

INSTALLATION INSTRUCTIONS

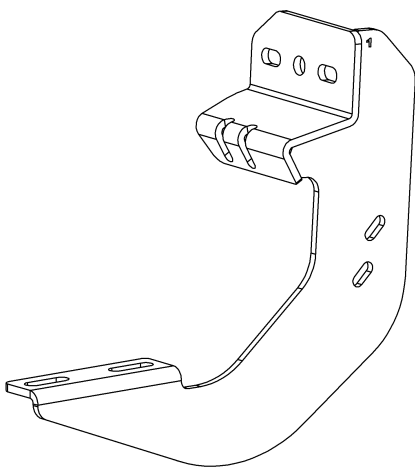
XD Step Board Mount Kit



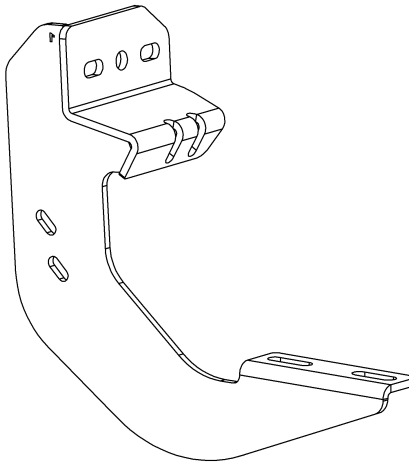
APPLICATION:
2010 and Up Ram 2500/3500

PART NUMBER:
27-51905

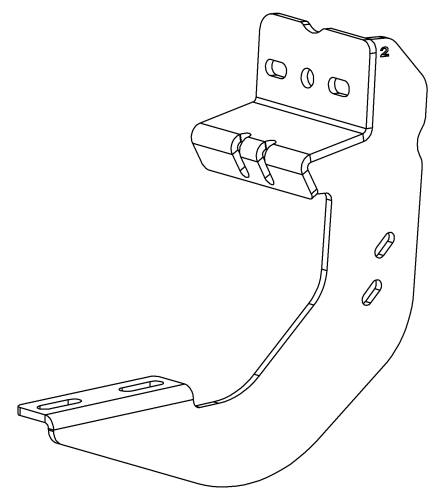
CONTENT			
ITEM	QUANTITY	DESCRIPTION	TOOLS REQUIRED
1	1	FRONT DRIVER BRACKET	13MM SOCKET
2	1	FRONT PASSENGER BRACKET	10MM SOCKET
3	1	CENTER DRIVER BRACKET	10MM WRENCH
4	1	CENTER PASSENGER BRACKET	5MM HEX TOOL
5	1	REAR DRIVER BRACKET	RATCHET
6	1	REAR PASSENGER BRACKET	TORQUE WRENCH
7	6	BRACKET COVER	DRILL
8	12	M8 HEX HEAD BOLT (YELLOW ZINC)	1/4" DRILL BIT
9	12	M8 SQUARE HEAD BOLT (YELLOW ZINC)	MASKING TAPE
10	24	M8 FLAT WASHER (YELLOW ZINC)	
11	12	M8 SPLIT LOCK WASHER (YELLOW ZINC)	
12	12	M8 NYLON LOCK NUT (YELLOW ZINC)	
13	12	M8 RIV-CERT (YELLOW ZINC)	
14	12	M6 HEX HEAD BOLT (YELLOW ZINC)	
15	12	M6 BUTTON HEAD BOLT (BLACK ZINC)	
16	24	M6 FLAT WASHER (YELLOW ZINC)	
17	12	M6 FLAT WASHER (BLACK ZINC)	
18	12	M6 SERRATED FLANGE HEX NUT (BLACK ZINC)	
19	12	M6 NYLON LOCK NUT (YELLOW ZINC)	
ANTI-SEIZE LUBRICANT MUST BE USED ON ALL STAINLESS STEEL FASTENERS TO PREVENT THREAD DAMAGE AND GALLING			



