

# INSTALLATION INSTRUCTIONS AND PARTS LIST

APPLICATION: MODEL 481039 LONG BOX EXTENSION SIDE ENTRY STEPS:  
SINGLE REAR WHEEL  
2010 AND NEWER DODGE RAM 2500/3500 SERIES 8.0' BOX

## PASSENGER SIDE INSTALLATION

1. READ INSTRUCTIONS COMPLETELY AND CHECK TO MAKE SURE THAT ALL REQUIRED PARTS (LISTED ON SERVICE PARTS LIST) ARE ON HAND BEFORE STARTING THE INSTALLATION.
2. PREPARE THE VEHICLE FOR SIDE ENTRY STEP INSTALLATION AS FOLLOWS:
  - 2.1. DRILL A 13/32" DIA. HOLE THRU THE BOTTOM SURFACE ON CENTERLINE OF THE FRONT BOX STIFFENER. LOCATE THE HOLE 1.00" FROM THE END. **ON THE SECOND BOX STIFFENER WHICH IS CLOSED, THE HOLE IN THE STIFFENER FOR THE REAR BRACE WILL BE DRILLED LATER.**
  - 2.2. REMOVE THE BOX HOLD DOWN BOLTS (18mm WRENCH) FROM THE FRONT AND SECOND BOX STIFFENER AND ATTACH THE UPPER BOX MOUNT BRACKETS (ITEM #12 & #13).
  - 2.3. REMOVE THE PLASTIC ROCK GUARD ON THE FRONT LOWER PART OF THE BOX. THIS WILL NOT BE REUSED.
3. MOUNT THE SES / BRACE WLDMT ASSY (ITEM #1 THRU #11 & ITEM #14 THRU #16) AS FOLLOWS.
  - 3.1. ROTATE THE FRONT AND REAR OUTBOARD TUBE BRACES (ITEM #14, #15 & #16) TO THE UPRIGHT POSITION AND INSTALL 5/16" X 1.00" CARRIAGE BOLTS (ITEM #26), 5/16" FLAT WASHER (ITEM #28) AND 5/16" SERRATED FLANGE NUT (ITEM #27).
  - 3.2. ASSEMBLE THE 3/8" THREADED STUDS AND FASTENERS TO THE BRACE PLATES.
    - 3.2.1. INSTALL 3/8" SERRATED FLANGE NUTS (ITEM #24) **BACKWARDS** ON EACH END OF THE STUDS (ITEM #19 & #20) SO THAT 5/8" OF THREAD IS EXPOSED.
    - 3.2.2. ON ONE END OF THE FULL THREADED STUD AND ON THE SHORT THREADED END OF THE DOUBLE ENDED STUD, INSTALL A 3/8" FLAT WASHER (ITEM #25). THEN, PUSH THE 3/4" THICK RUBBER WASHER (ITEM #21) AND FLAT WASHER TIGHT UP AGAINST THE SERRATED FLANGE NUT. **(THE END OF THE STUD MUST BE RECESSED BACK IN THE HOLE OF THE RUBBER WASHER APPROXIMATELY 3/16")**.
    - 3.2.3. INSTALL THE OTHER END OF THE THREADED STUD THRU A HOLE IN THE BRACE PLATE. **(ON 2500/3500 SERIES TRUCKS: BOTH 4 X 4 AND 4 X 2 MAY USE THE FRONT BOTTOM HOLE, BUT ON THE 4 X 2 APPLICATIONS, THE 8.50" LONG STUDS ARE USED ON BOTH FRONT AND REAR)**. INSTALL A 3/8" SERRATED FLANGE NUT (ITEM #24) AS SHOWN.
  - 3.3. POSITION THE ASSEMBLY UP UNDER THE ROCKER PANEL AND ATTACH THE TOP OF THE BRACES TO THE BOX MOUNT BRACKETS USING A 3/8" X 1.00" CARRIAGE BOLT (ITEM #23), 3/8" FLAT WASHER (ITEM #25) AND 3/8" SERRATED FLANGE NUT (ITEM #24).
  - 3.4. ATTACH THE OUTBOARD TUBE BRACES TO THE BOX STIFFENERS.
    - 3.4.1 ON THE FRONT: INSTALL A 3/8" MULTI THREAD U-NUT (ITEM #18) ON THE U-NUT RETAINER PLATE (ITEM #17) (**NOTE: DRIVERS SIDE RETAINER PLATE IS #31**). THE RAISED CENTER PORTION OF THE PLATE GOES UP AND THE THREADED PORTION OF THE U-NUT GOES ON TOP OF THE PLATE. INSERT THE RETAINER PLATE INTO THE END OF THE BOX STIFFENER AS SHOWN SO THAT THE U-NUT THREAD IS ABOVE THE PRE-DRILLED HOLE. INSTALL A 3/8" X 1.50" HEX HD SCREW (ITEM #22) WITH 3/8" FLAT WASHER (ITEM #25) UP THRU THE HOLE IN THE TOP FLAT SWAGE OF THE FRONT BRACE, THRU THE PRE-DRILLED HOLE IN THE BOTTOM OF THE BOX STIFFENER AND INTO THE U-NUT ON THE U-NUT RETAINER PLATE.



