

INSTALLATION INSTRUCTIONS AND PARTS LIST

APPLICATION: MODEL **480742/481442** (STAINLESS STEEL) SIDE ENTRY STEP BOARDS:
ROCKER PANEL MOUNT 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. WITH THE STEP BOARD BRACKETS ATTACHED TO THE VEHICLE, ON THE LEFT SIDE OF THE VEHICLE PLACE THE STEP BOARD (ITEM #1) ON THE BRACKETS AND CHECK THAT THE MOUNTING HOLES LINE UP. (THE LUVERNE STICKER SHOULD BE ON THE FRONT DRIVERS SIDE)
3. USING SIX (6) 10-24 X .75" CARRIAGE BOLTS (ITEM #3), AND SIX (6) 10-24 FLANGE NUTS (ITEM #4) ATTACH THE STEP BOARD TO THE BRACKETS.

NOTE: ON STEP # 481442 ONE CARRIAGE BOLT SHOULD ALREADY BE INSTALLED UNDERNEAT THE REAR STEP PAD.

4. ADJUST STEP IN/OUT TO ALIGN STEP WITH THE CAB.
5. TIGHTEN STEP MOUNTING BOLTS.
6. REPEAT FOR RIGHT SIDE OF VEHICLE.

SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	551373	1	STEP PLATE-SES,LH,480742
1	552397	1	STEP PLATE-SES,LH,481442
2	551372	1	STEP PLATE-SES,RH,480742
2	552398	1	STEP PLATE-SES,RH,481442
3	104258	12	BOLT – CARRIAGE – SST, 10-24 X .75"
4	104261	36	NUT – FLANGE, SST, 10-24
5	104250	2	END CAP – RH FRONT/LH REAR
6	104251	2	END CAP – LH FRONT/RH REAR
7	104255	2	TRIM – SEAL, EXTRUSION, 80.50"
8	105500	4	STEP PAD, 5.50 X 20.00
9	104257	8	NUT – HEX, SINGLE THREAD
10	107958	4	SCR-PPH, #8-18 X .5", SST
11	107645	4	CLIP-U, .118-.185, BLK
12	107863	24	BOLT – CARRIAGE, 10-24 X .5", BZP



INSTALLATION INSTRUCTIONS AND PARTS LIST

APPLICATION: MODEL **581442** (STAINLESS STEEL) SIDE ENTRY STEP BRACKETS ON:
2015 GM 2500/3500HD DOUBLE CAB PICKUPS, GAS
ROCKER PANEL MOUNT APPLICATION



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. THE SIDE ENTRY STEP ASSEMBLIES SHOULD BE MOUNTED TO THE PINCH WELD AND VERTICAL WALL OF THE ROCKER PANEL AS FOLLOWS. **NOTE: DEPENDING ON THE VEHICLE, THE HOLE CONFIGURATION MAY CHANGE. FASTENERS ARE PROVIDED FOR ALL APPLICATIONS.**
2. ON THE LEFT SIDE OF THE VEHICLE REMOVE THE PLASTIC BODY PLUGS THAT ARE LOCATED ON THE VERTICAL WALL OF THE ROCKER PANEL AND INSERT A 5/16"-18 U-NUT (ITEM #7) AS SHOWN. **NOTE: IF THERE ARE THREADED INSERTS IN THE UPPER LOCATION, USE THE BLACK M8-1.25 X 30 MM BOLTS (ITEM #9).**
3. POSITION THE MOUNTING BRACKETS (ITEM #2) SO THAT THE HOLES ON THE BRACKET LINE UP WITH THE HOLES ON THE INSIDE WALL OF THE ROCKER PANEL. INSTALL A 5/16"-18 X 1.0" HEX BOLT, AND A 5/16" FLAT WASHER (ITEMS #4, 5) FINGER TIGHT.
4. INSTALL A BLACK M8-1.25 X 30 MM HEX BOLT, 5/16" FLAT WASHER, AND THE PINCH WELD SUPPORT (ITEMS #5, 8, 9) THROUGH THE HOLE AND INSTALL AM8-1.25 NUT (ITEM #6) FINGER TIGHT ON THE BACK AS SHOWN.
5. REPEAT STEPS 3 – 4 FOR THE REMAINING BRACKETS
6. INSTALL THE STEP BOARD AS DESCRIBED BY THE INSTRUCTIONS INCLUDED WITH YOUR STEP BOARDS.
7. PRESS STEP DOWN AND BACK, TIGHTEN THE MOUNTING BOLTS TO 19 LB-FT STARTING WITH THE BOTTOM BOLTS FOLLOWED BY THE TOP BOLTS.
8. REPEAT STEPS 2 – 7 FOR THE RIGHT SIDE OF THE VEHICLE

SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	481442	1	STEP ASSEMBLY, SES, (MOD 481442)
2	552626	3	BRKT-MTG, LH, SES/MS 07+ GM PICKUPS
3	552625	3	BRKT-MTG, RH, SES/MS, 07+ GM PICKUPS
4	106998	12	5/16" – FLATWASHER SST, BZP
5	100647	6	5/16"-18 X 1.00" SCR ZP
6	105859	6	NUT SERR FLG, M8-1.25, ZP
7	105541	6	U-NUT,5/16"-18
8	551666	6	BRKT-MTG,PINCH WELD SUPPORT
9	100180	10	SCREW-HEX, M8-1.25 X 30MM, BZP



(A LUVERNE Company)

1200 E. Birch St.

Brandon, SD 57005

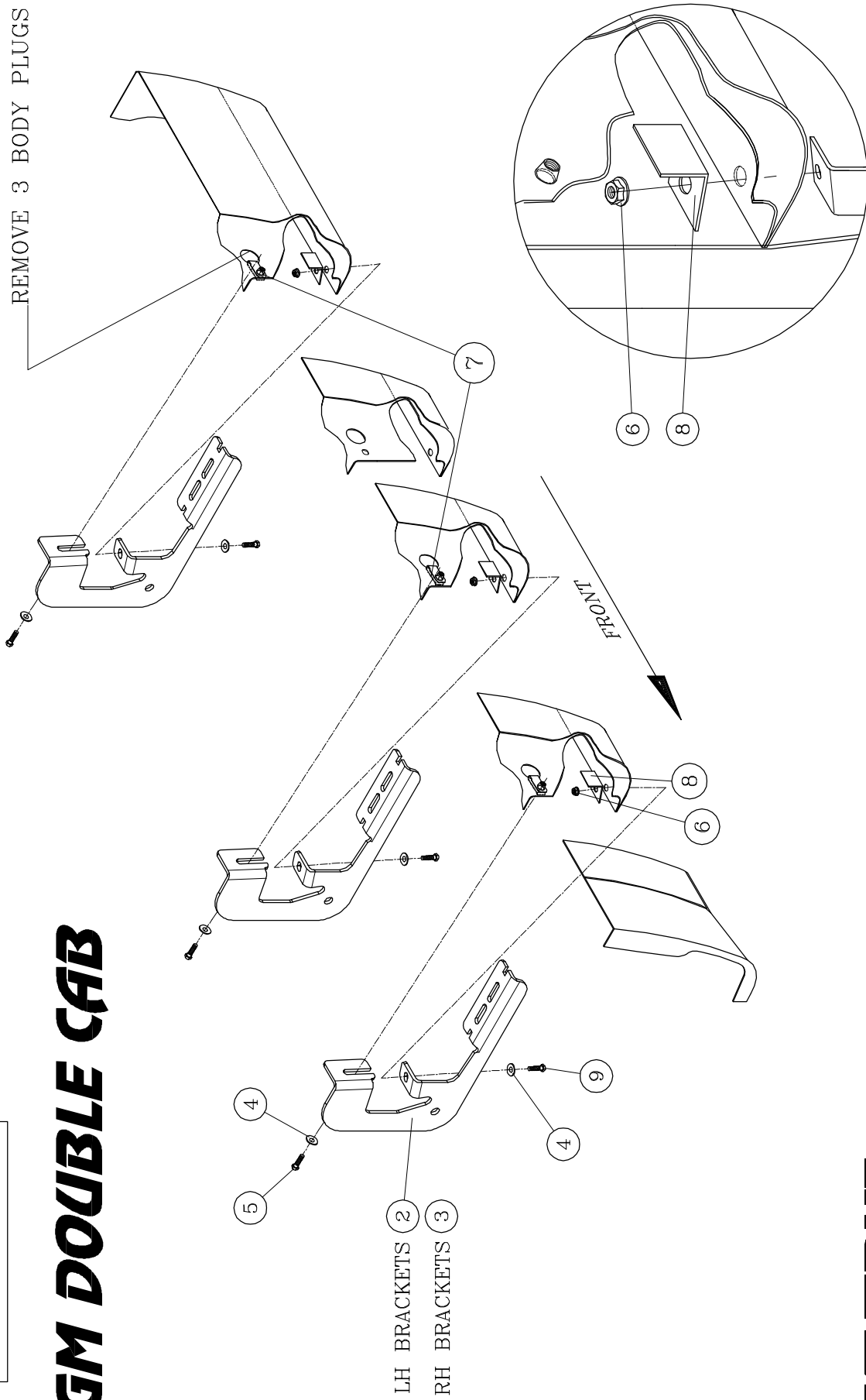
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SERVICE PARTS LIST

