



235 2<sup>nd</sup> Avenue NE  
Hickory, NC 28604

March 27, 2015

**“SAFETY RECALL NOTICE”**  
**NATIONAL HIGHWAY TRAFFIC SAFETY ADMINISTRATION**  
**RECALL NO: 15E013**

Attention: Forest River, Inc.

This notice is sent to you in accordance with the requirements of the National Traffic and Motor Vehicle Safety Act. No. 577.13, “*Notification to Dealers and Distributors*”.

HSM Inc., “formerly known as Hickory springs Manufacturing”, has determined that a defect which relates to motor vehicle safety exists in certain “RV Step” models manufactured by HSM, which were shipped between October 18<sup>th</sup>, 2012 and January 9<sup>th</sup>, 2015.

Specifically, HSM has determined that the rivets marked as #96 or rivets marked as #55, which connect the 2nd and 3rd step at the hinge point (2nd and 3rd step, defined as the 2nd step from the ground level and the 3rd step from the ground level) of the Quad step, may shear or pull out under load. HSM has further determined that on these RV Step configurations, the inboard rivets marked as #08 or 80, which connect the top step tread (top step, defined as the 4th step from the ground level) to the upper hinge bracket of the Quad Step, may shear or pull out under load.

*Please Note; these rivet numbers may be utilized at other locations within the step assembly. These other rivet locations are not affected by this recall and should be considered safe under continued use.*

There is no visual or audible warning which would precede this condition. All step models indicated in this notice are presumed to contain the defect and must be repaired in accordance with the enclosed Service Repair Procedure, SRP 1502-0001.

To correct this condition, an inspection of the RV Step must first be conducted to assure that the step is an HSM product. Once confirmed, repair must be conducted in accordance with the enclosed Service Repair Procedure SRP 1502-0001. HSM has developed a parts kit, HSM Kit # 185405, which contains all parts needed to affect the repair. The expected out of service time necessary to affect repair is .5 hours per step assembly. HSM will facilitate repairs relating to this recall, including both parts and labor, at no cost to you the manufacturer or to the vehicle owner. Repair kits for this recall are anticipated to be available for shipment on or before 04/06/2015.

Upon receipt of this Recall Notice, HSM is requesting that you provide notification of this Safety Recall to the Customer/Owner of the subject “RV Step(s)” and a copy of the enclosed

"RV Step Inspection Procedure". Again, inspection of the RV Step must be conducted to assure that the step is an HSM product. We will immediately ship repair kits containing all required parts and a copy of Service Repair Procedure SRP 1502-0001, to you or to the Customer/Owner at your direction.

Should you have any vehicle('s) in inventory that require the recall service work; please make certain that these vehicles are corrected prior to sale. The Federal Motor Vehicle Safety Standard No. 577.13 states that it is a violation of Federal law for a dealer to deliver a new motor vehicle or any new or used item of motor vehicle equipment (including a tire) covered by the notification under a sale or lease until the defect or noncompliance is remedied.

Based on our review of internal shipping records, The HSM has determined that "RV Step('s)" as indicated on the enclosed "Appendix – A", were shipped to your manufacturing location on the dates indicated.

If after contacting HSM, you have not received the Service repair Procedure and parts required to remedy the defect, in a reasonable period of time, you may contact:

ADMINISTRATOR  
NATIONAL HIGHWAY TRAFFIC SAFETY ADMINISTRATION  
1200 NEW JERSEY AVENUE, SE  
WASHINGTON, DC 20590  
1-888-327-4236  
TTY: 1-800-424-9153  
or go to: <http://www.safecar.gov>

If you have any questions about this recall please call HSM Customer Service at 479-646-6161 ext 375.

