

INSTALLATION INSTRUCTIONS AND PARTS LIST

APPLICATION: MODEL 480713 (STAINLESS STEEL) SIDE ENTRY STEPS ON:
2007 AND NEWER CHEVROLET SILVERADO AND GMC SIERRA CREW CAB PICKUPS



NO DRILL APPLICATION

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 PRE ASSEMBLED STEP PLATE TO REMOVE ANY VINYL COVERING RESIDUE. (A GOOD GLASS CLEANER IS SUGGESTED).
3. ASSEMBLE THE MOUNTING BRACKETS (ITEM #8) TO THE STEP PLATE ASSEMBLYS WITH THE #10-24 X 3/4" ROUND HEAD BOLTS (ITEM #15), #10-24 X 3/4" CLIPPED ROUND HEAD BOLTS (ITEM #16) AND THE #10-24 SERRATED FLANGE NUTS (ITEM #17), AS SHOWN IN THE DRAWING ON PAGE 3.
4. THE SIDE ENTRY STEP ASSEMBLIES ARE MOUNTED TO THE PINCH WELD AND VERTICAL WALL OF THE ROCKER PANEL AS FOLLOWS. NOTE: DEPENDING ON WHEN AND WHERE YOUR VEHICLE WAS MADE, THE HOLE LOCATIONS AND FASTNERS MAY CHANGE. FASTNERS ARE PROVIDED FOR ALL APPLICATIONS.
5. REMOVE THE PLASTIC BODY PLUGS THAT ARE LOCATED ON THE VERTICAL WALL OF THE ROCKER PANEL AND INSERT THE U-NUTS (ITEM #3) INTO THE HOLES AS SHOWN ON PAGE 3.
6. POSITION THE SIDE ENTRY STEP SO THAT THE HOLES IN THE BRACKETS LINE UP WITH THE HOLES ON THE INSIDE WALL OF THE ROCKER PANEL.
7. INSTALL THE FRONT TWO (2) TOP BOLTS IN THE THREADED HOLES FROM THE FACTORY USING THE BLACK ZINC PLATED M8 X 30mm X 1.25 BOLTS (ITEM #9) AND 5/16" FLAT WASHERS (ITEM #5). INSTALL THE TWO REAR BOLTS USING THE 5/16"-18 X 1.00" HEX BOLTS (ITEM #6) AND 5/16" FLAT WASHERS (ITEM #5) INTO THE U-NUTS (ITEM #3).
8. PLACE NYLON WASHERS (ITEM #4) BETWEEN THE BRACKETS AND THE ROCKER PANEL BOTTOM HOLE AND INSERT 5/16"-18 X 1.00" HEX BOLTS (ITEM #6) AND 5/16" FLAT WASHERS (ITEM #5) THROUGH THE HOLES AND PINCH WELD SUPPORT BRACKET (ITEM #19) THEN INSTALL 5/16"-18 SERRATED FLANGE NUTS (ITEM #7) ON THE BOLTS.
9. PRESS SIDE ENTRY STEP DOWN AND BACK. TIGHTEN BOTTOM BOLTS FIRST THEN TOP.

TORQUE ALL BOLTS TO 19 FT LBS



1200 E. Birch St.

Brandon, SD 57005

REVISED 20OCT08 LVL D
REVISED 28NOV07 LVL C
REVISED 17MAY07 LVL B
REVISED 17APR07 LVL A
551381 SHEET 1 OF 6 31JAN07

SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	551375	1	STEP PLATE - SES, LH,
2	551374	1	STEP PLATE - SES ,RH
3	105541	8	U-NUT, 5/16"-18
4	107182	8	WSHER - NYLON, 312 X 1.24 X .25
5	102734	16	FLAT WASHER - 5/16", SST
6	100647	16	SCREW - 5/16" X 1.00", ZP
7	102680	8	NUT - SERR FLG,SST,5/16"
8	551382	8	BRKT-MTG,RH/LH-SES/MS
9	100180	8	M8 X 30 X 1.25, SCR,SST,BZP
10	105859	2	NUT - HEX FLNG M8 X 1.25,YZP
11	104250	2	END CAP - RH FRONT/LH REAR
12	104251	2	END CAP - LH FRONT/RH REAR
13	102502	2	TRIM - SEAL, EXTRUSION, 95"
14	105500	4	STEP PAD - 5.50 X 20.00
15	104258	14	BOLT - ROUND HEAD, #10-24 X 3/4"
16	104259	2	BOLT - CLIPPED HEAD ROUND HEAD, #10-24 X 3/4"
17	104261	16	NUT - SERRATED FLANGE, #10-24
18	104257	12	NUT - HEX, SINGLE THREAD
19	551666	8	BRKT-MTG,PINCH WELD SUPPORT



