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IRON CROSS
AUTOMOTIVE INC.

51-572 41-572
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99-15 Silverado/Sierra
1500 Extended/Double Cab

01-15 Silverado/Sierra
2500/3500 Extended/Double Cab

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Tube Step Installation Sheet

Installation Instructions

Hardware

2	1522 Front Bracket	4	1/2" - 13 x 1 3/4" Hex Bolt
2	1522 Rear Bracket	8	1/2" Flat Washers
4	M12 - 1.75x120MM (4 3/4") Bolt	8	1/2" Lock Washers
2	6.5" Straps	2	1/4" - 14 x 1" Self Tapping Screw
2	5/16" - 18 x 1" Hex Bolt	2	5/16" Hex Nut
2	5/16" Flat Washer	2	5/16" Lock Washer
2	Round Plastic Washer	8	9/16" Lock Washer

Hardware - 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		



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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.

Tube Step Installation

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. (Fig1 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.*

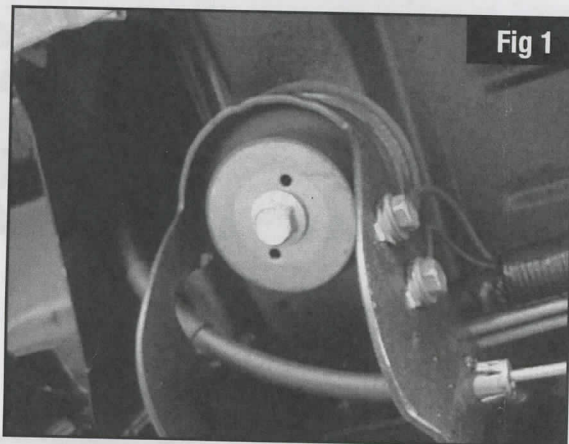


Fig 1

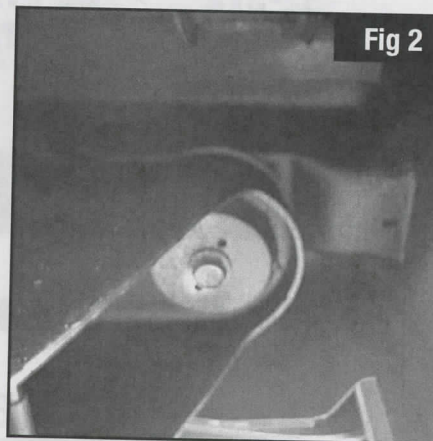


Fig 2

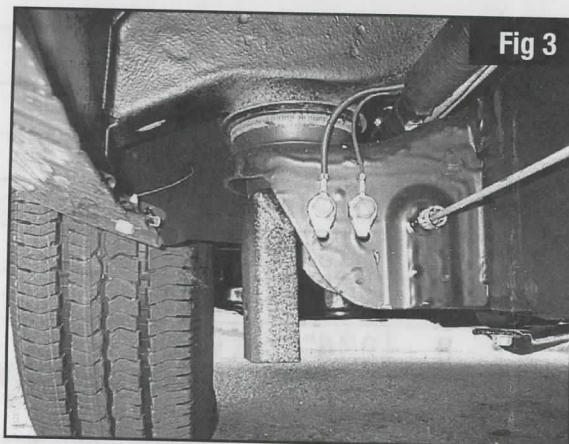


Fig 3

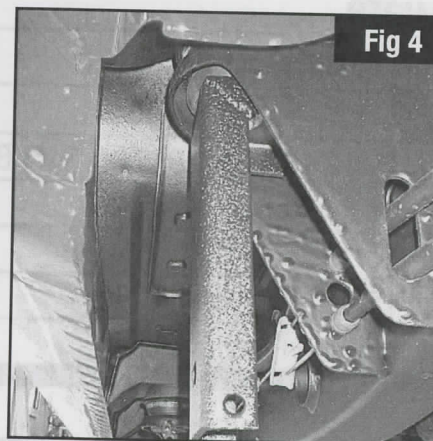


Fig 4

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 next.



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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 a round plastic washer between strap and body mount, rear bracket and strap.

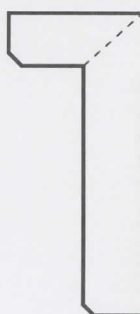
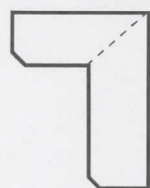
Step 4:

Repeat the steps for the other side of the vehicle.



FRONT Bracket

REAR Bracket



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

1/2" LOCK AND FLAT WASHER

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

FRONT BRACKET

PLASTIC TUBE RINGS

FACTORY WASHER
& RUBBER BUSHING

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

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

5/16" Lock Washer,
Flat Washer

REAR BRACKET

PLASTIC TUBE RINGS

DRIVER SIDE FRONT

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



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