

Step Bar Installation Instructions: Part Numbers 49-3841 and 49-3850/203001 & 203001-2

1980-96 Ford F-Series Standard Cab and Bronco

Content List: (Qty)

(1) LH Step Bar – long end of bar to rear of vehicle	(2) 3/8 x 1" hex head bolts
(1) RH Step Bar – long end of bar to rear of vehicle	(2) 3/8 x 1" square head bolts
(2) Front step bar mounting brackets	(2) 3/8" flat washers
(2) Rear step bar mounting brackets	(2) 3/8" lock washers
(2) Rear frame mounting brackets	(2) 7/16-14 x 1 3/4" coupling nuts
(2) Rear support brackets	(2) 7/16-20 x 1 3/4" coupling nuts
(2) Spacer tubes	(2) 7/16-14 x 1" hex head bolts
(2) 7/16-20 x 1" hex head bolts	(4) 12mm x 1.75 x 50mm step bar mounting bolts
(2) 7/16" flat washers	(4) 12mm flat washers
(4) 7/16" lock washers	(4) 12mm lock washers
(2) 1/2 x 1 1/2" hex head bolts	
(2) 1/2" flat washers	
(2) 1/2" lock washers	
(2) 1/2" hex nuts	

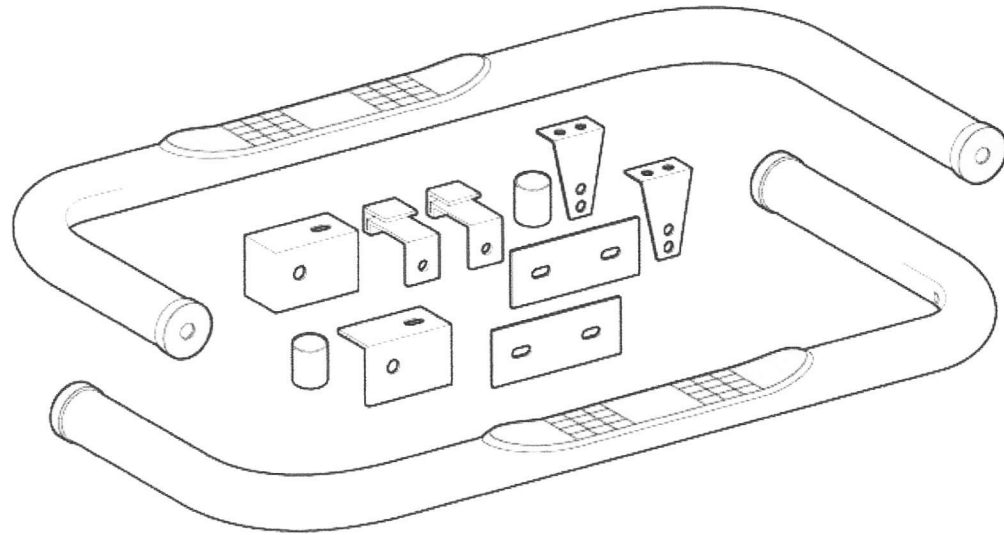
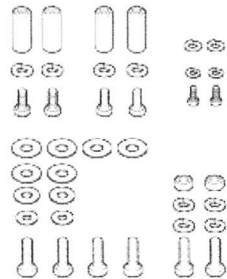
Instructions:

1. Read instructions completely before proceeding with installation.
2. To help identify the LH and RH step bar, notice the difference in length of the step bar mounting legs. When installed, the long leg is positioned to the rear of the vehicle.
3. Thread the 7/16-14 x 1 3/4" coupling nut onto the front body mount and torque to 40 ft./lbs. Thread the 7/16-20 x 1 3/4" coupling nut onto the seat belt bolt located near the rear of the door opening under the rocker panel and torque to 40 ft./lbs.
4. Thread the 3/8 x 1" square head set screw a couple of turns into the rear frame mounting bracket. Assemble the rear frame mounting bracket to the rear step bar mounting bracket with the 1/2 x 1 1/2" hex head bolt and corresponding lock washer, flat washer and hex nut. The rear frame mounting bracket should be rotated forward approximately 10° to follow the contour of the frame. Hand tighten the 1/2" fasteners.
5. Place the rear frame mounting bracket on the lower flange of the vehicle frame so that the front step bar mounting bracket is directly below the coupling nut on the front body mount. Insert the 3/8 x 1" square head set screw into the rear frame mounting bracket and tighten to hold the step bar in place. Position the step bar

on the vehicle using the 12mm x 1.75 x 50mm bolts, lock washers and flat washers.

6. At the front of the step bar, place the spacer tube over the front body mount coupling nut and insert the 7/16-14 x 1" hex head bolt with corresponding lock washer and flat washer up through the hole in the front step bar mounting bracket and thread it into the 7/16-14 x 1 3/4" coupling nut. Torque the bolt to 40 ft./lbs.
7. Mount the rear support bracket to the 7/16-20 x 1 3/4" coupling nut using the 7/16-20 x 1" hex head bolt, lock washer and flat washer. Verify that the side bar is level with the vehicle and then secure the rear support bracket to the side bar using the 3/8 x 1" hex head bolt, lock washer and flat washer. Torque to 20 ft./lbs.
8. Check alignment of step bar. Make any final adjustments and then tighten all bolts.
9. Repeat procedure for the opposite side.
10. Check fasteners periodically. Re-tighten as necessary.

Contents



Assembly

