



02-08 Dodge Ram 1500 , 03-09 2500/3500

QUAD CAB

51-610,614 41-610,612,614
52-610,612 42-610,612
53-610,612 43-612

TUBE STEP INSTALLATION SHEET

- STEP 1** REMOVE ALL CONTENTS FROM THE BRACKET BOX AND CHECK FOR CORRECT QUANTITY AND ANY DAMAGED PARTS.
- STEP 2** INSTALL FRAME LOCKING BOLTS INTO TRUCK BODY, USING THE BRACKETS TO DETERMINE CORRECT LOCATION. REFER TO FIG. 1 & 2 FOR CORRECT INSTALLATION METHOD.
- STEP 3** INSTALL FRONT AND REAR BRACKETS USING HARDWARE DESCRIBED. HAND TIGHTEN ALLOWING FOR FINAL ADJUSTMENTS.
- STEP 4** BOLT THE TUBE TO THE BRACKETS USING HARDWARE DESCRIBED. HAND TIGHTEN THE BOLTS. ALIGN THE TUBE WITH THE TRUCK AND TIGHTEN THE TUBE STEP BOLTS FIRST TO 65 FT./LBS. THEN TIGHTEN THE BRACKET BOLTS TO 35 FT./LBS.
- STEP 5** REPEAT STEPS 2 THROUGH 4 FOR INSTALLATION OF PASSENGER SIDE.

QTY.	PARTS LIST	QTY.	PARTS LIST
2	1610 FRONT BRACKETS	4	½" FLAT WASHERS
2	1610 REAR BRACKETS	4	½" LOCK WASHERS
4	½" X 1 -3/4" HEX BOLTS	2	TUBE STEPS
10	FRAME LOCKING BOLTS	10	3/8" FLANGE NUTS

For use on 52,53,42,43 series (extra parts for rear bracket only)

2	½" Nut	2	½" Lock Washer
2	½" Flat Washer		

MAINTENANCE AND CARE

Only use mild soap for regular cleaning. For heavy build up, a solution of ammonia and water can be used. Never use an abrasive material, i.e. steel wool, for cleaning purposes. Use terry cloth towels wiping in the direction of the tube at all times.

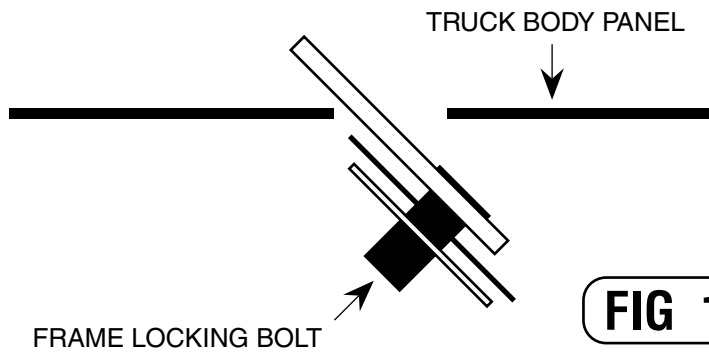


FIG 1

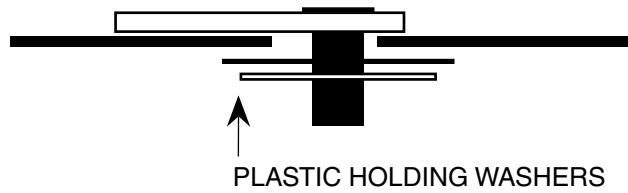
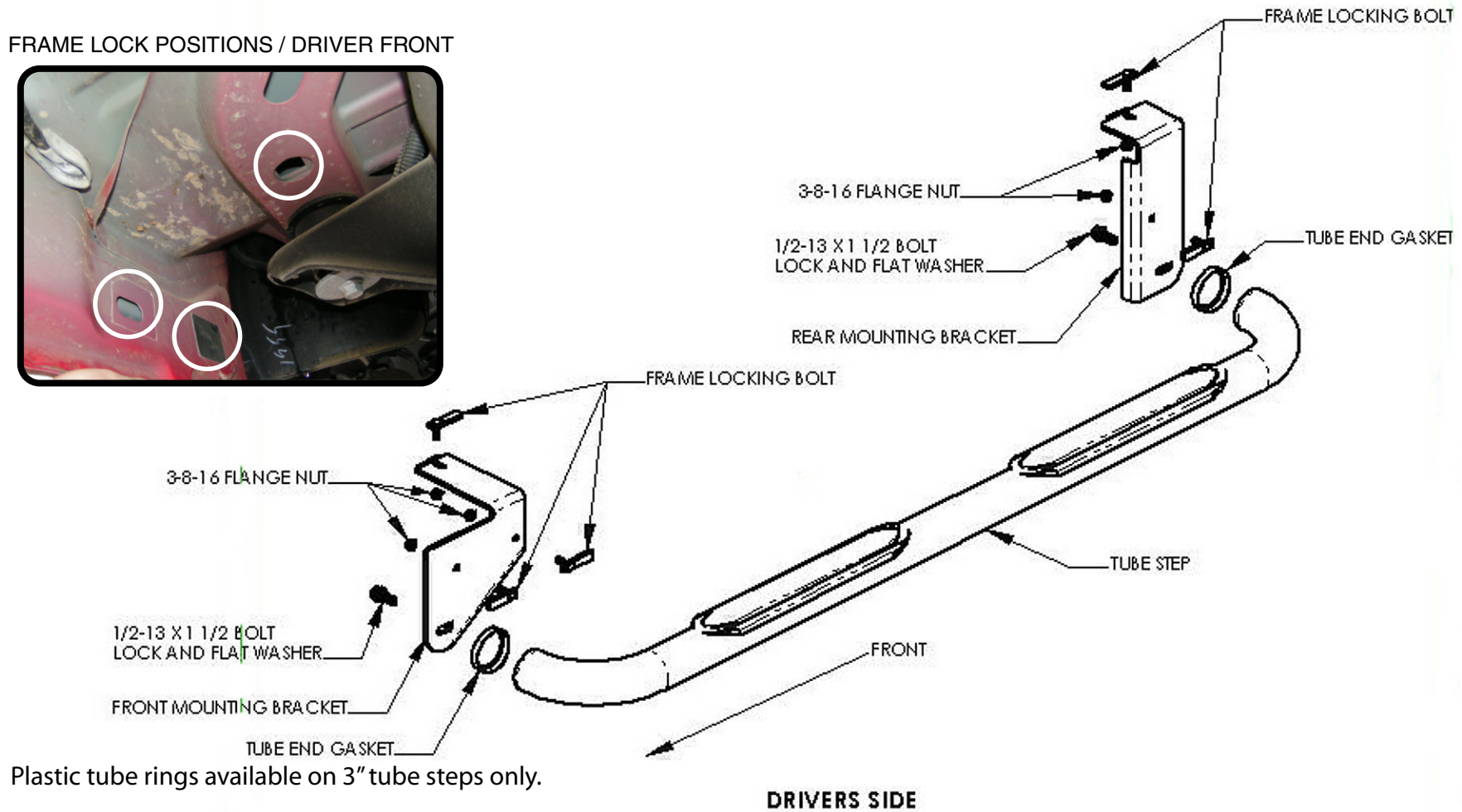


FIG 2

FRAME LOCK POSITIONS / DRIVER FRONT



Plastic tube rings available on 3" tube steps only.