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550252 SHEET 1 OF 5 22DEC09

- 3.4.2 ON THE REAR: DRILL A 17/64" DIA. HOLE THRU THE BOTTOM OF THE STIFFENER AT ABOUT THE BEGINNING OF THE OUTBOARD RADIUS. INSTALL A 5/16" X 3/4" HEX WASHER HEAD SCREW (ITEM # 29) AND 5/16 FLAT WASHER (ITEM #28) UP THRU THE HOLE IN TOP FLAT SWAGE OF THE REAR BRACE AND INTO THE PRE-DRILLED HOLE.
4. ALIGN THE STEP IN & OUT AND UP & DOWN SO THAT IT MATCHES THE CAB SIDE ENTRY STEP AND TIGHTEN ALL FASTENERS.
5. ADJUST THE FASTENERS ON THE DOUBLE ENDED FRONT STUD SO THAT THE RUBBER WASHER IS SNUG AGAINST THE SIDE OF THE FRAME. ADJUST THE FASTENERS ON THE REAR STUD SO THAT THE RUBBER WASHER IS SNUG AGAINST THE SIDE OF THE FRAME OR THE FRAME SPRING SHACKEL. LOCK THE STUDS BY TIGHTENING THE SERRATED FLANGE NUTS ON EITHER SIDE OF THE BRACE PLATE.

#### DRIVERS SIDE INSTALLATION

6. THE DRIVERS SIDE INSTALLATION USES BRACKETS (ITEM #13&30) AND RETAINER PLATE (ITEM #31) WITH 2 U-NUTS (ITEM #18) MOUNTED ON THE ENDS OF RETAINER PLATE (THE RAISED CENTER PORTION OF THE PLATE GOES UP AND THE THREADED PORTION OF THE U-NUTS GOES ON TOP OF THE PLATE).
- 6.1 INSERT THE RETAINER PLATE INTO THE END OF THE BOX STIFFENER AS SHOWN IN **FIG 2**, SO THAT THE U-NUT THREAD IS ABOVE THE INSIDE PRE-DRILLED HOLE. THE OUTSIDE HOLE IN THE RETAINER WILL HANG OVER THE BOX RAIL ON FRONT BOX STIFFENER. INSTALL A 3/8" X 1.50" HEX HD SCREW (ITEM #22) WITH 3/8" FLAT WASHER (ITEM #25) UP THRU THE HOLE IN THE TOP OF THE BRACKET (ITEM #30) THRU THE PRE-DRILLED HOLE IN THE BOTTOM OF THE BOX STIFFENER AND INTO THE U-NUT ON THE U-NUT RETAINER PLATE.
- 6.2 REMOVE THE BOX HOLD DOWN BOLTS (18mm WRENCH) FROM THE REAR BOX STIFFENER AND ATTACH THE UPPER BOX MOUNT BRACKET (ITEM #13) USING THE FACTORY 18mm BOLT.
- 6.3 REMOVE THE PLASTIC ROCK GUARD ON THE FRONT LOWER PART OF THE BOX. THIS WILL NOT BE REUSED.
7. MOUNT THE SES / BRACE WLDMT ASSY (ITEM #1 THRU #11 & ITEM #15&16) AS FOLLOWS.
- 7.1. ROTATE THE FRONT AND REAR OUTBOARD TUBE BRACES (ITEM #15 & #16) TO THE UPRIGHT POSITION AND INSTALL 5/16" X 1.00" CARRIAGE BOLTS (ITEM #26), 5/16" FLAT WASHER (ITEM #28) AND 5/16" SERRATED FLANGE NUT (ITEM #27).
8. REPEAT STEPS 3.3 TO 5



