

## INSTALLATION INSTRUCTIONS AND PARTS LIST

APPLICATION: MODEL **481031** (STAINLESS STEEL) SIDE ENTRY STEP BOARDS:  
**BODY MOUNT 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. WITH THE STEP BOARD BRACKETS ATTACHED TO THE VEHICLE, ON THE LEFT SIDE OF THE VEHICLE PLACE THE STEP BOARD (ITEM #1) ON THE BRACKETS AND CHECK THAT THE MOUNTING HOLES LINE UP. (THE LUVERNE STICKER SHOULD BE ON THE FRONT DRIVERS SIDE)
3. INSERT THE 10-24 X .75" CARRIAGE BOLTS (ITEM #3) INTO THE BLACK NEOPRENE WASHERS (ITEM #13).
4. USING FOUR (4) 10-24 X .75" CARRIAGE BOLTS (ITEM #3), AND FOUR (4) 10-24 FLANGE NUTS (ITEM #4) ATTACH THE STEP BOARD TO THE BRACKETS.
5. ADJUST STEP IN/OUT TO ALIGN STEP WITH THE CAB.
6. TIGHTEN THE STEP MOUNTING BOLTS.
7. REPEAT FOR RIGHT SIDE OF VEHICLE.

### SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	550160	1	STEP PLATE-SES, LH, 481032, QUAD CAB
2	550159	1	STEP PLATE-SES, RH, 481032, QUAD CAB
3	104258	8	BOLT – CARRIAGE – SST, 10-24 X .75"
4	104261	22	NUT – FLANGE, SST, 10-24
5	104250	2	END CAP – RH FRONT/LH REAR
6	104251	2	END CAP – LH FRONT/RH REAR
7	105500	2	STEP PAD, 5.50 X 20.00
8	104257	8	NUT – HEX, SINGLE THREAD
9	107958	4	SCR-PPH, #8-18 X .5", SST
10	107645	2	CLIP-U, .118-.185, BLK
11	107863	14	BOLT – CARRIAGE, 10-24 X .5", BZP
12	104256	2	TRIM – SEAL, EXTRUSION, 60.5"
13	104530	8	WASHER-NEOPRENE, .200 X .468 X .03



(A LUVERNE Company)

