

INSTALLATION INSTRUCTIONS AND PARTS LIST

APPLICATION: MODEL 481111 STAINLESS STEEL SIDE ENTRY STEPS ON:
2011 AND NEWER 1500/2500/3500 SERIES
CHEVROLET AND GMC REG 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. ASSEMBLE THE LOAD REACTION STUDS AND HARDWARE (ITEM #15 THRU #18) AS FOLLOWS.
 - 3.1. ON THE SHORT THREADED END OF THE LOAD REACTION STUD (ITEM #18), INSTALL A 3/8" SERRATED FLANGE NUT (ITEM #17) BACKWARDS TO THE BOTTTOM OF THE THREAD. THEN, INSTALL A 3/8" FLAT WASHER (ITEM #16) AND RUBBER "CUSHION" WASHER (ITEM # 15) TIGHT UP AGAINST THE SERRATED FLANGE NUT. (THE END OF THE STUD MUST BE RECESSED IN THE RUBBER WASHER APPROX. 3/16").
 - 3.2. ON THE LONG THREADED END OF THE STUD, INSTALL A 3/8" SERRATED FLANGE NUT (ITEM # 17) BACKWARDS TO NEAR TO THE BOTTTOM OF THE THREADS

NOTE: IF YOU ARE MOUNTING THE STEPS ON A 1500 MODEL PICKUP, YOU MUST ATTACH BRACKET 551571 (#22) TO BRACKETS 551814 & 551817 (#8 & 9) (SEE FIG 1) IN ORDER TO USE THE LOAD REACTION STUD.

4. ATTACH THE LOAD REACTION STUD ASSEMBLIES TO THE MOUNTING BRACKETS AS SHOWN.
 - 4.1. INSERT THE STUD, FROM WHAT WILL BE IN THE INBOARD OR FRAME SIDE THRU THE LOWEST HOLE IN THE BENT FLANGE OF THE BRACKET THAT WILL ALLOW THE RUBBER WASHER TO SEAT FIRM AGAINST THE SIDE WALL OF THE FRAME. INSTALL A BLACK FLANGE NUT (ITEM #17) ON THE OUTBOARD END OF THE STUD (FINGER TIGHT ONLY).

NOTE:

DUE TO EXCESSIVE THREAD LOCKER IN THE BODY MOUNT BOLT AREA ON THE 2010+ GM SILVERADO/SIERRA, LUVERNE TRUCK EQUIPMENT RECOMMENDS THE USE OF AN IMPACT WRENCH TO REMOVE THESE BODY MOUNT BOLTS IN ORDER TO REDUCE THE RISK OF CAUSING DAMAGE TO THE THREADED INSERTS INSIDE THE VEHICLE.

5. REMOVE THE FACTORY FRONT AND REAR BODY MOUNT BOLTS (ONE SIDE OF THE VEHICLE AT A TIME) AND INSTALL THE MOUNTING BRACKETS AND SIDE ENTRY STEPS PER THE FOLLOWING INSTRUCTIONS.
 - 5.1. INSTALL THE FRONT MTG BRKT (ITEM #8 & #9) TO THE FRONT BODY MOUNT AS SHOWN (LEAVE THESE FASTENERS FINGER TIGHT).
 - 5.2. INSTALL THE REAR MTG BRKT (ITEM #10 & #11) TO THE REAR BODY MOUNT AS SHOWN (LEAVE THESE FASTENERS FINGER TIGHT).
 - 5.3. ATTACH THE STEP PLATE ASSYS (ITEM #1 THRU #7) TO THE MTG BRKTS. USE #10-24 X 3/4 CARRIAGE BOLT (ITEM #12) & #10-24 SERRATED FLANGE NUT (ITEM #14). (TORQUE THESE FASTENERS TO 6 LB. IN.) (NOTE: INSURE THAT THE STEP PLATE MOUNTING BRACKETS DO NOT TOUCH THE INSIDE WALL OF THE BODY MOUNT HOUSING AND TORQUE THE BODY MOUNT FASTENERS TO MANUFACTURES SPECS.)
 - 5.4. POSITION THE STUD ASSY SO THAT THE RUBBER CUSHION IS SNUG UP AGAINST THE SIDE OF THE FRAME. TIGHTEN THE 3/8" FLG NUTS ON EITHER SIDE OF THE BRKT TO 19LB. FT.

SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	551820	1	STEP PLATE -RH, CHEVY/GMC 2500/3500, REG CAB
2	551821	1	STEP PLATE -LH, CHEVY/GMC 2500/3500, REG CAB
3	104250	2	END CAP-RH FRONT/LH REAR
4	104251	2	END CAP-LH FRONT/RH REAR
5	105500	2	PAD-MLD,STEP PLATE,20.00 X 5.50
6	104256	2	TRIM-SEAL,SES,EXTD,60.5", REG CAB
7	104257	12	NUT-HEX,SGL SELF THD,CAP WASHER,1/4"
8	551814	1	BRACKET-MTG, FRONT, LH, 481111
9	551817	1	BRACKET-MTG, FRONT, RH, 481111
10	551815	1	BRACKET-MTG, REAR, LH, 481111
11	551818	1	BRACKET-MTG, REAR, RH, 481111
12	104258	8	BOLT, ROUND HEAD, SST, #10-24 X 3/4"
13			
14	104261	8	NUT, SERR FLG, HEX, SST, #10-24
15	102592	4	WSHR, RUBBER, .354 ID X 1.00 OD X .75 THK
16	100062	4	WSHR, FL, 3/8", .438 ID X 1.00 OD X .083" THK
17	100181	12	NUT, SERR FLG, HEX, 3/8-16 UNC, ZP
18	104686	4	STUD, -DBL ENDED, STL, 3/8-16 X 4.00", ZP
19	108882	2	WSHR, FL, .59 ID X 1.06 OD X .19 THK, ZP
20	107645	2	CLIP-U, .115-.185, BLK
21	107958	4	SCR-PPH, #8-18 X 1/2, SST
22	551571	2	BRACKET-90 DEGREE, 3 HOLE
23	100178	2	NUT-SERR FLG, 5/16-18, ZP
24	100034	2	WSHR-FL, 5/16", ZP
25	100647	2	SCR-HEX HEAD, 5/16-18X1.00, ZP

