

INSTALLATION INSTRUCTIONS AND PARTS LIST

FOR MOUNTING 481519 LONG BOX EXTENSION SIDE ENTRY STEPS ON:
2014 + CHEVROLET SILVERADO & GMC SIERRA 1500 PICKUPS,
& 2015 + CHEVROLET SILVERADO & GMC SIERRA 2500/3500 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.

ATTACHING THE STEP (PASSENGER SIDE)

2. REMOVE THE FRONT TWO (2) FACTORY BOLTS THAT SECURE THE BOX TO THE FRAME. REMOVE THE M8 BOLT ON THE OUTER EDGE OF THE FRONT BOX STIFFENER, THIS BOLT WILL NOT BE REUSED.
3. ATTACH THE VERTICAL MOUNTING BRACES (ITEM #5, 6), AND TUBULAR STIFFENER BRACE (ITEM #8) TO THE BOX CROSS-MEMBERS AS FOLLOWS:
4. WITH THE VERTICAL BRACES (ITEM #5, & 6) IN PLACE, REINSTALL THE TWO (2) FACTORY BOLTS THAT ATTACH THE BOX TO THE FRAME IN THE INNER MOST HOLES OF THE VERTICAL BRACES (ITEM #5, 6) AS SHOWN IN **(FIG. 1)** LEAVE THEM FINGER TIGHT AT THIS TIME.
5. INSTALL THE M8 X 25mm SCREW (ITEM #26), FLAT WASHER (ITEM #16), THRU THE STRAIGHT END OF THE TUBULAR BRACE (ITEM #8) AND THRU THE OUTER MOST HOLE OF THE FRONT VERTICAL BRACE (ITEM #6). AS SHOWN IN **(FIG. 1 & FIG. 2)**

2014+ 1500 TRUCKS ONLY (FIG.1)

6. INSTALL THE 3/8" U-NUT (ITEM #20) TO THE NUT PLATE (ITEM #30) AND INSERT IT INTO THE END OF THE SECOND BOX CROSS-MEMBER. INSTALL THE 3/8-16 X 1-1/4" HEX BOLTS (ITEM #29), FLAT WASHER (ITEM #28) AND LOCK WASHERS (ITEM #27) UP THRU THE MIDDLE OBOURD HOLE IN THE REAR VERTICAL BRACE (ITEM #4), AND INTO THE U-NUT (ITEM #31). AS SHOWN IN **(FIG. 1)** LEAVE THESE FASTENERS FINGER TIGHT.

2015+ 2500/3500 HD TRUCKS ONLY (FIG. 2)

7. FOR THE 2015 + HEAVY DUTY MODELS FOLLOW **(FIG. 2)** USE THE 3/8-16 X 7.5" J-BOLT (ITEM #14) 3/8" FLAT WASHER (ITEM #28), AND THE 3/8-16 FLANGE NUT (ITEM #15) HOOK THE J-HOOK INTO THE SLOT ON THE SIDE OF THE SECOND BOX BRACE, USING THE OUTER MOST HOLE OF THE REAR VERTICAL BRACE (ITEM #5) AS SHOWN IN **(FIG. 2)** LEAVE LOOSE UNTIL EVERYTHING ELSE IS INSTALLED, THEN ADJUST AND TIGHTEN.
8. INSTALL THE OUTBOARD BRACKETS (ITEM # 10, 12) USING THE 5/16-18 X 1" HEX BOLTS (ITEM #17) FLAT WASHER (ITEM #16) AND 5/16-18 FLANGE NUT (ITEM #18) TO THE VERTICAL BRACES AS SHOWN IN **(FIG.1 & FIG. 2)** LEAVE FINGER TIGHT AT THIS POINT.
9. INSTALL THE RIGHT HAND MUD SHIELD (ITEM #24) TO THE LOWER FLANGE OF THE OUTSIDE BOX PANEL. **(NOTE: NOTCHED TO CLEAR FENDER BRACE RODS.)** BECAUSE OF THE WARPING OF THE MUD SHIELD INTO AN ARC IT MAY BE NECESSARY TO SECURE THE ENDS OF THE MUD SHIELD TO THE FENDER PANEL WITH THE #8 X 1 TEK SCREWS (ITEM #23) PROVIDED IN THE FASTENER PACKAGE. USE ONE ON EACH END APPROXIMATELY 1/2" IN FROM EACH END. PRE-DRILL A 1/8" DIAMETER HOLE FOR THE SCREW.



