IRON CROSS AUTOMOTIVE

01-10 GM HD Crew Cab, 04-09 1500 Crew Cab

51-524/526   41-524/526
52-524, 52-526   42-524, 42-526
53-524   43-524

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IRON CROSS AUTOMOTIVE INC. 2009
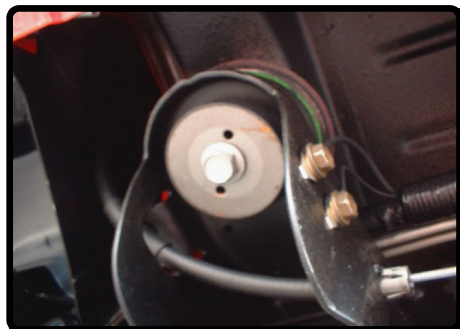
TUBE STEP INSTALLATION SHEET

FIG 1   **FIG 2**   **FIG 3**   **FIG 4**   **FIG 5**

STEP 1 Remove front and rear body mount bolts (Fig 1 & 2). 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. (Fig1 thru 4) ***On all 2006 and UP models use factory body mount 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 ½" bolts, lock washers, & flat washers supplied. On the rear bracket place the supplied strap between the flat washer and lock washer. (Fig 5)

STEP 3 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 4 Use the supplied self-tapping screw to attach the bracing strap to the frame mount. Place round plastic washer between brace and frame.

STEP 5 Repeat the steps for the other side of the vehicle.

QTY	PARTS LIST	QTY	PARTS LIST
2	1524 Front Bracket	4	½" – 13 x 1-3/4" Hex Bolt
2	1524 Rear Bracket	8	½" Flat Washer
4	M12-1.75x120MM (4-3/4") Bolt	8	½" Lock Washer
2	1524 Rear Brace	2	¼" Self Tapping Screw
2	5/16" x 1" Hex Head Bolt	2	5/16" Hex Nut
2	5/16" Flat Washer	2	5/16" Lock Washer
2	Round Plastic Washer	4	9/16" Lock Washer

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

2	½" Nut	2	½" Lock Washer
2	½" Flat 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.

RV 2.15.10

FRONT Bracket **REAR Bracket**
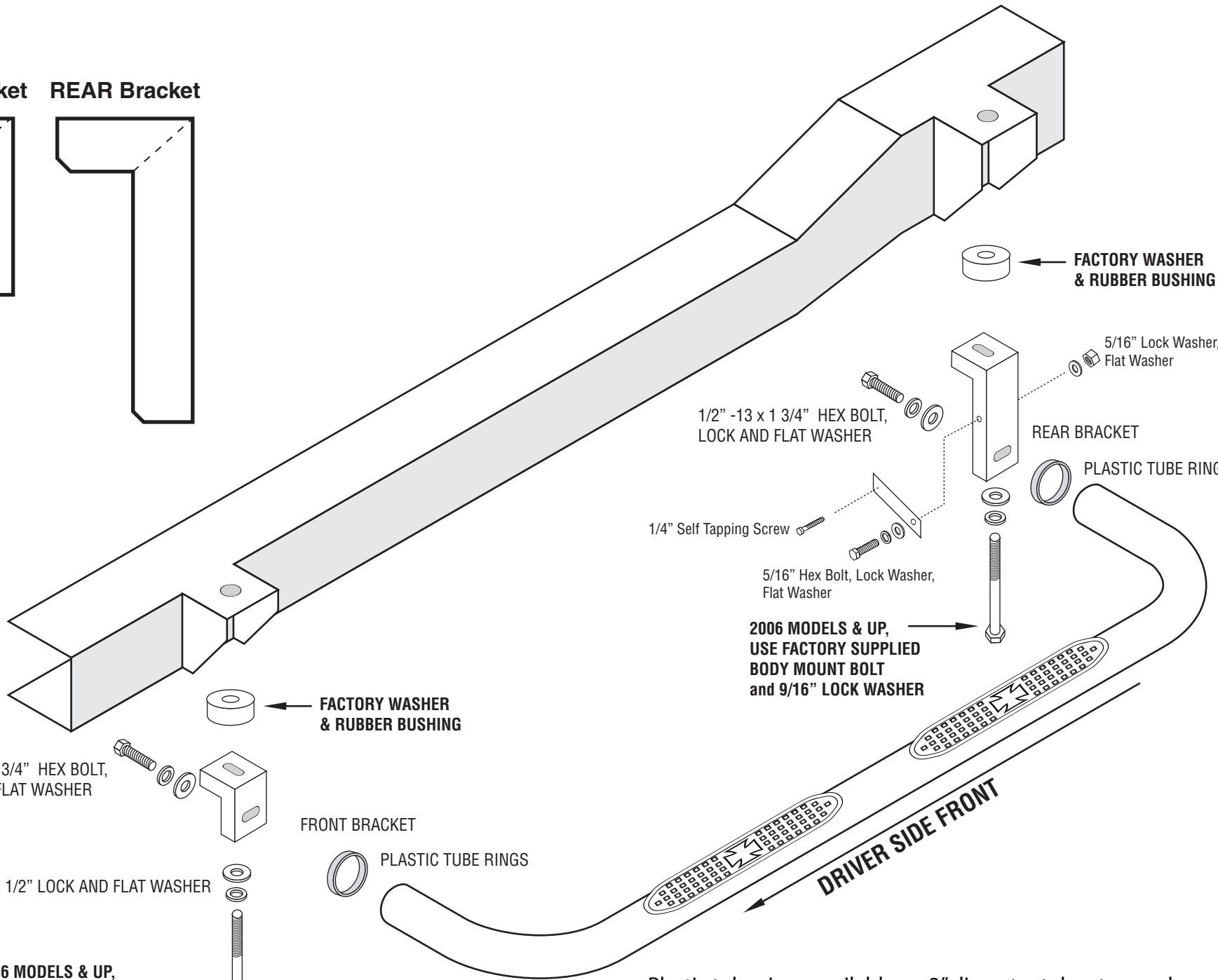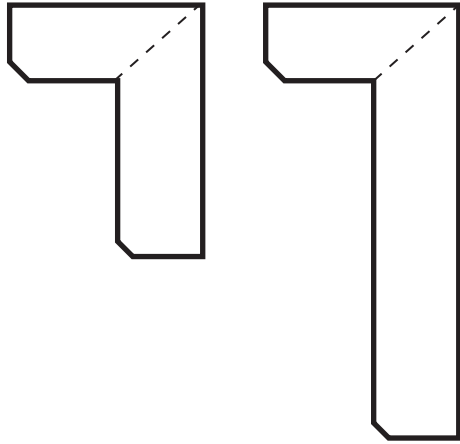
**FACTORY WASHER
& RUBBER BUSHING**

5/16" Lock Washer,
Flat Washer

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

REAR BRACKET

PLASTIC TUBE RINGS

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

PLASTIC TUBE RINGS

1/2" LOCK AND FLAT WASHER

**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.