

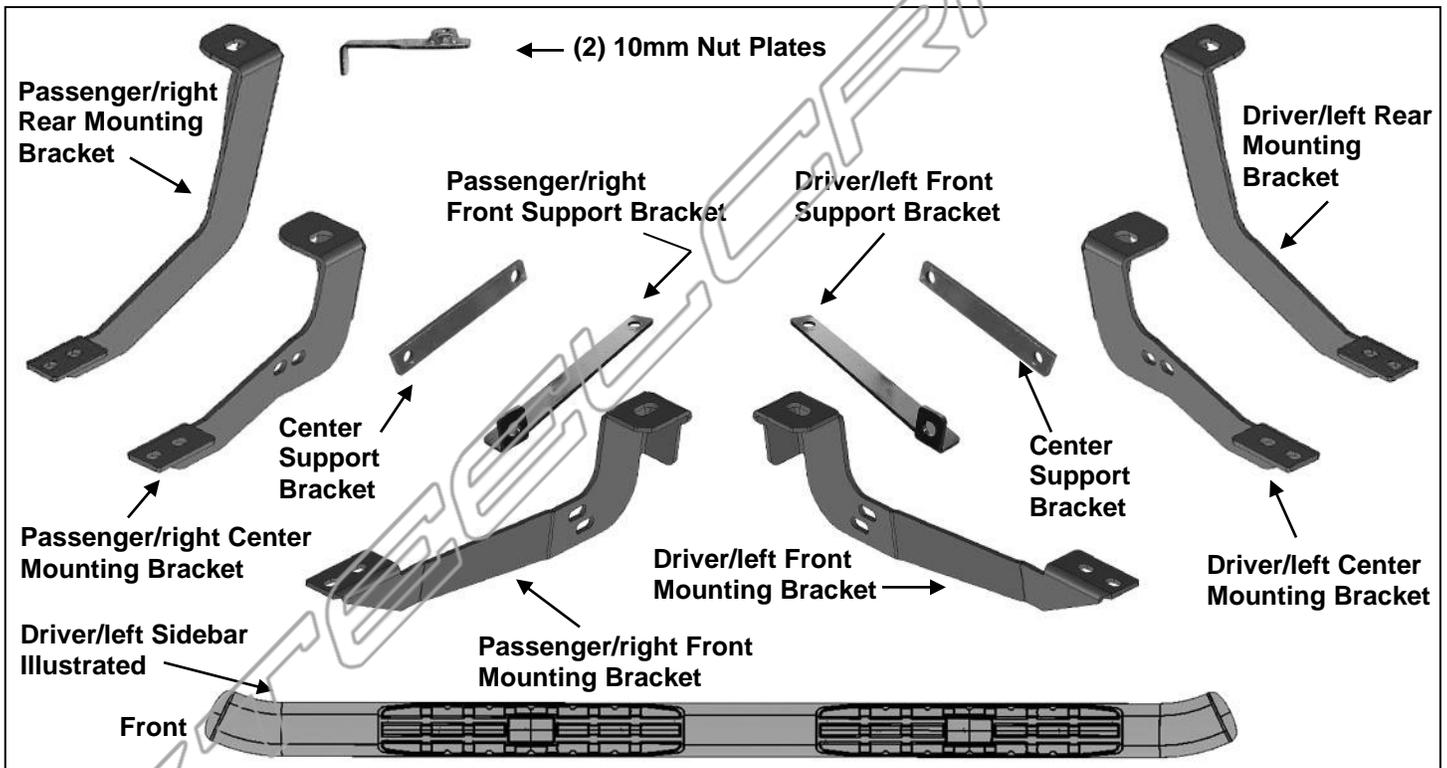
INSTALLATION INSTRUCTIONS

**4X SERIES 4" OVAL BENT END SIDE STEP
99-13 1500, 99-14 2500-3500 SILVERADO/SIERRA EXT CAB**

STEEL CRAFT

PARTS LIST:

1	Driver/Left Side Bar	2	12-1.75mm x 30mm Hex Bolts
1	Passenger/Right Side Bar	4	12mm x 32mm x 3mm Flat Washers
1	Driver/Left Front Mounting Bracket	2	12mm Lock Washers
1	Driver/Left Front Support Bracket	2	12mm Hex Nuts
1	Passenger/Right Front Mounting Bracket	2	10mm Nut Plates
1	Passenger/Right Front Support Bracket	6	10-1.50mm x 30mm Hex Bolts
1	Driver/Left Side Center Mounting Bracket	10	10mm x 20mm OD x 2mm Flat Washers
1	Passenger/Right Side Center Mounting Bracket	6	10mm Lock Washers
2	Center Support Brackets	4	10mm Hex Nuts
1	Driver/Left Rear Mounting Bracket	12	8-1.25mm x 25mm Combo Hex Bolts
1	Passenger/Right Rear Mounting Bracket		



