



# Installation Instructions

## Ford F250/F350 Side Steps “Cab Length”

Product Number: J1034  
Application: 1999-2012 Ford F250/F350 Crew Cab “Cab Length”

## SAFETY

### Your safety and the safety of others is very important.

- In order to help you make informed decisions about safety, we have provided installation instructions and other information.
- These instructions alert you to potential hazards that could hurt you or others.
- Please do a job safety analysis (JSA) before each task to identify potential hazards for your situation and remove/protect against them.
- You must use your own good judgment, and take your time.

**Read and understand all safety precautions and instructions before installing this product.**

THIS PRODUCT IS FOR OFFROAD USE ONLY. ALL LIABILITY FOR INSTALLATION AND USE RESTS WITH THE OWNER.

**CARELESS INSTALLATION AND OPERATION CAN RESULT IN SERIOUS INJURY OR EQUIPMENT DAMAGE.**

## Injury Hazard

### Failure to observe these instructions could lead to severe injury or death.

- Always** remove jewelry and wear eye protection.
- Always** use extreme caution when jacking up a vehicle for work. Set emergency brake and use tire blocks. Locate and use the vehicle manufacturers designated lifting points. Use jack stands.
- Always** use appropriate and adequate care in lifting components into place.
- Always** insure components will remain secure during installation and operation.
- Always** wear safety glasses when installing this kit. A drilling operation will cause flying metal chips. Flying chips can cause serious eye injury.
- Always** use extreme caution when drilling on a vehicle. Thoroughly inspect the area to be drilled (on both sides of material) prior to drilling, and relocate any objects that may be damaged.
- Always** use extreme caution when cutting and trimming during fitting.
- Always** tighten all nuts and bolts securely per installation instructions.
- Always** route electrical cables carefully. Avoid moving parts, components that become hot and rough or sharp edges.
- Always** insulate and protect all exposed wiring and electrical terminals.
- Always** perform regular inspections and maintenance on mounts and related hardware.



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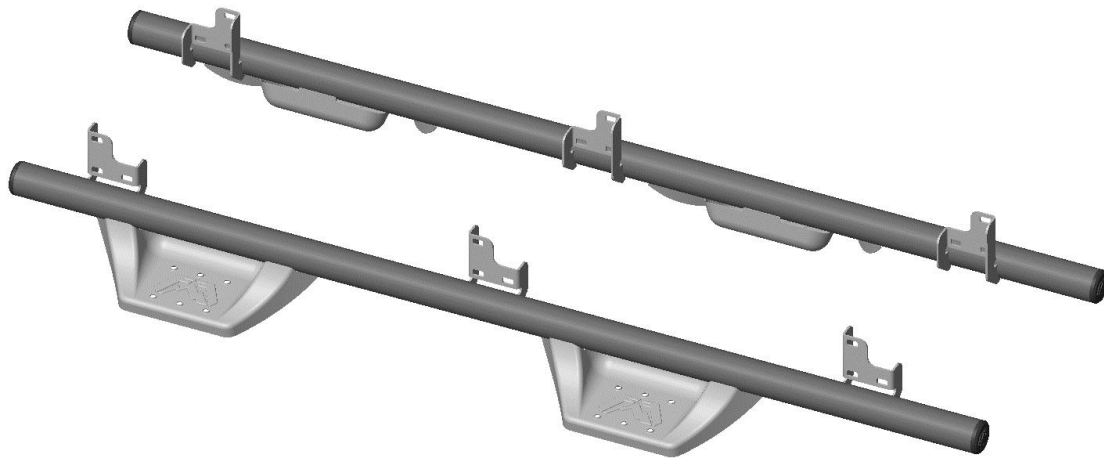
**PATENT NOTE:** There is one or more patent pending that covers this vehicle step assembly. Making or selling reproductions of the vehicle step assembly without prior written permission from Fab Fours Inc. is prohibited, except as allowed under the U.S. patent laws.

### I. Overview

Congratulations on your new purchase of the industries' best and most stylish Side Step available for the Ford F250/350! These Side Steps have been **engineered** for strength.

Your Side Steps are designed in 3-D from digitized data, CNC laser cut, fabricated, and powder coated... all in the U.S.A.