INSTALLATION INSTRUCTIONS AND PARTS LIST

10. INSTALL STEP PLATE ASSEMBLY ON TO OUTBOARD BRACKETS USING THE 10-24 X 3/4" SST CARRIAGE BOLTS (ITEM #19) NEOPRENE WASHER (ITEM #34) SST FLANGE NUTS (ITEM #21) AS SHOWN IN (FIG. 1 & FIG. 2)
11. ADJUST STEP IN/ OUT, AND UP/DOWN TO MATCH CAB BOARDS, AND TIGHTEN ALL FASTENERS.

NOTE: DRIVERS SIDE IS A MIRROR IMAGE OF PASSENGER SIDE.

SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	552480	2	STEP PLATE – SES, 481519
2	104250	2	END CAP-RH FRONT/LH REAR
3	104251	2	END CAP-LH FRONT/RH REAR
4	552469	1	LH SIDE REAR VERTICAL BRACE, 481518
5	552464	1	RH SIDE REAR VERTICAL BRACE, 481518
6	552468	1	RH SIDE FRONT VERTICAL BRACE, 481518
7	552463	1	LH SIDE FRONT VERTICAL BRACE, 481518
8	552099	1	RH SIDE TUBULAR BRACE, 481519
9	552098	1	LH SIDE TUBULAR BRACE, 481519
10	552470	1	RH SIDE FRONT OUTBOARD BRACKET, 481518
11	552465	1	LH SIDE FRONT OUTBOARD BRACKET, 481518
12	552479	1	RH SIDE REAR OUTBOARD BRACKET, 481519
13	552478	1	LH SIDE REAR OUTBOARD BRACKET, 481519
14	109639	2	J-BOLT 3/8-16 X 7.4375, ZP
15	100181	2	NUT-FLANGE, SERRATED, HEX, 3/8-16, ZP
16	100034	22	WASHER-FLAT, 5/16" ZP
17	110647	8	SCREW – CAP, HEX HEAD, 5/16-18 X 1" ZP
18	100178	10	NUT- SERR FLG, HEX, 5/16-18 UNC, STL, ZP
19	104258	8	BOLT-CARRIAGE, SST,#10-24 X 3/4" LG
20	104282	2	NUT - U, MULTI THD, 3/8-16
21	104261	20	NUT - SERR FLANGE, HEX, SST, #10-24
22	105500	2	PAD- MOLDING, STEP PLATE, 5.50 X 20.00" LG
23	103435	4	SCREW – TEK, SEMS, OVAL, XREC, #8 X 1, BLACK
24	552423	1	MUD SHIELD – RH, 481519
25	552424	1	MUD SHIELD – LH, 481519
26	102549	2	SCREW – CAP, HEX HEAD, M8-1.25 X 25mm-10.9, ZP
27	100059	2	WASHER – LOCK, 3/8"
28	100062	4	WASHER – FLAT, 3/8"
29	100047	2	SCREW – CAP, HEX HEAD, 3/8-16 X 1-1/4" ZP
30	549437	2	NUT PLATE – 209918SB
31	104257	8	NUT-HEX, SINGLE SELF THDG, CAP WASHER, 1/4"
32	100025	2	SCREW – CAP, HEX HEAD, 5/16-18 X 1-1/4" ZP
33	107683	14	BOLT-CARRIAGE,SST,#10-24X.50,BZP
34	104530	8	WSHR-FL, NPRN, .200 SQ. X .468 X .031



(A LUVERNE Company)

1200 E. Birch St.

Brandon, SD 57005

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SERVICE PARTS LIST
MODEL NO. - 481519

