



04-08 F-150 Regular Cab

51-420

TUBE STEP INSTALLATION SHEET

- STEP 1** REMOVE ALL PARTS FROM THE BRACKET BOX AND CHECK FOR CORRECT QUANTITY AND ANY DAMAGED PARTS.
- STEP 2** INSTALL THE FRONT BRACKET BY INSERTING CLIPS INTO THE BODY PANEL. REMOVE THE PLUG IN FRONT OF THE CLIPS AND INSERT IN THE FRAME LOCKER. BOLT UP THE BRACKET USING THE HARDWARE DESCRIBED IN THE ILLUSTRATION. HAND TIGHTEN AT THIS TIME ALLOWING FOR FINAL ADJUSTMENTS.
- STEP 3** INSTALL THE REAR BRACKET BY REMOVING BOTH OF THE REAR PLUGS ON THE INNER BODY PANEL. INSERT THE BOLT PLATE THROUGH THE LARGE HOLE AND BACK THROUGH THE SMALL ONE. ON SUPER CAB TRUCKS USE THE REAR TWO SLOTTED HOLES ON THE BRACKET. SUPER CAB OWNERS USE THE FORWARD TWO SLOTTED HOLES. HAND TIGHTEN AT THIS TIME TO ALLOW FOR FINAL ADJUSTMENT. DO NOT USE THE SELF TAPPING SCREWS AT THIS TIME.
- STEP 4** BOLT THE TUBE STEP TO THE BRACKETS AS SHOWN USING THE DESCRIBED HARDWARE. BOLT THE TUBE TO THE FRONT BRACKET FIRST.
- STEP 5** INSURE ALL PARTS ARE PROPERLY ALIGNED AND TIGHTEN ALL BOLTS. TIGHTEN THE TUBE STEP BOLTS FIRST TO 65 FT./LBS. TIGHTEN THE BRACKET BOLTS NEXT TO 35 FT./LBS.
- STEP 6** DOUBLE CHECK THE TUBE IS PROPERLY ALIGNED AND THEN USE THE SUPPLIED SELF TAPPING SCREWS FOR THE REAR BRACKET.
- STEP 7** REPEAT STEPS 2 THROUGH 5 FOR INSTALLATION OF PASSENGER SIDE.

QTY	PARTS LIST	QTY	PARTS LIST	QTY	PARTS LIST	QTY	PARTS LIST
2	1422 Front Bracket	4	1/2" -13 x 1-3/4" Hex Bolt	4	5/16" Nut Clip	4	5/16" Lock Washer
2	1422 Rear Bracket	4	1/2" Flat Washer	4	1/4" -14 x 1" Self Tapping Screws	4	3/8" Flat Washer
2	4-1/2" x 1-1/4" Plate	4	1/2" Lock Washer	4	5/16" -18 Hex Nut	4	3/8" Lock Washer
2	Frame Lock Assemblies	8	5/16" -18 x 1-1/2" Flange Bolt	4	5/16" Flat Washer	4	3/8" Hex Nut

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.

RV2.22.08

