

INSTALLATION INSTRUCTIONS AND PARTS LIST

APPLICATION: MODEL 200338SB SHORT BOX EXTENSION SIDE ENTRY STEPS ON:
2002 AND NEWER DODGE RAM 1500 SERIES SINGLE WHEEL PICKUPS
2003 AND NEWER DODGE RAM 2500/3500 SERIES SINGLE WHEEL PICKUPS

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. PEEL AWAY THE PROTECTIVE VINYL COVERING AND CLEAN THE TOP OF EACH STEP PLATE TO REMOVE ANY VINYL COVERING RESIDUE. (A GOOD GLASS CLEANER IS SUGGESTED).
3. PREPARE THE VEHICLE FOR SIDE ENTRY STEP INSTALLATION AS FOLLOWS:
 - 3.1. DRILL A 13/32" DIA. HOLE THRU THE BOTTOM SURFACE ON CENTERLINE OF THE FRONT BOX STIFFENER. LOCATE THE HOLE 1.00" FROM THE END.
 - 3.2. REMOVE THE BOX HOLD DOWN BOLTS (18mm WRENCH) FROM THE FRONT BOX STIFFENER AND ATTACH THE UPPER BOX MOUNT BRACKETS (ITEM #12 & #13) AS SHOWN.
 - 3.3. LOOSEN THE ROCKER PANEL ROD BRACE BOLT (10mm WRENCH) ON THE BOTTOM OF THE ROCKER PANEL AND INSTALL MOUNTING BRACKET (ITEM #17). LEAVE THE FASTENER SNUG ONLY SO THAT THE BRACKET CAN BE ADJUSTED LATER.
4. MOUNT THE SIDE ENTRY STEP / BRACE WLDMT ASSY (ITEM #1 THRU #15) AS FOLLOWS.
 - 4.1. ROTATE THE FRONT OUTBOARD TUBE BRACES (ITEM #14 & #15) TO THE UPRIGHT POSITION AND INSTALL A 5/16" X 1.00" CARRIAGE BOLT (ITEM #27), 5/16" FLAT WASHER (ITEM #30) AND 5/16" SERRATED FLANGE NUT (ITEM #29).
 - 4.2. ASSEMBLE THE 3/8" FULL THREADED STUD AND FASTENERS TO THE BRACE PLATE.
 - 4.2.1. INSTALL 3/8" SERRATED FLANGE NUTS (ITEM #25) BACKWARDS ON EACH END OF THE STUD (ITEM #21) SO THAT 5/8" OF THREAD IS EXPOSED.
 - 4.2.2. ON ONE END OF THE STUD INSTALL A 3/8" FLAT WASHER (ITEM #26). THEN, PUSH THE 3/4" THICK RUBBER WASHER (ITEM #22) AND FLAT WASHER TIGHT UP AGAINST THE SERRATED FLANGE NUT. (THE END OF THE STUD SHOULD BE RECESSED BACK IN THE HOLE OF THE RUBBER WASHER APPROXIMATELY 3/16").
 - 4.2.3. INSTALL THE OTHER END OF THE THREADED STUD THRU THE BOTTOM HOLE IN THE BRACE PLATE (1500 SER USE REAR HOLE AND 2500/3500 SER USE FRONT HOLE) AND INSTALL A 3/8" SERRATED FLANGE NUT (ITEM #25).
 - 4.3. POSITION THE ASSEMBLY UP UNDER THE ROCKER PANEL AND ATTACH THE TOP OF THE BRACE TO THE BOX MOUNT BRACKETS USING A 3/8" X 1.00" CARRIAGE BOLT (ITEM #24), 3/8" FLAT WASHER (ITEM #26) AND 3/8" SERRATED FLANGE NUT (ITEM #25).
 - 4.4. ATTACH THE OUTBOARD TUBE BRACE TO THE BOX STIFFENER. INSTALL A 3/8" MULTI THREAD U-NUT (ITEM #20) ON THE U-NUT RETAINER PLATE (ITEM #19). (THE RAISED CENTER PORTION OF THE PLATE GOES UP AND THE THREADED PORTION OF THE U-NUT GOES ON TOP OF THE PLATE). INSERT THE RETAINER PLATE INTO THE END OF THE BOX STIFFENER AS SHOWN SO THAT THE U-NUT THREAD IS ABOVE THE PRE-DRILLED HOLE. INSTALL A 3/8" X 1.50" HEX HD SCREW (ITEM #23) WITH 3/8" FLAT WASHER (ITEM #26) UP THRU THE HOLE IN THE TOP FLAT SWAGE OF THE FRONT BRACE, THRU THE PRE-DRILLED HOLE IN THE BOTTOM OF THE BOX STIFFENER AND INTO THE U-NUT ON THE U-NUT RETAINER PLATE.