1200 E. Birch St.

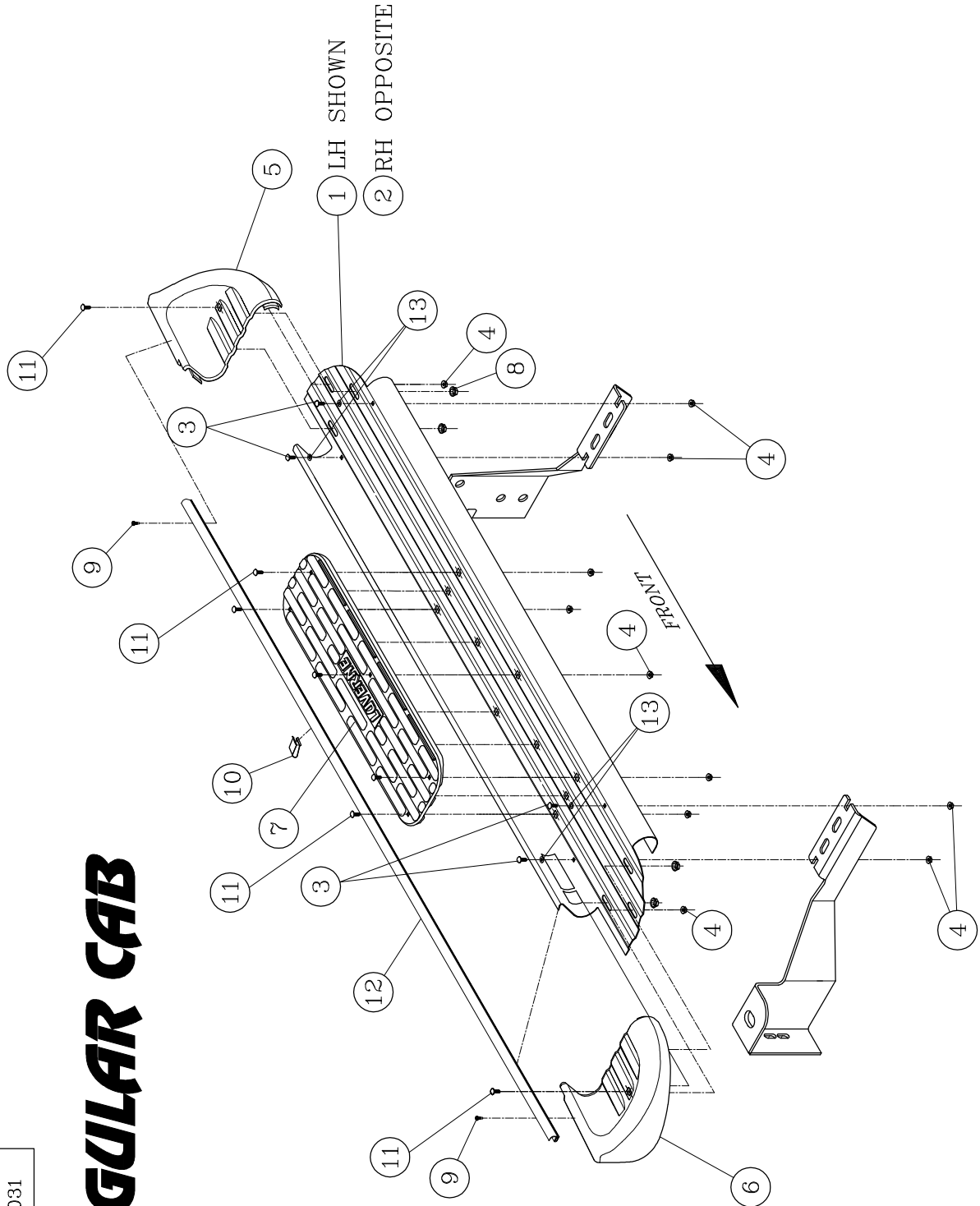
Brandon, SD 57005

552871 SHEET 1 OF 2 18MAY15

SERVICE PARTS LIST

MODEL NO. - 481031

# RAM REGULAR CAB



1200 E. Birch St.  
Evansville, IN 47605

## INSTALLATION INSTRUCTIONS AND PARTS LIST

APPLICATION: **MODEL 571631 SES, MEGA/OMEGA STEP BRACKET KIT:**

**2009+ DODGE RAM 1500 REGULAR CAB PICKUPS**

**2010+ DODGE RAM HD REGULAR CAB PICKUPS, & CHASSIS CABS.**

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. ATTACH THE MOUNTING BRACKETS TO THE VEHICLE AS FOLLOWS:

### **RAM TRUCKS WITH THREADED INSERTS IN THE ROCKER PANEL.**

- 2.1 PLACE THE DRIVERS SIDE FRONT BRACKET (ITEM #1) UP TO THE PINCHWELD SO THAT THE LOWER MOUNTING FLANGE IS TO THE OUTSIDE OF THE PINCHWELD, ALIGN THE TWO RECTANGULAR HOLES OF THE LOWER MOUNTING FLANGE OF (ITEM #1) WITH THE TWO OBOUND HOLES IN THE PINCHWELD, INSERT THE TWO 1/4-20 X 1" CARRIAGE BOLTS (ITEM #5) THROUGH THE LOWER MOUNTING FLANGE AND THEN THROUGH THE PINCHWELD, PLACE A 1/4" FLAT WASHER (ITEM #6), AND 1/4-20 FLANGE NUT (ITEM #7) ON TO THE CARRIAGE BOLTS, LEAVE FINGER TIGHT. **SEE FIGURES 1 & 2.**
- 2.2 INSERT AN M8 X 25mm SCREW (ITEM # 8) WITH A 5/16" FLAT WASHER (ITEM #9) THROUGH THE SLOTS ON THE UPPER MOUNTING FLANGE, LEAVE FINGER TIGHT.
- 2.3 REPEAT STEPS 2.1 & 2.2 ON THE REAR (ITEM #3) BRACKETS.
- 2.4 FOR THE PASSENGER SIDE THE INSTALLATION IS A MIRROR IMAGE OF THE DRIVERS SIDE, USE (ITEM #2) FOR THE FRONT BRACKET, & (ITEM #4) FOR THE REAR BRACKET.