(A LIVERNE Company)

1200 E. Birch St.

Brandon, SD 57005

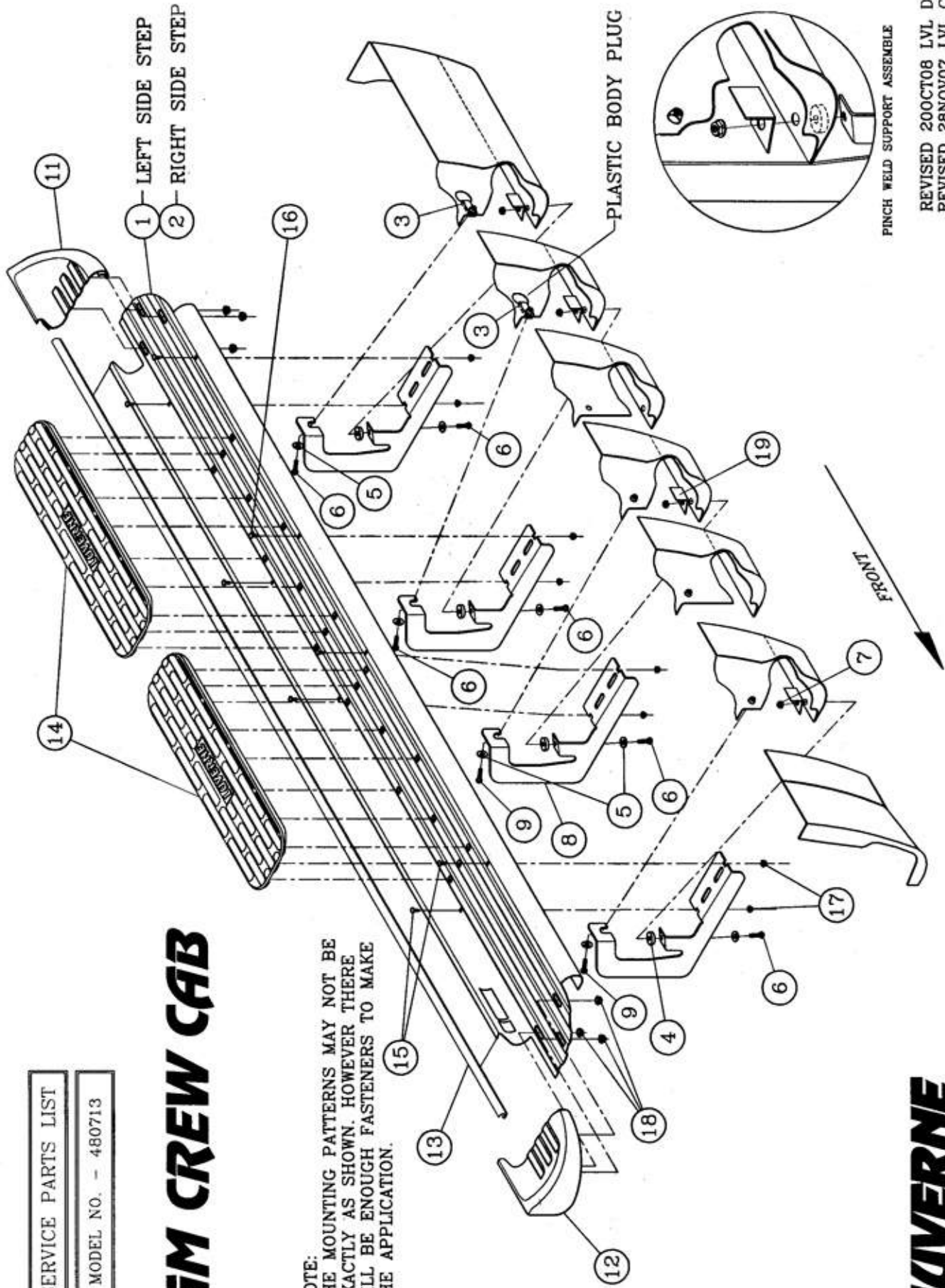
REVISED 20OCT08 LVL D
 REVISED 28NOV07 LVL C
 REVISED 17MAY07 LVL B
 REVISED 17APR07 LVL A
 551381 SHEET 2 OF 6 31 JAN 07

