



94-01 Dodge 1500 / 94-02 2500/3500 Reg. Ext. Quad

51-600,602,604 52-602

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 IRON CROSS AUTOMOTIVE INC. 2007

TUBE STEP INSTALLATION SHEET

- STEP 1** REMOVE ALL CONTENTS FROM THE BRACKET BOX AND CHECK FOR CORRECT QUANTITY AND ANY DAMAGED PARTS
- STEP 2** REMOVE FRONT AND REAR BODY MOUNT BOLTS. REPLACE BOLT WITH BRACKET, FLAT WASHER, AND LOCK WASHER. HAND TIGHTEN AT THIS TIME TO ALLOW FOR FINAL ADJUSTMENTS.
- STEP 3** TAKE ONE TUBE AND BOLT IT TO THE FRONT BRACKET FIRST, USING THE ½” BOLTS, LOCKWASHERS, AND FLATWASHERS 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.
- STEP 4** ALIGN THE TUBE WITH THE TRUCK AND TIGHTEN THE TUBE STEP BOLTS FIRST TO 65 FT./LBS. THEN TIGHTEN THE BRACKET BOLTS TO 65 FT./LBS
- STEP 5** ON SOME VEHICLES FOR ADDED SUPPORT YOU CAN USE THE SUPPLIED STRAPS. BOLT THE STRAPS TO THE FRONT AND REAR BRACKETS AND USE THE SUPPLIED SELF TAPPING SCREW TO MOUNT TO THE BODY MOUNT. PLACE ROUND WASHER BETWEEN BRACE AND FRAME.
- STEP 6** REPEAT STEPS 2 THROUGH 4 FOR INSTALLATION OF PASSENGER SIDE

QTY.	PARTS LIST	QTY.	PARTS LIST
2	1600 FRONT BRACKETS	2	8” Straps
2	1600 REAR BRACKETS	4	12MM – 1.75 x 120MM (4-3/4”) Hex Bolt
		4	½” – 13x1-3/4’ Hex Bolt
4	3/8” – 16 x 1-1/4” Hex Bolt	8	½” Lock Washer
8	½” Flat Washer	4	3/8” Lock Washer
4	3/8” – 16 Hex Nut	4	¼” – 14 x 1” Self Taping Screw
4	3/8” Flat Washer	4	Round Plastic 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 and abrasive material, i.e. steel wool, for cleaning purposes. Use terry cloth towels wiping in the direction of the tube at all times.