5. ATTACH THE REAR MOUNTING BRACE AND CLAMP.
 - 5.1. INSTALL THE TUBE CLAMP (ITEM #18) OVER THE END OF THE REAR SUPPORT BRACE (ITEM #16) (FLAT SIDE OF CLAMP MUST BE TO THE REAR). PINCH THE CLAMP TOGETHER WITH A VICE GRIP OR EQUAL SO THAT THE FASTENERS CAN BE INSTALLED.
 - 5.2. ATTACH THE BOTTOM OF THE TUBE BRACE TO THE TOP HOLE OF THE REAR TAB ON THE BRACE WELDMENT. INSTALL A 5/16" X 1.00" HEX HD CAP SCREW (ITEM #28), 5/16" FLAT WASHER (ITEM #30) AND 5/16" SERRATED FLANGE NUT (ITEM #29) AND CLAMP THE TOP OF THE BRACE TO THE WHEEL WELL FLANGE AS SHOWN.
 - 5.3. FASTEN THE TUBE CLAMP TO MOUNTING BRACKET (ITEM #17) WITH A 5/16" X 1.25" HEX HD CAP SCREW (ITEM #31), 5/16" FLAT WASHER (ITEM #30) AND 5/16" SERRATED FLANGE NUT (ITEM #29)
 - 5.4. USING THE HOLE IN THE REAR MOUNTING BRACE AS A PILOT, DRILL A 5/16" DIA. HOLE THRU THE WHEEL WELL FLANGE AND INSTALL A 5/16" X 1.00" HEX HD CAP SCREW (ITEM #28), 5/16" FLAT WASHER (ITEM #30) AND 5/16" SERRATED FLANGE NUT (ITEM #29)
6. ALIGN THE STEP IN & OUT AND UP & DOWN SO THAT IT MATCHES THE CAB SIDE ENTRY STEP AND TIGHTEN ALL FASTENERS.
7. ADJUST THE FASTENERS ON THE FULL THREADED STUD SO THAT IT IS SNUG AGAINST THE SIDE OF THE SPRING SHACKEL AND THEN LOCK THE STUD BY TIGHTENING THE SERRATED FLANGE NUTS ON EITHER SIDE OF THE BRACE PLATE.

SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	550005	2	STEP PLATE-SES,RH/LH,DODGE RAM,SHORT BOX
2	104250	2	END CAP-RH FRONT/LH REAR
3	104251	2	END CAP-LH FRONT/RH REAR
4	105501	2	PAD,SES,SPCL,5.50 X 5.50
5	104255	.5	TRIM-SEAL,SES,EXTRUDED
6	104257	16	NUT-HEX,SGL SELF THD,CAP WASHER,1/4"
7	104258	8	BOLT-CARRIAGE,SST,#10-24 X 3/4"LG
8	104261	8	NUT-SERRATED FLANGE,HEX,SST,#10-24
9	104530	8	WASHER-FLAT,NEOPRENE,.200SQ X .406 DIA
10	550007	1	BRACE WLDMT-TUBE,STEP MTG,RH,SB EXT
11	550009	1	BRACE WLDMT-TUBE,STEP MTG,LH,SB EXT
12	550012	1	BRACKET-MTG,RH,UPPER BOX MOUNT
13	550013	1	BRACKET-MTG,LH,UPPER BOX MOUNT
14	550014	1	BRACE-TUBE,FRT,RH,DODGE BOX EXT
15	550015	1	BRACE-TUBE,FRT,LH,DODGE BOX EXT
16	550016	2	BRACE-TUBE,STL,SWG ENDS,1.00 OD X 22.25 LG
17	550017	2	BRACKET-MTG,1.53 X 3.25 X 1.50 WIDE,BLK
18	602078	2	CLAMP-TUBE,STL,12 GA,BLK,662C
19	549437	2	PLATE-U-NUT RETAINER
20	104282	2	NUT-U,MULTI THD,STL,3/8-16 UNC,BLK
21	104697	2	STUD-FULL THD,3/8-16 UNC,RLD THD,3.00" LG,ZP
22	102592	2	WSHR-PL,TYPE EP BLK RBR,.354 X 1.00 X .748
23	100049	2	SCR-CAP,HEX HD,3/8-16 UNC X 1.50",STL,ZP
24	100053	2	BLT-CRG,3/8-16 UNC X 1.00,STL,ZP
25	100181	8	NUT-SERR FLG,HEX,STL,3/8-16 UNC,ZP
26	100062	6	WSHR-PL,A,STL,3/8,.438 X 1.00 X .083,ZP
27	100021	4	BLT-CRG,5/16-18 UNC X 1.00,STL,ZP
28	100647	4	SCR-CAP,HEX HD,5/16-18 UNC X 1.00",STL,ZP
29	100178	10	NUT-SERR FLG,HEX,STL,5/16-18 UNC,ZP
30	100034	14	WSHR-PL,A,STL,5/16,.38 X .88 X .083,ZP
31	100025	2	SCR-CAP,HEX HD,5/16-18 UNC X 1.25",STL,ZP

