



97-03 Ford F-150 Reg, Extended, & Super Crew Cab

51-400,402,406
52-402,406

TUBE STEP INSTALLATION SHEET

- STEP 1** REMOVE ALL CONTENTS FROM THE BRACKET BOX AND CHECK FOR CORRECT QUANTITY AND ANY DAMAGED PARTS
- STEP 2** REMOVE THE FOUR BLACK RUBBER PLUGS ON THE INSIDE BODY PANEL UNDER THE TRUCK
- STEP 3** INSTALL THE FRONT BRACKET BY INSERTING THE LARGER BOLT PLATE THROUGH THE HOLE IN THE BODY AS SHOWN IN FIG. 1, USING THE HARDWARE AS DESCRIBED IN FIG. 2. **DO NOT USE THE SELF TAPPING SCREWS AT THIS TIME.** MAKE SURE TO LEAVE THE BRACKETS LOOSE ENOUGH FOR FINAL ADJUSTMENTS.
- STEP 4** INSTALL THE REAR BRACKET BY INSERTING THE LARGER BOLT PLATE THROUGH THE HOLE IN THE BODY PANEL AS SHOWN IN FIG. 1, USING THE HARDWARE AS DESCRIBED IN FIG. 3. **DO NOT USE THE SELF TAPPING SCREWS AT THIS TIME.** MAKE SURE TO LEAVE THE BRACKETS LOOSE ENOUGH FOR FINAL ADJUSTMENTS.
- EXTENDED CAB TRUCKS** - YOU MUST USE THE SMALL BOLT PLATE ON THE REAR LEFT BRACKET, USING THE TWO LOWER HOLES IN THE BRACKET.
- STEP 5** THE TUBE STEP IS UNIVERSAL FROM SIDE TO SIDE. BOLT THE TUBE STEP TO THE BRACKET AS SPECIFIED IN FIG. 2 & 3. ALIGN THE TUBE WITH THE TRUCK AND TIGHTEN THE TUBE STEP TO THE BRACKETS. TIGHTEN THE BOLTS TO 65 FT./LBS. TIGHTEN ALL BRACKET BOLTS NEXT TO 28 FT./LBS.
- STEP 6** DOUBLE CHECK TUBE ALIGNMENT AND THEN INSTALL (3) 1/4" X " SELF TAPPING SCREWS IN EACH BRACKET.

QTY	PARTS LIST	QTY	PARTS LIST
2	1400 Front Bracket	4	1/2" Lock Washer
2	1400 Rear Bracket	8	3/8" Flat Washer
4	5-1/4" x 2-1/4" Plate	8	3/8" Lock Washer
1	4-1/2" x 1-1/4" Plate	8	3/8" - 16 Hex Nut
4	1/2" - 13 x 1-3/4" Hex Bolt	12	1/4" - 14 x 1" Self Tapping Screw
4	1/2" 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.

