

SIDEWINDER

AUTOMATIC FOLDING STEP SYSTEM

INSTALLATION INSTRUCTIONS

FOR KITS

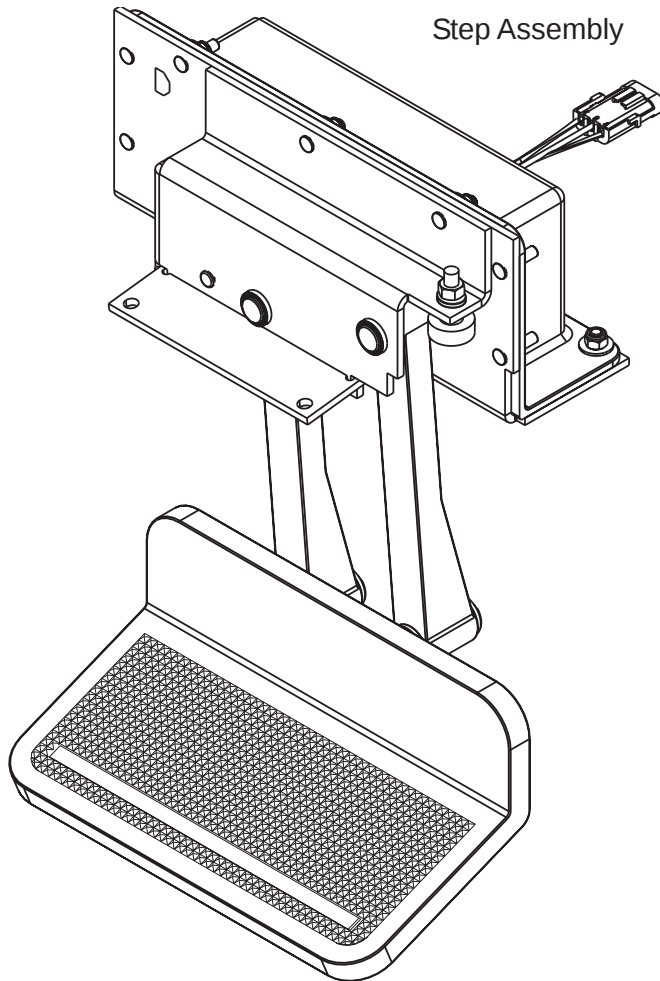
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1997-2006 Ford F-150/F-250 Pickup



Step Assembly

TOOLS REQUIRED FOR INSTALLATION

Safety Glasses

7/16" combination wrench and socket

1/2" combination wrench and socket

3/16" Allen wrench

3/8 or 1/2" drive electric drill

Drill bits -1/8"

1/4"

5/16"

3/8"

Phillips screwdriver

Wire cutters

Crimping Tool for electrical fasteners

Measuring tape

Marker or Scribe

Level

Hammer

Center Punch

HARDWARE KIT

- 1 Step Assembly
- 1 Left rear mounting bracket
- 1 Right rear mounting bracket
- 1 Rear crossmember angle bracket
- 2 Rear mounting 90 deg. 2" brackets
- 2 Rear long angle mounting brackets

FASTENER KIT

- 2 Button-head cap screws 5/16-18 x 3/4"
- 14 Flat washers 5/16"
- 8 Lock washers 5/16"
- 8 Hex nuts 5/16-18
- 6 Hex bolts 5/16-18
- 2 Hex bolts 1/4-20 x 1"
- 6 Flat washers 1/4"
- 2 Split lock washers 1/4"
- 2 1/4-20 Nut-sert
- 4 1/4-20 Nylock Nut

CAUTION: Before beginning any installation procedure, read all instructions carefully. Before drilling any holes make sure there is sufficient clearance on both sides

STEP INSTALLATION INSTRUCTIONS

1997-2006 Ford F-150/F-250 Pickup

Step 1) Measure 20 1/2" inches starting from the rear edge of the door along the kick panel toward the front of the vehicle, mark this location with a pencil as shown in Figure B. This is the approximate location of the rear kick-panel mounting bolt (do not drill at this time).

