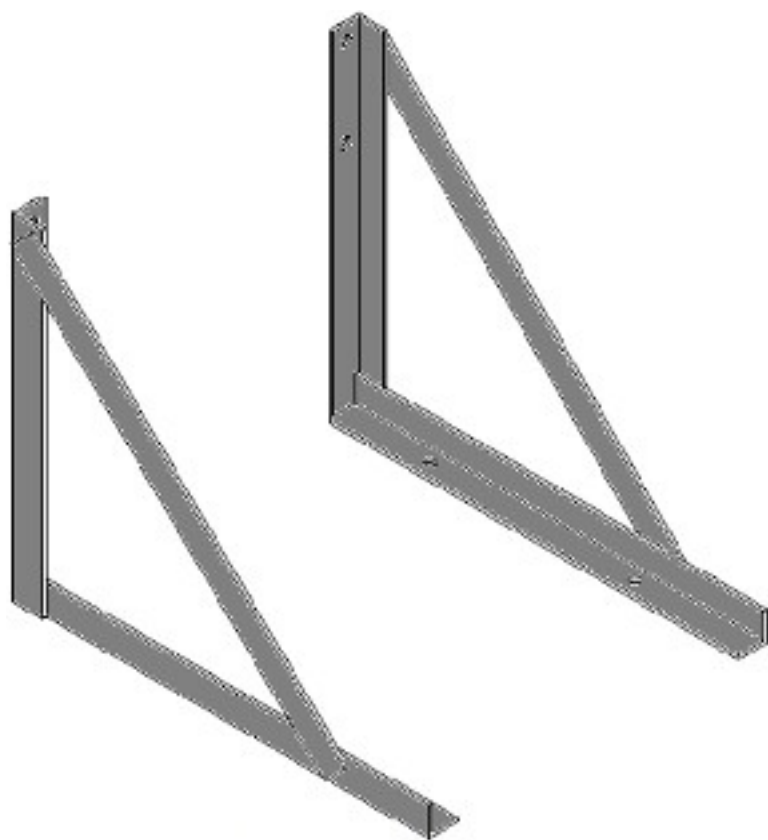


## STEPBOX INSTALLATION GUIDELINES

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21x23 Sturdy-Lite Stepbox Bracket  
- all-steel construction



available in widths of 12,  
18, 24, 30, and 36 inches



### **END-USER SAFETY NOTE:**

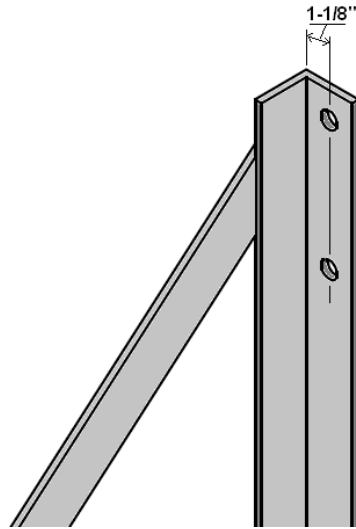
When attaching this step assembly for rear-of-cab access, grab handles and/or deck cover plates are also required in most states per individual state DOT regulations:

Cab grab handles are to be within arms' length of operator/end-user when accessing rear of cab via access steps (stepbox), so as to provide three-point contact. Grab handles and steps shall be positioned so the operator/end-user, when entering or exiting will maintain a three-point contact with the unit at all times.

**INSTALLATION (Supplies required for installation: tape measure; power drill with 5/8"-dia drill bit; torque wrench; manual wrench; black felt-tip marker)**

Steel (A36 hot-rolled) Stepbox Bracket sets (one Left, one Right), which can be supplied by Sturdy-Lite, must be used for securing the Stepbox to truck's main beam via the following procedure:

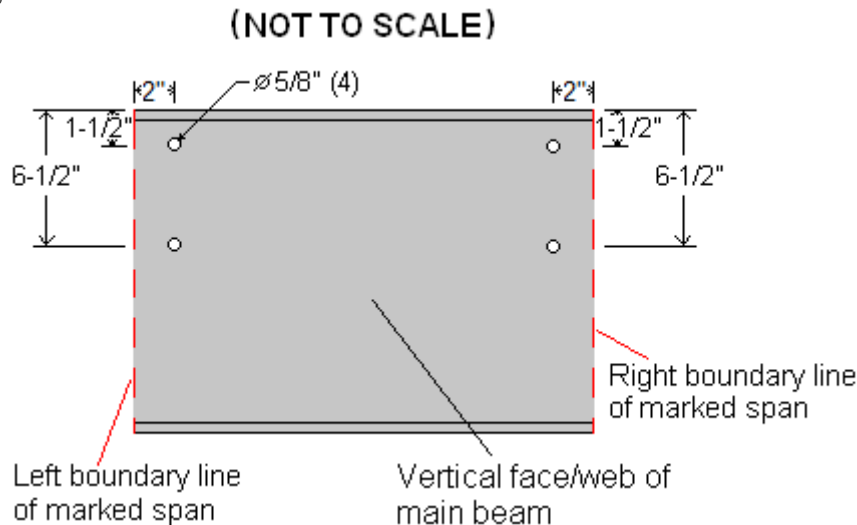
- 1) Select your desired installation location along the main beam's exterior vertical face that can accommodate the full width of the Stepbox which you will be using *plus* a nominal additional 3" (e.g. make sure there is an available lateral span of 15" for installation of a 12"-wide Stepbox & Bracket set). Mark each vertical side boundary for this span using a black marker or tape
- 2) With each unit of the Stepbox Bracket paired set available, measure from the outer edge of the flanged side to the hole center-lines on each Bracket's vertical angle piece, to ensure that the distance is 1-1/8" as shown using the Left Bracket as an example in Figure 1:



**Figure 1 – Illustration of 1-1/8" measurement from outer edge of the flanged side to the hole center-lines on Left Bracket's vertical angle piece**

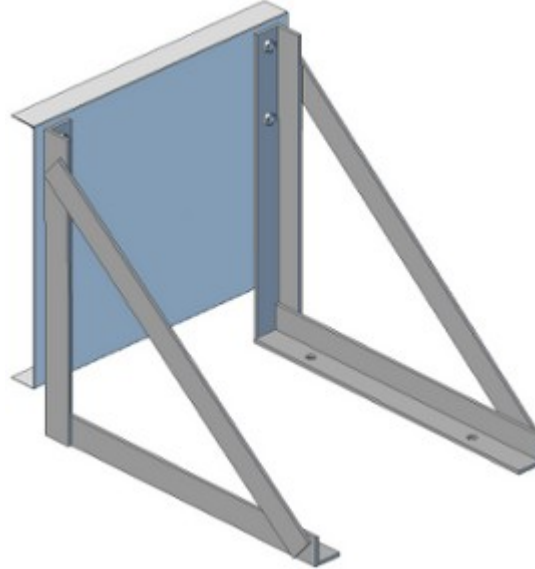
The OEM dimensional tolerance for this measurement is  $\pm 1/16"$  – if the as-measured dimension has any variance within this tolerance, take note of it for the next procedural step. If the as-measured dimension is beyond tolerance, the Stepbox Bracket must be replaced by Sturdy-Lite before this installation can proceed.

- 3) Using your tape measure and marker, mark a point exactly 1-1/2" vertically/transversely below the skyward-facing surface of the main beam's "top" flange and 2" horizontally/laterally inside the boundary span in step (1), from the line to your left. Next, mark a point exactly 6-1/2" vertically/transversely below the aforementioned top face, and same aforementioned 2" horizontal/lateral measurement. Repeat these two marks on the inside-right region of the boundary span.
- 4) Using your power drill and 5/8"-diameter drill bit, drill into the main beam's exterior vertical face/web at each of the four points that you marked in Step (3) above, all the way through. The basic view of your work thus far should look like that in Figure 2:



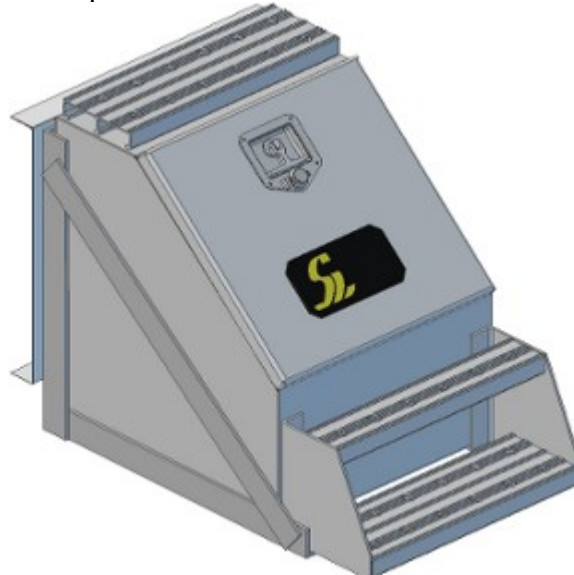
**Figure 2 – Illustration of procedurally-drilled locations as described in Steps (3) and (4)**

- 5) Butt the rear face of the Left Bracket's vertical angle piece against the main beam's exterior vertical face, and align the Bracket's vertical angle piece holes with the left-side pair of holes within the marked boundary span which you made in Step (4). Next, insert a supplied 5/8"-dia Grade 8 Hex Bolt through each aligned pair of holes. While keeping the Left Bracket butted against the main beam's exterior face, access the interior face and slide a supplied Lock Washer along each Bolt shaft until butted against the interior face. Finally, hand-twist a supplied Nut onto each bolt.
- 6) Using your torque wrench and a hand wrench, fasten each Lock Washer, Nut and Bolt set configured in Step (5) to a torque rating of 60 lbs/1"
- 7) Repeat Steps (5) and (6) for the Right Bracket by using the right-side pair of holes within the marked boundary span to align with the Right Bracket's vertical angle piece holes. The completed results of Steps (5) and (6) should resemble the illustrative view depicted in Figure 3:



**Figure 3 – As-installed illustrative view of Left and Right Stepbox Brackets against the main beam's exterior face**

- 8) Situate the Stepbox within the interior horizontal space between the Left and Right Brackets, making sure that all points of contact for the Stepbox bottom and the horizontal faces of each Bracket's horizontal angle piece are parallel i.e. flush and level contact. You may space away from the main beam's exterior vertical face in a depth-wise manner up to 2" if necessary in order to clear fastener heads of hucks or frame bolts
- 9) Using your drill, drill through the bottom face of the Stepbox in each hole location on each Bracket's horizontal angle piece. Install and torque each Bolt, Lock Washer and Nut as in Steps (5) and (6)
- 10) The final installed view of your Stepbox and Brackets should resemble the illustrative view shown in Figure 4:



**Figure 4 – As-installed illustrative view of Left and Right Stepbox Brackets against the main beam's exterior face**

## **MAINTENANCE**

**The end-user shall visually inspect each month, the Sturdy-Lite Stepbox, Steel Box Brackets, and all associated fasteners along with resultant structural connections (holes, butted joints, etc) that are installed. Any mechanical yield in the material at structural connection joints or otherwise should be noted for inspection by a certified technician during the end-user's next scheduled vehicular inspection appointment. If any joint is deemed a structural hazard, the inspection facility manager should uninstall the Stepbox and Box Brackets and contact Sturdy-Lite in order to order new units.**