PROCEDURE:

REMOVE CONTENTS FROM BOX. VERIFY ALL PARTS ARE PRESENT. READ FACTORY BODY BOLT REMOVAL INSTRUCTIONS AND INSTALLATION INSTRUCTIONS CAREFULLY BEFORE STARTING INSTALLATION.

1. Start the installation under the passenger side of the vehicle. Remove the front body mount bolt, **(Figure 1)**. Do not remove rubber bushings.
2. Attach the passenger side front mounting Bracket to the body mount reusing the factory hex bolt, **(Figures 2 & 3)**. Do not tighten hardware at this time.
3. Locate the two factory holes in the bottom of the frame towards the front of the vehicle, **(Figure 4)**. Insert (1) 10mm Nut Plate, **(Figure 5)**, into the oval hole and line up the threaded nut with the forward round hole, **(Figure 4)**. **NOTE:** Nut Plate and Support Brackets are not required on **2011-14 25-3500** models.

4. Attach the flat end of the passenger side front Support Bracket to the Nut Plate with (1) 10mm x 30mm Hex Bolt, (1) 10mm Lock Washer and (1) 10mm Flat Washer, **(Figures 6 & 7)**. Do not tighten hardware at this time.

1500 Models:

Attach the bent end of the Front Support Bracket to the outside hole in the Front Mounting Bracket with (1) 10mm x 30mm Hex Bolt, (2) 10mm Flat Washers, (1) 10mm Lock Washer and (1) 10mm Hex Nut, **(Figure 6)**. Do not tighten at this time.

Up to 2010 25-3500 Models-Support Bracket not required on 2011-14 25-3500 Models:

Note that the Front Support Bracket will not reach up to the Mounting Bracket, **(Figure 7)**.

Tighten the Support Bracket to the Nut Plate in the frame. Carefully push up on the Support Bracket until it reaches the inside hole in the Mounting Bracket. Bolt the Support Bracket to the hole in the Mounting Bracket with (1) 10mm x 30mm Hex Bolt, (2) 10mm Flat Washers, (1) 10mm Lock Washer and (1) 10mm Hex Nut, **(Figures 7 & 8)**. Do not tighten at this time.