SERVICE PARTS LIST

MODEL NO. - 200338SB

LUVERNE
 ASSOCIATED EQUIPMENT
 1700 BROADWAY
 BRUNNEN, SD 57005

FRONT BOX
STIFFENER

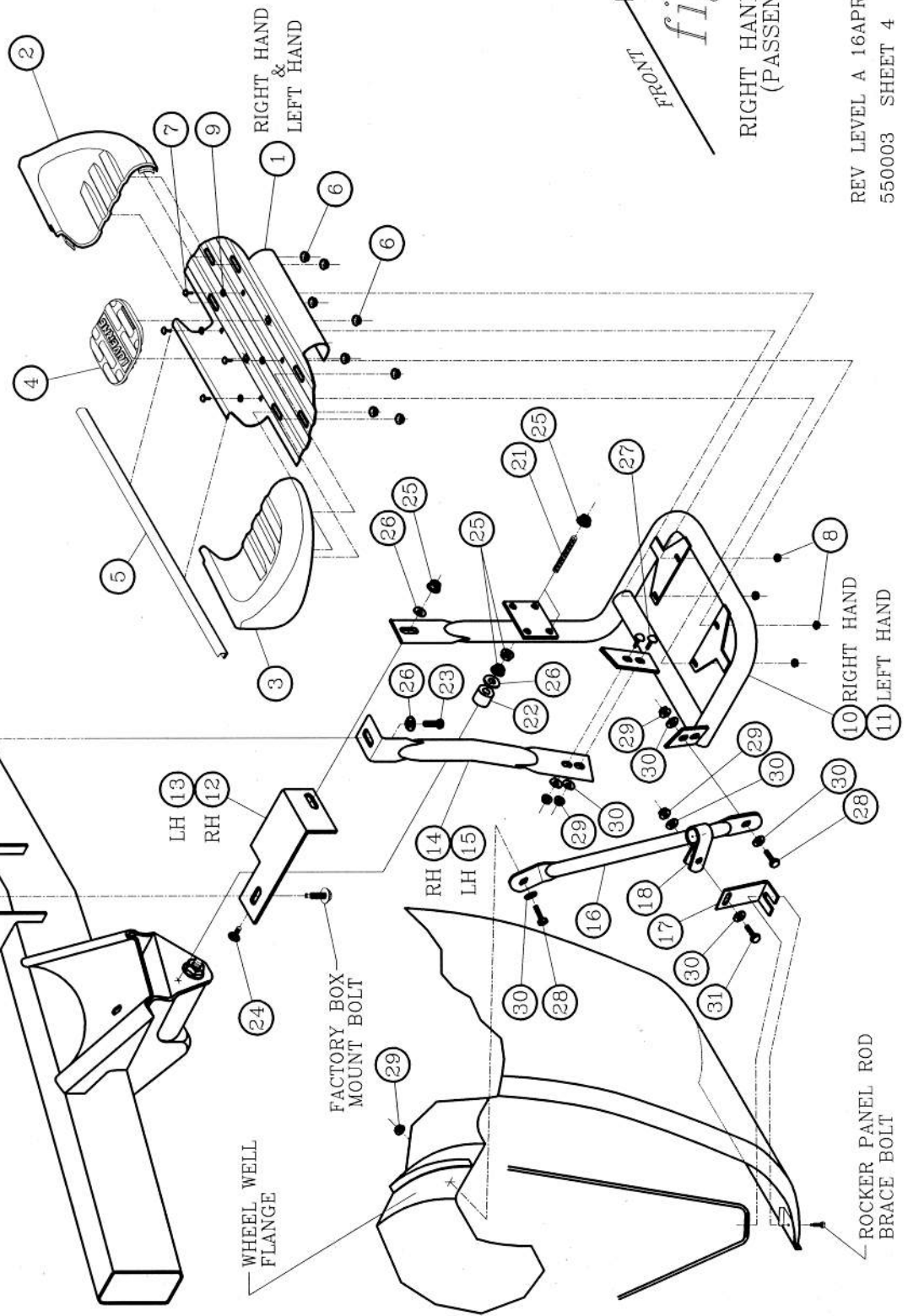
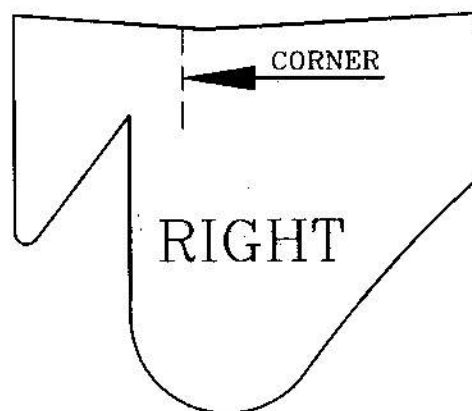
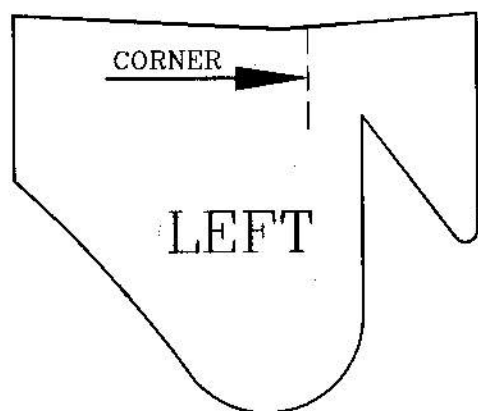
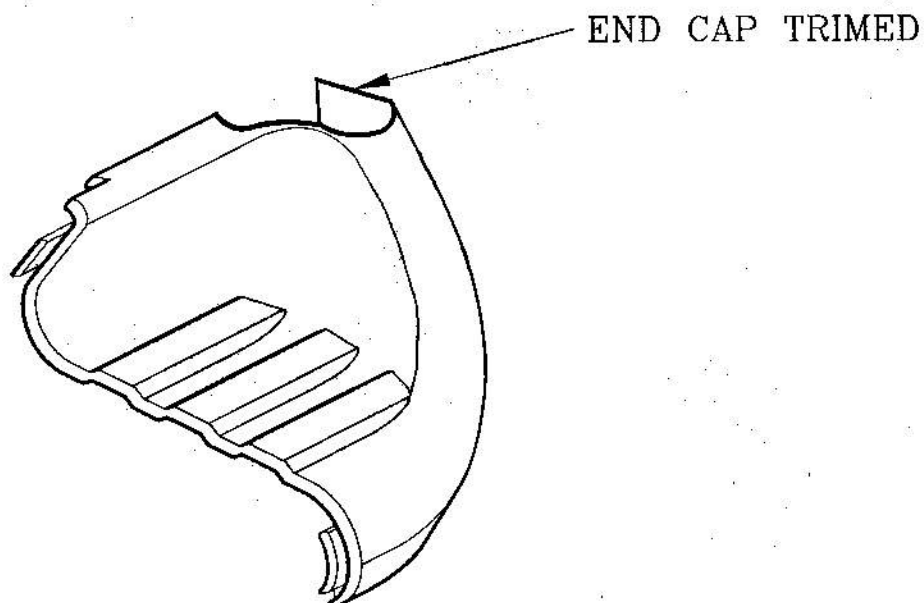


fig. 1

RIGHT HAND SIDE SHOWN
 (PASSENGER SIDE)

NOTE: IF YOU ARE INSTALLING ON A 2008-2009 DODGE DUALY MEGA CAB YOU WILL HAVE TO TRIM OFF $5\frac{1}{2}$ " OF THE TRIM SEAL ON EACH REAR SIDE OF BOARD AND USE TEMPLATES (BELOW) TO TRIM REAR END CAPS TO FIT DUALY FLARE ON BOTH REAR SIDES.



END CAP TEMPLATES



(A LUVERNE Company)

1200 E. Birch St.

Brandon, SD 57005

REV LEVEL A 16APR09
550003 SHEET 5 16APR09