Sincerely,

Darrell LaRue  
Customer Service Department  
E: [djlarue@hsmsolutions.com](mailto:djlarue@hsmsolutions.com)  
P: 479-646-6161 ext 375



**Transportation Solutions**

**RV QUAD STEP 24" x 8 x 8, RIVET REPLACEMENT**

REV.B032715

**HSM RV STEP:** (Affected Part Numbers, As Follows)

**LCI NO. / HSM NO.**

- 994240R - 24" RV Step 8x8 PRCD RAD
- 994240RXW - 24" RV Step 8x8 RAD
- 994240RBBW - 24" RV Step 8x8 ST PRC RAD RGR
- 994240RCW - 24" 8X8 QUAD PRCD RAD BOXED
- 984240RW - 24" RV Step 8x8 ST PRC RAD W/ BRKT.
- 235458 235458LCI - 24" RV 8X8 QUAD STEP RAD LCI
- 235458 / 235458LCIA - 24 RV 8X8 QUAD STEP SL RAD LCI
- 349749 349749LCI - 24 RV 8X8 QUAD ST FLAT RAD LCI
- 349749 / 349749LCIA - 24 RV 8X8 QUAD STEP FL RAD LCI
- 9942401RXW - 24" RV 8X8 QUAD STEP RAD

**ISSUE:**

HSM has determined that the rivets marked as #96 or rivets marked as #55, which connect the 2nd & 3rd step at the hinge point (2nd and 3rd step, defined as the 2nd step from the ground level and the 3rd step from the ground level) of the Quad step, may shear or pull out under load. HSM has further determined that on these RV Step configurations, the inboard rivets marked as #08 or 80, which connect the top step tread (top step, defined as the 4th step from the ground level) to the upper hinge bracket of the Quad Step, may shear or pull out under load.

**Please Note:**

*The rivet numbers referenced previously, may be utilized at other locations within the step assembly. These other rivet locations are not affected by this recall and should be considered safe under continued use.*

**ACTION:**

Inspect your vehicles step to assure that it is an HSM product and to determine the rivet configuration for selection of the proper repair procedure. Then follow the service procedure steps as defined in Appendix "A" or "B", to correct the condition.

**WARRANTY STATUS:**

Eligible under Safety Recall # 15E013

**NOTE: All warranty claims must be submitted in accordance with HSM warranty procedures and shall include a copy of the completed Recall Response Card for each step repair.**

**"ATTENTION"**

**Any RV Step repair request for steps manufactured outside the date range of this recall, must be preceded by a "Preauthorization Request" which includes photographs of the step clearly indicating the step manufacturer and the defective rivets.**

**SERVICE OPERATION: APPENDIX "A"**

**Approved Time:**

RV Step - # 96 Hinge Rivet Replacement @ Step Tread 2 & 3, LH & RH Rivet and #08 or 80 Top Tread Mount Rivet Replacement LH & RH.

.50 Hr.

(Total time to complete this SRP)

**SERVICE OPERATION: APPENDIX "B"**

**Approved Time:**

RV Step - # 55 Hinge Rivet Replacement @ Step Tread 2 & 3, LH & RH Rivet and #08 or 80 Top Tread Mount Rivet Replacement LH & RH.

.50 Hr.

(Total time to complete this SRP)

**STEP INSPECTION PROCEDURE:**

**NOTE: SAFETY GLASSES MUST BE WORN AT ALL TIMES DURING THIS INSPECTION PROCEDURE.**

1. Vehicle Staging - Stage the vehicle in a level, clean and dry area.
2. Secure for Service - Place wheel chocks at each axle to ensure that the vehicle cannot move during the inspection procedure.
3. Deploy the RV Step - Fully deploy the RV Step from the stowed position, extending it outward and unfold each step tread. This will position the step in the best position for inspection.

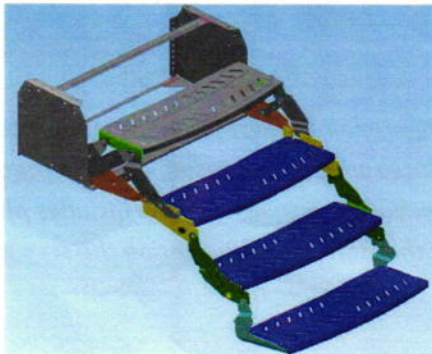
# SRP 1502 – 0001 (CONTINUED)

## CONFIRM MANUFACTURE:

The following features are unique to the HSM RV Quad Step and must be used for product identification.