**2014 + GM
SILVERADO/SEIRRA
1500 8' BOX**

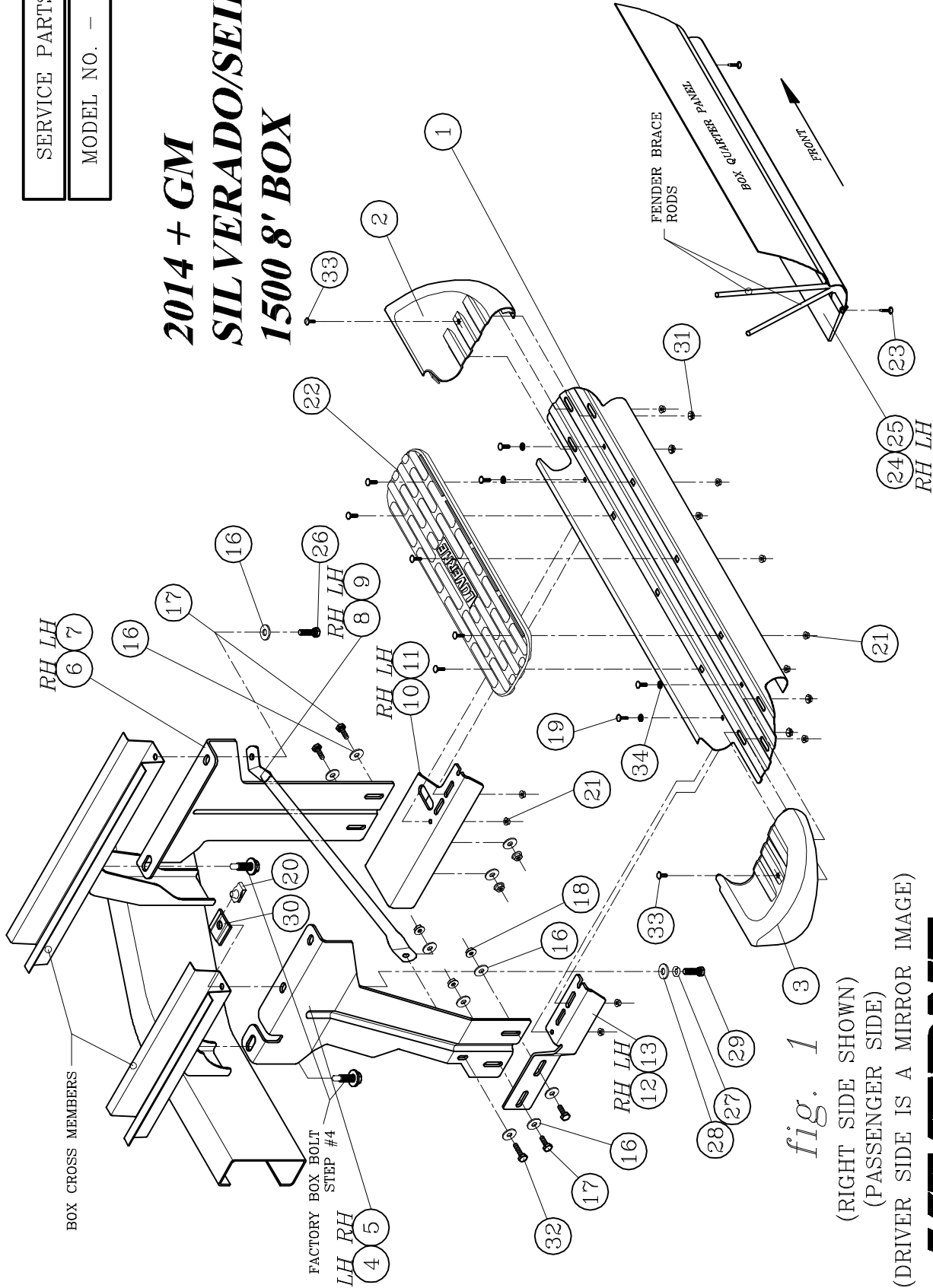


fig. 1 3

(RIGHT SIDE SHOWN)
(PASSENGER SIDE)
(DRIVER SIDE IS A MIRROR IMAGE)



