AUTOMOTIVE PRODUCTS, INC.

INSTRUCTIONS—INSTRUCCIONES—CONSIGNES

APPLICATION: 99-13 CHEVY/GMC SILVERADO/SIERRA EXTENDED CAB
01-13 CHEVY/GMC SILVERADO/SIERRA CREW CAB
EXCL.99-2000 HD 2500/3500 & 2011-13 DIESEL EQUIPED MODELS
APP PART # 20-1685, 20-1955, 20-1680, 20-1950
GEN-X STEP BARS

ITEM	QUANTITY	DESCRIPTION	TOOLS NEEDED
1	2	STEP BARS	ALLEN KEY (INCLUDED)
2	8	MOUNTING BRACKETS	13MM SOCKET
3	8	M8 HEX HEAD BOLTS	RATCHET
4	8	M8 FLAT WASHERS	TORQUE WRENCH
5	8	M8 LOCK WASHERS	HAND DRILL
6	16	M10 BUTTON HEAD BOLTS(STAINLESS STEEL)	3/8” DRILL BIT
7	16	M10 TOOTHED LOCK WASHERS (STAINLESS STEEL)	10MM SOCKET
8	16	M10 FLAT WASHERS (STAINLESS STEEL)	
9	16	M8 NUT CLIPS	
10	8	M8 FLANGE BOLTS	
11	8	M8 TOOTHED LOCK WASHERS	
12	16	SELF DRILLING SCREWS	

ANTI-SEIZE LUBRICANT MUST BE USED ON ALL STAINLESS STEEL FASTENERS TO PREVENT THREAD DAMAGE AND GALLING .

1. Remove contents from box, verify if all parts listed are present and free from damage. Carefully read and understand all instructions before attempting installation.
2. **FOR 07-12 CREW CAB:** Starting from the drivers side of the vehicle locate the threaded hole located in the rocker panel towards the front of the vehicle. Take (1) mounting bracket and attach it to the threaded hole using (1) M8 hex head bolt, (1) M8 lock washer, and (1) M8 flat washer . Locate the existing hole in the pinch weld and place (1) M8 clip nut onto the hole, attach the mounting bracket to the pinch weld using (1) M8 flange bolt, and (1) M8 toothed locked washer (FIG. 1). Do not fully tighten at this time
3. Move to the next threaded hole in the rocker panel and repeat step 2.
4. Remove the rubber plug from the bigger hole to access the smaller OD hole, and insert (1) M8 nut clip over the hole, attach (1) mounting bracket to the previously installed nut clip using (1) M8 hex head bolt, (1) M8 lock washer, and (1) M8 flat washer. Locate the existing hole in the pinch weld and place (1) M8 clip nut onto the hole, attach the mounting bracket to the pinch weld using (1) M8 flange bolt, and (1) M8 toothed lock washer (FIG. 2& 3). Do not fully tighten at this time
5. Move to the circular hole located at the rear of the vehicle and repeat step 4. Refer to FIG. 7 for bracket placement.
6. Repeat steps 2-5 for the passenger side.
7. Take the drivers side step bar and place it on the mounting cradles attach the step bar using (8) M10 button head bolts, (8) M10 toothed lock washers, and (8) M10 flat washers (FIG. 6). Do not fully tighten at this time. Repeat this step for the passenger side step bar.
8. Align and adjust step bars as needed then fully tighten all hardware at this time. Torque M10 hardware to 30-35 ft lbs,and M8 hardware to 25 ft lbs.

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1. **FOR 07-12 EXTENDED CAB:** Starting at the drivers side of the vehicle locate the existing circular hole in the rocker panel towards the front of the vehicle. Remove the rubber plug from the bigger hole to access the smaller OD hole and insert (1) M8 nut clip over the hole, attach (1) mounting bracket to the previously installed nut clip using (1) M8 hex head bolt, (1) M8 lock washer, and (1) M8 flat washer. Locate the existing hole in the pinch weld and place (1) M8 clip nut onto the hole, attach the mounting bracket to the pinch weld using (1) M8 flange bolt, and (1) M8 toothed lock washer (FIG. 2&3). Do not fully tighten at this time. Refer to Fig 8 for bracket placement.
2. Repeat step 1 for all of the mounting locations on the drivers side, and passenger side.
3. Take the drivers side step bar and place it on the mounting cradles attach the step bar using (8) M10 button head bolts, (8) M10 toothed lock washers, and (8) M10 flat washers (FIG. 6). Do not fully tighten at this time. Repeat this step for the passenger side step bar.
4. Align and adjust step bars as needed then fully tighten all hardware at this time. Torque M10 hardware to 30-35 ft lbs, and M8 hardware to 25 ft lbs.

