



FLEXIGLASS FITTING MANUAL - SECTION 5.1F

KIT140 SIDE STEP TO TRAY FIT - ISSA0

Note: Familiarise yourself with the instructions before you start to ensure you are clear on all aspects of the fit

SAFETY EQUIPMENT

- Hearing protection as required
- Eye protection as required

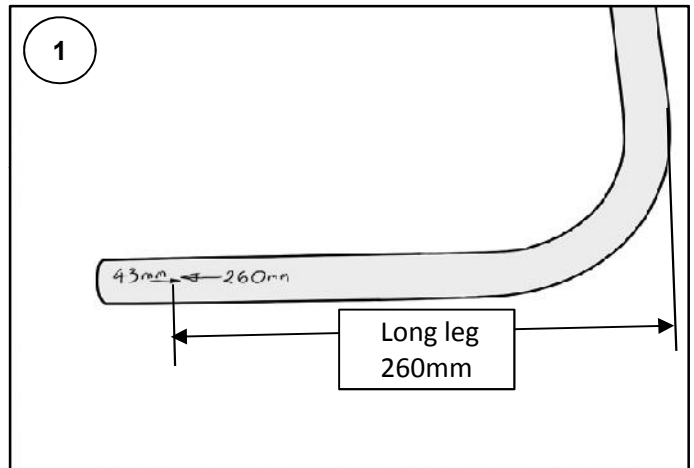
TOOLS REQUIRED

- Pneumatic drill, 10mm capacity.
- 5, 6 & 8mm drill bits.
- 10 & 13mm sockets and spanners.
- Pneumatic driver for above.
- Pneumatic hacksaw.
- 11R or 6R Vice Grips.

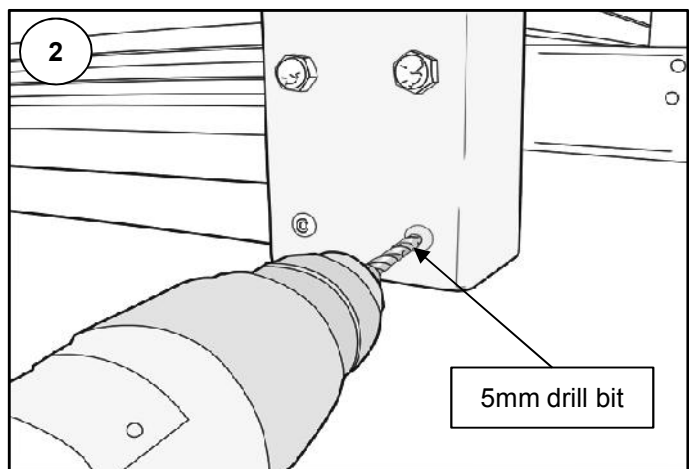
MATERIALS & PARTS REQUIRED KIT140

Part No.	Description	Qty.
BLTHHZP640	Bolt M6-40 ZP	2
BKT100	Side step bracket (25 Dia. "T" clamp)	1
NUT6N	Nut Nylock M6	2
SIDESTEP30	Side Step tube.	1

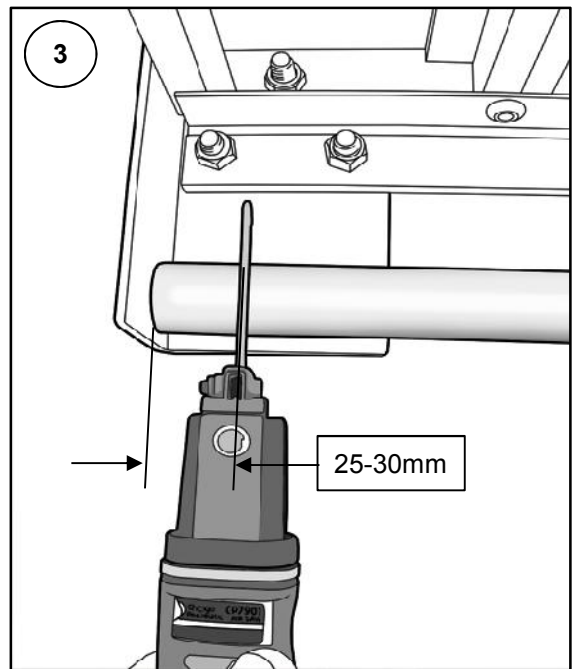
- 1 Check the length of the long leg of the **SIDESTEP30** and if necessary trim it to an overall length of 260mm. See **ILL 1**.