4. Is The Step an HSM Product - With the step fully deployed, look for the following unique features:

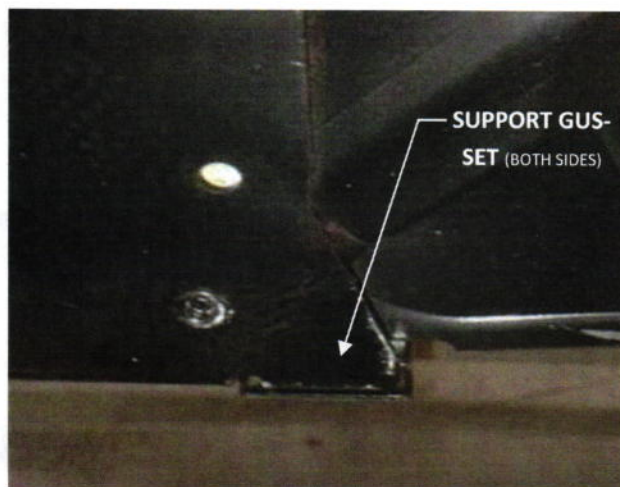
4.1 Does the step have a perforated or raised tread plate, as indicated in the following pictures?



HSM STYLE  
TREAD PLATE



4.2 Does the step have a lower gusset on the outboard side of the step side mounting plate, as indicated in the following pictures?



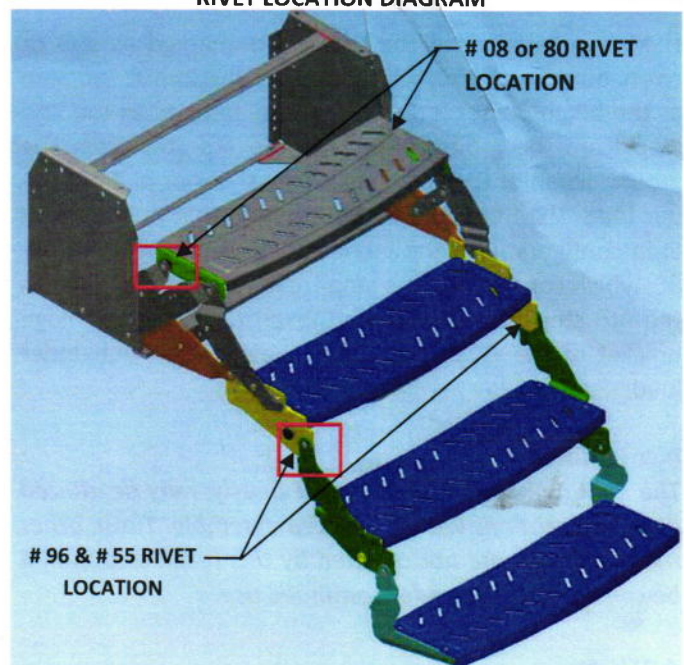
4.3 Does the step have an outboard lower cross-tube connecting the two end plates.



## DETERMINE YOUR RV STEP CONFIGURATION:

5. Inspect your step to determine your step configuration. HSM manufactured two different configurations of step assemblies which are affected by this recall.

### RIVET LOCATION DIAGRAM



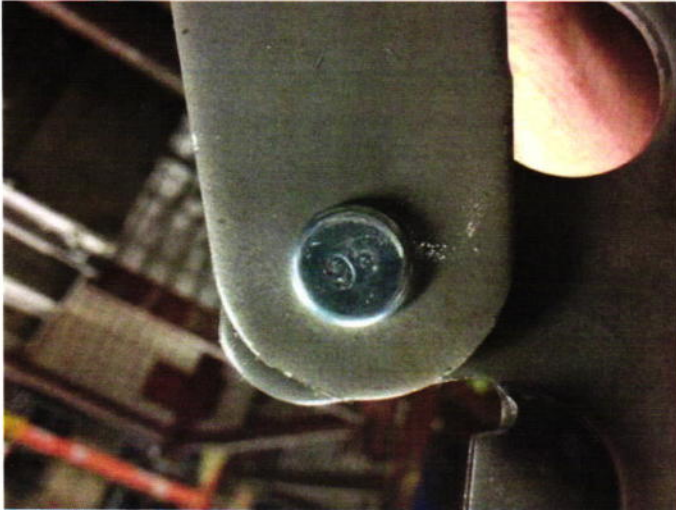
NOTE: Please use the following inspection procedure to determine your steps configuration and the relevant Service Repair Procedure "Appendix".