1. **FOR 01-06 CREW CAB:** Starting at the drivers side of the vehicle locate the existing circular hole in the rocker panel towards the front of the vehicle. Remove the rubber plug from the bigger hole to access the smaller OD hole and insert (1) M8 nut clip over the hole, attach (1) mounting bracket to the previously installed nut clip using (1) M8 hex head bolt, (1) M8 lock washer, and (1) M8 flat washer. Locate the existing hole in the pinch weld and enlarge this whole using a 3/8" drill bit. Once enlarged place (1) M8 clip nut onto the hole. Attach the mounting bracket to the pinch weld using (1) M8 flange bolt, and (1) M8 toothed lock washer (FIG. 2& 3). Do not fully tighten at this time. Move to the next circular hole in the rocker panel and repeat this step. Refer to FIG. 7 for bracket placement.
2. For the rear mounting brackets, locate the existing circular hole in the rocker panel towards the rear of the vehicle insert (1) M8 nut clip over the hole. Attach (1) mounting bracket to the previously installed nut clip using (1) M8 hex head bolt, (1) M8 lock washer, and (1) M8 flat washer. Using the mounting bracket as a template align it with the pinch weld and mark were the mounting point will be, it should be spaced 3/16" center from the edge of the pinch weld. Using a 3/8" drill bit, drill a hole in the pinch weld (FIG. 4) . Once the hole has been made place (1) M8 clip nut onto the hole. Attach the mounting bracket to the pinch weld using (1) M8 flange bolt, and (1) M8 toothed lock washer (FIG. 2&3). Do not fully tighten at this time. Move to the next circular hole in the rocker panel and repeat this step.
3. Take the drivers side step bar and place it on the mounting cradles. Attach the step bar using (8) M10 button head bolts, (8) M10 toothed lock washers, and (8) M10 flat washers (FIG. 6). Do not fully tighten at this time. Repeat this step for the passenger side step bar.
4. Align and adjust step bars as needed then fully tighten all hardware at this time. Torque M10 hardware to 30-35 ft lbs, and M8 hardware to 25 ft lbs.
5. **FOR 99-06 EXTENDED CAB:** Start by taking the drivers side step bar and attach the front and rear brackets to it using (4) M10 button head bolts, (4) M10 toothed lock washers, and (4) M10 flat washers (FIG. 7).
6. Take the assembled step bar and with assistance, place on the rocker panel of the truck. Once aligned, using the mounting brackets as a template and mark the mounting holes on the pinch weld ,it should be spaced 3/16" center from the edge of the pinch weld. (FIG. 4). Remove the bar from the rocker panel. Disassemble the brackets from the bar. Drill through the marked holes using a 3/8" drill bit. Once the holes have been made place (2) M8 clip nut onto the holes, attach the mounting brackets to the pinch weld using (2) M8 flange bolt, and (2) M8 toothed lock washer (FIG. 5). Refer to Fig 8 for bracket placement.
7. Once the brackets have been attached to the pinch weld attach the brackets to the rocker panel by using the provided self tapping screws. Attach the upper mounting hole using (1) self drilling screw, and (1) M8 flat washer, attach the lower mounting hole using (1) self drilling screw (FIG. 4).
8. Once the front and rear brackets have been installed, take the step bar and re-attach it to the brackets. Take the center mounting brackets and attach them to the step bar using (4) M10 button head bolts, (4) M10 toothed lock washers, and (4) M10 flat washers (FIG. 6). Align the brackets to the rocker panel and pinch weld and install the brackets as stated in step 2 & 3.
9. Repeat steps 1-4 for the passenger side.
10. Align and adjust step bars as needed then fully tighten all hardware at this time. Torque M10 hardware to 30-35 ft lbs, M8 hardware to 25 ft lbs, and the self drilling screws till tight.

