

INSTALLATION INSTRUCTIONS AND PARTS LIST
MODEL 477078, 477088, 477098 REGAL 7 OVAL STEPS (BOARDS ONLY)
UNIVERSAL APPLICATIONS



1. Read instructions completely and check to make sure that all required parts (listed on the service parts list) are on hand before starting the installation.
2. Follow the instructions included with the specific bracket package that you are using to mount the brackets to your vehicle.
3. The step is pre-assembled from the factory. The serial number label is located on the front inside drivers side step assembly.
4. Attaching the step to the mounting bracket:
 - 4.1 Set the step on the mounting brackets, and slide each support mounting plate (item #9) inside the oval step and above each bracket.
 - 4.2 Using the supplied 5/16-18 x 1" black stainless steel hex bolt, washer, and serrated flange nut (items # 10,11&12) attach the step assembly, support mounting plate and mounting bracket.
 - 4.3 Set the step plate in the correct position and tighten all fasteners.
Torque all 5/16" fasteners to 19 LB FT.

SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1&2	552059	2	REGAL 7 OVAL STEP, LH,RH,76",477078
1&2	552060	2	REGAL 7 OVAL STEP, LH,RH,86",477088
1	552061	1	REGAL 7 OVAL STEP, LH,96",477098
2	552062	1	REGAL 7 OVAL STEP, RH,96",477098
3	109233	2	END CAP LH REAR, RH FRONT,BLK PLASTIC
4	109232	2	END CAP RH REAR, LH FRONT,BLK PLASTIC
5	107863	8	BOLT-CARRAIGE, 10-24 X 0.50,SST, BLACK
6	108909	4	STEP PAD, 25" X 6.5", PLASTIC, BLACK
7	108908	24	BOLT-CARRAIGE, 10-24 X 1.0,SST, BLACK
8	107864	24	NUT-NYLOCK, 10-24, SST
9	552052	8	SUPPORT MTG PLT, 11 GA, GALV
10	106997	16	SCREW-HEX HD, 5/16-18X1.0,SST,BLACK
11	106998	16	WSHR-FLAT, 5/16, SST, BLACK
12	102680	16	NUT-SER FLG, 5/16-18, SST



(A LUVERNE Company)

1200 E. Birch St.

Brandon, SD 57005

REV A 31JUL12
552065 SHEET 1 OF 2 24FEB12

INSTALLATION INSTRUCTIONS AND PARTS LIST

APPLICATION:

MODEL 400922 STEP BRACKETS:

2004 FORD F-150 SUPER CAB / SUPERCREW CAB PICKUPS

1. READ INSTRUCTIONS COMPLETELY AND CHECK TO MAKE SURE THAT ALL REQUIRED PARTS (LISTED ON THE SERVICE PARTS LIST) ARE ON HAND BEFORE STARTING THE INSTALLATION.
2. INSTALL 5/16" MULTI THREAD U-NUTS (ITEM #5) IN THE TOP REAR HOLE OF THE SECOND PATTERN FROM THE FRONT AND IN THE TOP FRONT HOLE OF THE THIRD PATTERN FROM THE FRONT AS SHOWN. INSTALL THESE U-NUTS SO THAT THE THREADS ARE TO THE INSIDE OF THE ROCKER PANEL. (THIS IS DONE BY INSERTING THE THREADED HALF OF THE U-NUT THRU THE LARGE ACCESS HOLES AND SLIDING THE U-NUT TOWARDS THE ROUND HOLE UNTIL IT SEATS IN THE ROUND HOLE).
3. **FRONT AND REAR BRACKET:** [SEE FIG 1] THESE BRACKETS WILL NEED TO BE APPROXIMATELY 6" FROM THE BACK OF THE CAB AND 6" FROM THE FRONT OF THE CAB AND WILL REQUIRE SOME DRILLING.
 - 3.1. CLAMP THE BRACKETS INTO POSITION. DRILL A (11/32") HOLE IN THE PINCH WELD AREA TO LINE UP WITH THE BOTTOM HOLE IN THE BRACKET.
 - 3.2. ATTACH THE BOTTOM OF THE BRACKET TO THE PINCH WELD WITH A 5/16" X 1.00" BLACK PLATED HEX HEAD CAP SCREW (ITEM #2), 5/16" BLACK PLATED FLAT WASHER (ITEM #3) AND 5/16" SERRATED FLANGE NUT (ITEM #4). LEVEL THE BRACKETS AND TIGHTEN THE BOLTS.
 - 3.3. DRILL A (7/32") HOLE INTO THE TOP OF THE ROCKER PANEL. INSTALL A SELF TAPPING SCREW (ITEM #9) INTO THE SMALL HOLE AND TIGHTEN, BE CAREFUL NOT TO OVER TIGHTEN.