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MODEL NO. - 481519

2015 + GM SILVERADO/SEIRRA HD 2500/3500 8' BOX

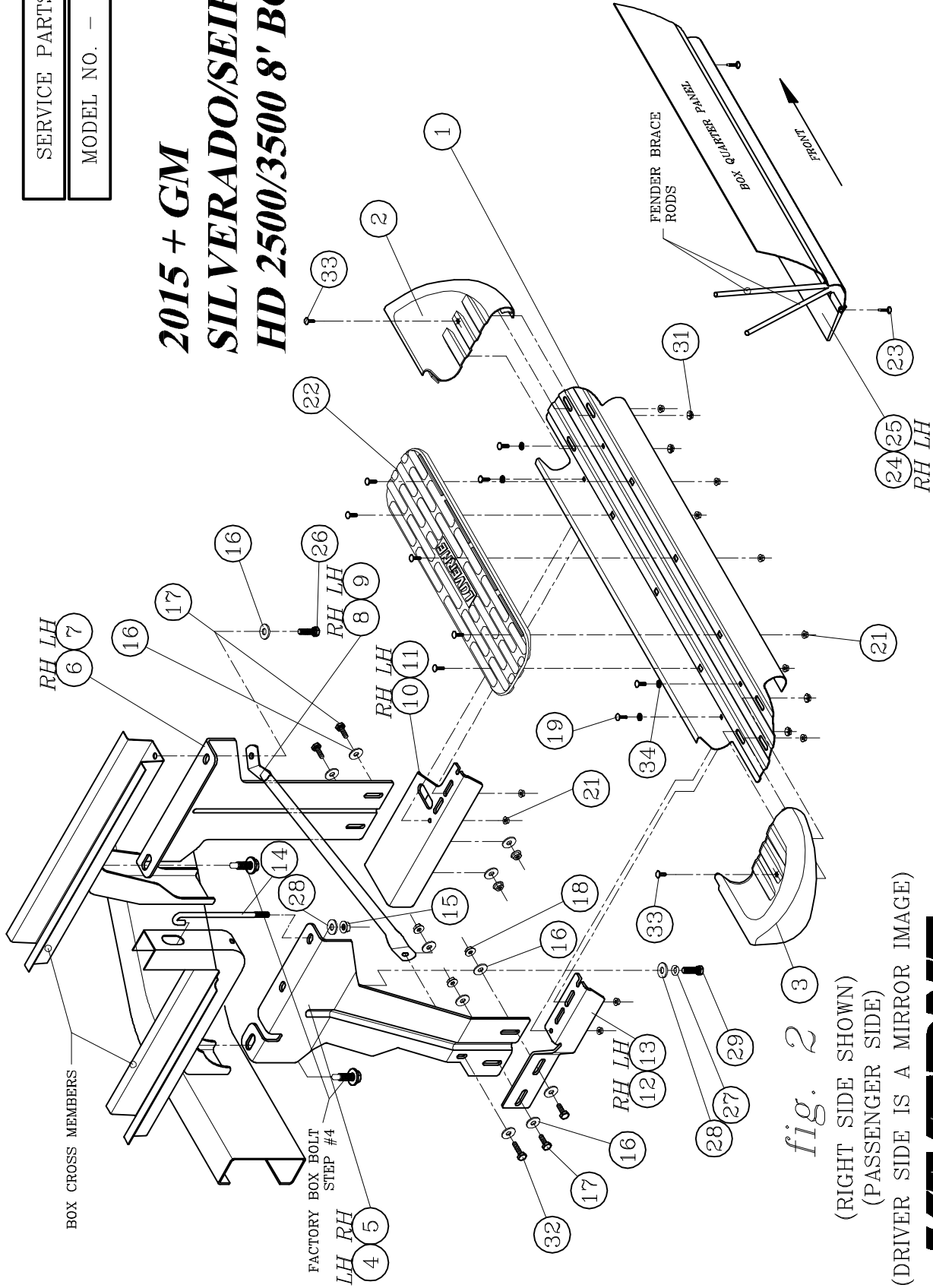


fig. 2 3

(RIGHT SIDE SHOWN)
(PASSENGER SIDE)
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