



01-10 GM Heavy Duty Regular Cab

51-520 41-520
 52-520 42-520
 53-520

(866) 476-6276 / (866) IRONCROSS
 www.ironcrossautomotive.com
 519 W. Dewey
 Sapulpa, OK 74066
 IRON CROSS AUTOMOTIVE INC. 2009

TUBE STEP INSTALLATION SHEET



FIG 1



FIG 2



FIG 3

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. (Fig 1 thru 3)

USE FACTORY BODY MOUNT BOLTS ON 2006 AND UP MODELS

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.

STEP 3 Repeat the steps for the other side of the vehicle.

QTY	PARTS LIST	QTY	PARTS LIST
2	1520 Front Bracket	4	1/2" - 13 x 1-3/4" Hex Bolt
2	1520 Rear Bracket	8	1/2" Flat Washer
4	M12-1.75x120MM (4 -3/4") Bolt	8	1/2" Lock Washer

For use on 52,53,42,43 series (extra parts for rear bracket only)

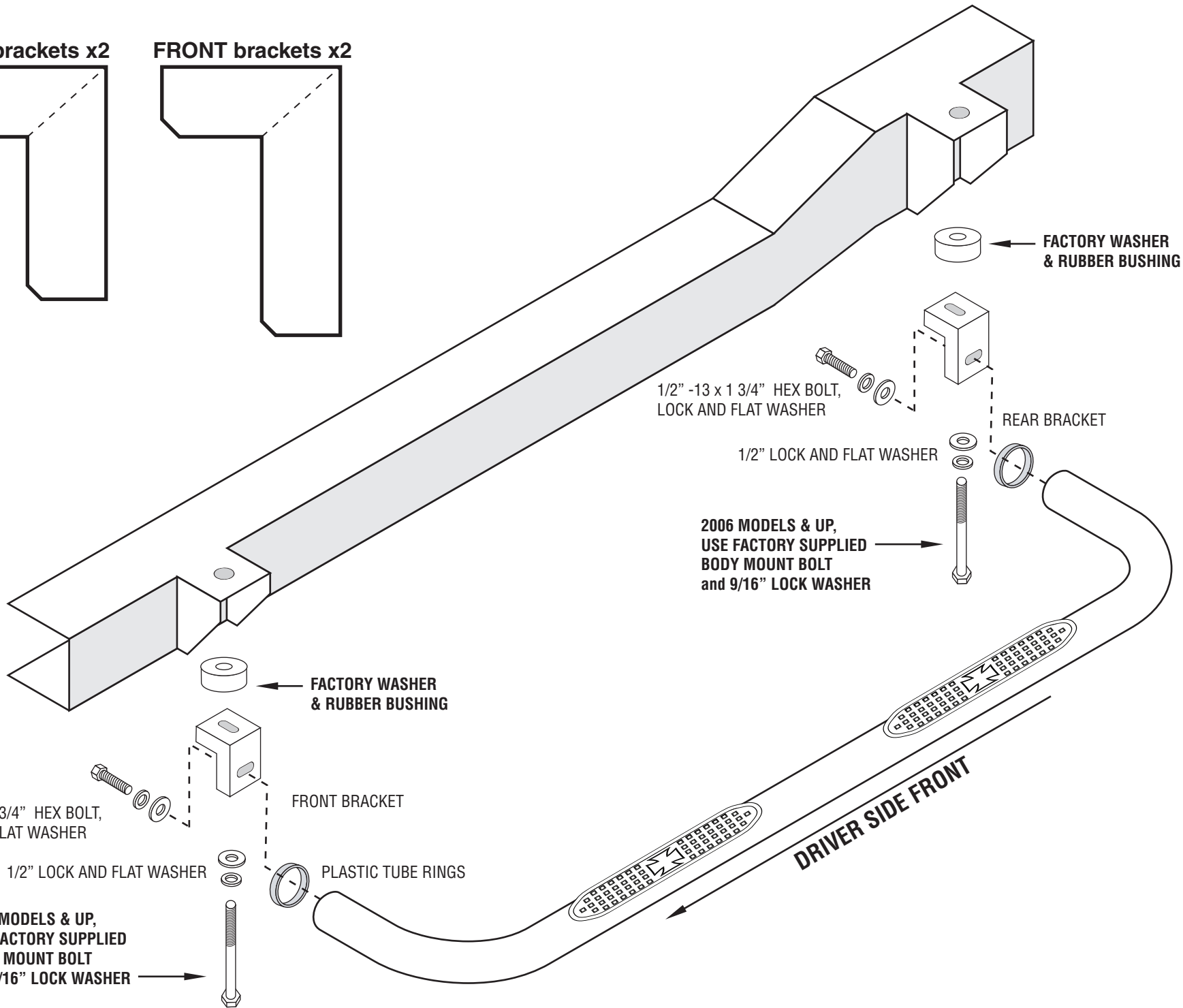
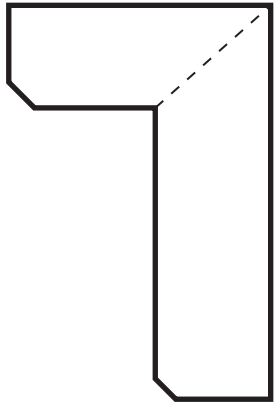
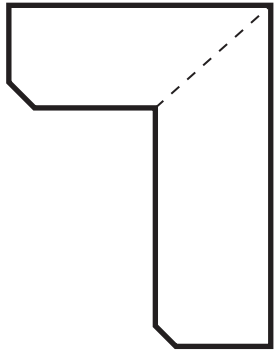
2	1/2" Nut	2	1/2" Lock Washer
2	1/2" Flat Washer		

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.

REAR brackets x2

FRONT brackets x2



FACTORY WASHER & RUBBER BUSHING

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

REAR BRACKET

1/2" LOCK AND FLAT WASHER

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

FACTORY WASHER & RUBBER BUSHING

FRONT BRACKET

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

1/2" LOCK AND FLAT WASHER

PLASTIC TUBE RINGS

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

DRIVER SIDE FRONT