

INSTALLATION INSTRUCTIONS AND PARTS LIST
MODEL 477054, 477060 REGAL 7 OVAL STEPS (BOARDS ONLY)
UNIVERSAL APPLICATIONS



1. Read instructions completely and check to make sure that all required parts (listed on the service parts list) are on hand before starting the installation.
2. Follow the instructions included with the specific bracket package that you are using to mount the brackets to your vehicle. The serial number label is located on the front inside drivers side step assembly.
3. The step is pre-assembled from the factory. The serial number label is located on the front inside drivers side step assembly.
- 4.
5. Attaching the step to the mounting bracket:
 - 4.1 Set the step on the mounting brackets, and slide each support mounting plate (item #9) inside the oval step and above each bracket.
 - 4.2 Using the supplied 5/16-18 x 1" black stainless steel hex bolt, washer, and serrated flange nut (items # 10,11&12) attach the step assembly, support mounting plate and mounting bracket.
 - 4.3 Set the step plate in the correct position and tighten all fasteners.
Torque all 5/16" fasteners to 19 LB FT.

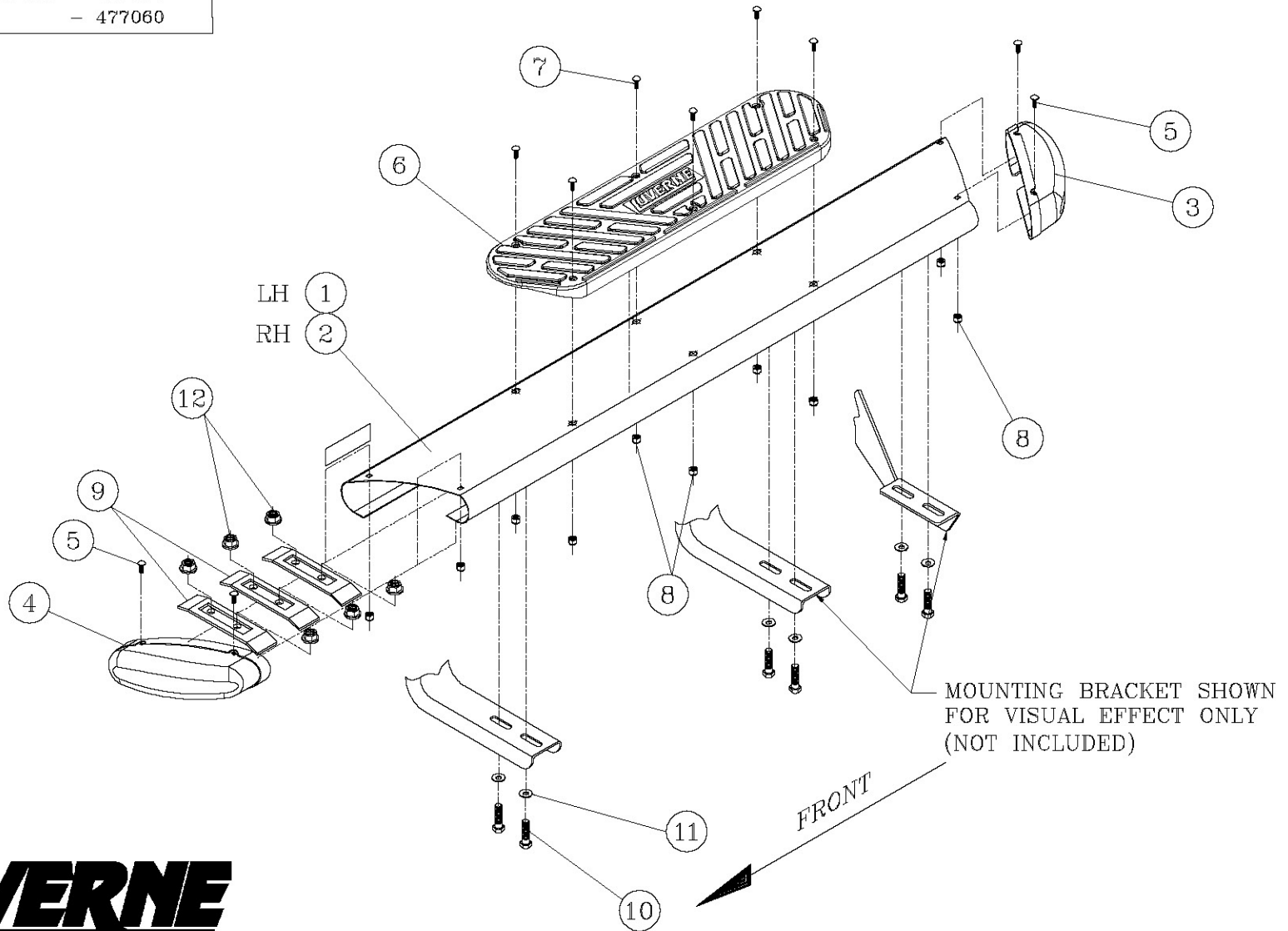
SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1&2	552054	2	REGAL 7 OVAL STEP, LH,RH,52",477054
1&2	552055	2	REGAL 7 OVAL STEP, LH,RH,58",477060
3	109233	2	END CAP LH REAR, RH FRONT,BLK PLASTIC
4	109232	2	END CAP RH REAR, LH FRONT,BLK PLASTIC
5	107863	8	BOLT-CARRAIGE, 10-24 X 0.50,SST, BLACK
6	108909	2	STEP PAD, 25" X 6.5", PLASTIC, BLACK
7	108908	12	BOLT-CARRAIGE, 10-24 X 1.0,SST, BLACK
8	107864	12	NUT-NYLOCK, 10-24, SST
9	552052	6	SUPPORT MTG PLT, 11 GA, GALV
10	106997	12	SCREW-HEX HD, 5/16-18X1.0,SST,BLACK
11	106998	12	WSHR-FLAT, 5/16, SST, BLACK
12	102680	12	NUT-SER FLG, 5/16-18, SST