Enjoy the fit and finish of quality Ford F250/350 Side Steps from FabFours Inc.





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### II. Tools Required

- Socket Wrench with 6” Extension
- ½” socket
- ½” combination wrench
- Rubber mallet

### III. Kit Contents

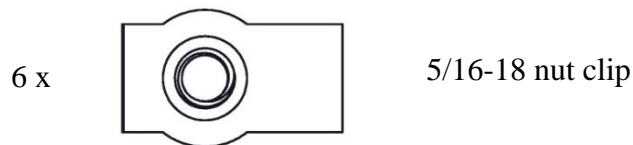
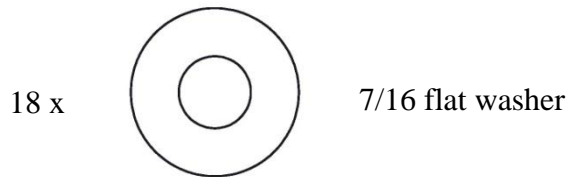
	QTY	DESCRIPTION	FAB FOURS PART NUMBER
	x 1	Driver-side Side Step	20438
	x 1	Passenger-side Side Step	20439
	x 4	End Cap	61367
	x 1	J1034 Hardware Kit	104711-HW
	x 1	J1034 Instruction Manual	J1035-IM



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**IV. Included Hardware**

**104711-HW**





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### V. Removal of OEM Side Steps (if applicable)

1. From underneath the driver side of the vehicle, remove the OEM side steps using a socket wrench with a 1/2” socket. Use a 6” extension if required.
  - a) The OEM steps are mounted using three (3) brackets on each side step.
  - b) Each OEM bracket uses three (3) 5/16-18 fasteners that are removed with a 1/2” socket.
  - c) The bottom two (2) bracket fasteners are fastened with a nut that can be held using a 1/2” combination wrench.
  - d) The front and rear bracket upper bolts can be used to hold the OEM side step in place as the other fasteners are removed. See below to identify the ‘upper’ fastener:

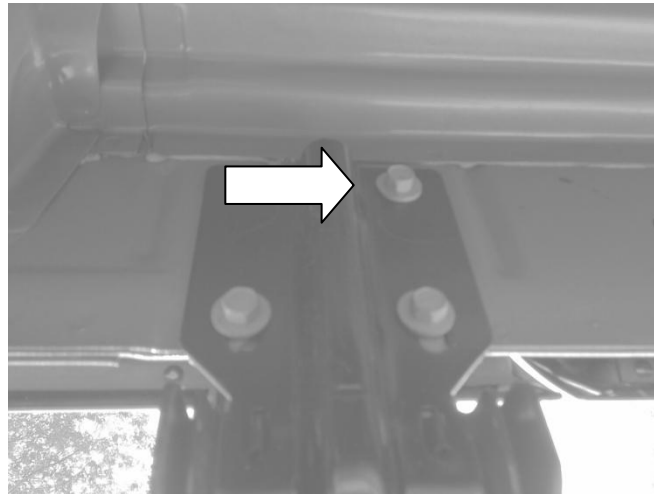


Figure 1 – OEM FORD SIDE STEP MOUNTING BRACKET

2. With the OEM fasteners removed, prepare your work area to remove the OEM side step.
3. If the front and rear bracket upper bolts are still in place, remove them now to lower the OEM side step from the vehicle.
4. With all of the OEM bolts removed, the OEM side step can be removed from the vehicle and set aside.
5. Repeat steps 1) thru 4) above to remove the passenger side OEM side step.

**NOTE:** The FabFours Side Steps are shipped with a hardware kit that includes all required hardware to install your new FabFours Side Steps. OEM fasteners can be



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set aside for use if desired/required, but are not needed for regular installation of FabFours Side Steps.

