

HD 18" Tube Step Installation Instructions

Part No's: 301890 / 301891



Quality and Style that Endures

Follow the diagram and the written directions carefully for a proper, safe installation.

Should you encounter an unusual, unforeseen problem, contact our Technical Help Line
7:00 AM – 3:00 PM Pacific Time
(951) 719-1068

Visit our web-site at
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Vehicle Application:

FORD
'98-'12 Ranger 2-Door Only

MAZDA
'98-'09 B-Series Pick-up 2-Door Only

MATERIAL NEEDED:

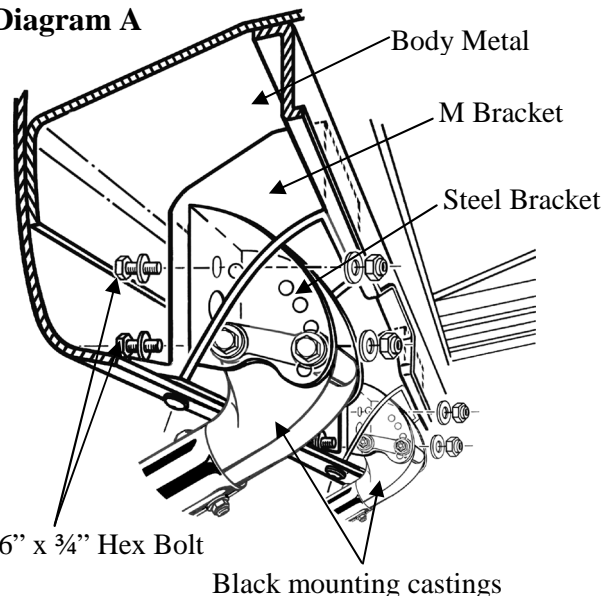
Drill motor, 5/16" drill bit, pencil, center punch, two 1/2" wrenches.

MATERIAL FURNISHED:

Two 18" tubes, four black mounting castings, four zinc plated steel brackets, four M Brackets, two hardware packs and instruction page.

1. Place the black mounting castings in the open ends of the tube. Line up the holes and securely fasten the castings to the tube with hardware provided. See **Detail A**.
2. Before positioning the M Bracket and step assembly against the body metal as

Diagram A

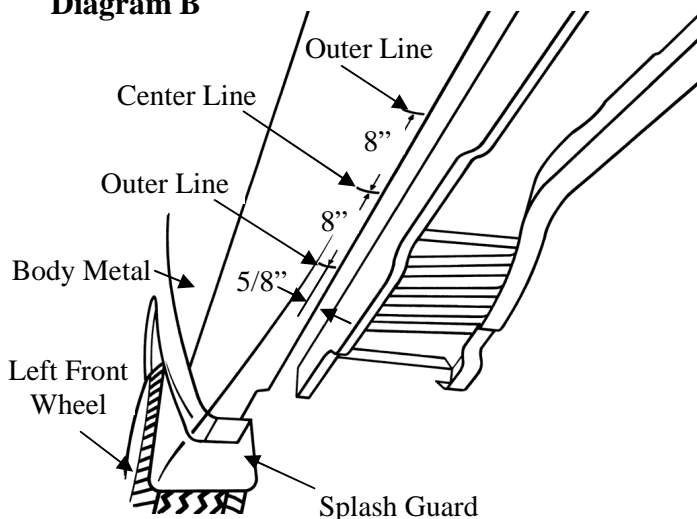


shown in **Diagram A**, assemble the M Brackets together with the steel mounting brackets only. NOTE: Do not attach the black mounting castings to the steel brackets at this time.

3. Use the 5/16" x 3/4" hex bolts and other 5/16" hardware provided and securely bolt together the steel brackets and M Brackets.
4. Now place the black mounting castings up into each steel bracket. Use the 1/4" hardware provided and securely tighten all hardware. See **Diagram A**.
5. For the proper position of the step, the front edge of the seat while in normal driving position should be in line with the center of the step. For personal preference or to avoid any obstruction underneath body metal, step assembly can be moved left or right.
6. Once the desired position of the step has been found, take a pencil and mark the center of the step on the painted body metal of your truck, on the bottom of the rocker panel.

NOTE: This operation is much easier to do while on your back. Refer to **Diagram B**.

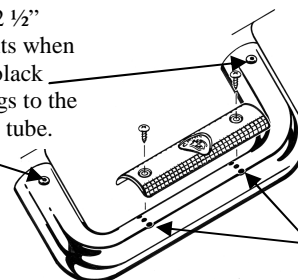
Diagram B



7. Measure 8" from each side of the marked center line on the same body metal surface.
8. Measure 5/8" in from the edge of the body metal, and mark a line across the marked outside lines. Refer to **Diagram B**.
9. Center-punch where the lines cross, then drill them out with 5/16" drill bit.

Use the 5/16 X 2 1/2" Button Head bolts when assembling the black mounting castings to the open ends of the tube.

Detail A



For proper alignment, the tread plate can be rotated in three different positions.