SERVICE PARTS LIST

MODEL NO. - 477054
- 477060



LUVERNE
TRUCK EQUIPMENT
(A LUVERNE Company)

INSTALLATION INSTRUCTIONS AND PARTS LIST

APPLICATION: MODEL **401741** GRIP-STEP/REGAL 7 BRACKETS ON:
2015 GM 2500/3500HD REGULAR CAB PICKUPS, GAS/DIESEL
BODY MOUNT APPLICATION



NO DRILL APPLICATION

1. READ INSTRUCTIONS COMPLETELY AND CHECK TO MAKE SURE THAT ALL REQUIRED PARTS (LISTED ON SERVICE PARTS LIST) ARE ON HAND BEFORE STARTING THE INSTALLATION.
2. ON THE LEFT SIDE OF THE VEHICLE PREASSEMBLE THE FRONT BRACKET (ITEMS #1, 3, 12) AS SHOWN IN **FIG. 1** USING THREE 3/8"-16 X 1.0" SCREWS, 3/8" FLAT WASHERS AND 3/8" FLANGE NUTS. (ITEMS #10, 7, 8). TORQUE TO 19 LB. FT.
3. ASSEMBLE THE LOAD REACTION STUDS AND HARDWARE (ITEMS #6 THRU #9) AS FOLLOWS.
 - 3.1. ON THE SHORT THREADED END OF THE LOAD REACTION STUD (ITEM #9), INSTALL A 3/8" SERRATED FLANGE NUT (ITEM #8) BACKWARDS TO THE BOTTOM OF THE THREAD. THEN INSTALL A 3/8" FLAT WASHER (ITEM #7) AND RUBBER "CUSHION" WASHER (ITEM #6) TIGHT UP AGAINST THE SERRATED FLANGE NUT. (THE END OF THE STUD MUST BE RECESSED IN THE RUBBER WASHER APPROX. 3/16").
 - 3.2. ON THE LONG THREADED END OF THE STUD, INSTALL A 3/8" SERRATED FLANGE NUT (ITEM #8) BACKWARDS TO NEAR TO THE BOTTOM OF THE THREADS
4. ATTACH THE LOAD REACTION STUD ASSEMBLIES TO THE MOUNTING BRACKETS AS SHOWN IN **FIG. 2**. INSERT THE STUD, FROM WHAT WILL BE THE INBOARD OR FRAME SIDE THRU THE LOWEST HOLE IN THE BENT FLANGE OF THE BRACKET THAT WILL ALLOW THE RUBBER WASHER TO SEAT FIRM AGAINST THE SIDE WALL OF THE FRAME. INSTALL A 3/8"-16 FLANGE NUT (ITEM #8) ON THE OUTBOARD END OF THE STUD (FINGER TIGHT ONLY).