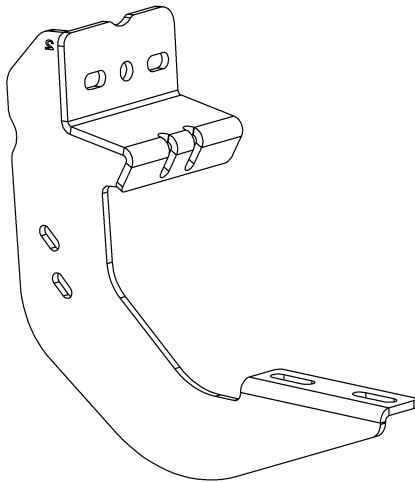
ITEM 1



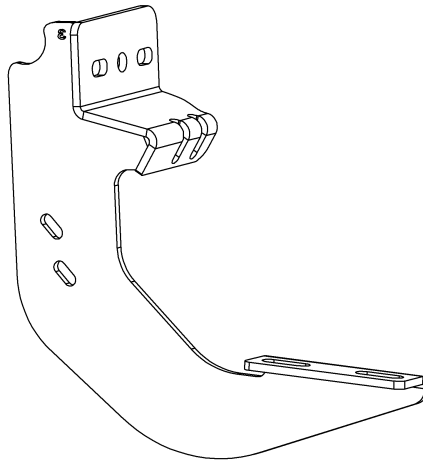
ITEM 2



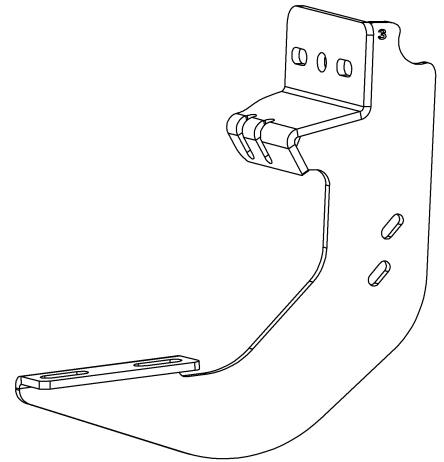
ITEM 3



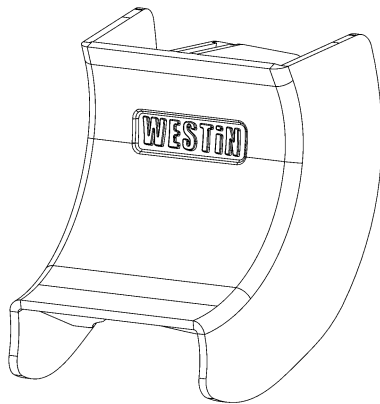
ITEM 4



ITEM 5



ITEM 6



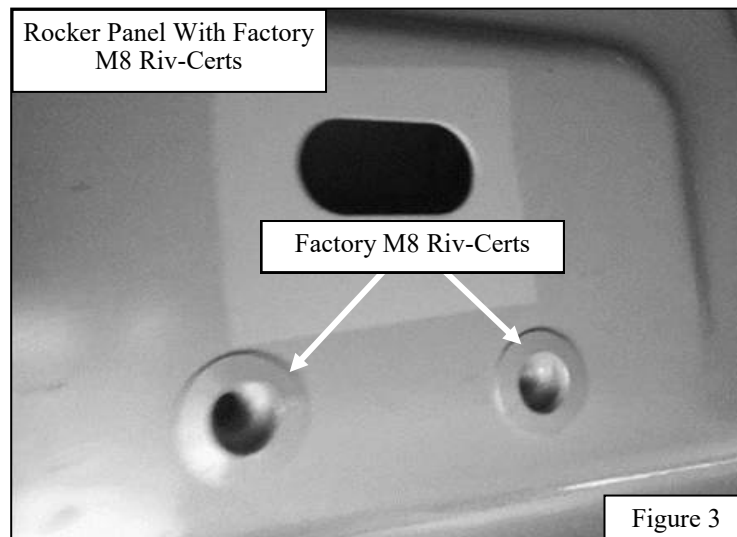
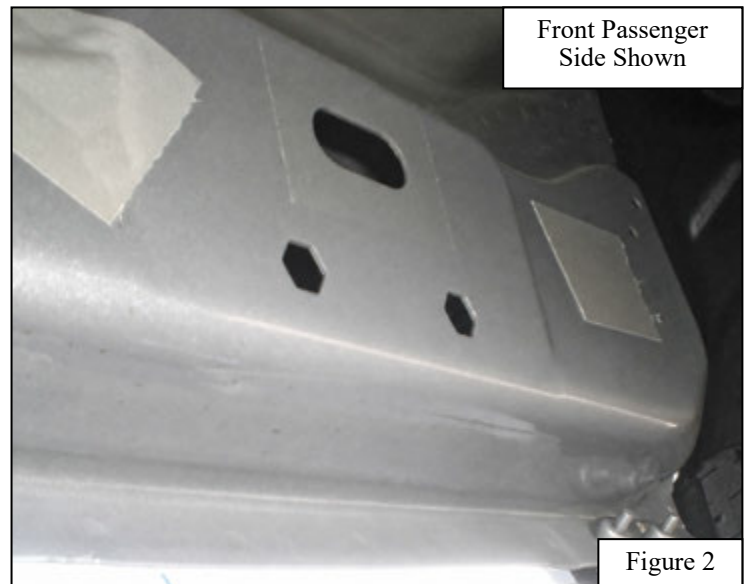
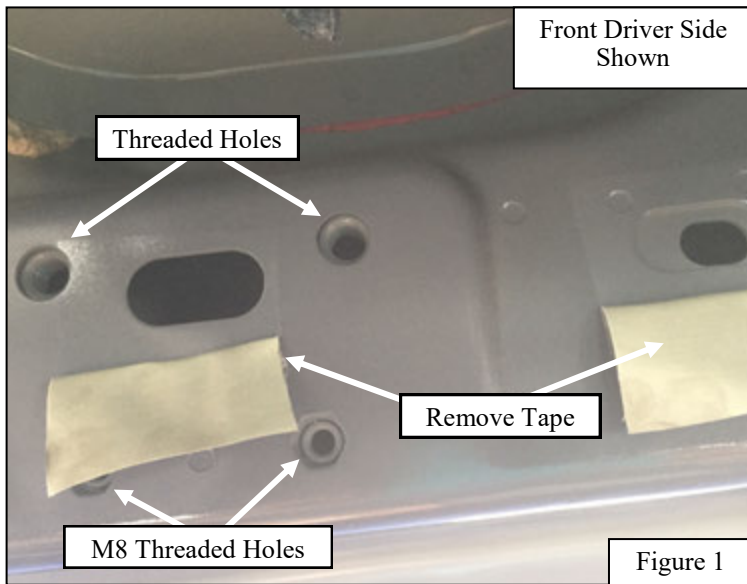
ITEM 7

PROCEDURE

1. Remove contents from box, verify if all parts listed are present and free from damage. Carefully read and understand all instructions before attempting installation.

Failure to identify damage before installation could lead to a rejection of any claim.

2. If present, remove the tape covering the bracket mounting holes.
3. Determine if M8 Riv-Certs (item 13) are needed. If threaded holes or factory riv-certs are present in the bracket mounting locations, the M8 Riv-Certs won't be needed. See **Figures 1-3**.

