

INSTALLATION INSTRUCTIONS

PT-A-203

2015-2020 FORD TRANSIT SIDE STEP

TOOLS REQUIRED:

Power drill	Ratchet	1.5" Hole saw
Metric and Standard socket set	Impact Gun	
1/2" Wrench	Pliers	

HARDWARE:

<u>QTY</u>	<u>DESCRIPTION</u>	<u>PART#</u>
1	Mounting bracket forward	ST006576
1	Mounting bracket rearward	ST006577
2	Rear Mounting supports	ST006578
2	Studded side mounting bracket lower	ST006961
2	Studded side mounting bracket upper	ST006962
4	8mm x 30mm Bolt	GSM33722
4	M8 nut	GSM30202
14	5/16" Nylon nut	GSM30017
12	5/16" flat washer	GSM31006
8	5/16" Fender washer	GSM31018
8	5/16" lock washer	GSM31027
6	5/16" bolt	GSM32970

Note:

If your van has the OEM side step installed, you will need to remove the step and use the provided 8mm hardware to mount the forward and rearward mounting brackets. The supplied studded mounting brackets will not be used.

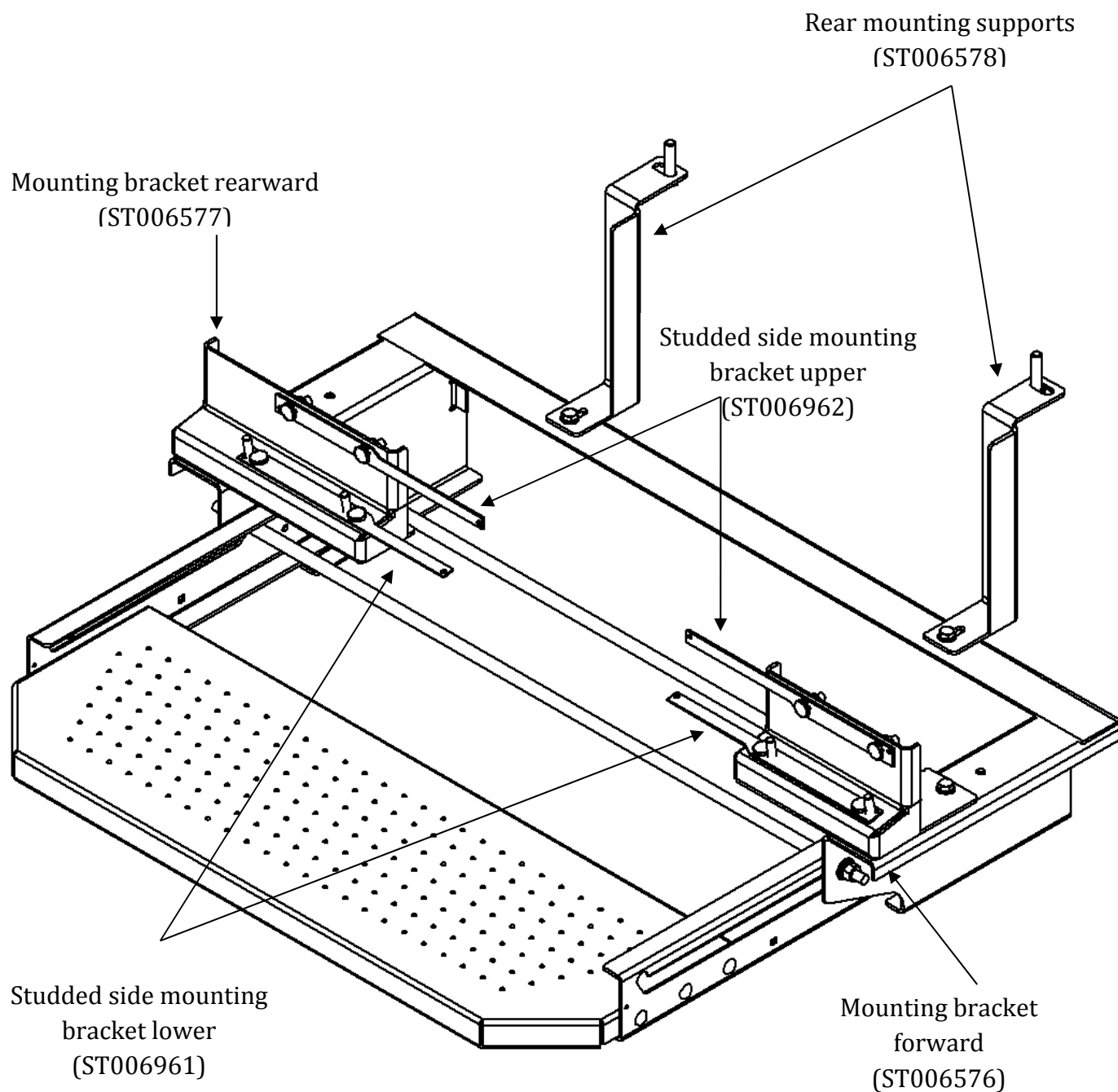
If your van does not have the OEM side step, there will be existing holes in the body for step mounting hardware. However you will need to drill holes and install studded mounting brackets as indicated below.