### **RAM TRUCKS WITHOUT THREADED INSERTS IN THE ROCKER PANEL.**

- 2.5 ON THE VERTICAL WALL OF THE ROCKER PANEL, INSTALL THE T-BOLT WELDMENT (ITEM #11) INTO THE LARGE OBOUND HOLE INSERTING THE NUT END FIRST, LEAVING THE THREADED STUD STICKING OUT OF THE OBOUND HOLE. **BE CAREFULL NOT TO DROP THE T-BOLT INSIDE OF THE ROCKER PANEL.** ATTACH THE FLAT PLASTIC BOLT RETAINER (ITEM #12) TO THE THREADED STUD OF THE T-BOLT. (THIS IS TO KEEP THE T-BOLT FROM FALLING INTO THE ROCKER PANEL.)
- 2.6 PLACE THE DRIVERS SIDE FRONT BRACKET (ITEM #1) UP TO THE PINCHWELD SO THAT THE LOWER MOUNTING FLANGE IS TO THE OUTSIDE OF THE PINCHWELD, ALIGN THE TWO RECTANGULAR HOLES OF THE LOWER MOUNTING FLANGE OF (ITEM #1) WITH THE TWO OBOUND HOLES IN THE PINCHWELD, INSERT THE TWO 1/4-20 X 1" CARRIAGE BOLTS (ITEM #5) THROUGH THE LOWER MOUNTING FLANGE AND THEN THROUGH THE PINCHWELD, PLACE A 1/4" FLAT WASHER (ITEM #6), AND 1/4-20 FLANGE NUT (ITEM #7) ON TO THE CARRIAGE BOLTS, LEAVE FINGER TIGHT. **SEE FIGURES 3 & 4.**
- 2.7 PLACE A FLAT WASHER (ITEM #9), AND AN M8 FLANGE NUT (ITEM #10), ON THE THREADED STUD OF THE T-BOLT (ITEM #11) LEAVE FINGER TIGHT.
- 2.8 ROTATE THE T-BOLT SO THAT THE THREADED NUT IS VISIBLE THROUGH THE SLOTTED HOLE IN THE UPPER MOUNTING FLANGE, INSERT AN M8 X 25mm SCREW (ITEM #8) WITH A 5/16" FLAT WASHER (ITEM #9), LEAVE FINGER TIGHT.
- 2.9 REPEAT STEPS 2.5 THRU 2.8 ON THE REAR (ITEM #3) BRACKETS.
- 2.10 FOR THE PASSENGER SIDE THE INSTALLATION IS A MIRROR IMAGE OF THE DRIVERS SIDE, USE (ITEM #2) FOR THE FRONT BRACKET, & (ITEM #4) FOR THE REAR BRACKET.

**NOTE: 2009 TO 2012 TRUCKS DO NOT HAVE THE OBOUND HOLES IN THE PINCH WELD, THEY WILL REQUIRE DRILLING (2) 5/16" HOLES FOR EACH BRACKET, TO GET THE PROPER LOACTION FOR DRILLING FOLOW STEP 2.5, AND THEN SKIP TO STEP 2.7 & 2.8, WITH THE BRACKET IN PLACE, NOW MARK THE PINCHWELD FOR DRILLING.**