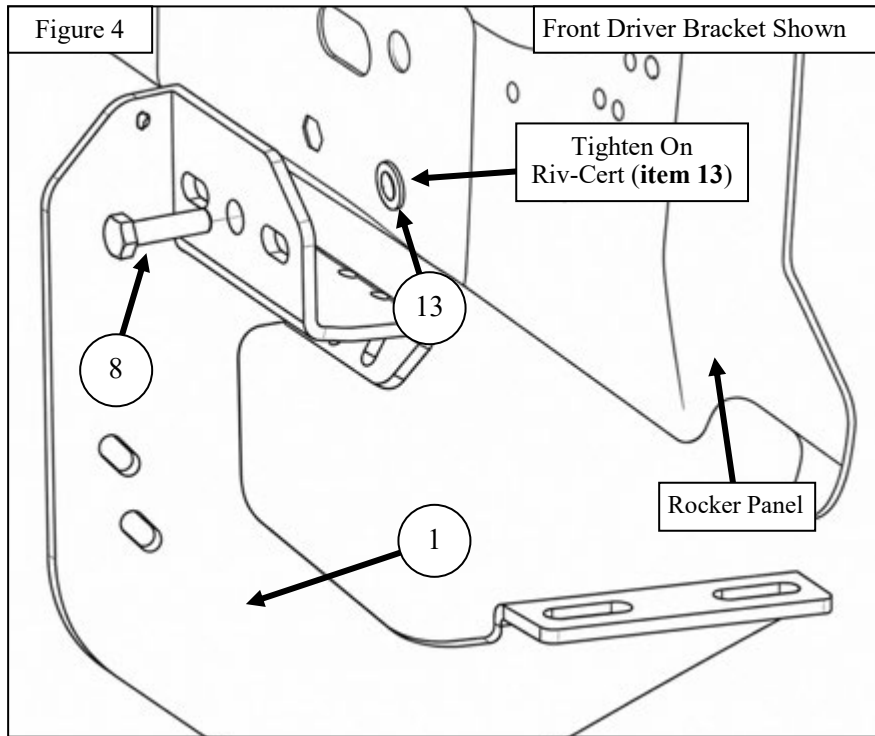


RIV-CERT INSTALLATION

4. For each bracket mounting location where M8 Riv-Certs are needed, install two M8 Riv-Certs.
 - Insert one M8 riv-cert (**item 13**) into each hex hole.
 - Using the center hole of the Front Driver Bracket (**item 1**) as a guide, hand tighten an M8 Hex Head Bolt (**item 8**) into the first M8 Riv-Cert.
 - Torque the M8 bolt to 18 ft-lbs. **See Figure 4.** Use a **13 mm Socket** and a **Torque Wrench**.
 - Remove the M8 bolt and bracket.
 - Repeat this process on the second riv-cert.

Note: This procedure presses in the riv-certs and will permanently install them onto your vehicle.

Note 2: The center hole on all brackets will **not** be used again.