# SRP 1502 – 0001 (CONTINUED)

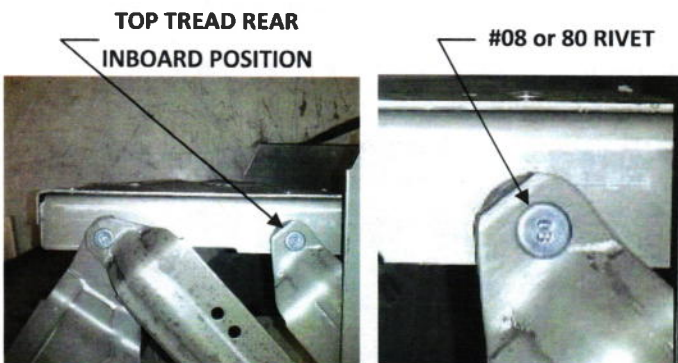
5.1 **CONFIGURATION "A"** - HSM RV Step with a shipping date between October 18<sup>th</sup>, 2012 and February 14<sup>th</sup>, 2014.

5.1.1 This configuration has a hinge point rivet marked with the #96 at the 2<sup>nd</sup> & 3<sup>rd</sup> Step (2<sup>nd</sup> & 3<sup>rd</sup> step, defined as the 2<sup>nd</sup> step from the ground level and the 3<sup>rd</sup> step from the ground level).

**HINGE POINT RIVET MARKED #96 @ 2<sup>nd</sup> & 3<sup>rd</sup> STEP**



5.1.2 And a Top Tread mount point rivet marked with the # 08 or 80 at the rear inboard mounting position, both left and right sides.



**NOTE: CONFIGURATION "A" - MUST BE REPAIRED IN ACCORDANCE WITH SRP-APPENDIX "A" .**

## **REPAIR PROCEDURE SELECTION:**

*Upon confirmation of the step manufacturer and step configuration, please select the appropriate Service Repair Procedure Appendix, "A" or "B" and conduct the appropriate repairs.*

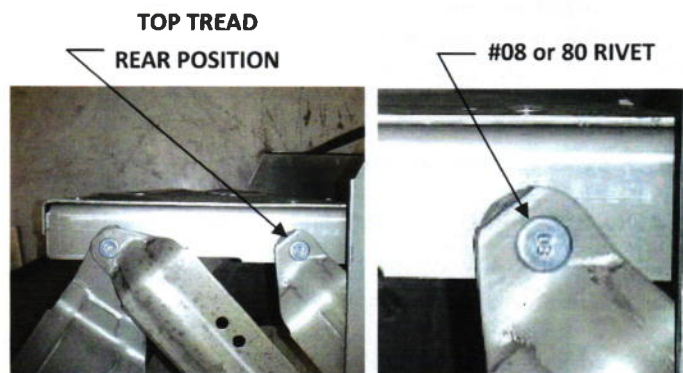
5.2 **CONFIGURATION "B"** - HSM RV Step with a shipping date between February 16<sup>th</sup>, 2014 and January 9<sup>th</sup>, 2015.

5.2.1 This configuration has a hinge point rivet marked with the #55 at the 2<sup>nd</sup> & 3<sup>rd</sup> Step (2<sup>nd</sup> & 3<sup>rd</sup> step, defined as the 2<sup>nd</sup> step from the ground level and the 3<sup>rd</sup> step from the ground level).

**HINGE POINT RIVET MARKED #55 @ 2<sup>nd</sup> & 3<sup>rd</sup> STEP**



5.2.2 And a Top Tread mount point rivet marked with the # 08 or 80 at the rear inboard mounting position, both left and right sides.