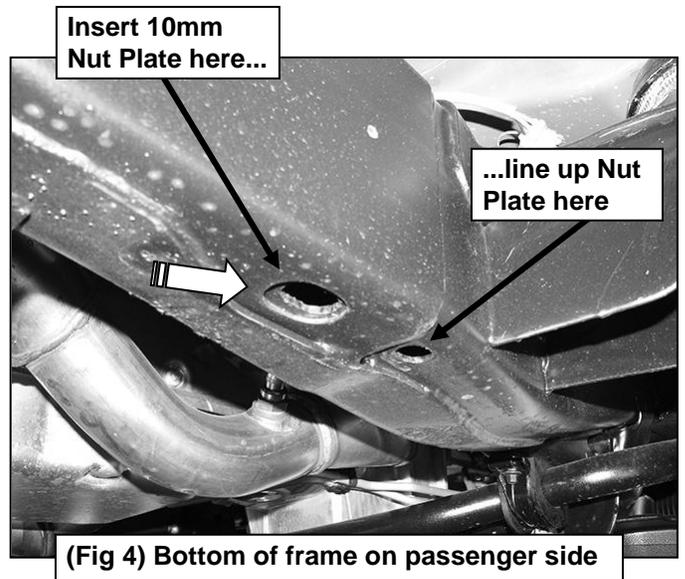
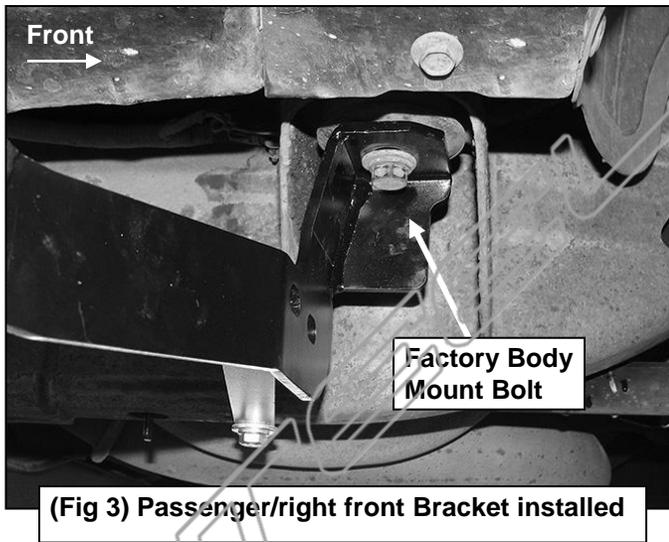
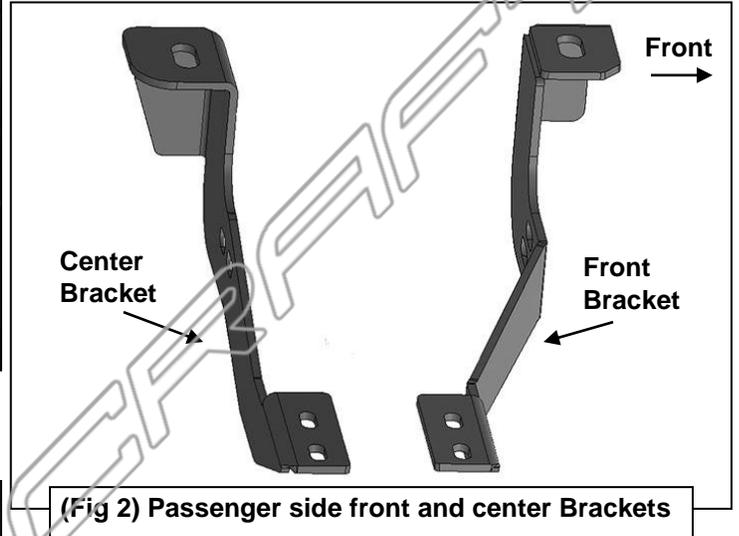
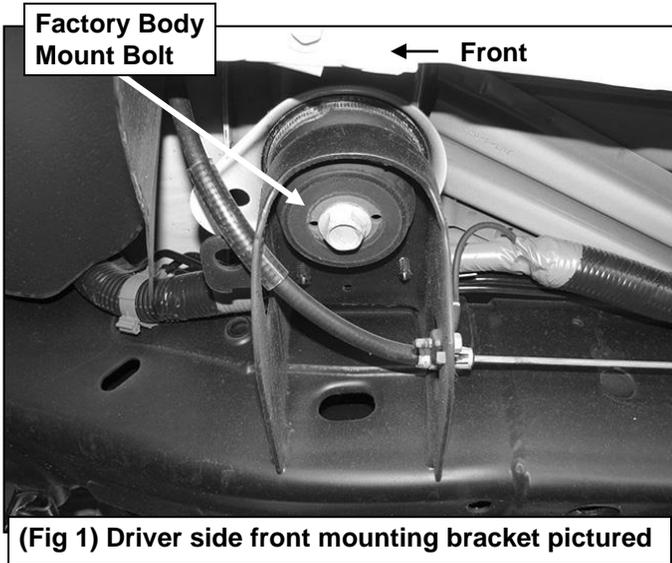
5. Move to the center body mount and remove the factory bolt. Select the passenger side center Bracket, **(Figure 2)**. Repeat **Steps 1 & 2** to attach the center Bracket, **(Figures 9 & 10)**.
6. Next, select (1) Center Support Bracket. **IMPORTANT:** Center Support Brackets are not required on **2011—14 25-3500** Models. Note the two different sizes of mounting holes in the Support Bracket. Slide the end of the Center Support Bracket with the larger mounting hole between the factory body mount and the Center Bracket, **(Figures 9 & 10)**. Attach the Support Bracket to the holes in the side of the body mount with (1) 12mm x 30mm Hex Bolt, (2) 12mm Flat Washers, (1) 12mm Lock Washer and (1) 12mm Hex Nut. Do not tighten at this time.
7. Attach the opposite end of the Support Bracket to the front of the Center Bracket with (1) 10mm x 30mm Hex Bolt, (2) 10mm Flat Washers, (1) 10mm Lock Washer and (1) 10mm Hex Nut, **(Figures 9 & 10)**. Do not tighten at this time.
8. Continue on to the rear body mount. Repeat **Steps 1 & 2** to attach the passenger side rear Mounting Bracket to the body mount, **(Figure 11)**. Leave hardware loose at this time.
9. Carefully position the passenger Sidebar onto the Mounting Brackets. Attach the Sidebar to the Mounting Brackets with (6) 8mm x 25mm Combo Hex Bolts, **(Figures 12 & 13)**. Do not tighten hardware at this time.
10. Level and adjust the Sidebar and fully tighten all hardware.
11. Repeat **Steps 1—10** for driver/left Sidebar installation.
12. Do periodic inspections to the installation to make sure that all hardware is secure and tight.