5. Loosely install the Center Driver Bracket (**item 3**).

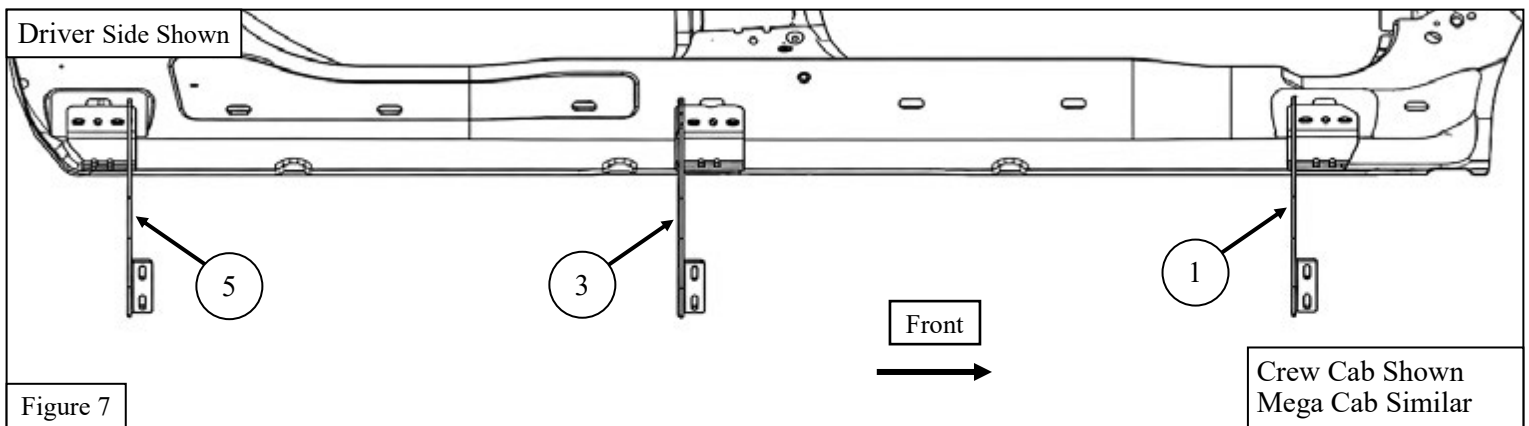
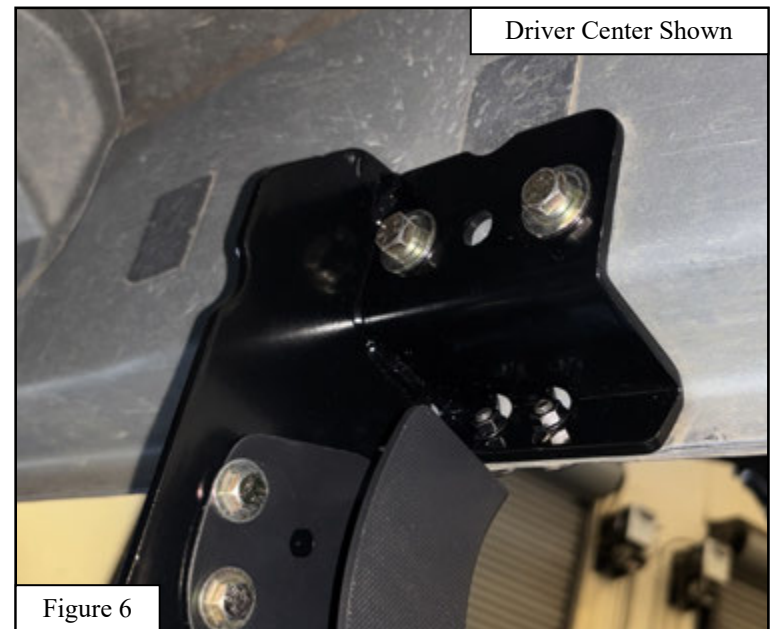
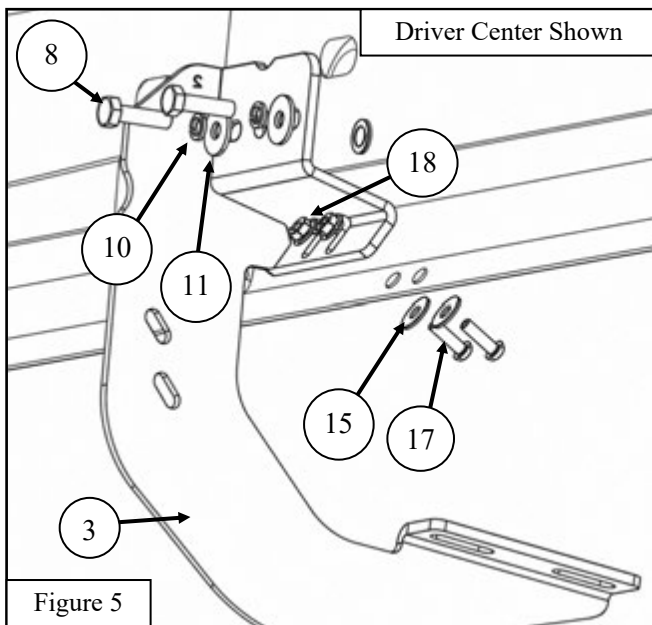
- Loosely attach the bracket onto the rocker panel using the M8 hardware (**items 8, 10, 11**). See **Figures 5 and 6**.
- Loosely attach the bracket to the pinch weld using the M6 hardware (**items 15, 17, 18**). See **Figures 5 and 6**.

Note: It may be necessary to drill two 1/4" holes in the pinch weld if factory holes are not present.