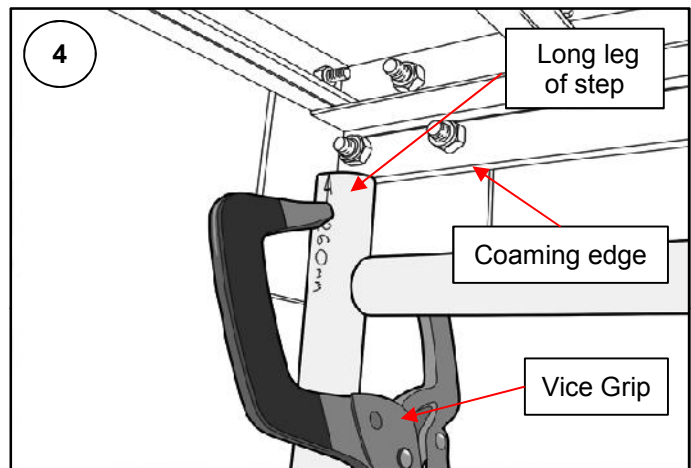
- 2 Drill out the front rivet securing the rope rail with a 5mm drill bit. See **ILL 2**.



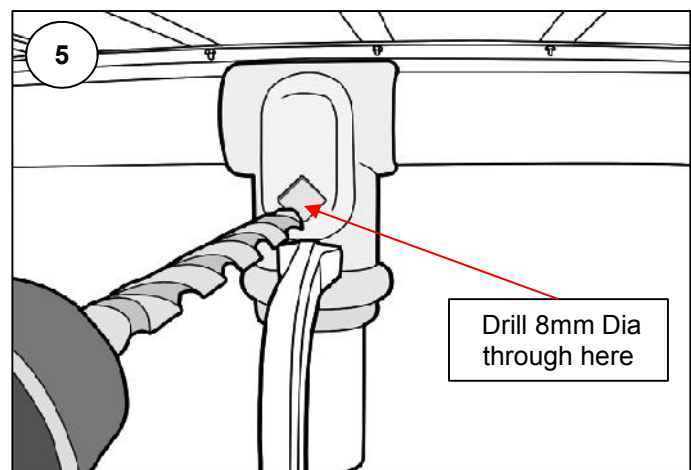
- 3 Working beneath the tray deck, trim 25-30mm from the front of the rope rail. (Touch up any scratches on the headboard angle with zinc rich primer) See **ILL 3**.



- 4 Locate the step tube under the headboard angle in the gap cut in stage 3. Ensure the end is hard up against the coaming edge and is pushed as far forward as possible, See **ILL 4**. Clamp in position with Vice Grips making sure that the empty rivet hole in the angle can be reached with a drill later on.



- 5 Fit the two halves of the clamp **BKT100** over the rope rail and around the shorter end of the step tube. See **ILL 5**. Ensure that the step end is pushed hard up against the rail, then clamp in position with Vice Grips.



- 6 Carefully drill an 8mm hole through the end of the step tube using the hole in the clamp as a guide. See **ILL 5**.
- 7 Fit the cup head 8mm clamp bolt through the hole (head to the outside) and fully tighten.

- 8 With a 6mm drill open out the empty rivet hole from stage 2 and drill the step tube behind it through both sides.
- 9 Fit and tighten one of the M6 x 40mm bolts through the assembly.
- 10 Remove the Vice Grips from the angle and about 30mm above the previous hole, drill another as shown in **ILL 6**.
- 11 Fit and fully tighten the remaining M6 x 40mm bolt through this hole.
- 12 Repeat procedure on the opposite side of the tray.