6. After both OEM side steps are removed, the vehicle is ready to install your new FabFours Side Steps.

### VI. Installation of FabFours Side Steps

1. Install End Caps (61367) on your driver and passenger side FabFours Side Steps prior to installing steps on your vehicle. If needed, a rubber mallet can be used to fully seat the end caps into the FabFours Side Step tube. See below:

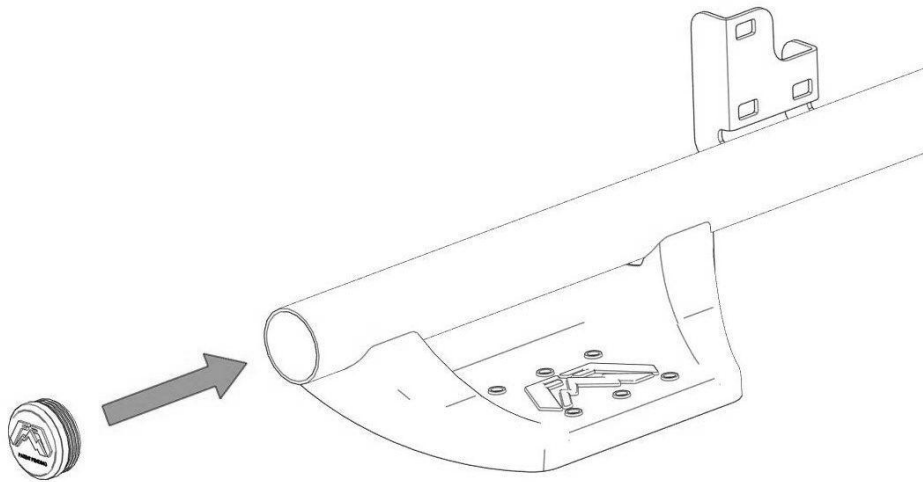


Figure 2 - INSTALLING THE FABFOURS SIDE STEP END CAPS

2. From underneath the vehicle, verify that a 5/16-18 nut clip has been added to each side step mount point. The nut clip is always inserted in the upper right hole as shown in the image below. Either use 1) an OEM installed 5/16-18 nut clip, or 2) install a FabFours provided 5/16-18 nut clip. See below for position reference:

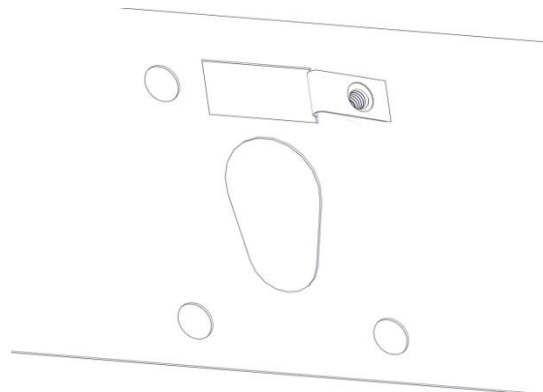


Figure 3 - ADD NUT CLIPS TO THE UPPER RIGHT BODY HOLE FOR SIDE STEP BRACKETS



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**NOTE:** Some installations may not require the use of all hardware provided by FabFours. Hardware remaining after installation is not an indication of faulty installation.