3. INSTALL THE STEP PLATES, AND ADJUST BRACKETS, AND BOARDS BEFORE TIGHTENING ALL THE FASTENERS.



## SERVICE PARTS LIST

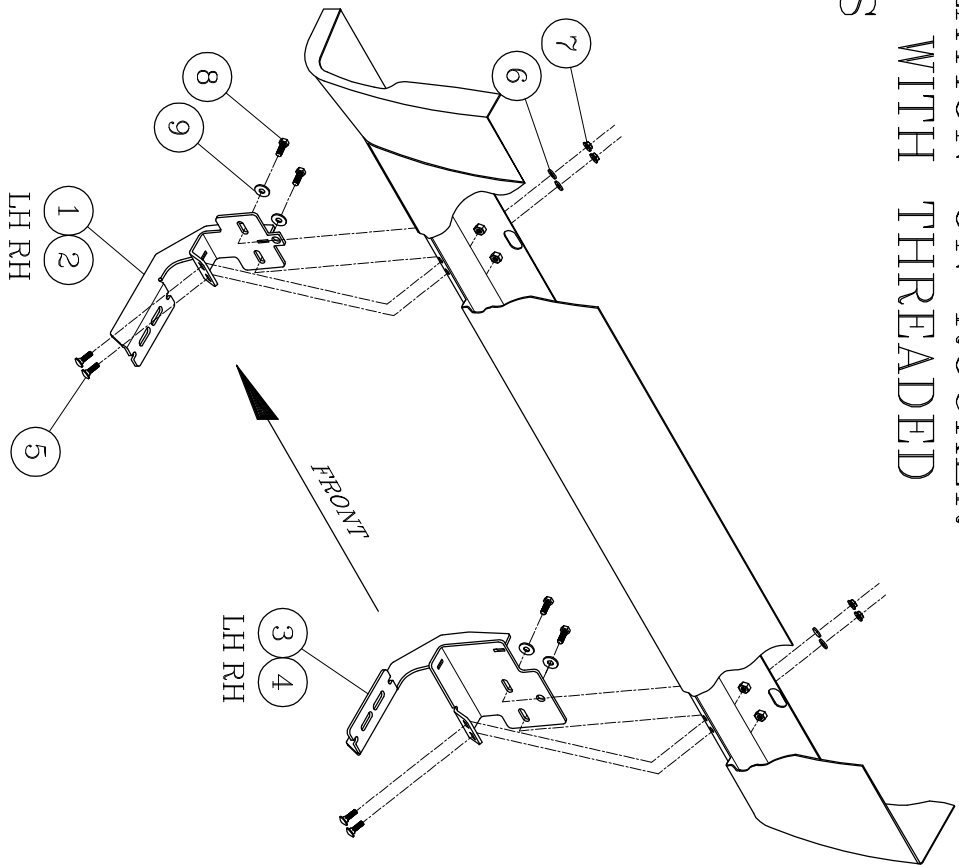
ITEM	PART NO.	QTY	DESCRIPTION
1	553006	1	BRKT-MTG, WLDMNT, FRONT LH, 571632
2	553007	1	BRKT-MTG, WLDMNT, FRONT RH, 571632
3	553008	1	BRKT-MTG, WLDMNT, REAR LH, 571632
4	553009	1	BRKT-MTG, WLDMNT, REAR RH, 571632
5	101320	8	BLT-CRG, 1/4-20 X 1.00", SST, BLK, EM6219
6	101370	8	WSHR-FL, SST, .281 X .625 X .065
7	102366	8	NUT-FLG, HEX, 1/4-20, SST
8	102549	8	SCR-HEX HD, M8 X 1.25 X 25mm, ZP
9	100034	8	WSHR-FL, 5/16, ZP
10	105859	4	NUT HEX-FLG, M8 X 1.25, ZP
11	553012	4	T-BOLT WELDMENT, ZP, 571632
12	101572	4	BOLT RETAINER-PLASTIC, 8mm

