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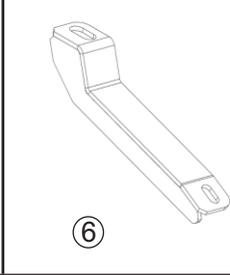
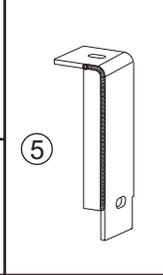
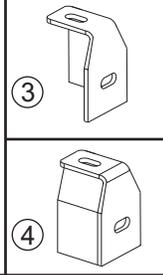
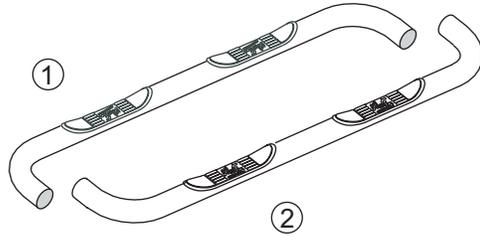
# INSTALLATION INSTRUCTIONS

APPLICATION: 2001-12 SILVERADO/SIERRA 2500/3500 HD EXTENDED CAB  
1999-12 SILVERADO/SIERRA EXTENDED CAB 1500/2500 LD

AUTOMOTIVE PRODUCTS, INC.

## STRIP ASSEMBLIES

21-1680  
21-1685  
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ITEM	QTY	CONTENTS	TOOLS
1,2	2	STEP BAR, PASSENGER (1) AND DRIVER (2)	3/4" SOCKET 3/4" WRENCH 16MM SOCKET 18MM SOCKET 21MM SOCKET EXTENSION RATCHET
3,4	2	FRONT BRACKET, PASSENGER (3) AND DRIVER (4)	
5	2	REAR BRACKET	
6	2	CENTER BRACKET	
7	4	1/2-13 X 1.75" HEX HEAD BOLT	
8	4	1/2" FLAT WASHER	
9	4	1/2" LOCK WASHER	
10	2	M10-1.5 X 25MM HEX HEAD BOLT	
11	2	M10 FLAT WASHER	
12	2	M10 LOCK WASHER	

- STEP 1. Remove contents from box and check for damage. Verify all parts are present. Read instructions completely before beginning.  
STEP 2. Remove drivers side body mount bolts located under cab of vehicle, All bolts, washers, and bushings removed will be re-used.

STEP 3. Position front bracket up to the front body mount and attach with the factory fasteners. Adjust bracket in towards the frame so there is at least 1/8" clearance between the brackets and the body mount pocket. Hand tighten. **SEE FIGURE 1 AND 2.** As you tighten up the brackets, make sure you maintain the desired clearance between the bracket and the body mount pocket.

STEP 4. Repeat step 3 for the center and rear brackets as shown. Hand tighten. **SEE FIGURE 1.**

STEP 5. Attach step bar as shown. Hand tighten. The step pad closer to the bend goes to the rear of the vehicle. **SEE FIGURE 1.**

STEP 6. Make sure step bar and brackets are properly aligned and tighten fasteners. Recommended torque values are 74 Ft.Lbs. for factory bolts, 64 Ft.Lbs. for 1/2" fasteners, 79 Ft.Lbs. for M12 fasteners and 26 FT.LBS. for 3/8" fasteners. **NOTE:** Westin advises the installer to use a thread lubricant such as Permatex Anti-Seize on the 1/2-13 bolt threads for stainless steel applications.

STEP 7. Repeat for passenger side.

STEP 5. Attach bar as shown. Hand tighten the step pad closer to bend goes to the rear SEE FIG 1

STEP 6. Make sure step bar and brackets are properly aligned and tighten fasteners. Recommended torque values are 74 Ft.Lbs. for factory bolts, 55 Ft.Lbs. for 1/2" fasteners and 26 FT.LBS. for M10 fasteners. **NOTE:** Westin advises the installer to use a thread lubricant bolt threads for stainless steel applications.

