



MANUAL STEP OEM INSTALLATION MANUAL

L I P P E R T
C O M P O N E N T STM

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Introduction

This document details the installation of manual steps.

Safety

WARNING

The “WARNING” symbol above is a sign that an installation procedure has a safety risk involved and may cause death or serious injury if not performed safely and within the parameters set forth in this manual. Always wear eye protection when performing this installation procedure. Other safety equipment to consider would be hearing protection, gloves and possibly a full face shield, depending on the nature of the installation procedure.

WARNING

The trailer **MUST** be supported per manufacturer's specifications before working underneath. Failure to do so may result in death or serious injury.

CAUTION

Moving parts can pinch, crush or cut. Keep clear and use caution.

Preparation

Resources Required

- Cordless or Electric Drill or Screw Gun
- Appropriate Drive Bits
- $\frac{9}{16}$ " Socket
- Four $\frac{3}{8}$ " - 16 x 1" Bolts, Grade 2
- Four $\frac{3}{8}$ - 16 Flange Nuts, Grade 2
- 2 self-tapping 1" x $\frac{1}{4}$ " screws (If needed for step support brackets)

Installation

1. Verify the location and squareness of the step outriggers.
2. Ensure the step is completely backed up against the I-beam.

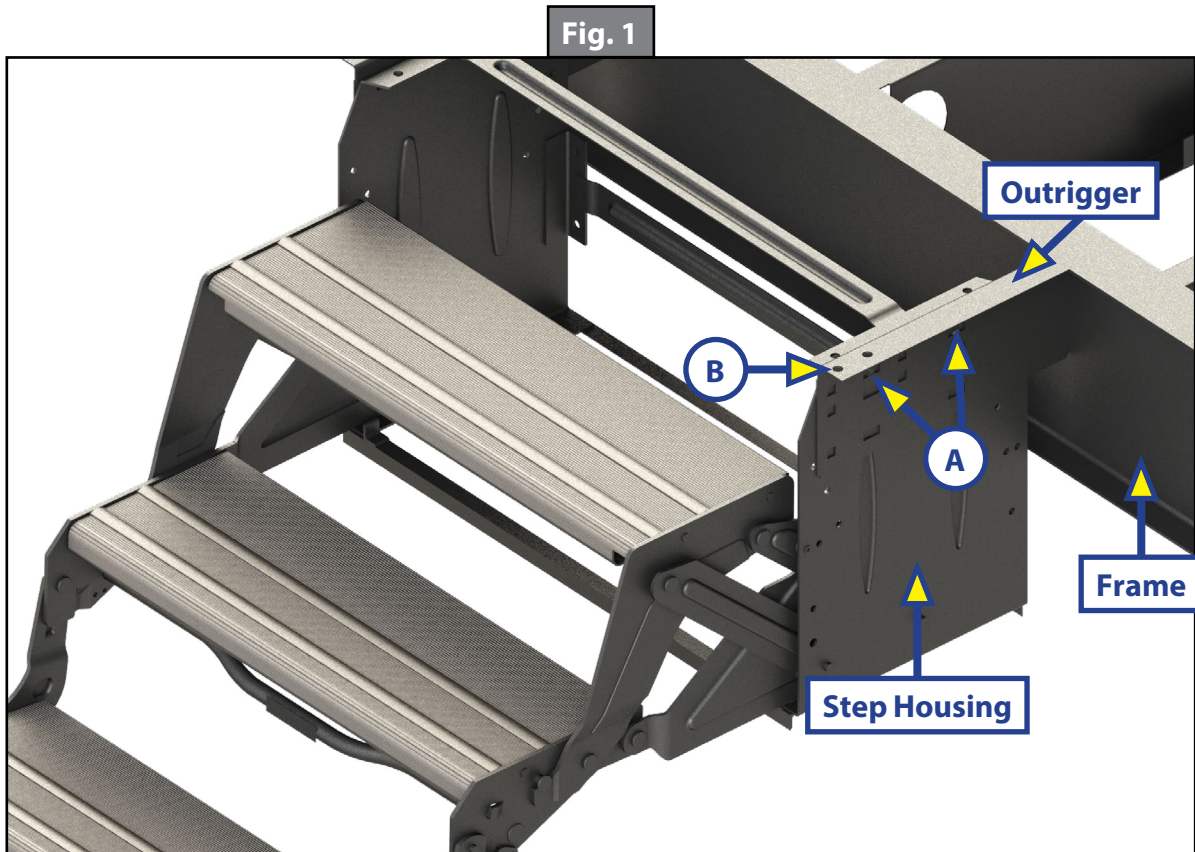
NOTE: Some OEM designs allow the steps to rest against the I-beam and lag directly to the web of the beam. Other designs include step supports and, if supports are present, steps should be completely backed up against the step supports on the frame (angle or tube).

3. Align holes in step with holes in the outrigger (Fig. 1A). Insert two bolts and flange lock nuts per side. Tighten only until snug to allow for adjustments.
4. Verify that the step housing is square, level to the outrigger and plumb to the chassis. Once verified, tighten the bolts to 20 ft-lbs of torque.

NOTE: If step support brackets are located on the step, they should be secured to the chassis I-beam or step support angles on the chassis by 1 self-tapping 1" x $\frac{1}{4}$ " screw per each side of the step.

NOTE: The adjustable step bracket is optional and may not be included on all steps.

5. Attach lag bolt or bolts to the floor through the outer end holes in the outrigger (Fig. 1B) as per manufacturer's recommendations.





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