SERVICE PARTS LIST

MODEL NO. - 480713

GM CREW CAB

NOTE:
THE MOUNTING PATTERNS MAY NOT BE
EXACTLY AS SHOWN. HOWEVER THERE
WILL BE ENOUGH FASTENERS TO MAKE
THE APPLICATION.



PINCH WELD SUPPORT ASSEMBLY

REVISED 20OCT08 LVL D
REVISED 28NOV07 LVL C
REVISED 17MAY07 LVL B
REVISED 17APR07 LVL A
561381 SHEET 3 OF 6 31JAN07

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

LOVERNE
TRUCK EQUIPMENT
(A LOVERNE COMPANY)
1200 E. 84th St.
Grand Rapids, MI 49505

INSTALLATION INSTRUCTIONS AND PARTS LIST

APPLICATION: MODEL 480713 (STAINLESS STEEL) SIDE ENTRY STEPS ON:
2001 TO 2007 CHEVROLET SILVERADO AND GMC SIERRA CREW CAB PICKUPS

DRILL APPLICATION

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 PRE ASSEMBLED STEP PLATE TO REMOVE ANY VINYL COVERING RESIDUE. (A GOOD GLASS CLEANER IS SUGGESTED).
3. ASSEMBLE THE MOUNTING BRACKETS (ITEM #8) TO THE STEP PLATE ASSEMBLYS WITH THE #10-24 X 3/4" ROUND HEAD BOLTS (ITEM #15), #10-24 X 3/4" CLIPPED ROUND HEAD BOLTS (ITEM #16) AND THE #10-24 SERRATED FLANGE NUTS (ITEM #17), AS SHOWN IN THE DRAWING ON PAGE 6.
4. CLAMP THE STEP ASSEMBLYS TO THE PINCH WELD AND VERTICAL WALL OF THE ROCKER PANEL. (NOTE: THE STEP SHOULD BE FLUSH WITH THE BACK OF THE CAB.) USING THE HOLES IN THE MOUNTING BRACKETS AS A GUIDE, DRILL AN Ø11/32" HOLE THROUGH THE PINCH WELD AT EACH BRACKET.
5. PLACE NYLON WASHERS (ITEM #4) BETWEEN THE BRACKETS AND THE PINCH WELD BOTTOM HOLES AND INSERT 5/16" X 1" HEX BOLTS (ITEM #6) AND 5/16" FLAT WASHERS (ITEM #5) THROUGH THE HOLES AND PINCH WELD SUPPORT (ITEM # 19) THEN PLACE A 5/16" FLANGE NUT (ITEM #7) ON THE BACK TO HOLD THE STEP IN PLACE, WHILE MARKING THE TOP HOLE LOCATIONS FOR DRILLING.
6. REMOVE THE STEP PLATE AND DRILL Ø7/32" HOLES AT THE MARKED LOCATIONS.
7. REINSTALL THE STEP PLATE AS IN STEP #5, THEN INSTALL THE 5/16" AB SCREWS (ITEM #9) IN THE TOP HOLES IN THE ROCKER PANEL.
8. TIGHTEN THE BOTTOM BOLTS FIRST, THEN SNUG UP THE 5/16" TOP SCREWS, BUT DO NOT OVER TIGHTEN.