STEP 7. Repeat for passenger side.

## FINISH PROTECTION

Westin products have a high quality finish that must be cared for like any other exposed finish on the vehicle. Protect the finish with a non-abrasive automotive wax, (e.g. Pure Carnauba) on a regular basis. The use of any soap, polish or wax that contains an abrasive is detrimental, as the compounds scratch the finish and open it to corrosion.

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

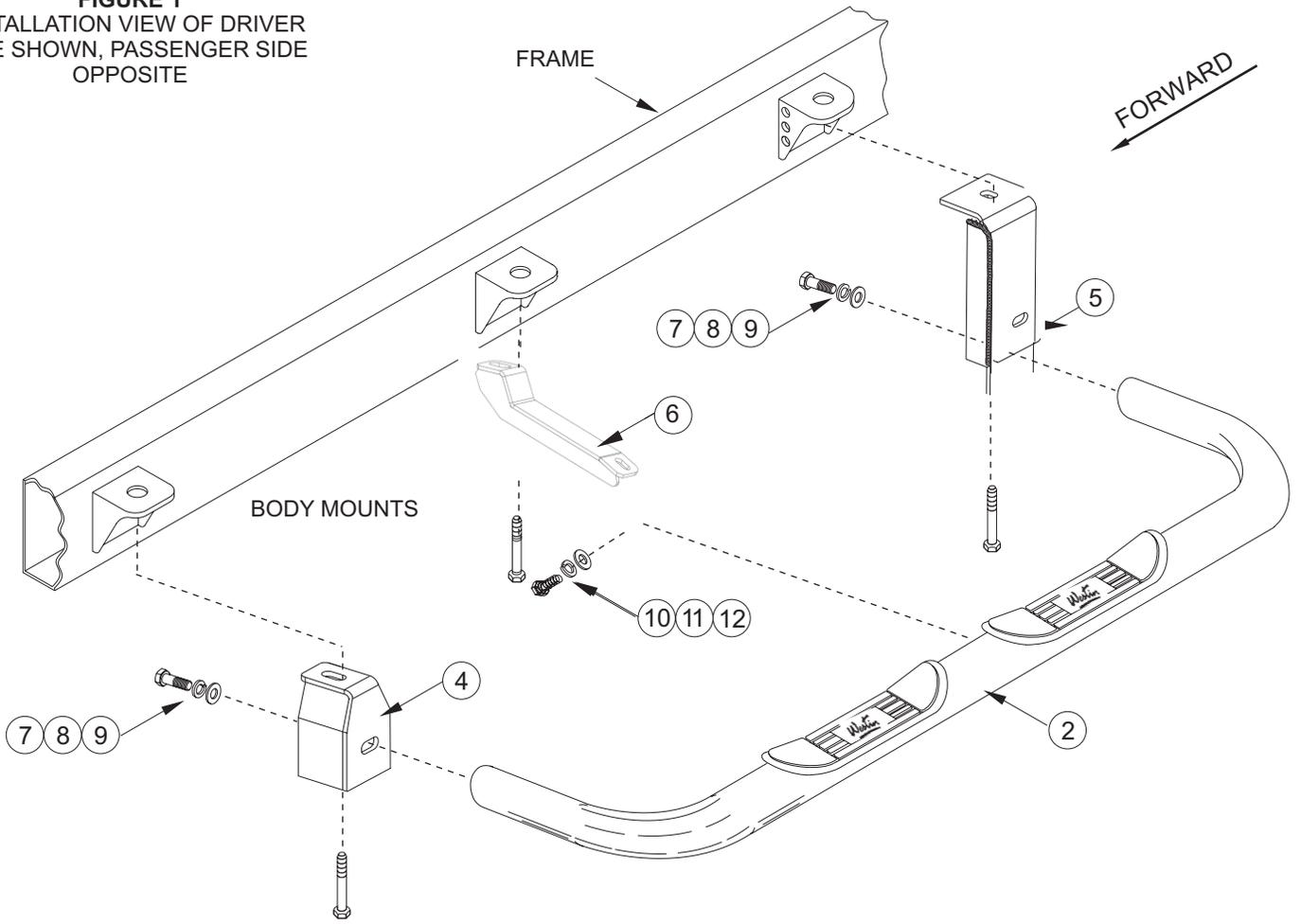
We only recommend the use of hand tools to slowly remove and reinstall body mount bolts on all GM vehicles.