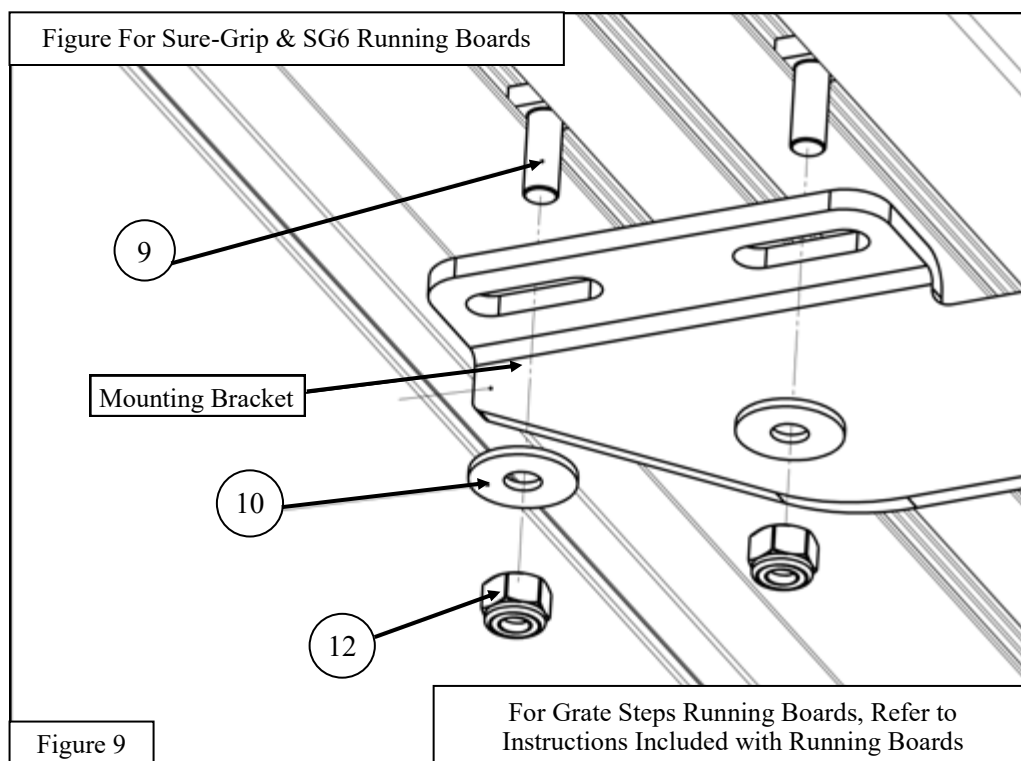
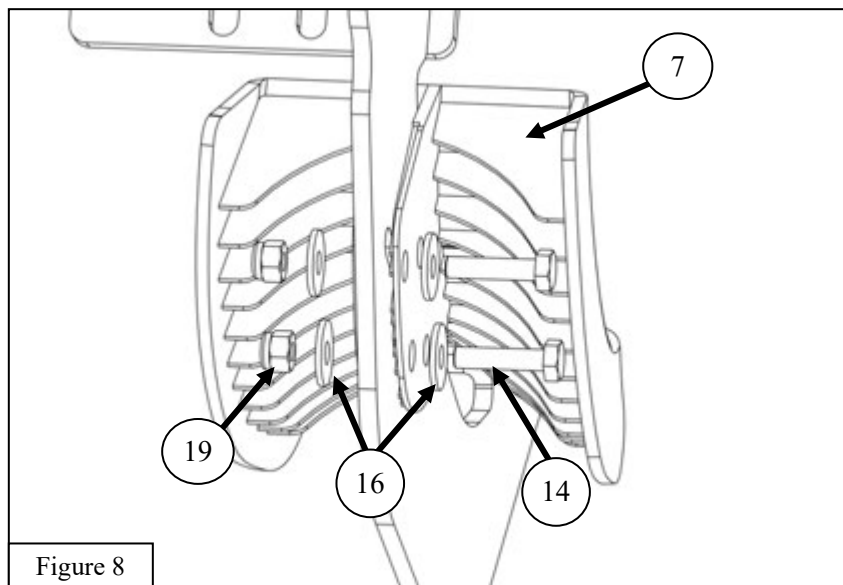
If drilling is necessary, drill two 1/4" holes to install the M6 hardware.

