

# INSTALLATION INSTRUCTIONS AND PARTS LIST

**439923/499923 BLACK, & STAINLESS STEEL BAJA STEPS:  
1999 AND NEWER FORD SUPER DUTY CREW CAB TRUCKS**



## NO DRILL INSTALLATION

1. READ INSTRUCTIONS COMPLETELY AND CHECK TO MAKE SURE THAT ALL THE REQUIRED PARTS (LISTED ON THE SERVICE PARTS LIST) ARE ON HAND BEFORE STARTING THE INSTALLATION.
2. ASSEMBLE THE NERF BAR TUBES AND MOUNTING BRACKETS AS FOLLOWS.  
NOTE: THE 1" X 3" SERIAL NUMBER DECAL IS LOCATED ON THE FRONT LEG OF THE LEFT (DRIVERS SIDE) NERF BAR ASSEMBLY.
  - 2.1. LAY NERF BAR ASSEMBLIES (ITEM #1, & 2) ON FLAT SURFACE, AND ATTACH THE MOUNTING BRACKETS (ITEMS #3) TO EACH NERF BAR IN THE LOCATIONS AS SHOWN IN (FIG. 1), USING THE SUPPLIED 3/8-16 X 1 SCREW, 3/8" FLAT WASHER, & 3/8-16 SERRATED FLANGE NUT, (ITEMS #8, 9, & 10). LEAVE THESE FASTENERS FINGER TIGHT AT THIS TIME.
3. EXISTING MOUNTING HOLE PATTERNS ARE LOCATED ON THE INTERIOR WALL OF THE ROCKER PANEL. THE SECOND, AND FIFTH HOLE PATTERN LOCATIONS FROM THE FRONT OF THE VEHICLE WILL BE USED.
  - 3.1. INSERT TWO 5/16-18 MULTI THREAD U-NUTS (ITEMS #6), INTO THE TOP HOLES OF BOTH PATTERN LOCATIONS, 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 .75" X 1.50" RECTANGULAR SLOT AND SLIDING THE U-NUT TOWARDS THE ROUND HOLE UNTIL THE U-NUT SEATS IN THE ROUND HOLE).
4. POSITION THE DRIVERS SIDE NERF BAR/BACKET ASSEMBLY UP UNDER THE DRIVERS SIDE ROCKER PANEL SO THE HOLES IN THE MOUNTING BRACKETS LINE UP WITH THE MOUNTING HOLES IN THE PINCH WELD. INSTALL THE 5/16-18 X 3/4" CARRIAGE BOLTS (ITEMS #11), AND THE 5/16-18 SERRATED FLANGE NUTS (ITEM #5). LEAVE FASTENERS FINGER TIGHT AT THIS TIME.
5. ON THE TOP HOLES OF EACH BRACKET, INSTALL THE 5/16-18 X 1.00" HEX HEAD CAP SCREWS (ITEMS #4), AND A 5/16 FLAT WASHER (ITEMS #7), THRU THE MOUNTING BRACKET AND INTO THE U-NUT.

NOTE: TORQUE ALL 5/16" FASTENERS TO 11 LB. FT. AND ALL 3/8" FASTENERS TO 33 LB. FT.



1200 E. Birch St.

Brandon, SD 57005

REV B 14AUG13  
REV A 07SEP12  
552047 SHEET 1 OF 3 10JUL12

## SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	552042	1	BAJA-STEP WLDMT, BLK, LH, 439923
2	552043	1	BAJA-STEP WLDMT, BLK, RH, 439923
1	552334	1	BAJA-STEP WLDMT, SST, LH, 499923
2	552335	1	BAJA-STEP WLDMT, SST, RH, 499923
3	552038	4	BRACKET MOUNTING, 439922/439923
4	100647	8	SCREW-HEX HD, 5/16-18 X 1.00", ZP
5	102680	8	NUT-SERRATED FLNG, HEX, SST, 5/16-18
6	104264	8	U-NUT, MULTI THREAD, 5/16-18, STL, BLK
7	100034	8	FLAT WASHER, 5/16, ZP
8	100040	8	SCREW-HEX HD, 3/8-16 X 1.00", ZP
9	100062	8	WASHER-FLAT, 3/8, ZP
10	100181	8	FLANGE NUT-HEX, 3/8-16, ZP
11	104262	8	BOLT-CARRIAGE, SST, 5/16-18 X 3/4"