3. Identify the driver side FabFours Side Step. The driver side FabFours Side Step is shown below:

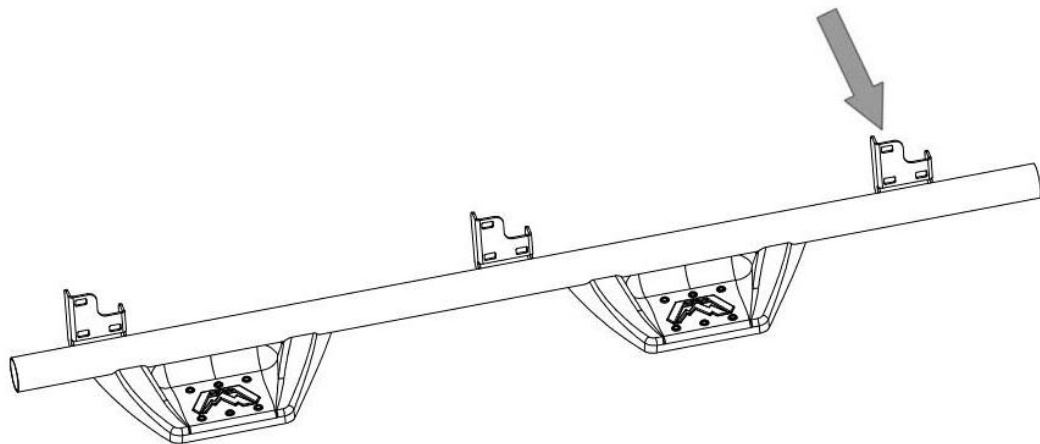


Figure 4 - DRIVER SIDE FABFOURS SIDE STEP

4. From underneath the driver side of the vehicle, lift the FabFours Side Step to a position where the front top 5/16-18 bolt, flat washer and lock washer can be installed. **Do not tighten!** This bolt can be used to hold the FabFours Side Step in position as the other hardware is added. Stack-up of fasteners is shown in Figure 7 for additional reference. See below for front fastener identification:

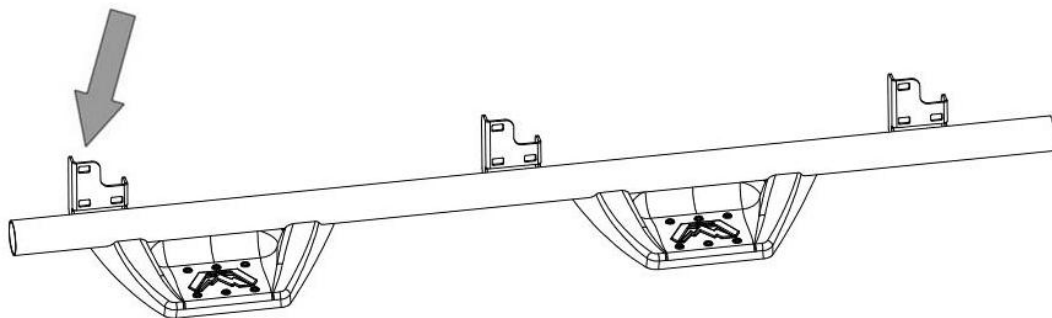


Figure 5 - ADD FRONT 5/16-18 BOLT TO HOLD STEP FIRST

5. Move to the rear mounting bracket, lift the FabFours Side Step into position and install the rear 5/16-18 bolt, flat washer and lock washer into the nut clip. **Do not tighten!** At this time, the step is supported by the vehicle and ready for the remaining hardware to be added.