**NOTE: CONFIGURATION "B" - MUST BE REPAIRED IN ACCORDANCE WITH SRP-APPENDIX "B" .**

## RV QUAD STEP 24” x 8 x 8 - Hinge Point Rivet Replacement #96 @ 2nd & 3rd Step & Top Tread Mount Rivet #08 @ Inboard Mounting Position, LH & RH

### **ACTION:**

*This Appendix Addresses Step Configuration “A”:*

HSM has determined that the rivet marked as #96, which connects the 2nd and 3rd step at the hinge point (2nd and 3rd step, defined as the 2nd step from the ground level and the 3rd step from the ground level) of the Quad step, may shear or pull out under load.

HSM has further determined that the inboard rivets marked as #08 or 80, which connect the Top Step Tread (top step, defined as the 4th step from the ground level) to the upper hinge bracket of the Quad step, may shear or pull out under load.

Please note, these rivet numbers may be utilized at other locations within the step assembly. These other rivet locations are not affected by this recall and should be considered safe under continued use.

The affected population of potentially defective products shipped to HSM customers between the dates of October 18<sup>th</sup>, 2012 and February 14<sup>th</sup>, 2014 .

### **TOOLS REQUIRED:** (Configuration “A”)

- (1EA.) - SAFETY GLASSES
- (1PR.) - MECHANICS GLOVES
- (1EA.) - AIR DRILL, 1/2” CHUCK
- (1EA.) - DRILL BIT, METAL- 3/8”
- (1EA.) - AIR RATCHET WRENCH, SQ DRIVE 3/8”
- (1EA.) - TORQUE WRENCH 3/8” DRIVE
- (2EA.) - 9/16” SOCKET, 3/8” DRIVE
- (1EA.) - 5/8” WRENCH, BOXED END
- (1EA.) - DRIFT PUNCH 1/4” DIA.
- (1EA.) - 16 oz. BALLPEEN HAMMER

### **PARTS REQUIRED:** HSM KIT # 185405

#### **2nd & 3rd STEP HARDWARE REQ'D: # 96 RIVET KIT**

- (2EA.) - SCREW, CAP HEX HD G5 3/8-18 UNC 1.00 GRIP LGTH = 0.58
- (2EA.) - WASHER, 1.00 OD x .390 ID x .060 THK 660 NYLON
- (2EA.) - STEEL FLAT WASHER, 3/8 TYPE A—WIDE
- (2EA.) - STOVER NUT, 3/8-16

#### **TOP STEP HARDWARE REQ'D: # 08/80 RIVET KIT**

- (2EA.) - SCREW, CAP HEX HD G5 3/8-16 UNC 1.25 GRIP LGTH = 0.64
- (2EA.) - SPACER, 1.00 OD x .390 ID x .395 THK 660 NYLON
- (2EA.) - STEEL FLAT WASHER, 3/8 TYPE A—WIDE
- (2EA.) - STOVER NUT, 3/8-16

- (1EA.) - Paint, Rust-Oleum Protective Enamel Spray Gloss Black  
(Not Included W/ Parts Kit)

**NOTE:** The HSM Parts Kit # 185405 contains parts to service all step configurations. Part utilization is dependent upon the step configuration; therefore there will be unused parts upon completion of the service work.

### **SERVICE REPAIR PROCEDURE:**

#### **“ATTENTION”**

**“DO NOT USE THE RV STEP DURING THE REPAIR PROCESS”**

**“MAKE SURE THE ENTRY DOOR IS IN THE CLOSED POSITION DURING THIS PROCEDURE”**

**SAFETY GLASSES MUST BE WORN AT ALL TIMES DURING THIS REPAIR PROCEDURE.**

1. Vehicle Staging - Stage the vehicle in a level, clean and dry area.
2. Secure for Service - Place wheel chocks at each axle to ensure that the vehicle can not move during the service procedure.