NOTE:

DUE TO EXCESSIVE THREAD LOCKER IN THE BODY MOUNT BOLT AREA ON THE SILVERADO/SIERRA, USE CAUTION WHEN REMOVING THE BODY MOUNT BOLTS.

5. REMOVE THE FACTORY FRONT, AND REAR BODY MOUNT BOLTS AND INSTALL THE MOUNTING BRACKETS PER THE FOLLOWING INSTRUCTIONS:
 - 5.1. INSTALL THE FRONT MOUNTING BRACKET (ITEM #1, 3) TO THE FRONT BODY MOUNT AS SHOWN (LEAVE THESE FASTENERS FINGER TIGHT).
 - 5.2. INSTALL THE REAR MOUNTING BRACKET (ITEM #4) & WASHER (ITEM #11) TO THE REAR BODY MOUNT AS SHOWN (LEAVE THESE FASTENERS FINGER TIGHT).
6. INSTALL THE STEP BOARDS AS DESCRIBED BY THE INSTRUCTIONS INCLUDED WITH YOUR STEP BOARDS. (**NOTE: INSURE THAT THE MOUNTING BRACKETS DO NOT TOUCH THE INSIDE WALL OF THE BODY MOUNT HOUSING AND TORQUE THE BODY MOUNT FASTENERS TO MANUFACTURES SPECS**).
7. POSITION THE LOAD REACTION BOLT ASSEMBLY SO THAT THE RUBBER CUSHION IS SNUG UP AGAINST THE SIDE OF THE FRAME. TIGHTEN THE 3/8" FLANGE NUTS ON EITHER SIDE OF THE BRACKET TO 19LB. FT.
8. REPEAT STEPS 2-7 FOR THE RIGHT SIDE OF THE VEHICLE.

