



Work Instruction: Install ROXOR Side Steps

ROXOR Side Steps (P/N 2302CUA00151N)

WORK INSTRUCTION OVERVIEW

⚠ WARNING

- DO NOT ATTEMPT THIS PROCEDURE IF YOU DO NOT HAVE PROPER TOOLS, TRAINING, AND FACILITIES.
- Never consider using a two-post lift that is not certified according to ANSI/ALI ALCTV-2011 or ANSI/UL 201. (autolift.org)
- Read and follow all instructions provided when installing this product. Failure to do so may result in placing occupants at risk of serious injury or death.
- To protect bystanders and the service technician(s), shut vehicle off, remove the Ignition Key and secure vehicle to prevent unintended movement.
- Never operate the vehicle in excess of manufacturer's specifications.

TOOLS REQUIRED

<ul style="list-style-type: none"> ◦ 13 mm Wrench ◦ 13 mm Socket ◦ Socket Driver / Extension 	<ul style="list-style-type: none"> ◦ Torque Wrench (N•m) ◦ Utility Knife ◦ Protective Eye-wear
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TORQUE SPECIFICATION

Tighten each fastener to the torque specification below:

- **M8 Fasteners** – 24.5 N•m (±3.5 N•m)

SIDE STEP BAR

Part Number - 2302CUA00151N

Kit Component	Description	Qty
	Side Step Bar P/N-0076602	2
	M8 x 1.25 x 30 Hex Bolt P/N-3108228C	8
	M8 Hex Lock Nut P/N-5308202	8
	M8 Flat Washer P/N-0028552	16

INSTALLATION PROCEDURE

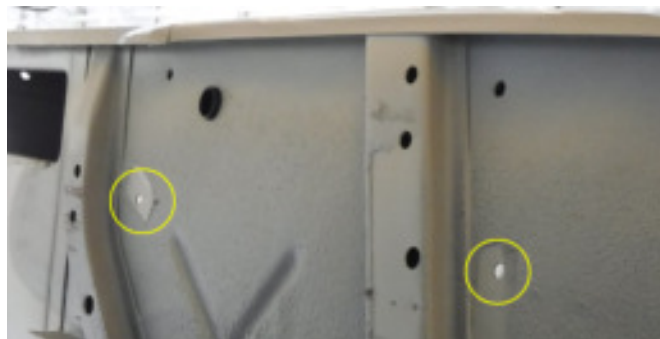
1. The Side Step Bars share (2) mounting holes with the Side Nets, which are factory installed.



2. There are (2) additional factory installed holes used for mounting the Side Step Bars, shown here in yellow.



3. These (2) holes will typically be covered with floor lining material. Use a sharp knife to pierce both holes from underneath the vehicle, then carefully trim out the floor lining material from each hole from inside the vehicle.





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- 4. Remove the (2) Side Net fasteners and set aside for reuse.



- 5. Install Side Step Bars with (4) bolts, (4) lock nuts and (8) washers and torque to specifications.

NOTICE *be sure to reattach the Side Net strap retainers to the outboard fasteners in their original locations.*



- 6. Install the drivers side Step Bar, then repeat these steps on the passengers side.