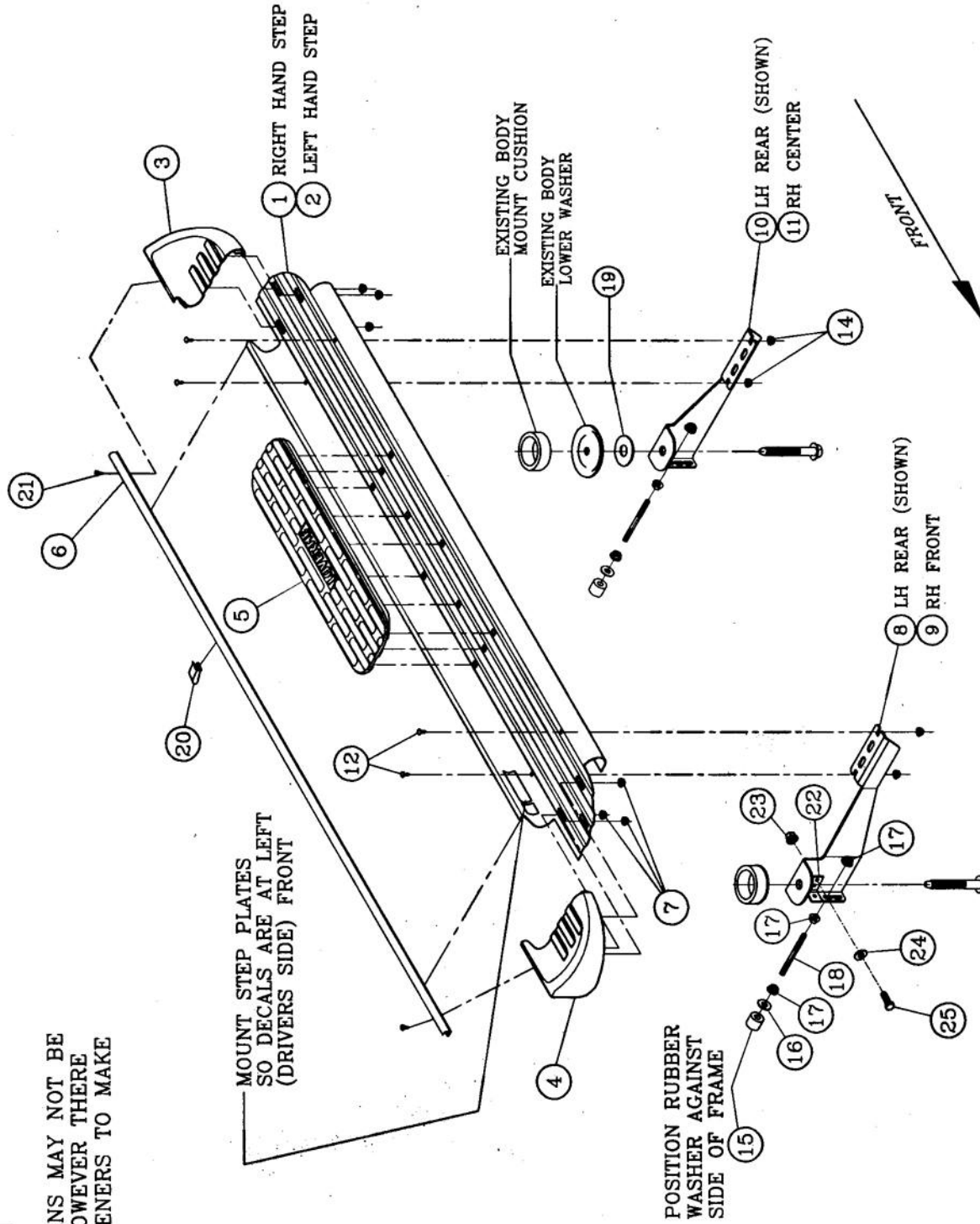
SERVICE PARTS LIST

MODEL NO. -481111

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

GM REG CAB HD

FIG. 1



#22, 23, 24, & 25 ARE USED ON 1500 MODELS ONLY

M14 EXISTING BODY MOUNT BOLTS TORQUE PER INSTRUCTION

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

LUVERNE
TRUCK
EQUIPMENT
INC
1200 Birch Street
Brandon, SD 57005

REV B 01OCT10
REV A 1SEPT10
551830 SHEET 3 OF 3 27JUL10