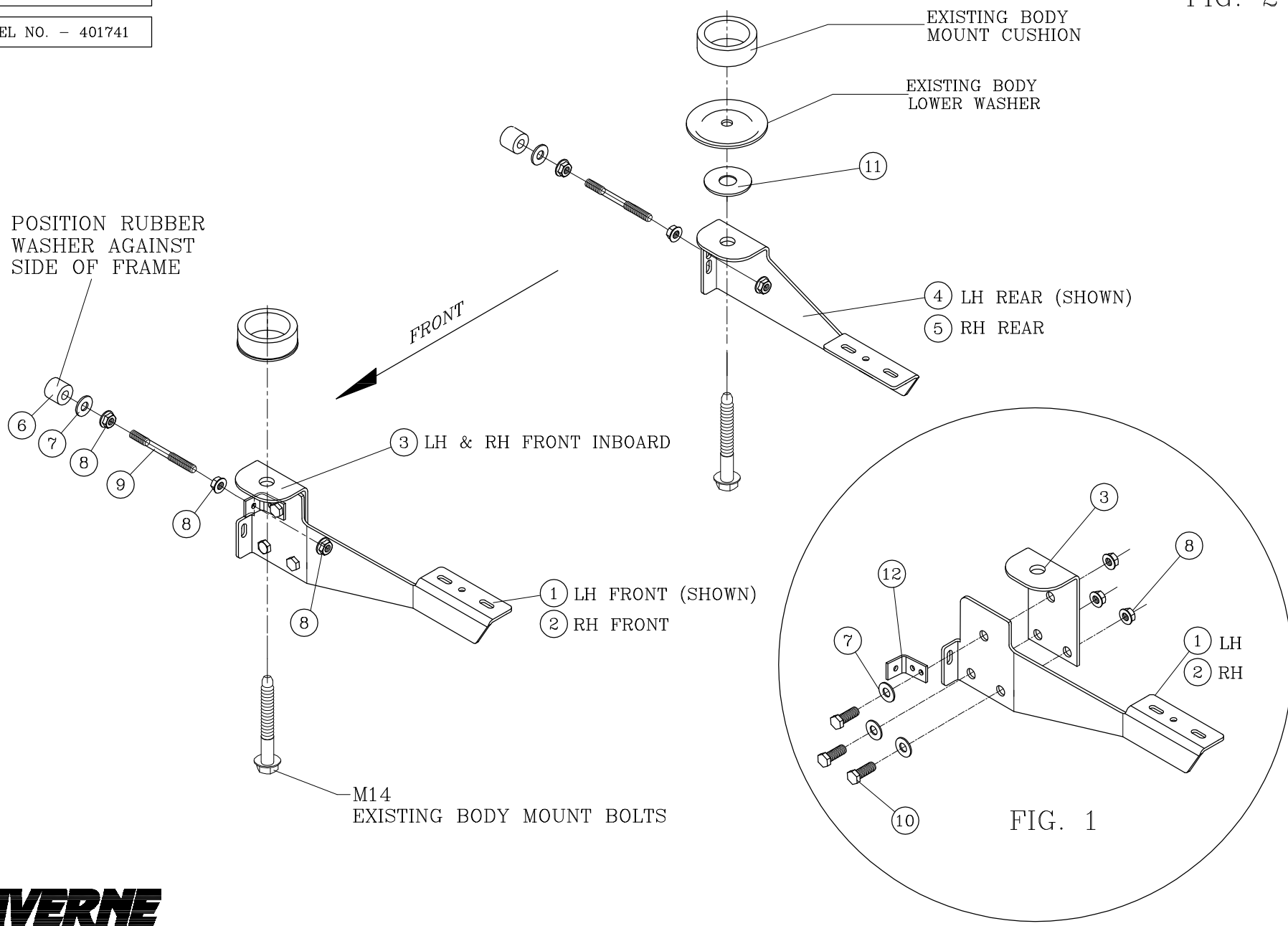
SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	552729	1	BRACKET-MTG, FRONT, LH, 401541
2	553124	1	BRACKET-MTG, FRONT, RH, 401741
3	552718	2	BRACKET-MTG, FRONT, INBOARD, 581541
4	552731	1	BRACKET-MTG, CENTER, LH, 401541
5	552730	1	BRACKET-MTG, CENTER, RH, 401541
6	102592	4	WSHR, RUBBER, .354 ID X 1.00 OD X .75 THK
7	100062	10	WSHR, FL, 3/8", .438 ID X 1.00 OD X .083" THK
8	100181	18	NUT, SERR FLG, HEX, 3/8-16 UNC, ZP
9	104686	4	STUD, -DBL ENDED, STL, 3/8-16 X 4.00", ZP
10	100040	6	SCR-HEX HD, 3/8"-16 X 1.0" UNC, ZP
11	108882	2	WSHR, FL, .59 ID X 1.06 OD X .19 THK, ZP
12	551571	2	BRACKET, 90° 3 HOLE BLACK

SERVICE PARTS LIST

MODEL NO. - 401741

FIG. 2



LEFT (DRIVER) SIDE SHOWN
-RIGHT (PASSENGER) SIDE OPPOSITE-

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