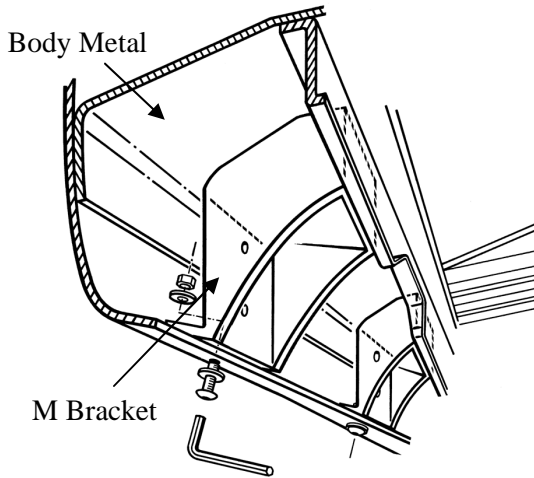
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WARNINGS!

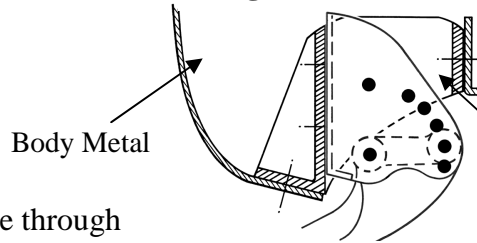
- ✓ Do not over tighten the nuts and bolts or damage to the castings and or stripping of the threads could result.
- ✓ FOR SAFE AND PROPER USAGE OF THIS PRODUCT, THE MOUNTING INSTRUCTIONS MUST BE FOLLOWED CAREFULLY AND COMPLETELY.
- ✓ The manufacturer and distributor of this product are in no way responsible for the consumer's failure to adhere to the warnings and directions of these instructions in the event of damage to the consumer's vehicle, other properties and or personal injury.

Diagram C



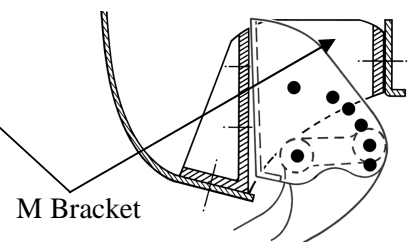
10. Move the entire step assembly over each hole. Take the 5/16" button head bolts, Allen wrench, and hardware provided, and hand tighten each M Bracket. Refer to **Diagram C**. NOTE: If the holes don't line up perfectly, oversize the holes in the M Brackets until the holes line up. IMPORTANT: The body metal should not protrude beyond the M Bracket where the step will mount! If it does, oversize the holes in the M Brackets until the edge of the body metal is flush with the flat mounting area of the step. Refer to **Diagrams D & E**.

Diagram D



CORRECT ALIGNMENT

Diagram E

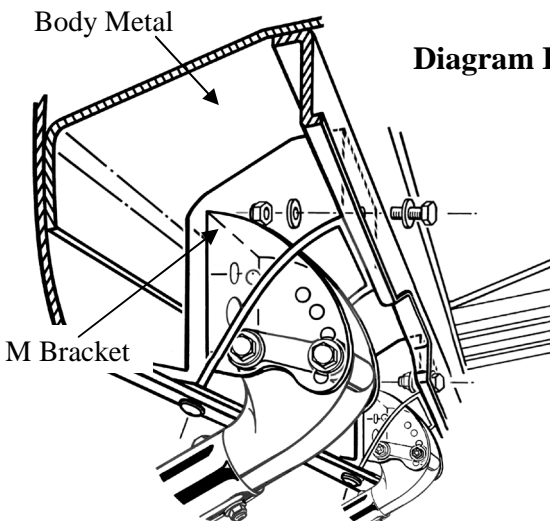


INCORRECT ALIGNMENT

11. Take your drill motor and drill a 5/16" hole through the body metal and the center of the back side of the M Bracket. This hole will have to be drilled at an angle

unless you have a 90 degree drill motor. Refer to **Diagram F**. Take the remaining 5/16" hardware and bolt the M Brackets to the body metal.

Diagram F



12. Tighten all hardware securely.
13. Repeat the same procedures for the other side.
14. To maintain the luster of your steps, polish them with aluminum polish as often as you clean your vehicle.

**WAX YOUR STEP ON A
REGULAR BASIS TO
MAINTAIN ITS LUSTER**

Finishes: Limited Lifetime
Structural Warranty: Limited Lifetime

Warranty Conditions:

- a. All warranties start from consumer's date of purchase.
- b. A new product will be sent out immediately to replace a warranty claim.
- c. The above guidelines apply only to the Original Purchaser.
- d. Original proof of purchase must be submitted for all warranty and returns issues.

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- b. Warranty coverage does not extend to damage caused by: collision, fire, theft, freezing, vandalism, riot, explosion or object striking the product, or misuse of the product and/or the vehicle on which the product is being installed.
- c. Warranty coverage does not extend to damage caused by: airborne fallout (chemicals, tree sap, etc.), stones, hail, earthquake, water or flood, windstorm, lightning, the application of chemicals or sealants subsequent to manufacture.
- d. Warranty coverage does not extend to damages caused by: normal wear and tear, abuse, modification or improper installation of the product.
- e. Warranty coverage does not extend to any economic loss or extra expense including (without limitation), payment for the loss of time or pay, inconvenience, storage, loss of vehicle use, vehicle rental expense, equipment rental expense, lodging, meals, or other travel costs.

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Warranty Policy