIGHT AT THIS TIME).
6. COMPLETE THE INSTALLATION AS FOLLOWS.
  - 6.1. POSITION THE STEP ASSEMBLY AGAINST THE SIDE OF THE FRAME SO THAT THE THREADS OF ALL CARRIAGE BOLTS (ITEM #16) STICK THRU THE HOLES IN THE MOUNTING BRACES.
  - 6.2. ATTACH THE ASSEMBLY TO THE CARRIAGE BOLTS WITH 5/8" FLAT WASHERS (ITEM #20), 5/8" LOCK WASHERS (ITEM #21) AND 5/8-11 HEX NUTS (ITEM #17).
  - 6.3. REATTACH THE MOUNTING BRACE TO THE STEP PLATE AT MOUNTING HOLE LOCATION #4
  - 6.4. TIGHTEN ALL FASTENERS AS REQUIRED.

**LIVERNE**  
ISO9001 QS9000 CERTIFIED TRUCK  
EQUIPMENT  
1200 Birch Street  
Brandon, SD 57005 INC.

REV B 12 MAY 04  
REV A 19 MAR 04  
549852 SHEET 1 23FEB04

## SERVICE PARTS LIST

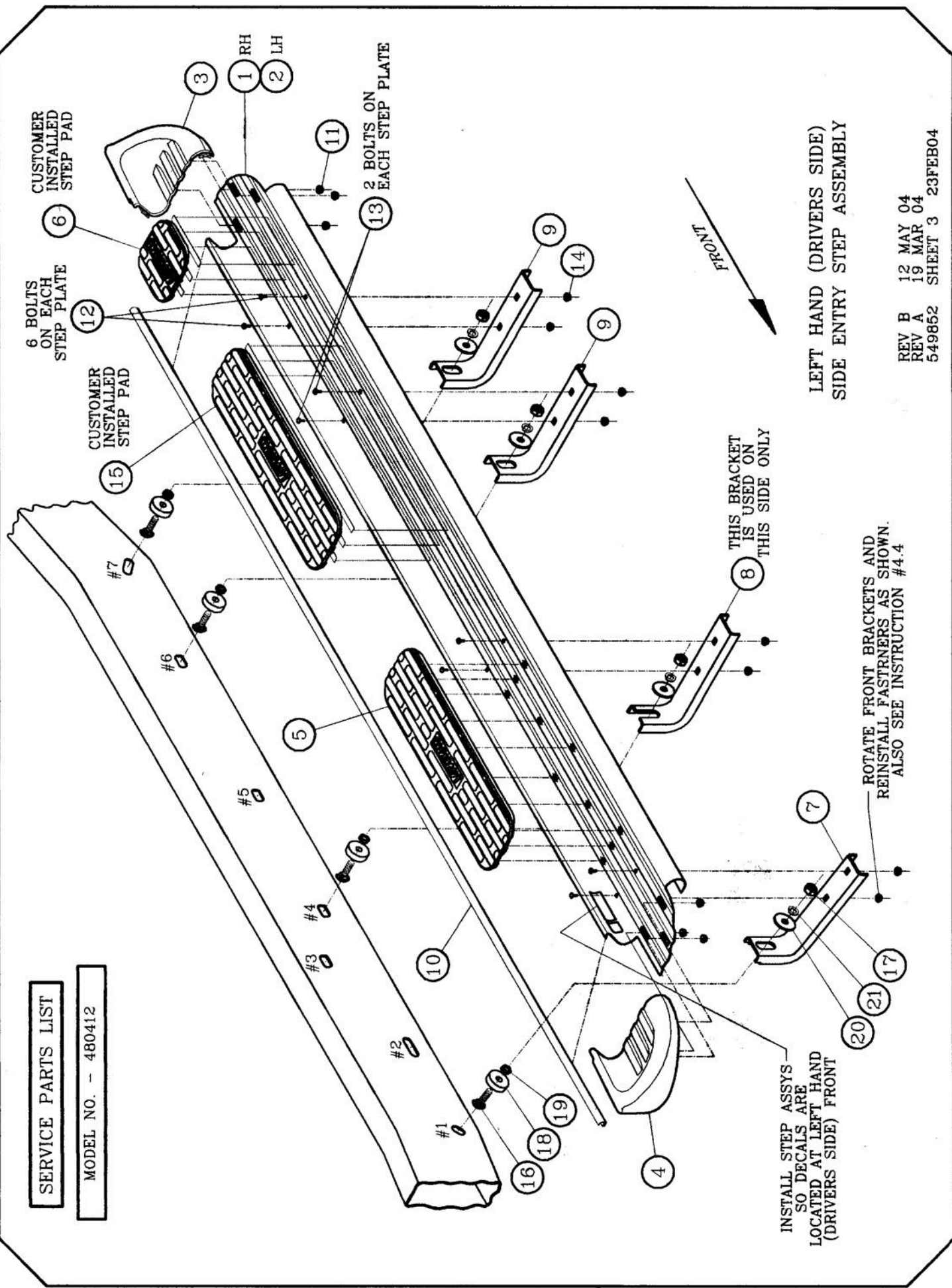
ITEM	PART NO.	QTY	DESCRIPTION
1	549853	1	STEP PLATE-SES, RH, COLORADO/CANYON, EXT/CREW CAB
2	549854	1	STEP PLATE-SES, LH, COLORADO/CANYON, EXT/CREW CAB
3	104250	2	END CAP-RH FRONT/LH REAR
4	104251	2	END CAP-LH FRONT/RH REAR
5	105500	2	PAD-MOLDED, STEP PL, 5.50 X 20.00
6	549859	2	PAD ASSY-MOLDED, STEP PL, 5.50 X 5.50, SPECIAL
7	549845	2	BRACE-MTG, FRONT, SES, RH/LH, GM COLORADO/CANYON
8	549846	1	BRACE-MTG, SES, GM COLORADO/CANYON