MODEL NO. - 581442

GM DOUBLE CAB

REMOVE 3 BODY PLUGS



PINCH WELD SUPPORT ASSEMBLY

LEFT (DRIVER) SIDE SHOWN

- RIGHT (PASSENGER) SIDE OPPOSITE -

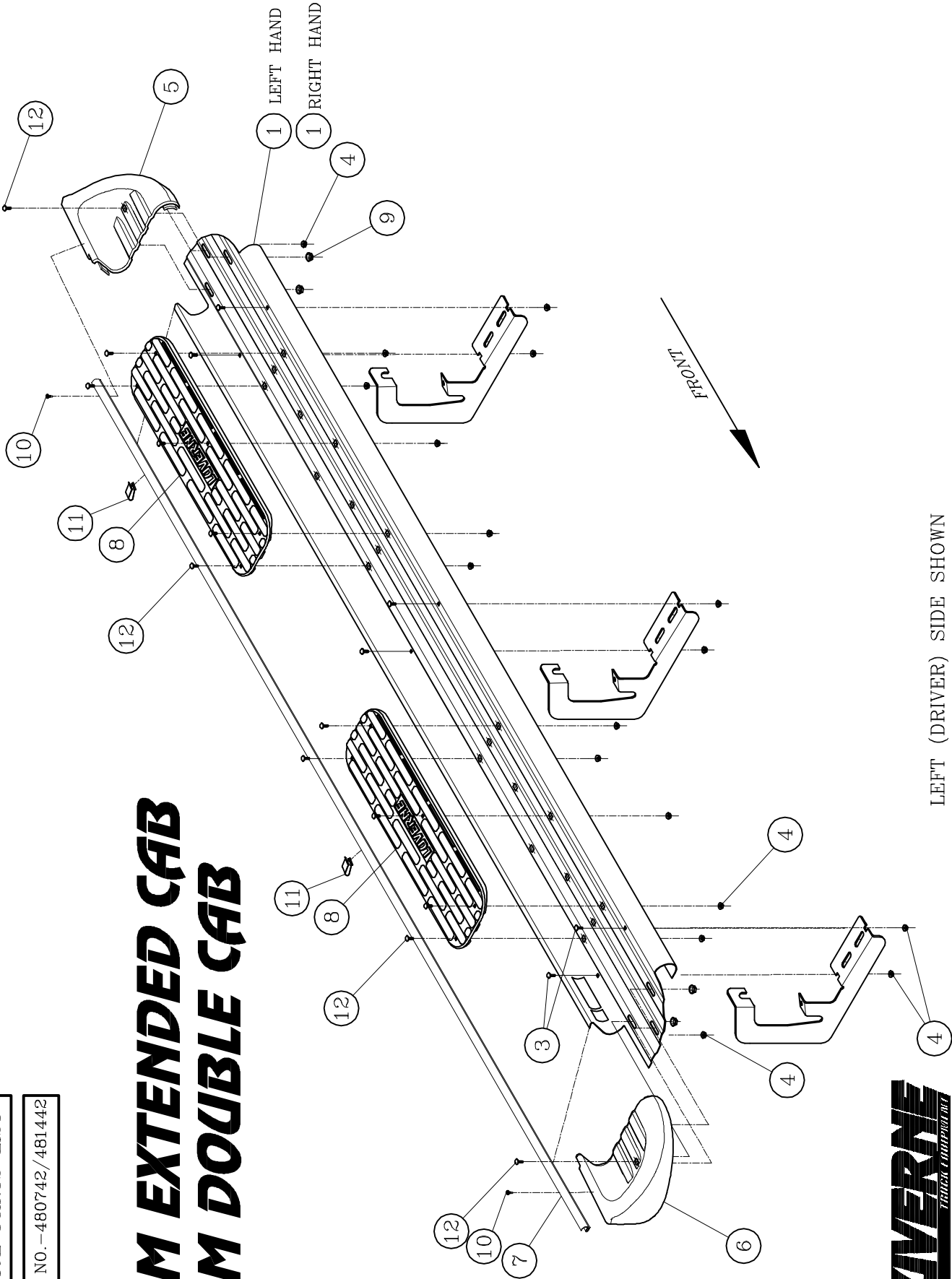


1280 E. 21st St. Spindon, GB S7606

SERVICE PARTS LIST

MODEL NO.-480742/481442

GM EXTENDED CAB GM DOUBLE CAB



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



1280 E. 21st St.
Spokane, WA 99205