To protect your investment, wax this product after installing. Regular waxing is recommended to add a protective layer over the finish. Do not use any type of polish or wax that may contain abrasives that could damage the finish.

For stainless steel: Aluminum polish may be used to polish small scratches and scuffs on the finish. Mild soap may be used also to clean the Sidebar.

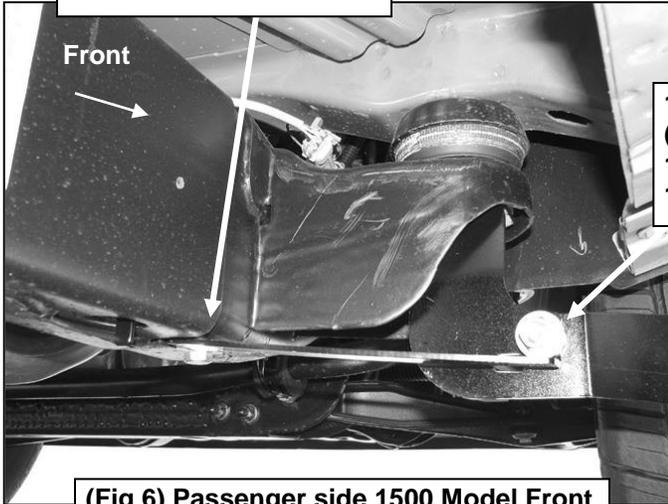
For gloss black finishes: Mild soap may be used to clean the Sidebar.