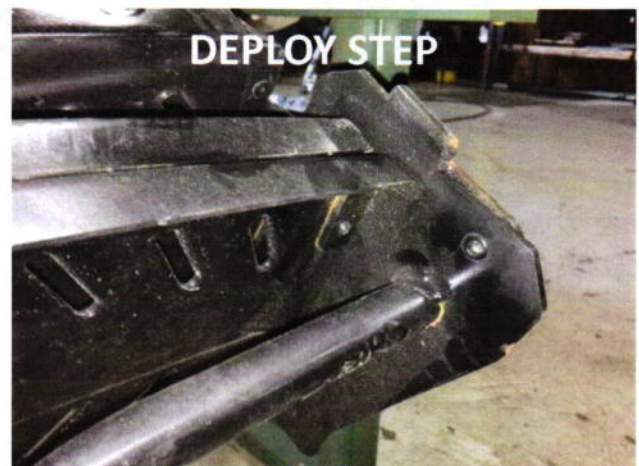
### **RIVET REMOVAL / BOLT INSTALL @ 2nd & 3rd STEP**

3. In accordance with the following procedures, remove the RH Rivet first and install the bolt set. Repeat steps 4.1 thru 4.4 and 5.1 thru 5.4 for the LH Rivet.

**NOTE: ONLY REPLACE ONE RIVET JOINT AT A TIME, THIS WILL MAKE REASSEMBLY EASIER!**

- 3.1 Deploy the RV Step - Partially deploy the RV Step from the stowed position, extending it outward approximately 6”. This will position the hinge rivet in the best position for removal.

**NOTE: “Do not unfold any of the step treads from their stowed position”.**



## SRP 1502 – 0001

4.1 Drill The Rivet - Using a 3/8" drill bit, drill out the hinge rivet on the inner side of the step.

### DRILL RIVET



4.2 Remove Rivet - Remove the hinge rivet from the step bracket. If necessary use the 1/4" Drift Punch and Ballpeen Hammer to drive the Rivet from the mounting hole.

### REMOVE RIVET



4.3 Disconnect Step - With the rivet now removed, disconnect the lower step (step treads 1 and 2) from the step assembly.

## APPENDIX "A" (CONTINUED)

### DISCONNECT STEP



4.4 Enlarge hole of the inner bracket using 3/8" drill bit. This hole must be enlarged for the 3/8" hex head bolt.

### ENLARGE HOLE



# SRP 1502 – 0001

## RV STEP REASSEMBLY @ HINGE POINT 2 & 3 STEP

5. In accordance with the following procedures, reassemble the RH Bolt first and then repeat steps 5.1 thru 5.4 for the LH Rivet.

### **REQUIRED FASTENERS FOR 2nd & 3rd STEP HINGE JOINT**

#### To Replace 96 Rivet

- (2EA.) - SCREW, CAP HEX HD G5 3/8-18 UNC 1.00 GRIP LGTH = 0.58
- (2EA.) - WASHER, 1.00 OD x .390 ID x .060 THK 660 NYLON
- (2EA.) - STEEL FLAT WASHER, 3/8 TYPE A—WIDE
- (2EA.) - STOVER NUT, 3/8-16
- (1EA.) - Paint, Rust-Oleum Protective Enamel Spray Gloss Black  
(Not Included W/ Parts Kit)

5.1 Align The Step - Align the step mounting hole at the RH side of the step. If necessary insert the 1/4" Drift Punch through the hinge hole as an alignment guide.

5.2 Insert Nylon Washer - Insert Nylon Washer between the lower step hinge bracket and the upper step hinge bracket.

5.3 Insert Bolt (3/8" x 1" long bolt to replace 96 rivet) - From outside of the lower step hinge bracket, insert bolt through the hinge bracket hole, the Nylon Washer and the upper step hinge bracket hole. This should place the threaded end of the bolt toward the interior of the step assembly.

**Note: Make sure the Nylon washer is located between the inner and outer brackets.**

## **INSERT BOLT & WASHER**



# APPENDIX "A" (CONTINUED)

5.4 Install Flat Washer and Stover Nut onto end of bolt.

**NOTE: Install to 12-16 ft. lbs. of torque for proper step operation.**

## **INSERT NUT & WASHER**



## RIVET REMOVAL/BOLT INSTALL @ TOP STEP

6. In accordance with the following procedures, remove the RH Rivet first and install the bolt set. Repeat steps 7.1 thru 7.3 and 8.1 thru 8.4 for the LH Rivet.

**NOTE: ONLY REPLACE ONE RIVET JOINT AT A TIME, THIS WILL MAKE REASSEMBLY EASIER!**

6.1 Deploy the RV Step - Deploy the RV Step from the stowed position, extending it outward to a resting position. This will position the Top Tread rivet in the best position for removal.