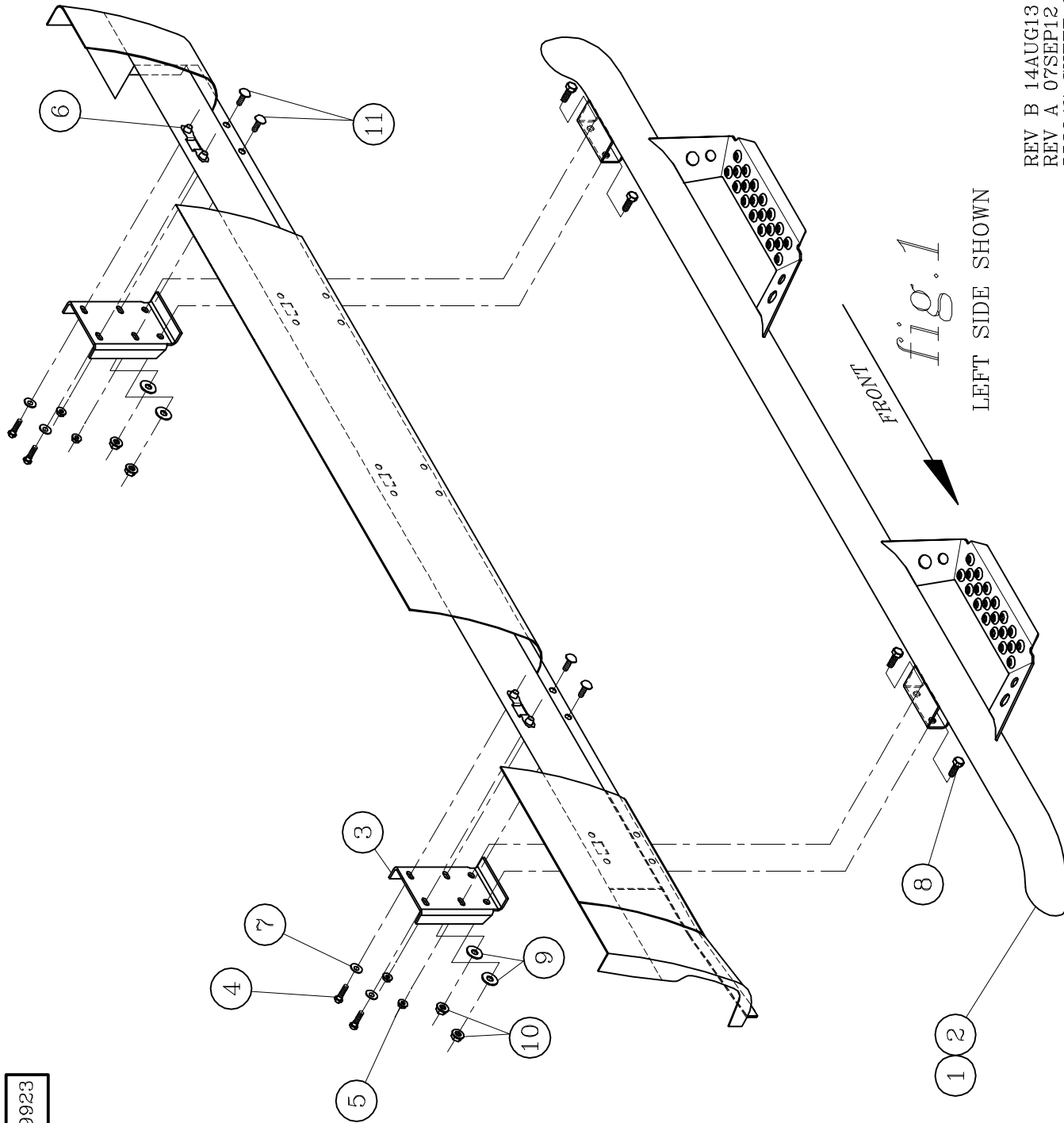
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INSTALLATION INSTRUCTIONS  
AND SERVICE PARTS LIST

MODEL NO. - 439923/499923



**LVERNE**  
TRUCK PARTS DIV.

(A LVERNE COMPANY)

1289 E. Birch St.

Evansville, IN 47705

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