SUPER CAB

4. ATTACH THE CENTER TWO MOUNTING BRACKETS (ITEM #1) TO THE VEHICLE.
 - 4.1. POSITION THE (2) BRACKETS ON THE VEHICLE SO THAT THE TOP HOLE LINES UP WITH THE MULTI THREAD U-NUT AND THE HOLE IN THE OFFSET LINES UP WITH THE HOLE IN THE PINCH WELD. ATTACH THE TOP OF THE BRACKET WITH A 5/16" X 1.00" ZINC PLATED HEX HEAD CAP SCREW (ITEM #7) AND 5/16" ZINC PLATED FLAT WASHER (ITEM #8). ATTACH THE BOTTOM OF THE BRACKET TO THE PINCH WELD WITH A 5/16" X 1.00" BLACK PLATED HEX HEAD CAP SCREW (ITEM #2), 5/16" BLACK PLATED FLAT WASHER (ITEM #3) AND 5/16" SERRATED FLANGE NUT (ITEM #4). LEVEL THE BRACKETS AND TIGHTEN THE FASTENERS.

SUPERCREW ONLY

5. ATTACH THE SECOND FROM THE FRONT MOUNTING BRACKET (ITEM #1) TO THE VEHICLE.
 - 5.1. ATTACH ANGLE BRACKET (ITEM #6) TO MOUNTING BRACKET (ITEM #1) WITH A 5/16" X 1.00" ZINC PLATED HEX HEAD CAP SCREW (ITEM #7) AND 5/16" ZINC PLATED FLAT WASHER (ITEM #8). AND A 5/16" SERRATED FLANGE NUT (ITEM #4) TOGETHER WITH THE ANGLE TOWARDS THE MULTI THREAD U-NUT IN THE HOLE THAT IS OFFSET FROM THE PINCH WELD HOLE. REPEAT STEP 4.1 USING ANGLE BRKT.
6. ATTACHING THE STEP ASSEMBLY:

PLEASE REVIEW THE INSTALLATION INSTRUCTIONS THAT ARE INCLUDED IN YOUR STEP ASSEMBLY FOR SPECIFIC DETAILS.

TORQUE ALL 5/16" FASTENERS TO 19 LB FT.



(A LUVERNE Company)

1200 E. Birch St.

Brandon, SD 57005

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551853 SHEET 1 OF 3 09JUN10

INSTALLATION INSTRUCTIONS AND PARTS LIST

APPLICATION:

MODEL 400922 STEP BRACKETS:

2004 FORD F-150 SUPER CAB / SUPERCREW CAB PICKUPS

SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
PARTS INCLUDED IN THE BRACKET PACKAGE			
1	551851	8	MOUNTING BRACKET, BLK, F150, GRIP STEP
2	106997	8	SCREW- HEX HEAD CAP, 5/16_18 UNC X 1.00", SST, BZP
3	106998	8	WSHR-PL, A, SST, 5/16,.375 ID X .875 OD X .083 THK, BZP
4	102680	10	NUT-SERR FLG,HX,SST,WX,5/16-18
5	104264	4	U-NUT- MULTI THREAD, 5/16-18 UNC, STL, BLK
6	551559	2	BRKT-MTG,ANGLE, 09 F-150
7	100647	6	SCREW- HEX HEAD CAP, 5/16_18 UNC X 1.00".ZP
8	100034	6	WSHR-PL, A, STL, 5/16,.375 ID X .875 OD X .083 THK, ZP
9	104267	4	5/16"X3/4" SELF TAPPING SCREW



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1200 E. Birch St.