## **DEPLOY STEP**

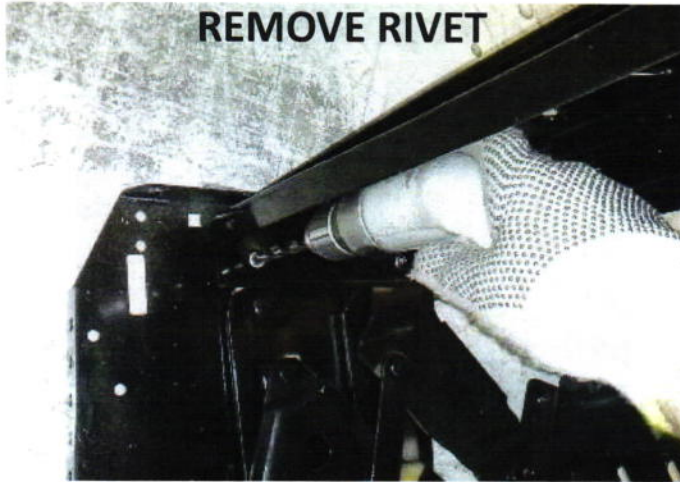


# SRP 1502 – 0001

# APPENDIX “A” (CONTINUED)

**NOTE:** “Do not unfold any of the step treads from their stowed position”.

7.1 Drill The Rivet - Position yourself below the step, then using an air drill with a 3/8” drill bit, drill through the flange area of the Top Tread inboard rivet.



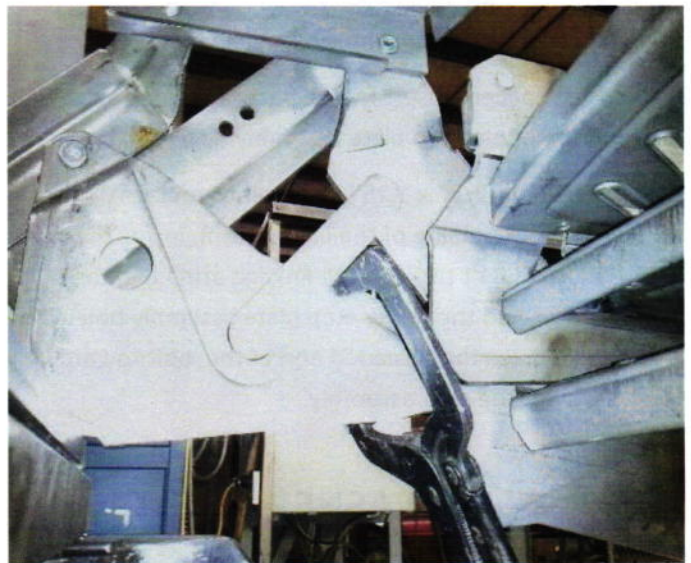
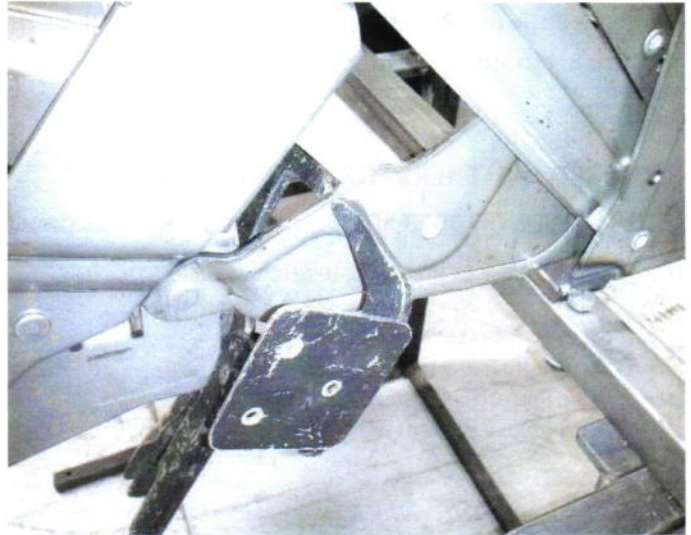
7.2 Remove Rivet - Remove the mounting rivet from the step bracket. If necessary use the 1/4” Drift Punch and Ballpeen Hammer to drive the Rivet from the mounting hole.