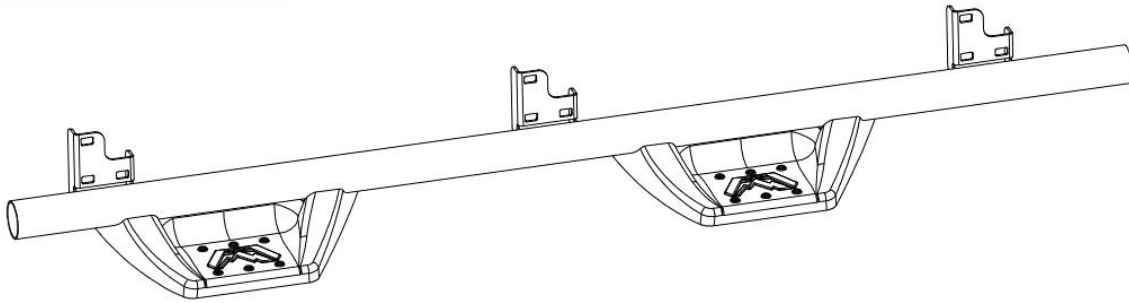




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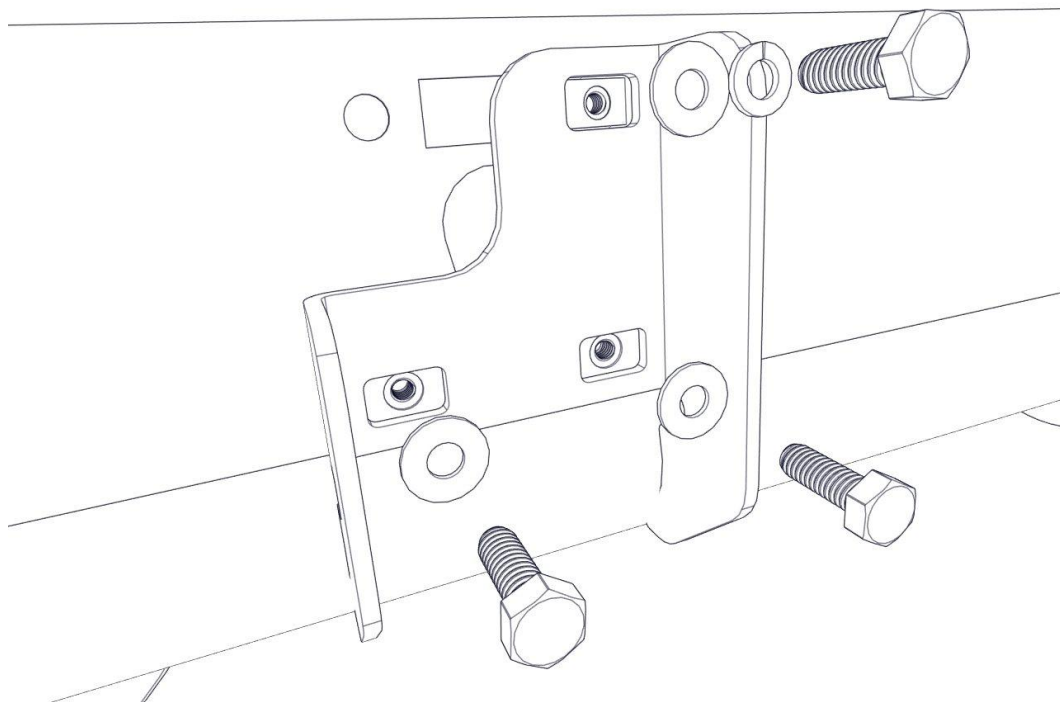
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**Figure 6 – ADD REAR M8 BOLT TO HOLD STEP SECOND**

6. Add the lower two (2) 5/16-18 flange nuts, flat washers and 5/16-18 bolts to the bottom two vertical M8 bolts. **Do not tighten!**



**Figure 7 - HARDWARE STACKUP FOR MOUNTING SIDE STEP**

7. Once all fasteners have been loosely threaded into position, the step can be adjusted front or back as needed to best match your vehicle installation requirements.
8. With all hardware in place, the fasteners can be tightened with a 1/2" socket and 1/2" combination wrench. Verify that each FabFours Side Step mounting bracket is tight against the body at the vertical mounting surfaces before final tightening.

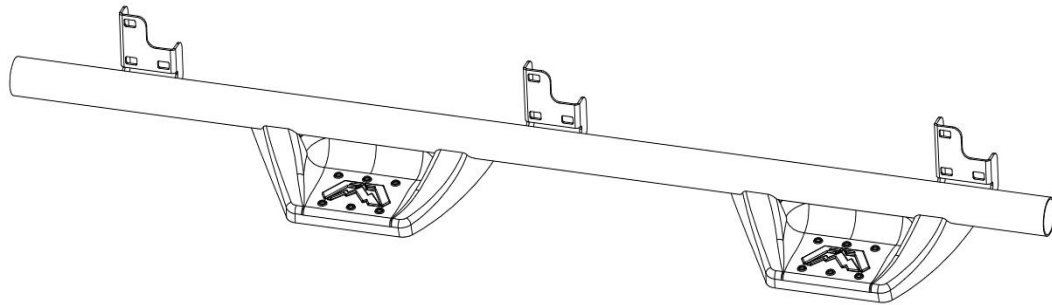


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9. Congratulations, your new FabFours Side Step has been installed successfully on the driver side of your vehicle!
10. Identify the passenger side FabFours Side Step. The passenger side FabFours Side Step is shown below:



**Figure 8 - PASSENGER SIDE FABFOURS SIDE STEP**

11. Repeat steps 3) thru 9) above to install the passenger side FabFours Side Step.
12. Congratulations, your new FabFours Side Step has been installed successfully on the passenger side of your vehicle!



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### VII. Maintenance/Care

- Periodically check and tighten all fasteners.
- Stripped, fractured, or bent bolts or nuts need to be replaced.
- After washing of the vehicle make sure to fully dry all surfaces



More than expected... Better than expected