



AUTOMOTIVE PRODUCTS, INC.

# INSTALLATION INSTRUCTIONS

APPLICATION:01-03 FORD F150 SUPERCREW

APP. PART # 23-1880, 23-1885

3" ROUND STEP BARS

ITEM	QUANTITY	DESCRIPTION	TOOLS NEEDED
1	2	STEP BARS	3/4" SOCKET
2,3	2	FRONT MOUNTING BRACKET (2) DRIVERS SIDE, (3) PASSENGER SIDE	16MM SOCKET
4,5	2	REAR MOUNTING BRACKET (4) DRIVERS SIDE, (5) PASSENGER SIDE	13MM SOCKET
6	4	1/2" HEX HEAD BOLTS	RATCHET
7	4	1/2" LOCK WASHERS	TORQUE WRENCH
8	4	1/2" FLAT WASHERS	
9	2	M10 OFFSET DOUBLE BOLT PLATES ( FOR FRONT ONLY)	
10	2	M10 DOUBLE BOLT PLATES (FOR REAR ONLY)	
11	8	M10 FLAT WASHERS	
12	8	M10 LOCK WASHERS	
13	8	M10 HEX NUTS	
14	8	M8 HEX HEAD BOLTS	
15	16	M8 FLAT WASHERS	
16	8	M8 LOCK WASHERS	
17	8	M8 HEX NUTS	

1. Remove all contents from box, verify all parts listed are present and free from damage. Carefully read and understand all instructions before attempting installation.
2. From under the driver side front of the vehicle, remove the oval grommet located on the inside of the rocker panel, (Figure 1). Insert (1) Offset Double Bolt Plate, (with threaded studs toward the top), into the factory oval hole, (Figure 2).
3. Locate the driver side front Mounting Bracket. Hold the Double Bolt Plate from one side while you position and attach the Mounting Bracket to the opposite side. Secure the Bolt Plate with one M10 Flat Washer, M10 Lock Washer and M10 Hex Nut. Proceed to install the rest of the hardware to secure the Mounting Bracket to the Double Bolt Plate. (Figure 3). Do not tighten hardware at this time.
4. Align the Mounting Bracket with holes in the pinch weld. Attach the Mounting Bracket to the pinch weld using the included (2) M8 Hex Bolts, (4) M8 Flat Washers, (2) M8 Lock Washers and (2) M8 Hex Nuts. NOTE: Insert Bolt with Flat Washer from the outside-in. Do not tighten hardware at this time.
5. Moving to the rear, use one of the (centered) Double Bolt Plates and hardware to install the Rear Bracket. Repeat steps 2- 4 for driver side rear Mounting Bracket. Depending on model year, slots in rear Mounting Brackets may align with only one factory hole along pinch weld, (Figure 4). If desired, installer may drill through Pinch Weld for second Pinch Weld bolt, (included). IMPORTANT: Do not drill for second hole until the Sidebar has been completely installed and adjusted to properly locate the Mounting Bracket on the vehicle. Do not tighten hardware at this time.
6. Once the Mounting Brackets have been partially installed, carefully unpack and separate the driver and passenger Sidebar. Position Sidebar onto Mounting Brackets using the included (2) 1/2" Hex Head Bolts, (2) 1/2" Lock Washers, and (2) 1/2" Flat Washers, (Figure 4). Do not tighten hardware.
7. Level and adjust the Sidebar, drill for second Pinch Weld Bolt if necessary, then tighten all hardware at this time. Torque all 1/2" hardware to 50-55 ft lbs, M10 to 35-40 ft lbs, M8 to 25-30 ft lbs.
8. Repeat steps 2-7 for passenger side.

**CARE INSTRUCTIONS**

- REGULAR WAXING IS RECOMMENDED. DO NOT USE ANY TYPE OF POLISH OR WAX THAT MAY CONTAIN ABRASIVES
- STAINLESS STEEL PRODUCTS CAN BE CLEANED WITH MILD SOAP AND WATER. STAINLESS STEEL POLISH SHOULD BE USED TO POLISH SMALL SCRATCHES.
- GLOSS BLACK FINISHES SHOULD BE CLEANED WITH MILD SOAP AND WATER