CARE INSTRUCTIONS

- REGULAR WAXING IS RECOMMENDED. DO NOT USE ANY TYPE OF POLISH OR WAX THAT MAY CONTAIN ABRASIVES
- STAINLESS STEEL PRODUCTS CAN BE CLEANED WITH MILD SOAP AND WATER. STAINLESS STEEL POLISH SHOULD BE USED TO POLISH SMALL SCRATCHES.
- GLOSS BLACK FINISHES SHOULD BE CLEANED WITH MILD SOAP AND WATER

"PATENTED - U.S. Patent# 6588783 & 6874801"

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Fig 1



Fig 2

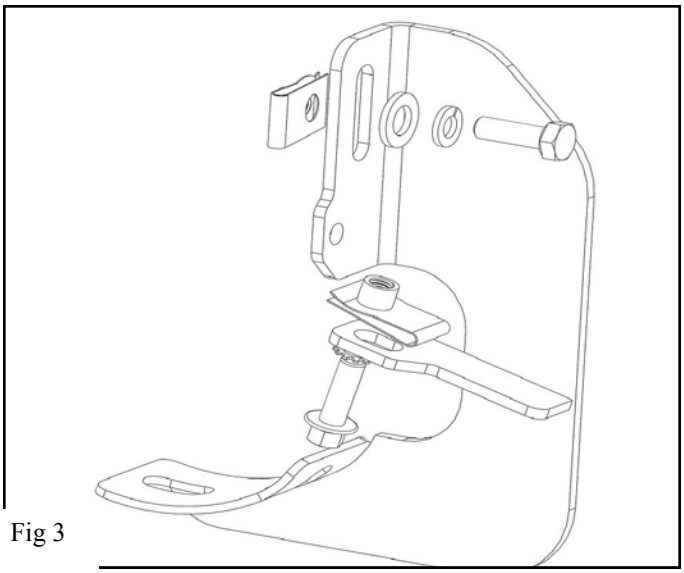


Fig 3

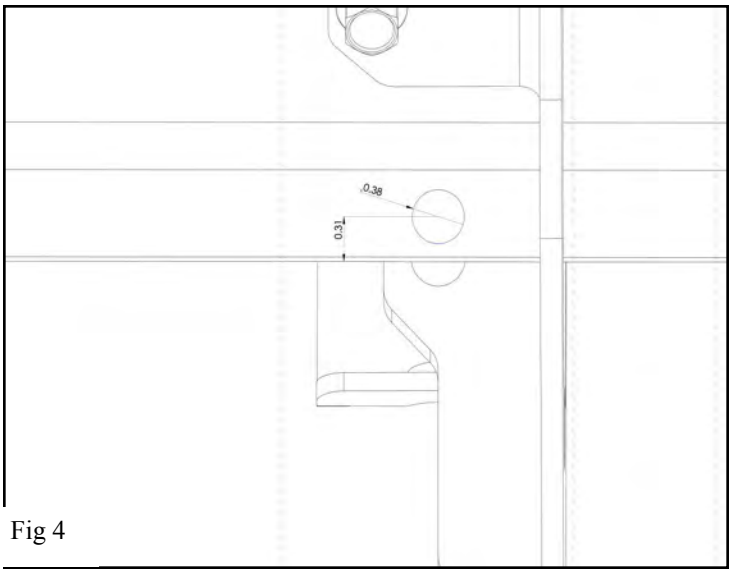


Fig 4

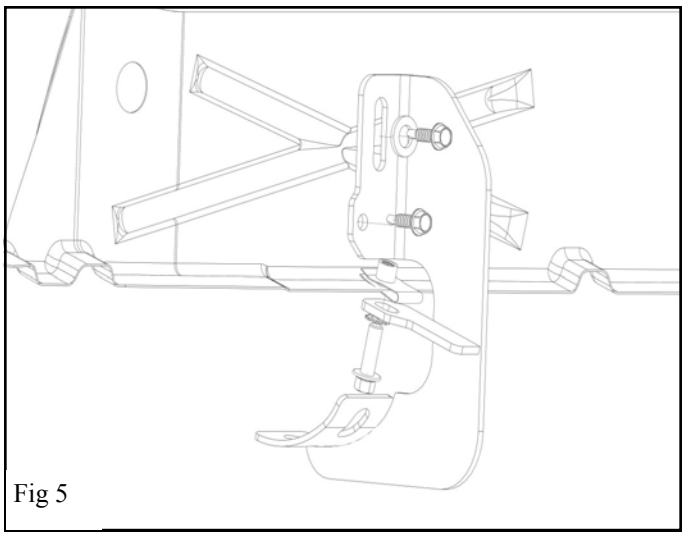


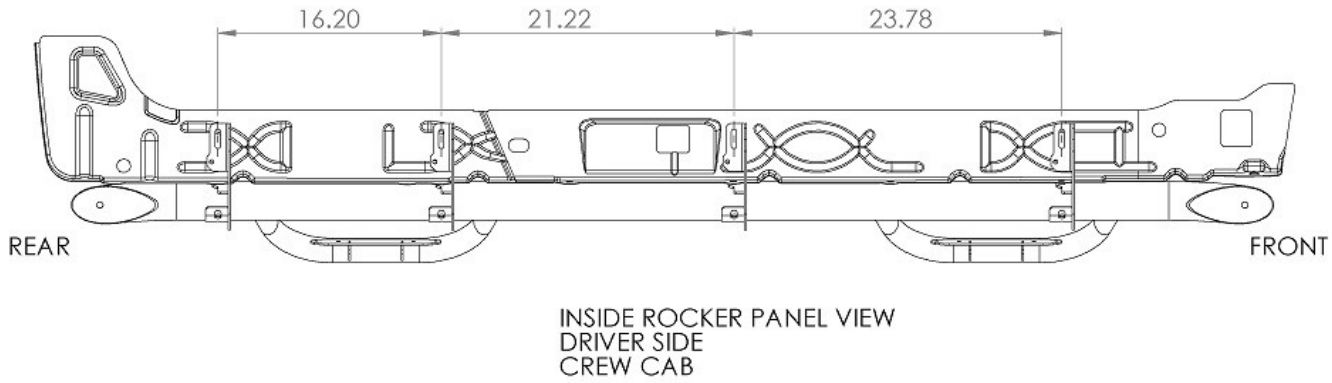
Fig 5



Fig 6

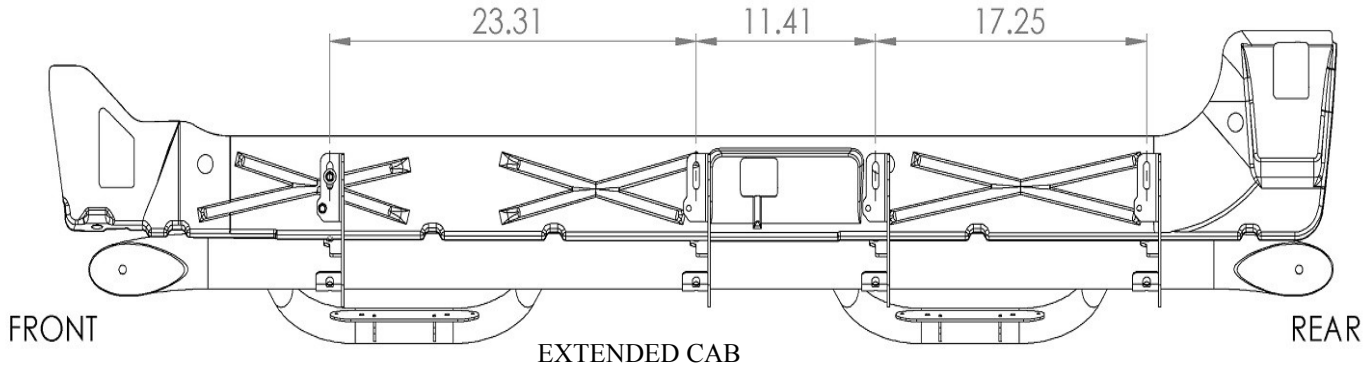
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INSIDE ROCKER PANEL VIEW
DRIVER SIDE
CREW CAB

Fig 7



EXTENDED CAB

INSIDE ROCKER PANEL VIEW
PASSENGER SIDE

Fig 8