

# **INSTALLATION INSTRUCTIONS**

**3" SIDE BARS WITH BENT ENDS**

**2001-2012 SILVERADO/SIERRA CREW CAB 2500HD & 3500**

**2002-2012 SILVERADO/SIERRA CREW CAB 1500HD**

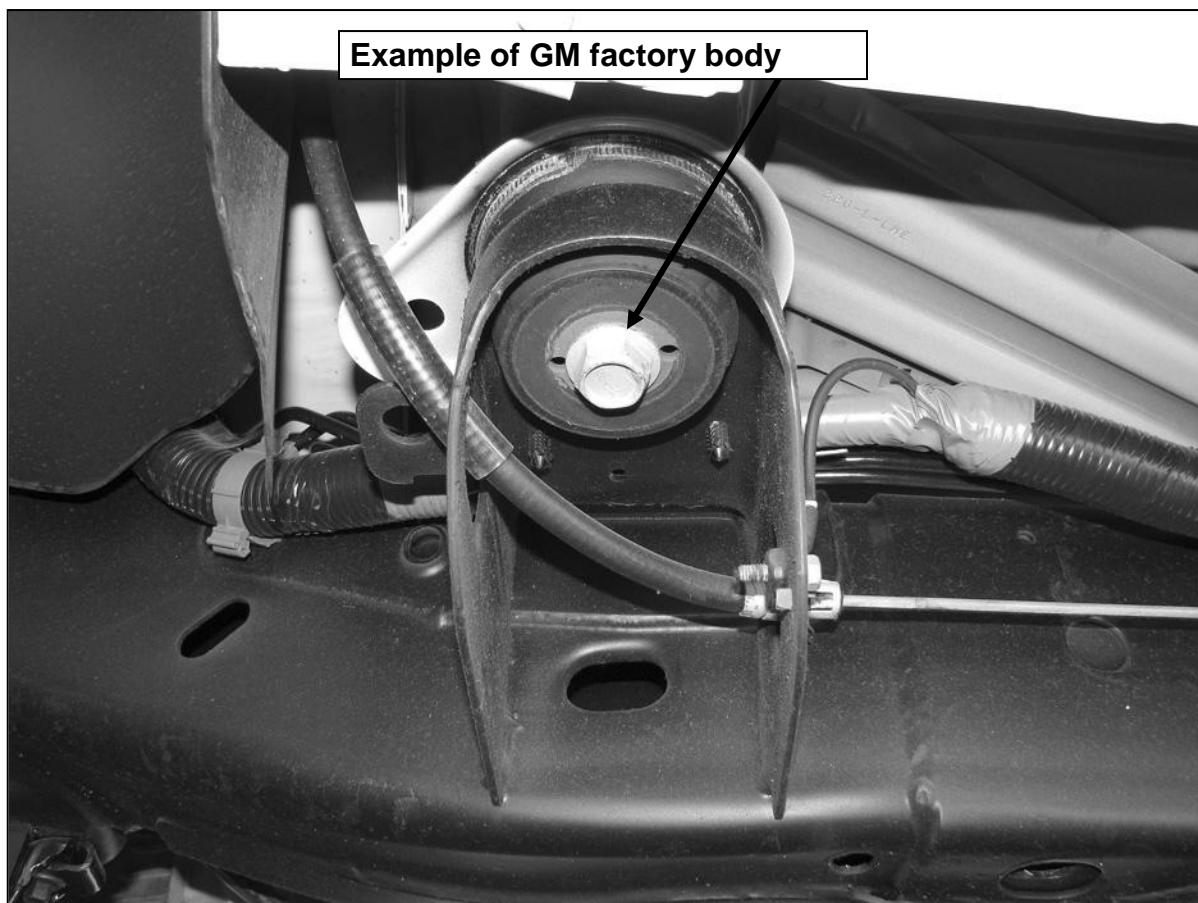
Part number 100591

**IMPORTANT ALERT: GM uses a very strong thread-locking compound on all body bolts. Use of an air assisted impact ratchet can cause damage to the threads on factory body mount bolts and the internal nut assembly because of this thread locking compound.**

