

## INSTALLATION INSTRUCTIONS AND PARTS LIST

APPLICATION: MODEL **480741** (STAINLESS STEEL) SIDE ENTRY STEP BOARDS:  
**ROCKER PANEL 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. 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.
4. ADJUST STEP IN/OUT TO ALIGN STEP WITH THE CAB.
5. TIGHTEN THE STEP MOUNTING BOLTS.
6. REPEAT FOR RIGHT SIDE OF VEHICLE.

### SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	551371	1	STEP PLATE-SES,LH,480741
2	551370	1	STEP PLATE-SES,RH,480741
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	104256	2	TRIM – SEAL, EXTRUSION, 60.50"
8	105500	2	STEP PAD, 5.50 X 20.00
9	104257	8	NUT – HEX, SINGLE THREAD
10	107958	4	SCR-PPH, #8-18 X .5", SST
11	107645	2	CLIP-U, .118-.185, BLK
12	107863	14	BOLT – CARRIAGE, 10-24 X .5", BZP



(A LUVERNE Company)

1200 E. Birch St.

Brandon, SD 57005

552657 SHEET 1 OF 2 13OCT14

## INSTALLATION INSTRUCTIONS AND PARTS LIST

APPLICATION: MODEL **581441** (STAINLESS STEEL) SIDE ENTRY STEP BRACKETS ON:  
2014+ GM 1500 REGULAR CAB PICKUPS, GAS  
2015 GM 2500/3500HD REGULAR CAB PICKUPS, GAS  
**ROCKER PANEL 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. THE SIDE ENTRY STEP ASSEMBLIES SHOULD BE MOUNTED TO THE PINCH WELD AND VERTICAL WALL OF THE ROCKER PANEL AS FOLLOWS. **NOTE: DEPENDING ON THE VEHICLE, THE HOLE CONFIGURATION MAY CHANGE. FASTENERS ARE PROVIDED FOR ALL APPLICATIONS.**
2. ON THE LEFT SIDE OF THE VEHICLE REMOVE THE PLASTIC BODY PLUGS THAT ARE LOCATED ON THE VERTICAL WALL OF THE ROCKER PANEL AND INSERT A 5/16"-18 U-NUT (ITEM #7) AS SHOWN. (IF THERE ARE THREADED INSERTS IN THE UPPER LOCATION, USE THE BLACK M8-1.25X30 BOLTS (ITEM #)).
3. POSITION THE MOUNTING BRACKETS (ITEM #3) SO THAT THE HOLES ON THE BRACKET LINE UP WITH THE HOLES ON THE INSIDE WALL OF THE ROCKER PANEL. INSTALL A 5/16"-18 X 1.0" HEX BOLT, AND A 5/16" FLAT WASHER (ITEMS #5, 4) FINGER TIGHT.
4. INSTALL A BLACK M8-1.25 X 30MMHEX BOLT, 5/16" FLAT WASHER, AND THE PINCH WELD SUPPORT (ITEMS #4, 8, 9) THROUGH THE HOLE AND INSTALL A M8-1.25 NUT (ITEM #6) FINGER TIGHT ON THE BACK AS SHOWN.
5. REPEAT STEPS 3 – 4 FOR THE REMAINING BRACKETS.
6. INSTALL THE STEP BOARD AS DESCRIBED BY THE INSTRUCTIONS INCLUDED WITH YOUR STEP BOARDS.
7. PRESS STEP DOWN AND BACK, TIGHTEN THE MOUNTING BOLTS TO 19 LB-FT STARTING WITH THE BOTTOM BOLTS FOLLOWED BY THE TOP BOLTS.
8. REPEAT STEPS 2 – 7 FOR THE RIGHT SIDE OF THE VEHICLE.