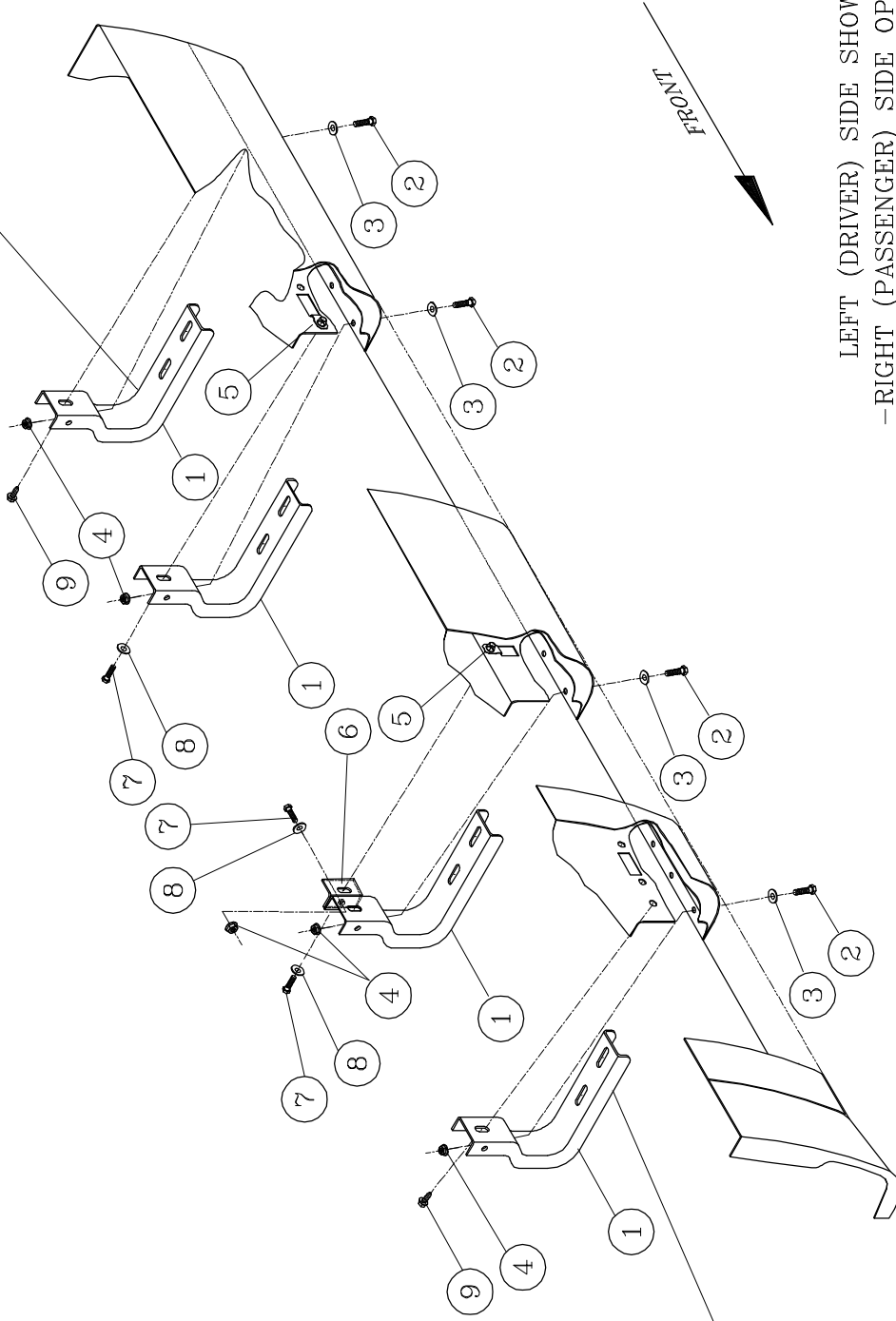
Brandon, SD 57005

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551853 SHEET 2 OF 3 09JUN10

SERVICE PARTS LIST

MODEL NO. - 400922

ADDITIONAL
REAR BRACKET



MOVE FRONT
BRACKET FORWARD

LEFT (DRIVER) SIDE SHOWN
-RIGHT (PASSENGER) SIDE OPPOSITE-

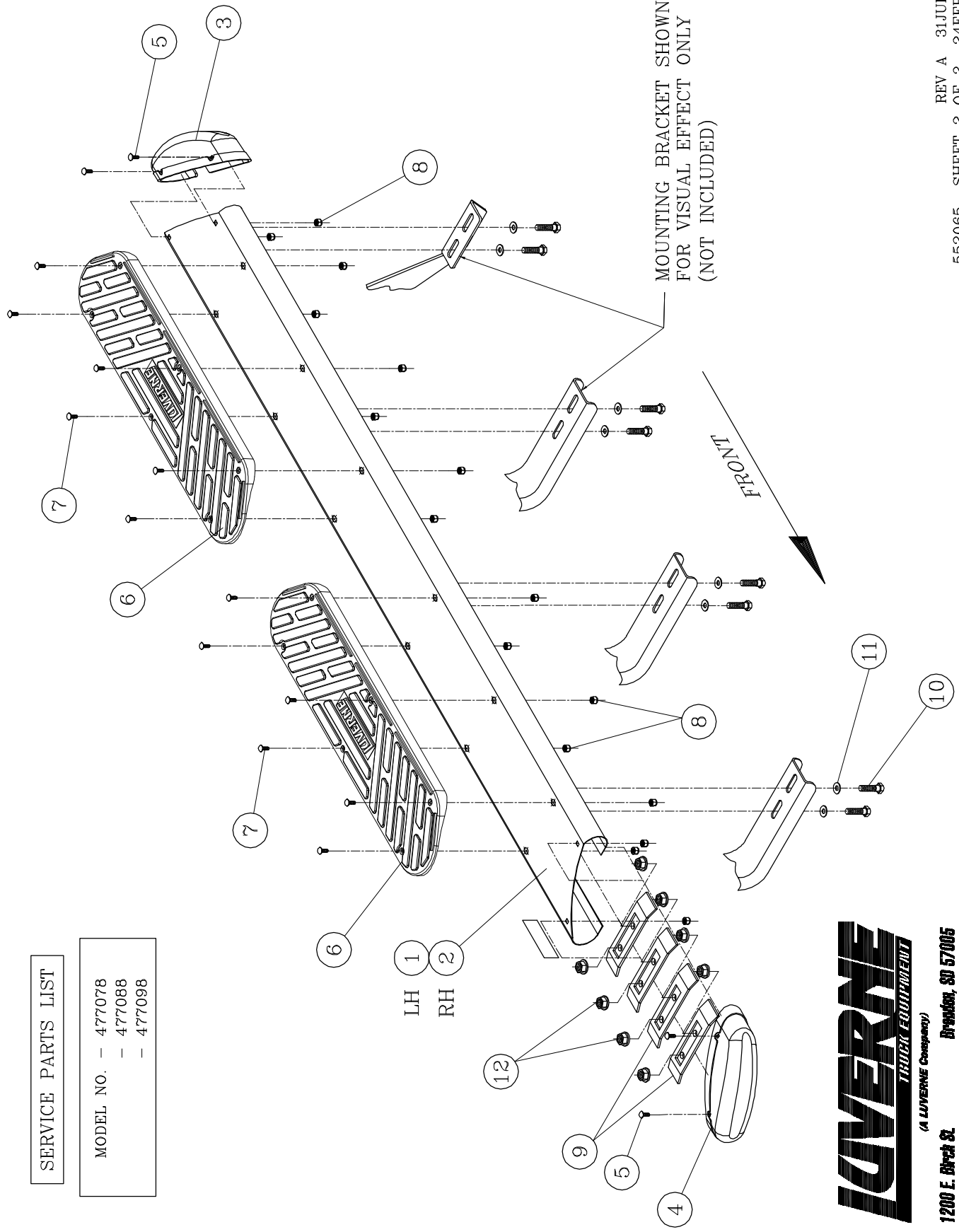
FIG. 1



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Beverly, MA 01824

SERVICE PARTS LIST

MODEL NO. - 477078
 - 477088
 - 477098



MOUNTING BRACKET SHOWN
 FOR VISUAL EFFECT ONLY
 (NOT INCLUDED)

FRONT

LAVERNE
 TRUCK EQUIPMENT
 (A LUYERNE Company)

1200 E. Birch St.
 Brandon, SD 57005