

# INSTALLATION INSTRUCTIONS

## SIDE BAR PART NO. #81593.03/81590.03

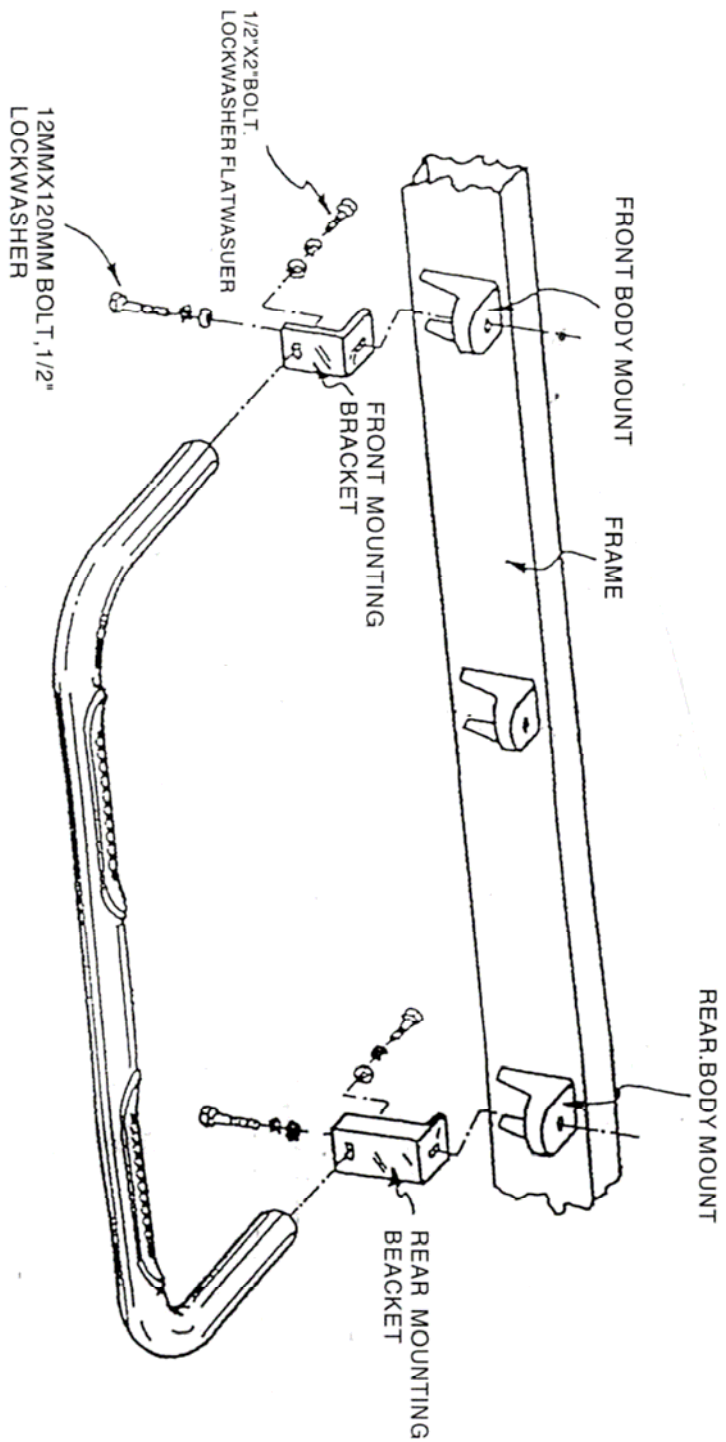
FOR 07 CHEVY TAHOE/01-07 CADILLAC ESCALADE

### **PARTS LIST**

- |   |                                  |
|---|----------------------------------|
| (2) SIDE TUBES WITH STEPS                     | (4) ½" FLAT WASHERS, Zinc Plated |
| (2) FRONT MOUNT BRACKETS                      | (4) ½" LOCK WASHERS, Zinc Plated |
| (2) REAR MOUNT BRACKETS                       |                                  |
| (4) M12*120 Hex Head Bolt, Zinc Plated        |                                  |
| (4) 1/2-13 X 2.00" Hex Head Bolt, Zinc Plated |                                  |
| (4) M12 FLAT WASHERS, Zinc Plated             |                                  |
| (4) M12 LOCK WASHERS, Zinc Plated             |                                  |

### **PROCEDURE**

1. Begin installation by working on driver side of the vehicle (see illustration).
2. From underneath truck, loosen and remove body mount bolts that run upward through mounts into floorboard. Attach and secure Front Mount Bracket to underside of vehicles front body mount, re-using isolator and puck, but replacing factory bolt with (1) M12 x 120mm bolt, (1) M12 split lock washer, and (1) M12 flat washer. Hand Tighten.  
**Note:** Use caution when removing bolts as the rubber isolators and metal pucks may fall.
3. Attach and secure Rear Mount Bracket to underside of vehicles rear body mount in same manner as the front.
4. Attach Side Tube to Front and Rear Brackets using (1) ½" x 2" bolt, (1) ½" split lock washer, and (1) ½" flat washer for each bracket, and hand tighten. Torque 1/2" bolts first to 65 ft-lbs and then the ½" bolts that secure the Side Bar to 65 ft-lbs, to complete the driver-side assembly.  
**Note:** Step Pad closer to the end of the tube goes to the rear.
5. Repeat process for passenger side of vehicle to complete installation.



( The image is only for reference, actual brackets may be different)