### SERVICE PARTS LIST

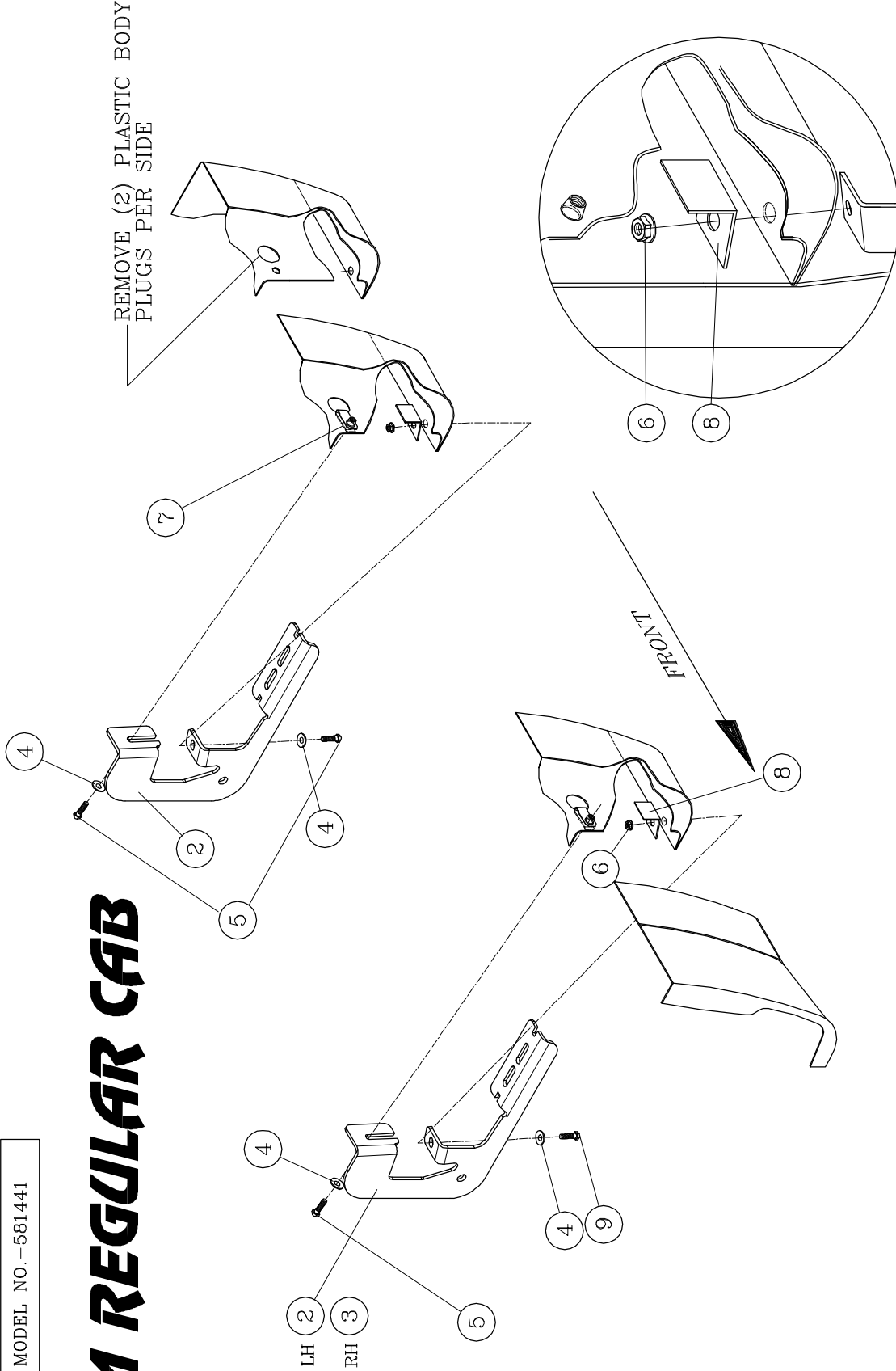
ITEM	PART NO.	QTY	DESCRIPTION
1	480741	1	STEP ASSEMBLY, SES, (MOD. 480741)
2	552626	2	BRKT-MTG, LH, SES, 581441
3	552625	2	BRKT-MTG, RH, SES, 581441
4	106998	8	5/16" FLATWASHER, SST, BZP
5	100647	4	5/16"-18 X 1.00" SCR ZP
6	105859	4	NUT SERR FLG, M8-1.25, ZP
7	105541	4	U-NUT,5/16"-18
8	551666	4	BRKT-MTG,PINCH WELD SUPPORT
9	100180	4	M8-1.25 X 30MM, SCR, SST, BZP



