



INSTALLATION INSTRUCTIONS  
2004-08 F-150 REG CAB  
PART # 203017 / 203017-2

**PARTS LIST**

2- ARIES STEP BAR (1) DRIVER SIDE (1) PASSENGER SIDE  
2- FRONT MOUNTING BRACKETS: (1) DRIVER SIDE (1) PASSENGER SIDE  
2- REAR MOUNTING BRACKETS: (1) DRIVER SIDE (1) PASSENGER SIDE  
4- ½" – 13 X 2" HEX BOLTS  
2- ½" – 13 HEX BOLTS  
6- ½" FLAT WASHERS  
6- ½" LOCK WASHERS  
16- 5/16" – 18 X 1.25" HEX BOLTS  
24- 5/16" FLAT WASHERS  
16- 5/16" LOCK WASHERS  
8- 5/16" HEX NUTS  
2- ½" BOLT PLATES  
8- CLIP NUTS  
2- PLASTIC WASHERS

**INSTALLING NERF BARS**

- (1) BEFORE INSTALLING, REVIEW THE INSTRUCTIONS CAREFULLY, MAKE SURE YOU UNDERSTAND THE CONCEPTS OF THE INSTALLATION. USE THE INSTALLATIONS AND PARTS LIST TO VERIFY ALL THE PARTS INCLUDED.
- (2) LOCATE ALL THE FACTORY OPENINGS THAT WILL BE USED FRO THIS INSTALLATION, LOCATE ON THE INNER WALL OF YOUR TRUCK'S ROCKER PANEL (SEE FIG.A)
- (3) PRY OFF THE RUBBER COVERS AND BLACK TAPE ON THESE OPENINGS. INSTALL THE CLIP NUTS ONTO THE OPENINGS SHOWN IN FIG. A.
- (4) INSTALL THE ½" BOLTS PLATE THROUGH THE REAR OPENINGS SHOWN IN FIG. A. ATTACHES THE PLASTIC WASHERS TO THE ½" BOLT PLATE (HOLD PLATE IN PLACE) BEFORE INSERTING INTO THE ROCKER PANEL.
- (5) ATTACH THE FRONT AND REAR BRACKETS TO THE DESIGNATED HOLES ON THE ROCKER PANEL USING THE 5/16" & ½" HARDWARE (SEE FIG.A FOR BRACKETS PLACEMENT). HAND TIGHTEN FOR NOW.
- (6) IDENTIFY THE STEP BAR FOR THE DRIVER SIDE AND FOR THE PASSENGER SIDE. USE THE ½" X 2" BOLTS TO MOUNT THE TUBE ONTO THE MOUNTING BRACKETS (SEE FIG.A). LEVEL AND ALIGN THE BAR WITH THE FRONT EDGE OF THE ROCKER PANEL, THAN FIRMLY TIGHTEN ALL BOLTS AND NUTS. APPLY A PROPER TOQUE (60-FT LBS FOR ½" BOLTLS AND HEX NUTS. 20 FT-LBS FOR 5/16" BOLTS) TO EACH TO INSURE PROPER INSTALLATION. REPEAT ON OTHER SIDE.
- (7) CAREFULLY STEP ONTO THE TOP OF THE STEP BARS FOR THE FINAL INSPECTION.

driver side shown

1/2" hex bolt  
1/2 lock washer  
1/2" flat washer

figure A