For Rear Door Applications on Extended Cab Pickups, measure 16" from the rear of the door to mark the position of the first bolt hole.

Step 2) There are multiple methods of applying the rear mounting brackets. Two of the options are shown in Figures A, B, and Figure C. Lift the step into position as shown in Figures A and B, line up the rear most hole in the front mounting bracket of the step to the mark made in Step 1. These are not the only options for mounting your step, if you are not satisfied with one of the arrangements shown, try different positioning of the step and brackets to find a suitable fit for your needs. Assemble the rear mounting brackets to the step.

Step 3) The front most rear mounting bracket should now line up with the forward body cross frame as shown in Figure B. Adjust the step forward or back to a best fit location. Keep Step 2 in mind as you locate the brackets and step. With the brackets in

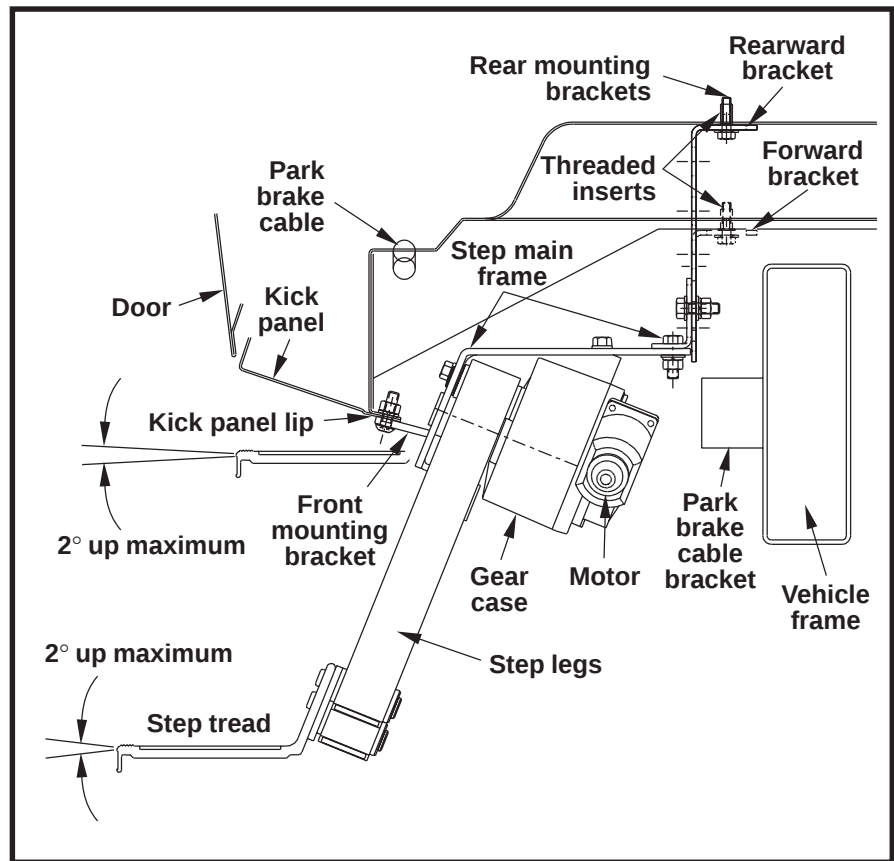


Figure A - Side view

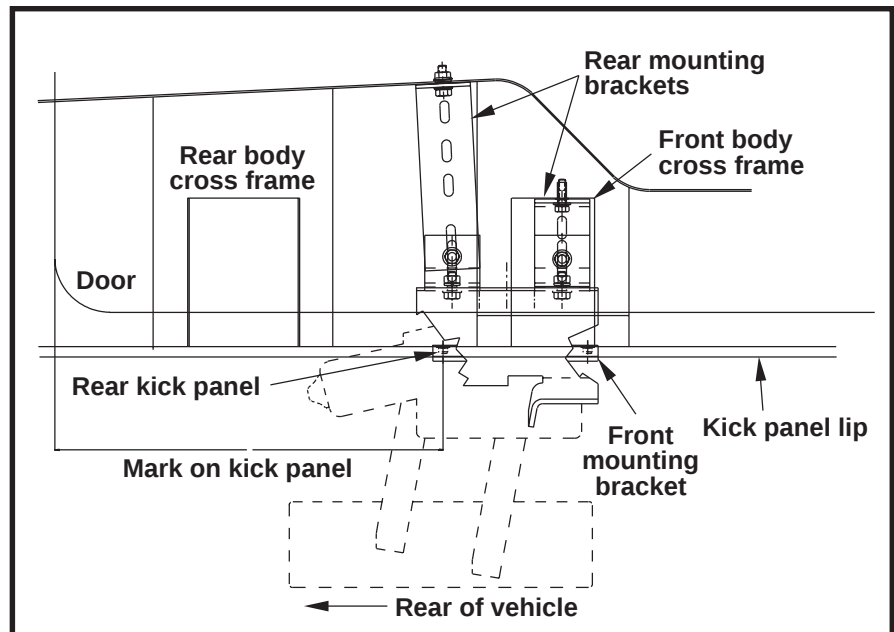


Figure B - Rear view

position as shown in Figures A and B, mark the location for the rear mounting bolts in the body cross frame and floor of the cab, or other location as determined, as well as the hole locations in the kick panel. Watch carefully for obstructions.

Step 4) Double check bolt hole location marks made in Step 3 and center punch bolt hole locations.

CAUTION: When drilling or cutting, always look on the other side to make sure the drill is not going to hit an obstruction. Hazards may include fuel lines, electrical wires, or a dangerous combination of both.

Step 5) If there are no obstructions and you are sure about the step location then carefully drill the holes, observe all safety precautions when performing these procedures.

NOTE: Mounting to the body cross frame is preferable to drilling holes in the floor.