**We only recommend the use of hand tools to slowly remove and reinstall body mount bolts on all GM vehicles.**

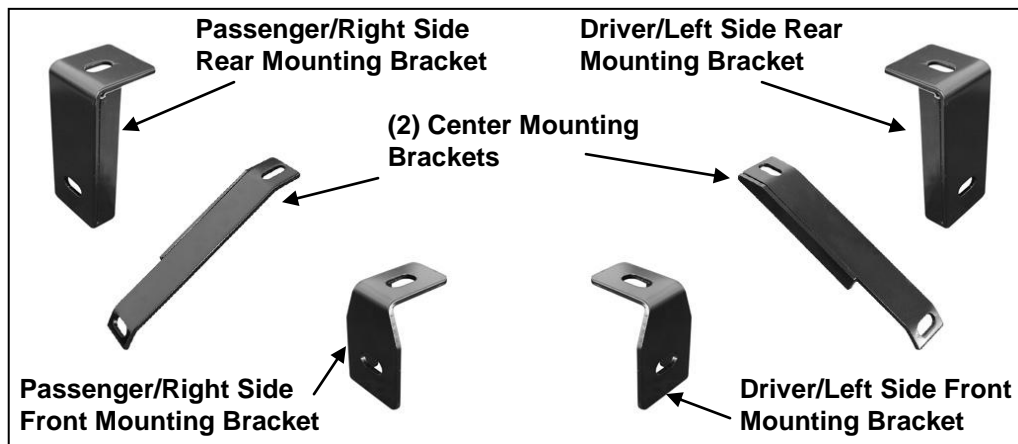
**PROCEDURE:**

**CRITICAL INFORMATION: If during the removal process, it becomes increasingly difficult to unscrew the body mount bolt with hand tools, tighten the bolt several rotations to clear the thread locking compound from the threads, then reverse direction and continue to unscrew until the body mount bolt is out. Repeat this process as necessary on all GM body mount bolts. Use of an appropriate anti-seize compound is highly recommended for re-installation. Tighten body mount bolt to factory torque specifications for your particular model year.**



**PARTS LIST:**

1	Driver/Left Side Bar	4	1/2" ID x 1-1/2" OD x 1/8" Large Flat Washers
1	Passenger/Right Side Bar	4	1/2" Lock Washers
1	Driver Side/Left Front Mounting Bracket	6	12-1.75mm x120mm x 35mm Hex Bolts Gr. 10.9
1	Passenger Side/Right Front Mounting Bracket	6	12mm ID x 32mm OD x 3mm Flat Washers
2	Center Mounting Brackets	6	12mm Lock Washers
1	Driver Side/Left Rear Mounting Bracket	2	10-1.50mm x 25mm Hex Bolts
1	Passenger Side/Right Rear Mounting Bracket	2	10mm Lock Washers
4	1/2" x 2" Hex Bolts	2	10mm ID x 27mm OD x 3mm Flat Washers

**PROCEDURE:**

- 1. REMOVE CONTENTS FROM BOX. VERIFY ALL PARTS ARE PRESENT. READ INSTRUCTIONS CAREFULLY.**
- From underside of vehicle, remove the driver side front body mount bolt, steel washer (if equipped), and rubber bushing, **(Figure 1)**.
- Select the driver side front Mounting Bracket. Insert the factory body mount bolt through the Mounting Bracket and into the steel washer, (if equipped), and rubber bushing. Hang the Mounting Bracket in position by partially threading the factory body mount bolt up into place, **(Figure 2)**. Repeat this step for the Center Mounting Bracket, **(Figure 3)**, and the Rear Mounting Bracket, **(Figure 4)**. **NOTE:** Longer 12mm x 120mm Hex Bolts, 12mm Lock Washers and 12mm x 32mm OD Flat Washers have been provided to replace the factory body bolts. Use only if necessary. Snug but do not tighten hardware at this time.

**VERY IMPORTANT!** There are several different designs, (depending on model year), for the factory steel body mount bracket, **(Figure 1)**. If necessary, the Front and Rear Mounting Brackets can be switched, driver side to passenger side, to provide additional clearance between the gusset on the Mounting Bracket and the factory steel body mount bracket welded to the frame. **To prevent unnecessary noise, adjust the position of all Mounting Brackets so that once tightened, the Mounting Brackets do not come in contact with the factory steel body mount bracket.**

- With help position the Side Bar onto the Mounting Brackets. Attach front and rear Mounting Brackets to Side Bar using the included (2) 1/2" x 2" Hex Bolts, (2) 1/2" Flat Washers and (2) 1/2" Lock Washers, **(Figure 4)**. Do not tighten at this time.
- Attach center Mounting Bracket to Side Bar using the included (1) 10-1.50mm x 25mm Hex Bolt, (1) 10mm Flat Washer and (1) 10mm Lock Washer, **(Figure 3)**. **IMPORTANT:** If threaded insert in Sidebar does not line up correctly with Center Mounting Bracket, switch Sidebars, driver side to passenger side. Do not tighten hardware at this time.

6. Level and adjust the Side Bar, tighten all hardware and check all mounting locations for clearance between factory steel body mount brackets and Mounting Brackets. Once satisfied with fit, tighten all hardware.
7. Repeat steps 2-6 for passenger Side Bar installation.
8. Do periodic inspections to the installation to make sure that all hardware is secure and tight.

