



Step Bar Installation Instructions: Part Numbers 37-6321 and 37-6351, 204036

1967-72 Chevrolet and GMC 2 Wheel Drive 3/4Ton and all 4 Wheel Drive Pickups

Content List: (Qty)

(1) LH step Bar – long end of bar to rear of vehicle	(4) 3/8 x 1-1/4" hex head bolts
(1) RH step Bar – long end of bar to rear of vehicle	(4) 3/8" hex nuts
(1) LH front step bar mounting bracket	(8) 3/8" flat washers
(1) LH front support bracket	(4) 3/8" lock washers
(1) RH front step bar mounting bracket	(2) 7/16 x 9" hex head bolts
(1) RH front support bracket	(4) 7/16" flat washers
(2) Rear step bar mounting brackets	(2) Rear support brackets
(4) 3/16" thick spacer washers	(2) 9/16 x 6" hex head bolts
(4) 9/16" flat washers	(2) 9/16" torque lock nuts
(4) 12mm x 1.75 x 50mm hex head bolts	(8) 12mm flat washers
(4) 12mm lock washers	

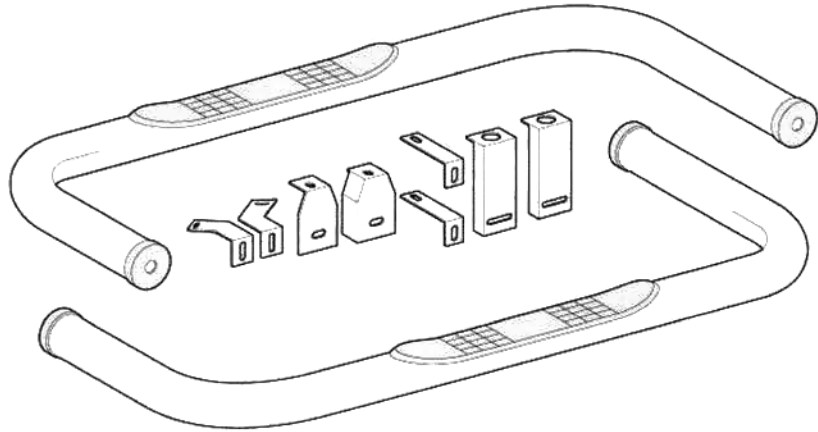
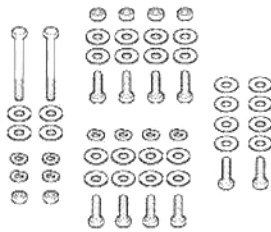
Instructions:

1. Read instructions completely before proceeding with installation.
2. To help identify the LH and RH step bar, notice the difference in length of the step bar mounting legs. When installed, the long leg is positioned to the rear of the vehicle.
3. Remove the nut from the front cab mount bolt. Depending on its condition, you may be able to reuse your existing bolt. To remove the front cab bolt you will need to access the interior side of the cab floor and then install the 9/16 x 6" bolt with flat washer. Install the front step bar mounting bracket to the front cab mount bolt. Install flat washer and lock nut and hand tighten.
4. Remove rear cab mount bolt. Remove lower bushing from sleeve and install rear step bar mounting bracket. Note the order of assembly – bracket, bushing, flat washer and 7/16 x 9" bolt. Install rear cab mount bolt and hand tighten.
5. Install step bar to front and rear brackets using the 12mm x 1.75 x 50mm bolts, lock washers and flat washers. With the bar bolted to front and rear brackets, check for proper clearance between step bar and rocker panel. If additional clearance is necessary, use the 3/16" spacer washers, as required, between the flat washer on the bottom side of cab bushings and step bar mounting brackets.
6. With proper clearance established, the front support bracket can be installed. The front support bracket will require drilling one 3/8" hole per side in the horizontal portion of the lower frame rail. It will be bolted to the frame using the 3/8 x 1-

1/4" bolt and is secured to the step bar mounting bracket with the step bar mounting bolt. The end of the front support bracket with the 90° bend mounts to the step bar mounting bracket and is held in place with the 1/2 x 2" step bar mounting bolt. Remove the step bar mounting bolt. Position the step bar support bracket so the flat horizontal surface of the support contacts the underside of the frame rail. Reinstall step bar mounting bolt and hand tighten. With the support bracket in position, mark hole location on frame rail. Drill hole. Secure support bracket to frame with a 3/8 x 1-1/4" bolt and corresponding lock washer, flat washer and hex nut. Hand tighten.

7. The rear support bracket will require drilling one 3/8" mounting hole per side in the horizontal portion of the lower frame rail. It will be bolted to the frame using the 3/8 x 1-1/4" bolt and is secured to the step bar mounting bracket with the step bar mounting bolt. Remove step bar mounting bolt and position rear support bracket so the flat horizontal surface of the support contacts the underside of the frame rail. Install step bar mounting bolt and hand tighten. Mark hole location on frame rail. To allow room for drilling operation, remove step bar mounting bolt, rear support bracket and the step bar mounting bracket. With hole drilled, reinstall the step bar mounting bracket, rear support bracket and step bar mounting bolt. Secure the rear support bracket to frame with 3/8 x 1-1/4" bolt and corresponding lock washer, flat washer and lock nut.
8. Check alignment of step bar. Make any final adjustments and then tighten all bolts.
9. Repeat procedure for the opposite side.
10. Check fasteners periodically. Re-tighten as necessary.

Contents



Assembly