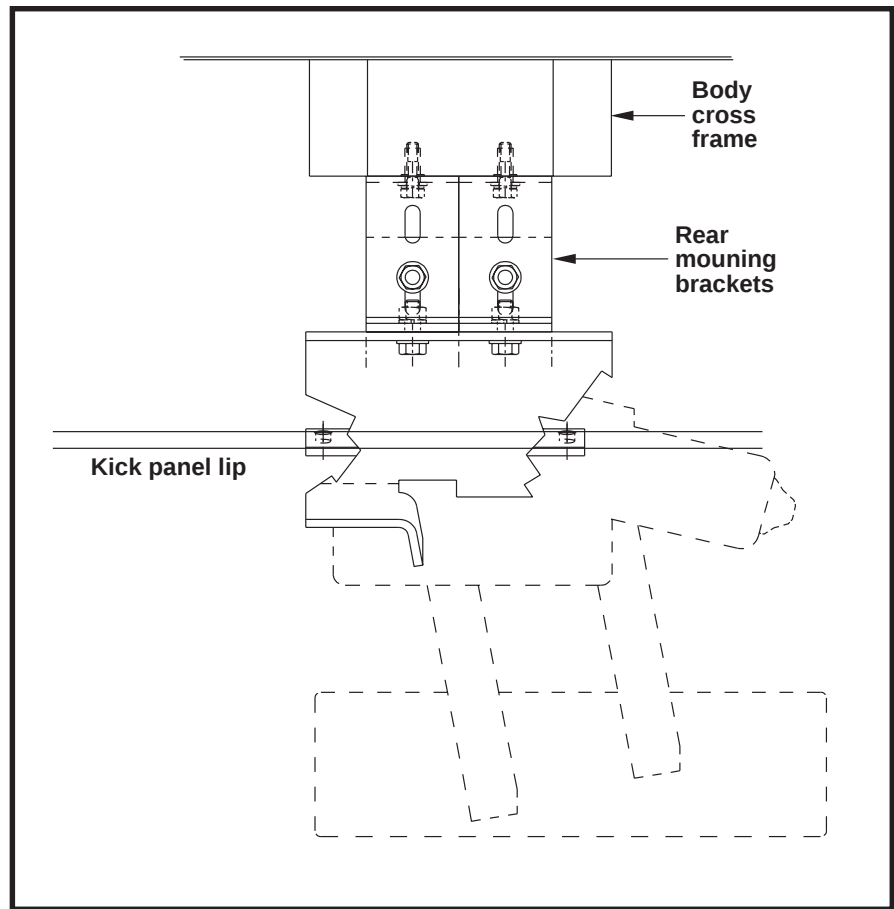


Figure C - Rear view (rear door)

Step 6) Install threaded inserts into the body cross frame and/or the floor of the cab. Use a threaded insert tool or make one using a bolt and washers. Threaded inserts are affixed to the hole by squashing or collapsing as a bolt is tightened into them.

Step 7) Place the step into position and insert the bolts in the kick panel (tighten). Insert bolts in the rear mounting brackets and adjust the outer edge of the step to have slight upward tilt of no more than two degrees as shown in Figure A. Tighten bolts and double check all bolts and clearances. Continue on to Door Switch Installation.

1997-2006 Ford F-150/F-250 Rear Door application

Step 1) Locate the third body cross frame (there are three on each side of the vehicle) shown in Figure C (See Photo 1 for clarification). The step will mount directly to this body member.

Step 2) Install the rear mounting brackets finger tight, to the step, using two 90 degree 2" (275068) brackets, and two rear angle short (275057) brackets as shown in Figure C.

Step 3) Lift the step into position and line up so that the step main frames center line is in line with the body cross frame center line. This will allow two brackets to be mounted side by side to the cross frame (See Figure C).

Step 4) Mark the hole locations in the cross frame and in the kick panel. Watch for obstructions.

Step 5) Center punch the locations marked in Step 4.

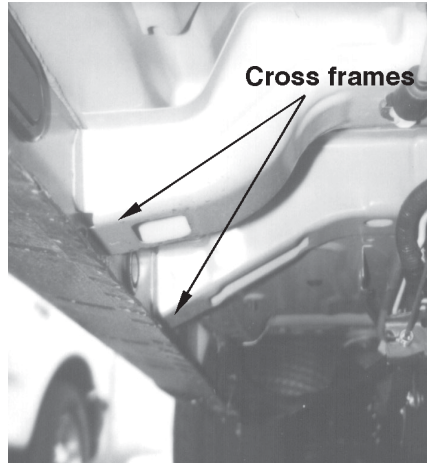


Photo 1 - Two of three cross frames shown

CAUTION: When drilling or cutting, always look on the other side to make sure the drill is not going to hit an obstruction. Hazards may include fuel lines, electrical wires, or a dangerous combination of both.

Step 6) Drill 3/8" holes at the marks made in Step 5. Be sure to observe all safety precautions while performing these procedures.

Step 7) Install the two threaded inserts into the body cross frame and/or floor of the cab.

Note: Mounting to the body cross frame is preferable to drilling holes in the floor. Use a threaded insert tool or make one using a bolt and washers. Threaded inserts are affixed to the hole by squashing or collapsing as a bolt is tightened into them.

Step 8) Lift the step into position and insert all bolts, tighten only the bolts in the kick panel at this time.

Step 9) Adjust the outer edge of the step tread to have a slight upward tilt of no more than two degrees as shown in Figure 1.

Step 10) Tighten all bolts and double check for obstructions. Step installation is complete. Continue on to door switch installation.



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