SERVICE PARTS LIST

MODEL NO. -581441

# GM REGULAR CAB



PINCH WELD SUPPORT ASSEMBLY



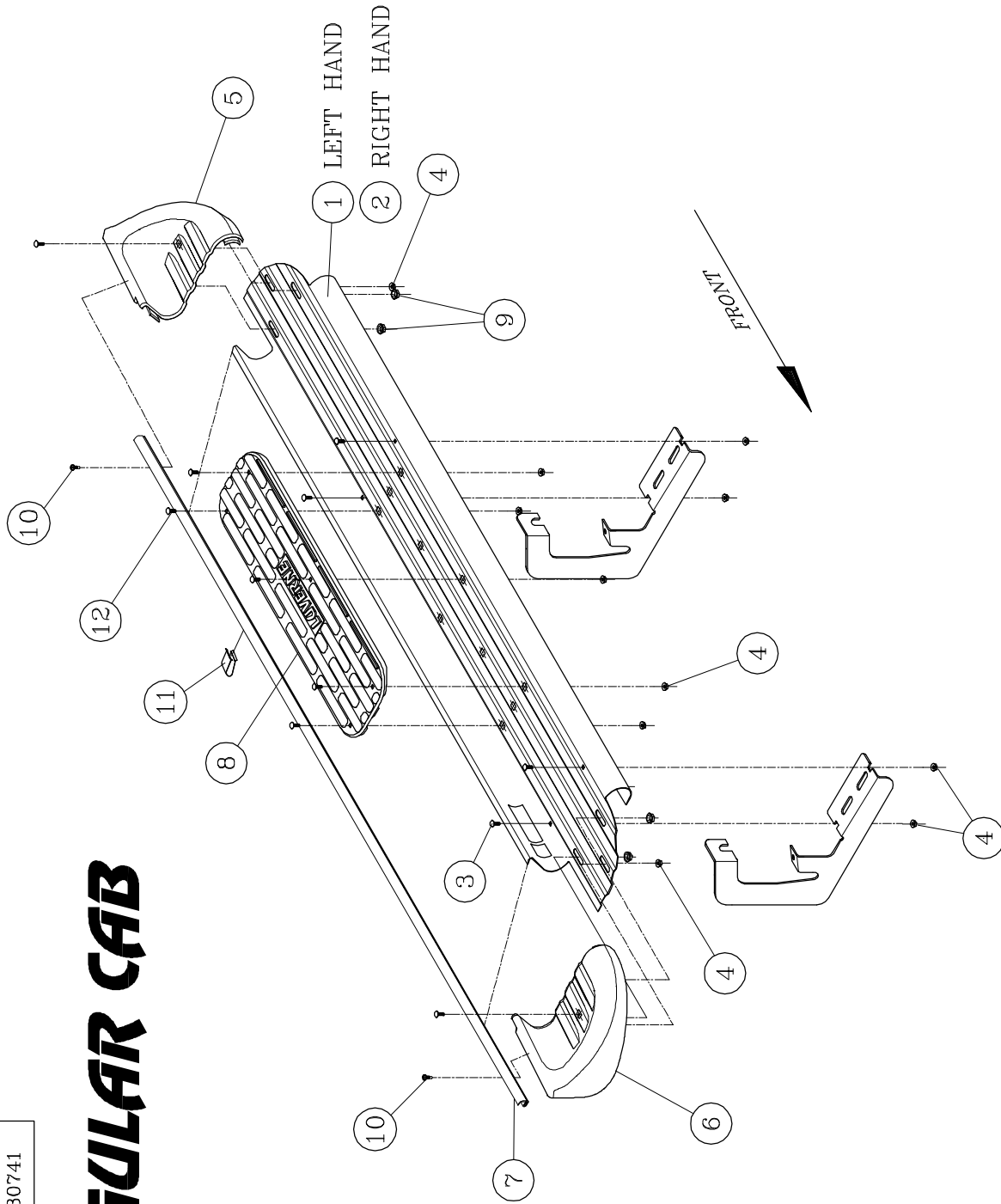
1280 E. Birch St. Spindon, GB S7606

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

SERVICE PARTS LIST

MODEL NO. - 480741

# GM REGULAR CAB



**LOVERNE**  
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