SERVICE PARTS LIST

BRACKET NO. - 571631

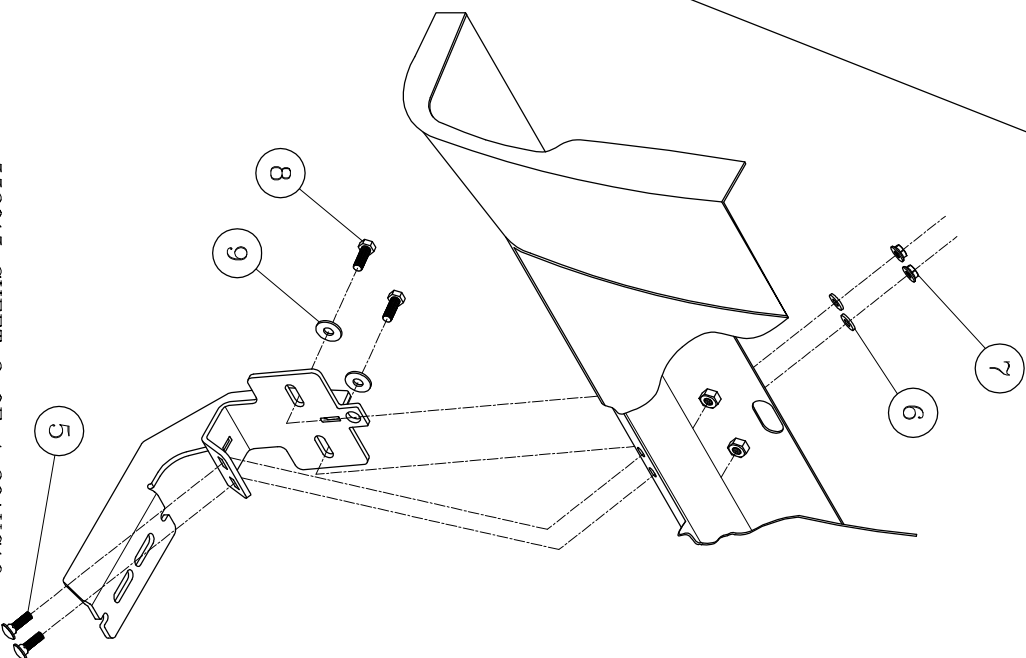
Fig. 1

INSTALLATION ON ROCKER  
PANELS WITH THREADED  
INSERTS



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

Fig. 2

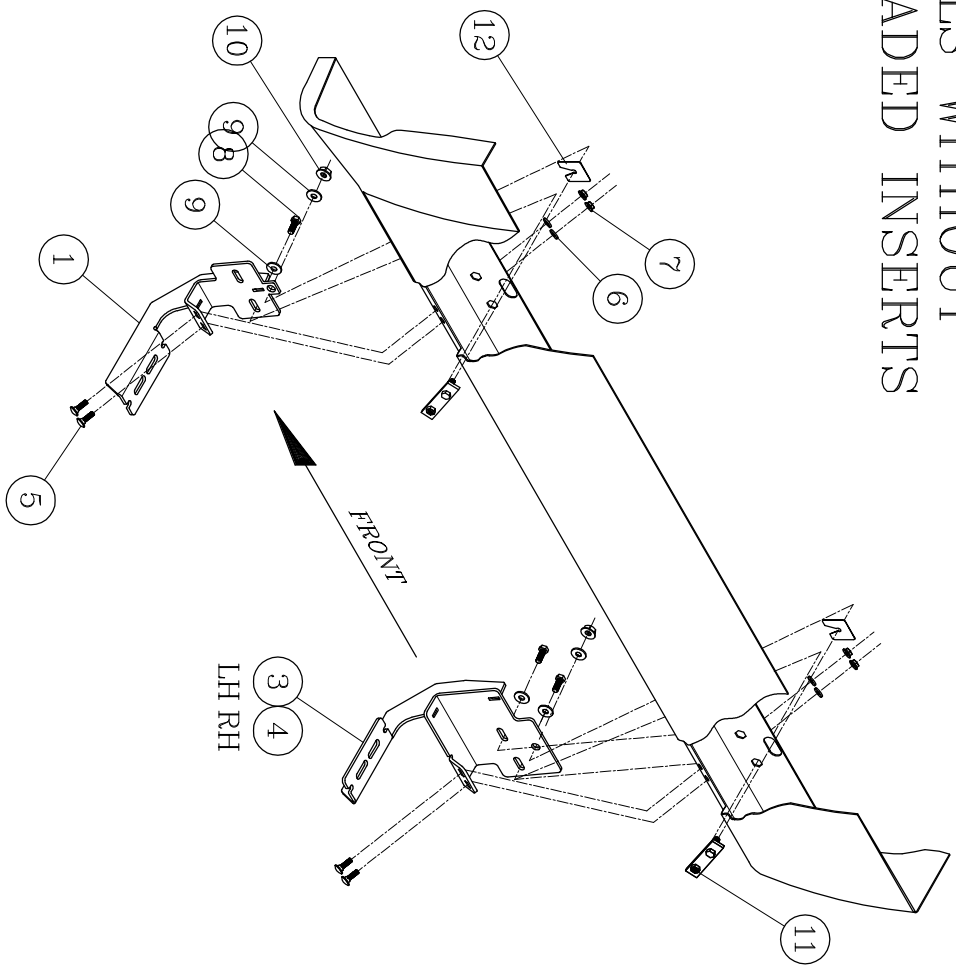


SERVICE PARTS LIST

