



**99-10 GM Silverado/Sierra Extended Cab  
01-10 GM Heavy Duty Ext Cab**

**51-512/522 41-512/522  
52-512/522 42-512/522  
53-512/522 43-512/522**

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IRON CROSS AUTOMOTIVE INC. 2009

# TUBE STEP INSTALLATION SHEET



**FIG 1**



**FIG 2**



**FIG 3**



**FIG 4**



**FIG 5**

**STEP 1** Remove front and rear body mount bolts. Replace with M12 & 4-3/4" bolt, lock washer, & flat washer supplied in the bracket kit. Adding the front and rear bracket under the lower body bushing and tighten these bolts to allow for minor adjustments. (Fig 1 thru 4) **On all 2006 and up models use factory body bolt. Making sure though to add 9/16" lock washer before replacing with bracket**

**STEP 2** Take one tube and bolt it to the front bracket using 1/2" bolts, lock washers, & flat washers supplied. Make sure to use the plastic o-ring supplied on the tube ends. Hand tighten the bolts making sure to leave them loose enough for final adjustments. Align the tube to your liking on the truck. Tighten the body mount bolts to 65 ft lbs first. Then tighten the tube step bolts to 65 ft lbs

**STEP 3** On some vehicles for added support you can use the supplied strap. Bolt the strap to the rear bracket and use the supplied self tapping screw to mount to the body mount. (Fig 5) Place round washer between brace and frame.

**STEP 4** Repeat the steps for the other side of the vehicle.

**For use on 52,53,42,43 series (extra parts for rear bracket only)**

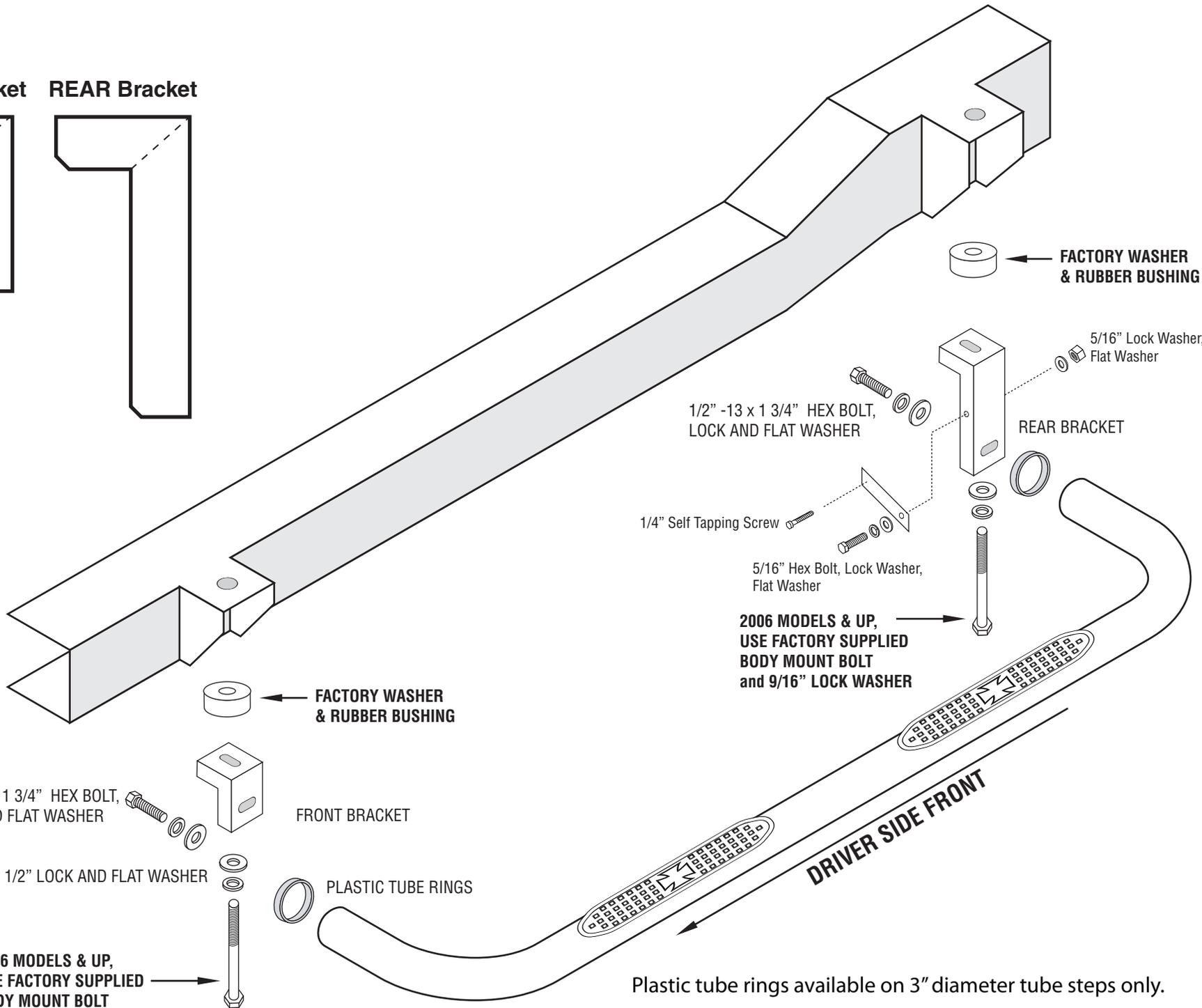
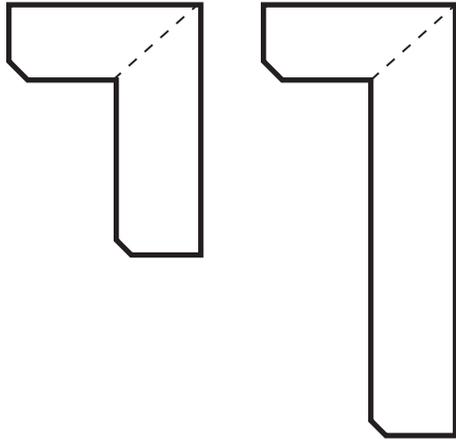
2	1/2" Nut	2	1/2" Lock Washer
2	1/2" Flat Washer		

