



## 05-07 Dodge Dakota Club Cab

# 51-630

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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

2	1630 Front Bracket	8	½" Flat Washer
2	1630 Rear Bracket	2	5/16" Flat Washer
4	M12 – 1.75 x 120MM Bolt	2	5/16" Hex nut
4	½" – 13 x 1-3/4" Hex Bolt	8	½" Lock Washer
2	¼" – 14 x 1" Self Tapping Screw	2	5/16" – 18 x 1" Hex Bolt
2	6.5" Galv. Straps	2	Tube Steps
2	5/16" 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.