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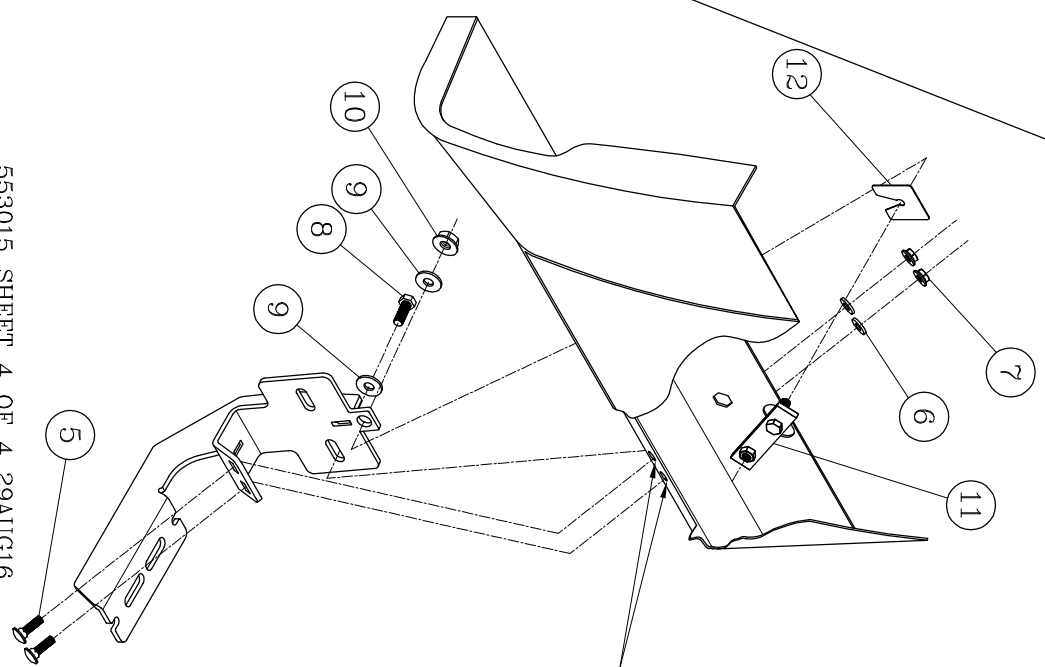
# INSTALLATION ON ROCKER PANELS WITHOUT THREADED INSERTS

Fig. 3



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

Fig. 4



NOTE: 2009-12 WILL REQUIRE DRILLING THESE HOLES IN THE PINCHWELD.