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550252 SHEET 2 OF 5 22DEC09

## SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	550263	2	STEP PLATE-SES,LH/RH,DODGE RAM,LONG BOX
2	104250	2	END CAP-RH FRONT/LH REAR
3	104251	2	END CAP-LH FRONT/RH REAR
4	105500	2	PAD,SES,SPCL,5.50 X 20.00
5	104255	1	TRIM-SEAL,SES,EXTRUDED
6	104257	12	NUT-HEX,SGL SELF THD,CAP WASHER,1/4"
7	104258	8	BOLT-CARRIAGE,SST,#10-24 X 3/4"LG
8	104261	8	NUT-SERRATED FLANGE,HEX,SST,#10-24
9	104530	8	WASHER-FLAT,NEOPRENE,.200SQ X .406 DIA
10	550256	1	BRACE WLDMT-TUBE,STEP MTG,RH,LB EXT
11	550254	1	BRACE WLDMT-TUBE,STEP MTG,LH,LB EXT
12	550012	2	BRACKET-MTG,RH,UPPER BOX MOUNT
13	550013	1	BRACKET-MTG,LH,UPPER BOX MOUNT
14	550261	1	BRACE-TUBE,FRT,RH,DODGE BOX EXT
15	550260	1	BRACE-TUBE,FRT,LH,DODGE BOX EXT
16	550259	2	BRACE-TUBE.STL,1.25 DIA,SWG @90, ONE END @ 90
17	549437	1	PLATE-U-NUT RETAINER
18	104282	3	NUT-U,MULTI THD,STL,3/8-16 UNC,BLK
19	104697	2	STUD-FULL THD,3/8-16 UNC,RLD THD,3.00" LG,ZP
20	104698	4	STUD-DBL END,3/8-16 UNC,RLD THD,8.50" LG,ZP
21	102592	4	WSHR-PL,TYPE EP BLK RBR,.354 X 1.00 X .748
22	100049	3	SCR-CAP,HEX HD,3/8-16 UNC X 1.50",STL,ZP
23	100053	4	BLT-CRG,3/8-16 UNC X 1.00,STL,ZP
24	100181	16	NUT-SERR FLG,HEX,STL,3/8-16 UNC,ZP
25	100062	11	WSHR-PL,A,STL,3/8,.438 X 1.00 X .083,ZP
26	100021	4	BLT-CRG,5/16-18 UNC X 1.00,STL,ZP
27	100178	4	NUT-SERR FLG,HEX,STL,5/16-18 UNC,ZP
28	100034	6	WSHR-PL,A,STL,5/16,.38 X .88 X .083,ZP
29	104267	2	SCREW-HEX WSHR HD,THD FMG,AB,5/16 X 3/4
30	550288	1	BRACKET-MTG,LH,UPPER BOX MOUNT
31	550291	1	PLATE-U-NUT RETAINER,9.25