Passenger Side Installation Pictured



NOTE: Support Brackets not required on 2011-14 25-3500 Models

10mm x 30mm Hex Bolt
10mm Lock Washer
10mm Flat Washer

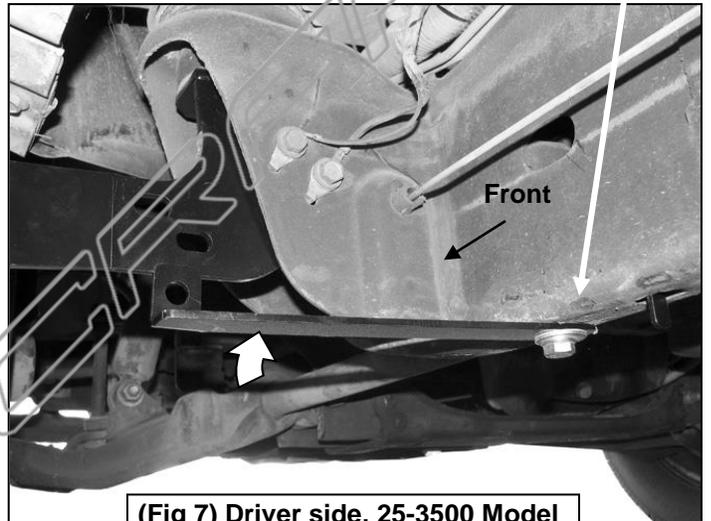


(Fig 6) Passenger side 1500 Model Front Support Bracket Installation Pictured

NOTE: Support Brackets not required on 2011-14 25-3500 Models

10mm x 30mm Hex Bolt
(2) 10mm Flat Washers
10mm Lock Washer
10mm Hex Nut

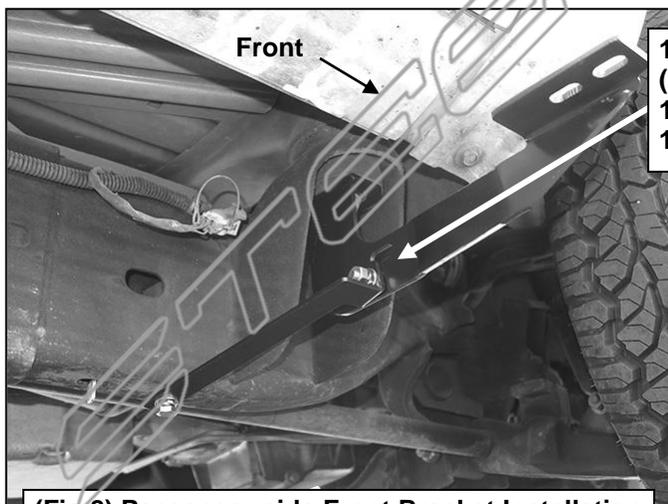
10mm x 30mm Hex Bolt
10mm Lock Washer
10mm Flat Washer



(Fig 7) Driver side, 25-3500 Model Front Support Bracket Installation

IMPORTANT NOTE:
Bend Support Bracket up by hand to meet the inner hole in the Front Mounting Bracket

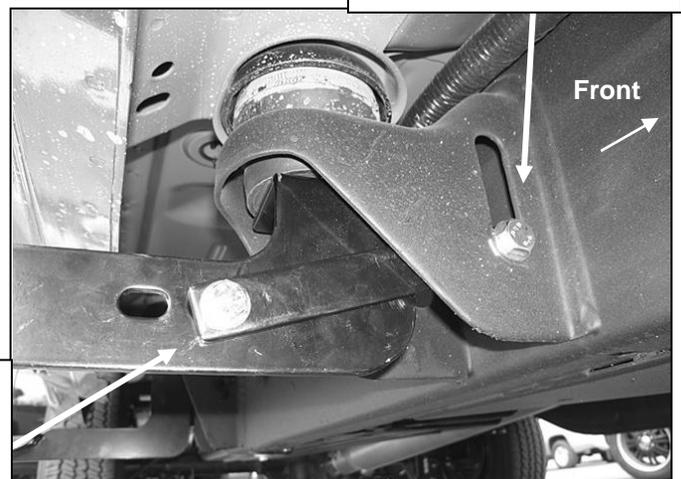
NOTE: Support Bracket not required on 2011-14 25-3500 Models



(Fig 8) Passenger side Front Bracket Installation

10mm x 30mm Hex Bolt
(2) 10mm Flat Washers
10mm Lock Washer
10mm Hex Nut

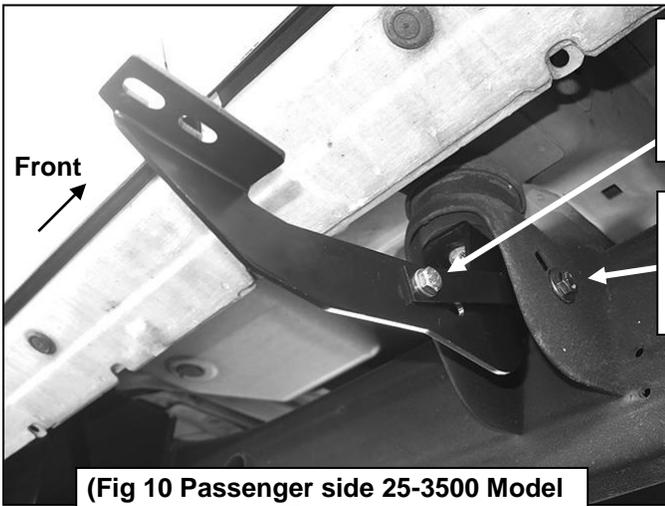
12mm x 30mm Hex Bolt
(2) 12mm Flat Washers
12mm Lock Washer
12mm Hex Nut



(Fig 9) Example of passenger side, 1500 Model Center Bracket and Support Bracket Installation