QTY	PARTS LIST	QTY	PARTS LIST
2	5/16" Hex Nut	4	1/2" - 13 x 1-3/4" Hex Bolt
2	5/16" Lock Washer	2	5/16" - 18 x 1" Hex Bolt
2	1522 Front Bracket	2	1/4" - 14 x 1" Self Tapping Screw
2	1522 Rear Bracket	8	1/2" Flat Washer
2	6-12" Straps	2	5/16" Flat Washer
4	M12-1.75x120MM (4 -3/4") Bolt	8	1/2" Lock Washer
8	9/16" Lock Washer	2	Round Plastic Washer

## MAINTENANCE AND CARE

Only use mild soap for regular cleaning. For heavy build up, a solution of ammonia and water can be used. Never use an abrasive material, i.e. steel wool, for cleaning purposes. Use terry cloth towels wiping in the direction of the tube at all times.

**FRONT Bracket**    **REAR Bracket**



**FACTORY WASHER & RUBBER BUSHING**

5/16" Lock Washer, Flat Washer

1/2" -13 x 1 3/4" HEX BOLT, LOCK AND FLAT WASHER

**REAR BRACKET**

1/4" Self Tapping Screw

5/16" Hex Bolt, Lock Washer, Flat Washer

**2006 MODELS & UP, USE FACTORY SUPPLIED BODY MOUNT BOLT and 9/16" LOCK WASHER**

**FACTORY WASHER & RUBBER BUSHING**

1/2" -13 x 1 3/4" HEX BOLT, LOCK AND FLAT WASHER

**FRONT BRACKET**

1/2" LOCK AND FLAT WASHER

**PLASTIC TUBE RINGS**

**2006 MODELS & UP, USE FACTORY SUPPLIED BODY MOUNT BOLT and 9/16" LOCK WASHER**

**DRIVER SIDE FRONT**

Plastic tube rings available on 3" diameter tube steps only.