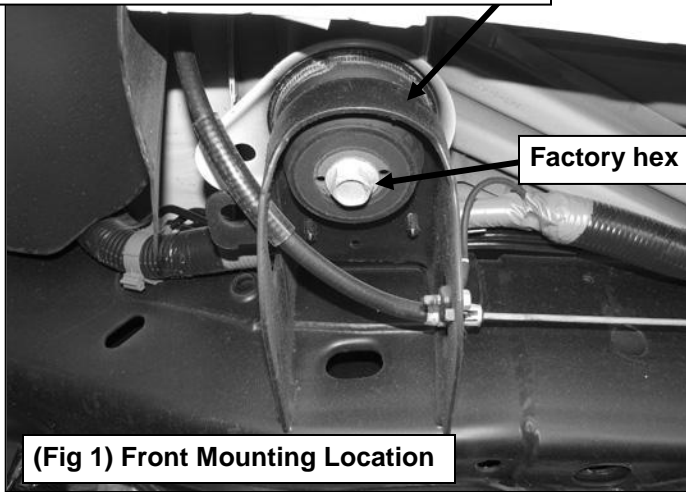
**To protect your investment**, wax this product after installing. Regular waxing is recommended to add a protective layer over the finish. Do not use any type of polish or wax that may contain abrasives that could damage the finish.

**For stainless steel:** Aluminum polish may be used to polish small scratches and scuffs on the finish. Mild soap may be used also to clean the Sidebar.

**For gloss black finishes:** Mild soap may be used to clean the Sidebar.

**Driver side installation pictured**

Factory welded steel body mount bracket



Factory hex bolt

(Fig 1) Front Mounting Location

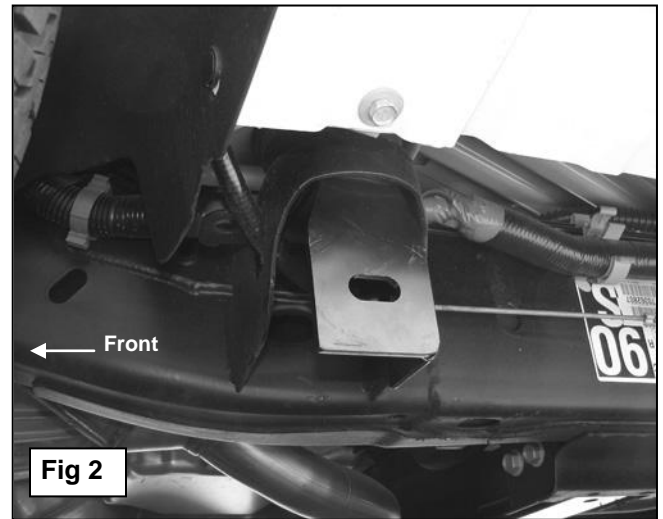
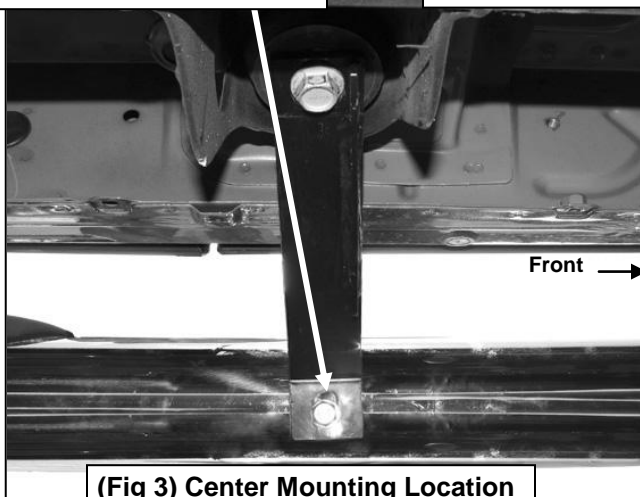


Fig 2

10mm x 25mm Hex Bolt  
10mm Lock Washer  
10mm Flat Washer

Factory hex bolt

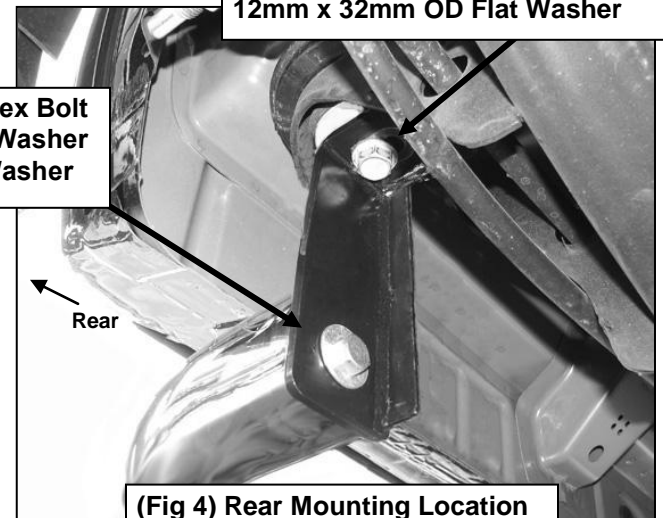


Front →

(Fig 3) Center Mounting Location

1/2" x 2" Hex Bolt  
1/2" Lock Washer  
1/2" Flat Washer

Factory hex bolt or replace with:  
12mm x 120mm Hex Bolt  
12mm Lock Washer  
12mm x 32mm OD Flat Washer



← Rear

(Fig 4) Rear Mounting Location