9	549847	5	BRACE-MTG, SES, RH/LH, GM COLORADO/CANYON
10	102502	2	TRIM-SEAL, SES, EXTRUDED, 95.00"
11	104257	12	NUT-HEX, SGL SELF THD, CAP WASHER, 1/4"
12	104258	12	BOLT-CARRIAGE, SST, #10-24 X 3/4"LG
13	104259	4	BOLT-CARRIAGE, CLP HD, SST, #10-24 X 3/4"LG
14	104261	16	NUT-SERRATED FLANGE, HEX, SST, #10-24
15	549857	2	PAD ASSY-MOLDED, STEP PL, 5.50 X 20.00, SPECIAL
16	104692	8	BOLT-CRG, CLPD HD, STL 5/8-11 UNC X 2.00", ZP
17	100149	8	NUT-HEX HD, FIN, STL, 5/8-11, ZP
18	106277	8	WSHR-POLYETHYLENE, .50 ID X 1.75 OD X .50 THK
19	105874	8	NUT-LOCK, 5/8-11, PALNUT
20	100147	8	WSHR-PL, A, STL, 5/8, .69 ID X 1.75 OD X .134 THK, ZP
21	100148	8	WSHR-LOCK, HS, REG, STL, 5/8", ZP

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**SERVICE PARTS LIST**

MODEL NO. - 480412



CUSTOMER INSTALLED STEP PAD

6 BOLTS ON EACH STEP PLATE

CUSTOMER INSTALLED STEP PAD

2 BOLTS ON EACH STEP PLATE

THIS BRACKET IS USED ON THIS SIDE ONLY

INSTALL STEP ASSYS SO DECALS ARE LOCATED AT LEFT HAND (DRIVERS SIDE) FRONT

ROTATE FRONT BRACKETS AND REINSTALL FASTENERS AS SHOWN. ALSO SEE INSTRUCTION #4.4

LEFT HAND (DRIVERS SIDE) SIDE ENTRY STEP ASSEMBLY

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