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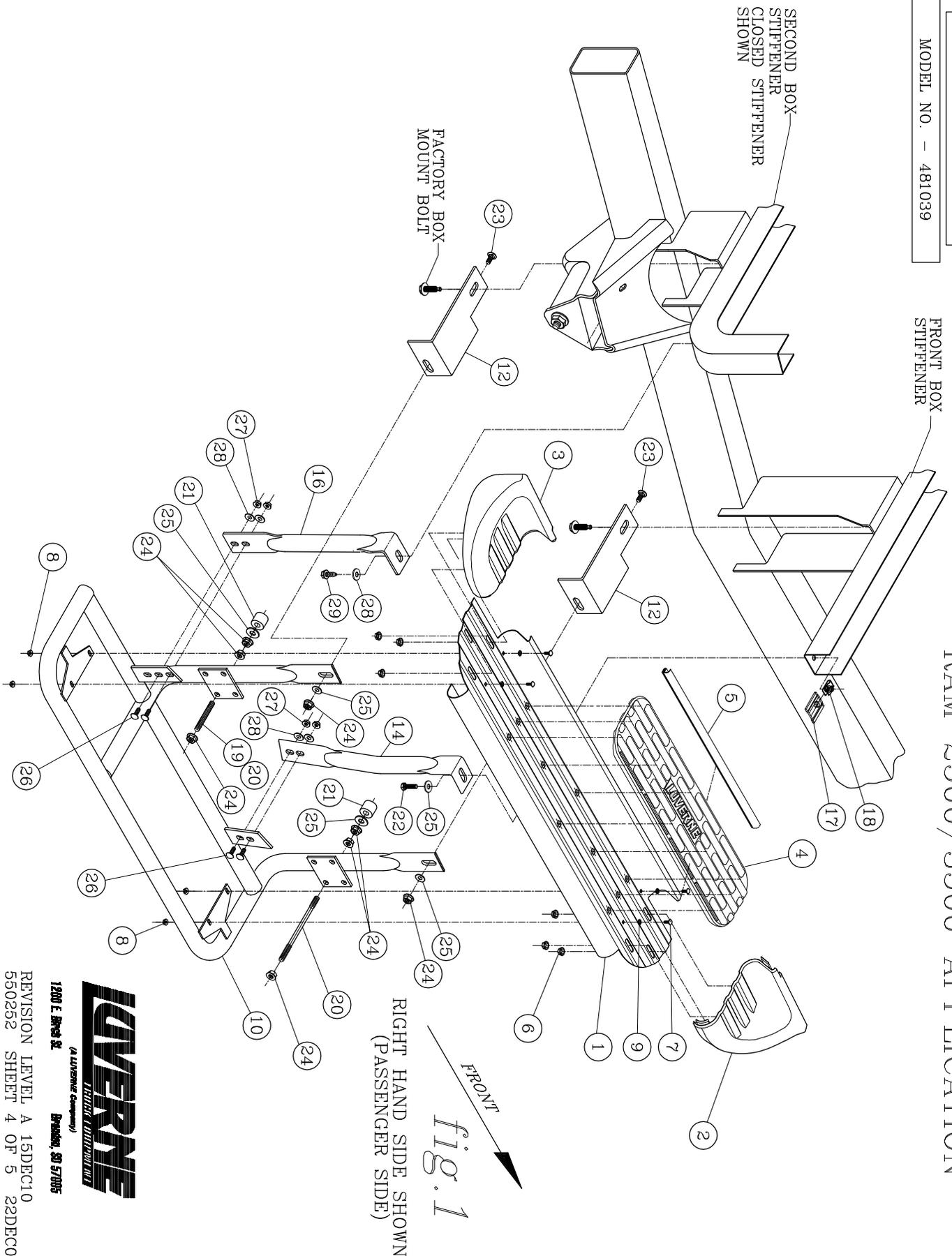
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550252 SHEET 3 OF 5 22DEC09

SERVICE PARTS LIST

MODEL NO. - 481039

RAM 2500/3500 APPLICATION



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550252 SHEET 4 OF 5 22DEC09