10mm x 30mm Hex Bolt
(2) 10mm Flat Washers
10mm Lock Washer
10mm Hex Nut

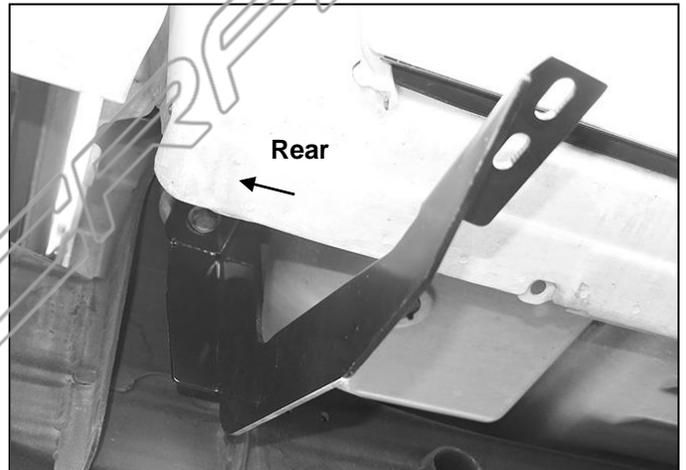
Passenger Side Installation Pictured



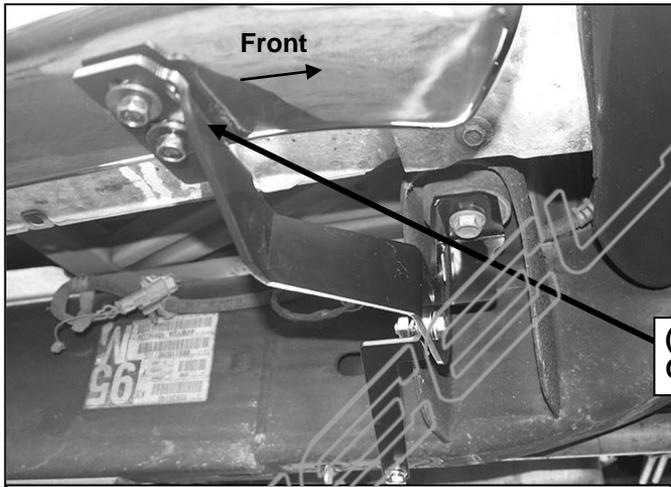
10mm x 30mm Hex Bolt
(2) 10mm Flat Washers
10mm Lock Washer
10mm Hex Nut

12mm x 30mm Hex Bolt
(2) 12mm Flat Washers
12mm Lock Washer
12mm Hex Nut

(Fig 10) Passenger side 25-3500 Model
Center Support Bracket Installation

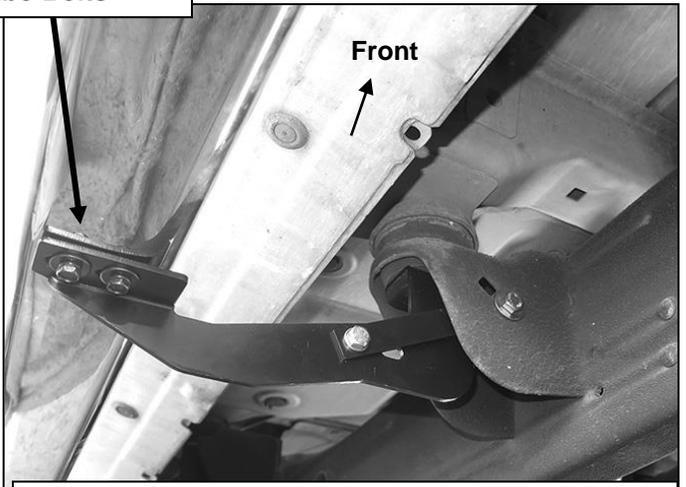


(Fig 11) Passenger side Rear Bracket Installation

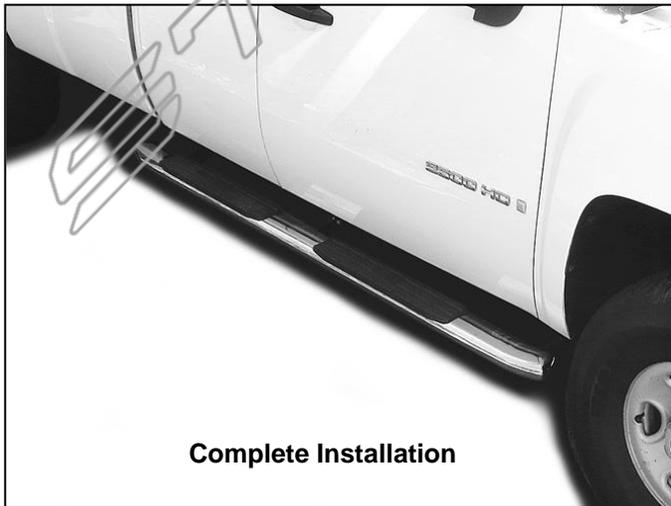


(2) 8mm x 25mm
Combo Bolts

(Fig 12) Passenger side Front Bracket Installation



(Fig 13) Passenger side Center Bracket Installation



Complete Installation