- Place **Masking Tape** on the outside of the pinch weld where the holes will be drilled.
- Tighten and torque the M8 hardware to 18 ft-lbs using a **13 mm Socket and Torque Wrench**. Use this as a guide for drilling holes.
- Using the bracket slots as guides, drill two 1/4" holes through the pinch weld. Use a **Drill** and 1/4" **Drill Bit**.
- Remove Masking Tape.
- Loosen the M8 hardware.
- Loosely attach the bracket to the pinch weld using the M6 hardware (**items 15, 17, 18**).

6. Loosely install the Front Driver Bracket (**item 1**) and Rear Driver Bracket (**item 5**) using the same installation method described in **Step 5**. See **Figure 7** for bracket configuration.



7. Loosely install the Bracket Covers (**item 7**) onto the brackets using the provided M6 hardware (**items 14, 16, and 19**). See **Figure 8**. Use a **10 mm Wrench, 10 mm Socket, and Ratchet**.
8. Install the passenger side brackets and bracket covers (**items 2, 4, 6, and 7**) repeating **Steps 5-7**.
9. Fasten the running boards to the mounting brackets on each side using the provided M8 hardware (**items 9, 10, and 12**). See **Figure 9**.
Note 1: Running boards sold separately.
Note 2: For Grate Steps Running Boards, refer to the installation instructions included with the running boards.
10. Adjust and align the mounting brackets, Bracket Covers, and running boards as needed.
11. Tighten and torque all hardware to the following specifications: M8 hardware to 18 ft-lbs and M6 hardware to 7-8 ft-lbs. Use a **5 mm Hex Tool, 10 mm Socket, 10 mm Wrench, 13 mm Socket, and Torque Wrench**.





CARE INSTRUCTIONS

- TEXTURE BLACK FINISHES SHOULD BE CLEANED WITH MILD SOAP AND WATER ONLY (DO NOT WAX).
- GLOSS BLACK FINISHES SHOULD BE CLEAN WITH MILD SOAP AND WATER.
- POLISHED STAINLESS PRODUCTS SHOULD BE CLEANED WITH MILD SOAP AND WATER. STAINLESS STEEL POLISH MAY BE USED TO REMOVE SMALL SCRATCHES.
- REGULAR WAXING IS RECOMMENDED FOR GLOSS BLACK AND STAINLESS STEEL PRODUCTS. DO NOT USE WAX THAT MAY CONTAIN ABRASIVES.



Westin Automotive Products, Inc.
320 W. Covina Blvd
San Dimas, Ca. 91773

Thank you for choosing Westin products
for additional installation assistance please call
Customer Service (800) 793-7846
www.westinautomotive.com



WARNING



Failure to follow these instructions could lead to death, personal injury, and / or property damage.

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FASTENERS:

All Westin supplied fasteners must be utilized and installed in accordance with the installation instructions and apply torque to the specifications as defined. **DOUBLE CHECK ALL FASTENERS BEFORE INITIAL USE, AND PERIODICALLY IN THE FUTURE TO ENSURE PROPER FUNCTION AND SAFETY.**

DRILLING:

Most Westin products do not require drilling for installation. If drilling is defined as required, use caution when drilling a vehicle. **FAILURE TO REVIEW AN AREA TO BE DRILLED MAY RESULT IN PERSONAL INJURY AND/OR INJURY TO OTHERS AS WELL AS VEHICLE DAMAGE.**

EYE PROTECTION:

ALWAYS WEAR SAFETY GLASSES OR GOGGLES DURING THE INSTALLATION PROCESS TO AVOID PERSONAL INJURY.

MAXIMUM TOWING/CARRYING CAPACITY: (if applicable)

The Westin Receiver Hitches will have a visible tow rating label affixed directly on the product. User should never exceed the vehicle manufacturers maximum tow and weight rating regardless of the capacity of the hitch. **FAILURE TO FOLLOW THESE GUIDELINES WILL VOID THE WESTIN WARRANTY AND MAY RESULT IN PERSONAL INJURY AND/OR INJURY TO OTHERS AS WELL AS VEHICLE DAMAGE.**

FOR CALIFORNIA RESIDENTS ONLY-PROP 65 WARNING:

Some products may contain chemicals such as DEHP, which can cause cancer, birth defects or other reproductive harm. For more info go to www.p65warnings.ca.gov



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