#### **PROCEDURE:**

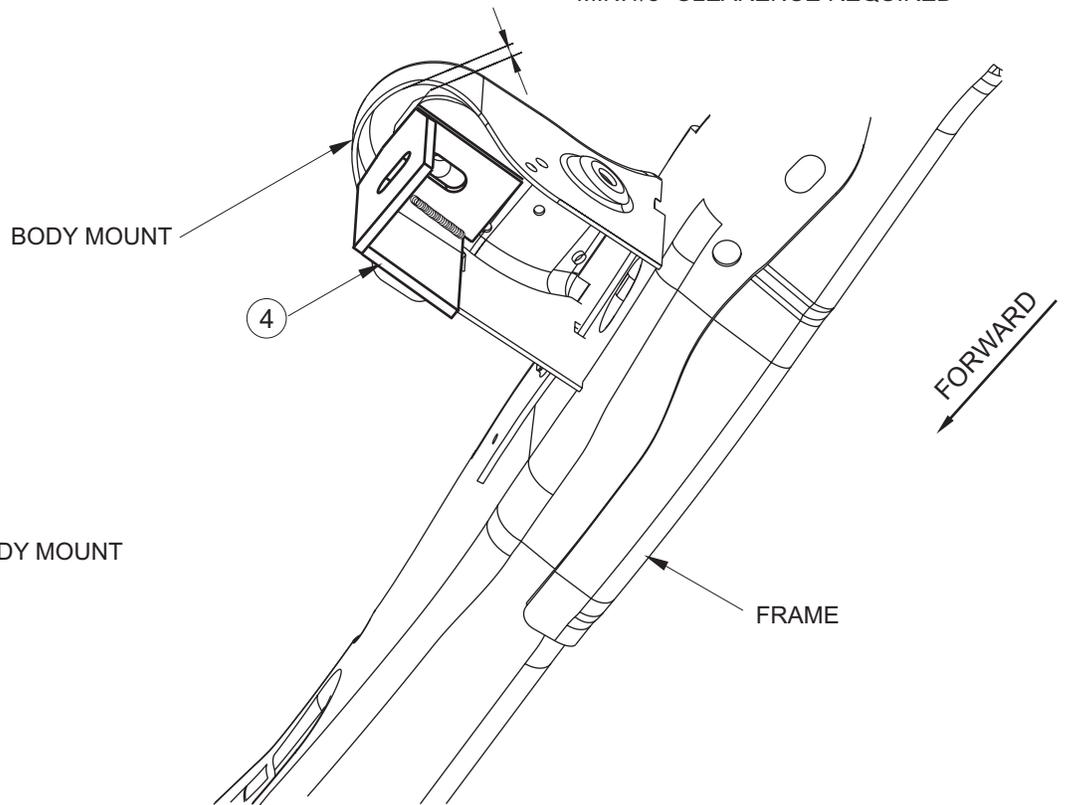
**CRITICAL INFORMATION:** If during the removal process, it becomes increasingly difficult to unscrew the body mount bolt with hand tools, tighten the bolt several rotations to clear the thread locking compound from the threads, then reverse direction and continue to unscrew until the body mount bolt 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.



**FIGURE 1**  
 INSTALLATION VIEW OF DRIVER  
 SIDE SHOWN, PASSENGER SIDE  
 OPPOSITE



MIN. 1/8" CLEARANCE REQUIRED



**FIGURE 2**  
 DRIVER SIDE FRONT BODY MOUNT