TORQUE ALL BOLTS TO 19 FT LBS



(A LUVERNE Company)

1200 E. Birch St.

Brandon, SD 57005

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551381 SHEET 4 OF 6 31JAN07

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LUPERNE
TRUCK EQUIPMENT

(A LUPERNE Company)

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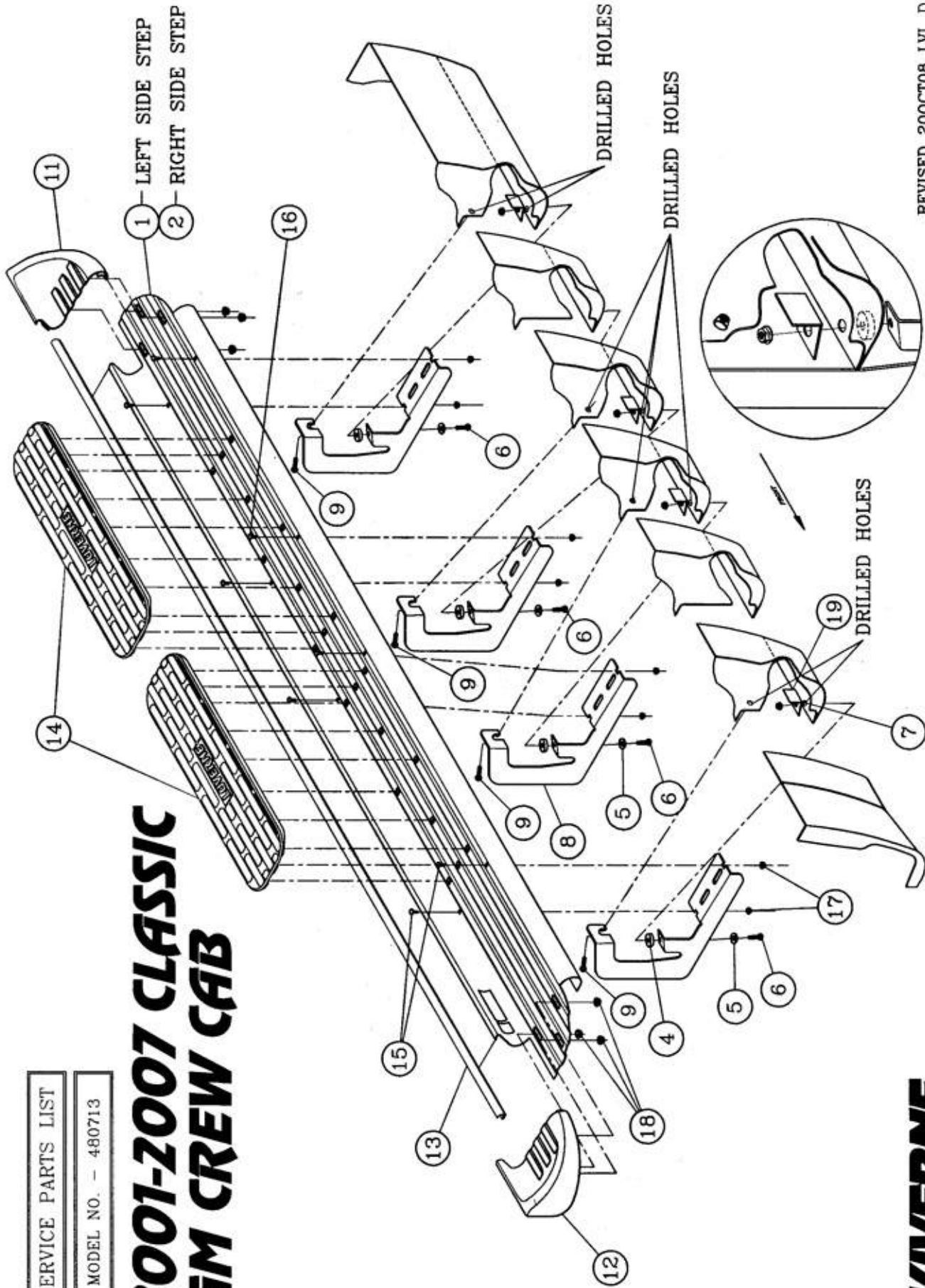
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551381 SHEET 5 OF 6 31 JAN 07

SERVICE PARTS LIST

MODEL NO. - 480713

2001-2007 CLASSIC GM CREW CAB



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REVISED 28NOV07 LVL. C
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551381 SHEET 6 OF 6 31JAN07

PINCH WELD SUPPORT ASSEMBLY

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

LIVERNE
TRUCK EQUIPMENT
A LIVERNE COMPANY

1280 E. Birch St. Brandon, SD 57005