Some vans will come with the studs pre-installed for an OEM step. The studded mounting brackets will not be used in this application. Follow instructions below.

Always!

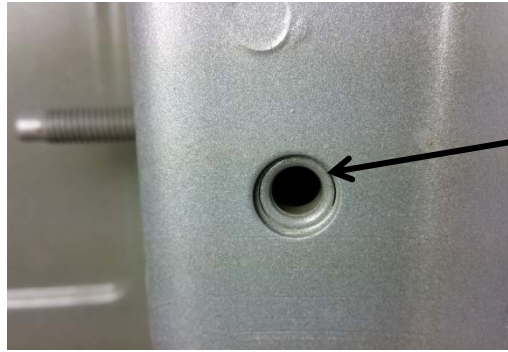
- Read all instructions before installing any Havis, Inc. products.
- Check for obstructions (Wires, brake lines, fuel tank, etc.) before drilling any holes!
- Use hardware provided with install kit

PT-A-203 Step Assembly





Some vans have provisions for a factory installed side step. The studded mounting brackets are not used in this application.



If the van has the provisions for a side step but did not come with one you will need to tap the inserts to 8mm x 1.25 and use hardware provided. Threading holes to 5/16" will also work. But hardware is not included.



Repeat the process for the Forward location.

If your van did not come with a side step or provisions for one, you will need to use the studded brackets



Drill a 1.5" hole in the underside of the van body so you can insert the studded mounting brackets. Place the arbor above the hole slightly and open up the hole a bit.



The studded mounting bracket is designed to be bent for properly lining up to the holes in the body. Using two pairs of pliers bending opposite ways works very well for bending angles into the bracket.



Insert the mounting bracket into the 1.5" hole so that the studs protrude through the existing holes in the body.



Take note of the different hole patterns for the upper and lower brackets. The lower brackets have the studs spaced further apart.



Repeat process for the rearward mounting holes. Loosely holding up the bracket will give you an idea on the rearward section where to drill your 1.5" hole.



Loosely attach the forward bracket (ST006576) to the body using four (4) 5/16" nylock nuts and four (4) **fender** washers.



Repeat for rearward mounting bracket (ST006577)



Line up the frame mounted support brackets (ST006578) with the unthreaded inserts in the frame. Use impact gun to drive the 3/8"x 1.75" thread cutting bolts into the inserts



Repeat for the rearward frame support bracket



Loosely attach the step assembly to the body brackets using four (4) 5/16" x 1" bolts, eight (8) washers, and four (4) nylock nuts.



Attach the step assembly to the two rear frame supports (ST006578) using two (2) 5/16" x 1" bolts, four (4) washers, and two (2) 5/16" nylock nuts



Tighten all hardware. Take the excess bracket material and bend it so you are able to get all the metal into the 1.5" hole.



Insert the 1.5" grommet (GSM20017-2) into the hole and silicone around it to prevent rust.



Installation is now complete



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