7.3 Enlarge hole of step plate assembly using a 3/8” drill bit. The linkage arm can be used as a guide by lifting up steps with one hand to line up holes of linkage arm and step plate assembly.

## ENLARGE HOLE



7.3.1 (Optional) Clamps can also be used as shown below to clamp step in position .



# SRP 1502 – 0001

## TOP STEP TREAD REASSEMBLY

8. In accordance with the following procedures, reassemble the RH Bolt first and then repeat steps 8.1 thru 8.4 for the LH Rivet.

### **REQUIRED FASTENERS FOR THE TOP STEP TREAD MOUNT - # 08/80 RIVET KIT**

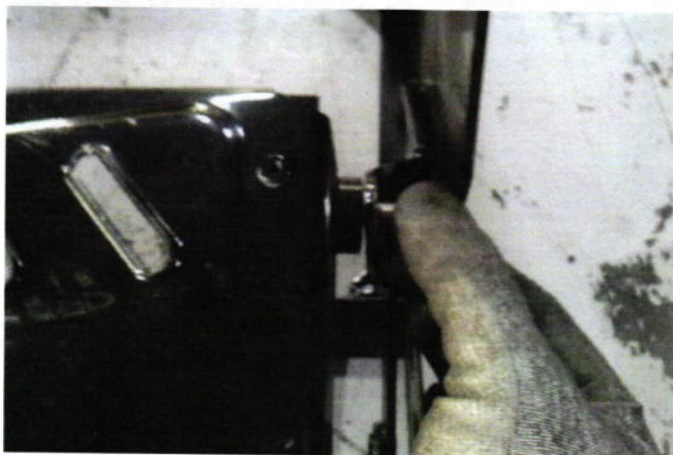
- (2EA.) - SCREW, CAP HEX HD G5 3/8-16 UNC 1.25 GRIP LGTH = 0.64
- (2EA.) - SPACER, 1.00 OD x .390 ID x .395 THK 660 NYLON
- (2EA.) - STEEL FLAT WASHER, 3/8 TYPE A—WIDE
- (2EA.) - STOVER NUT, 3/8-16
- (1EA.) - Paint, Rust-Oleum Protective Enamel Spray Gloss Black  
(Not Included W/ Parts Kit)

8.1 Align The Step - Align the step mounting hole at the RH side of the step. If necessary insert the 1/4" Drift Punch through the linkage hole as an alignment guide.

8.2 Insert Spacer - Insert Nylon Spacer between linkage arm and the upper step plate assembly.

8.3 Insert Bolt (3/8" x 1.25" long bolt to replace 08 or 80 rivet) - From outside of the linkage arm, insert the 3/8" Hex Head Bolt through the linkage arm hole, the Nylon Spacer and the upper step plate assembly hole. This should place the threaded end of the bolt toward the interior of the step assembly.

### **INSERT WASHER / BOLT**

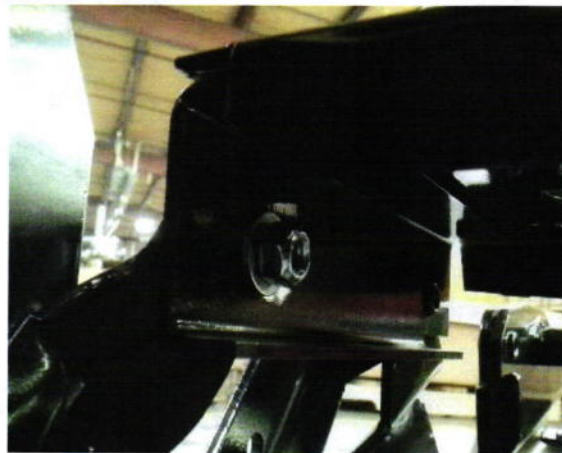


# APPENDIX "A" (CONTINUED)

8.4 Install Flat Washer and Lock Nut - Install the 3/8" Flat Washer and 3/8" Stover Nut onto the end of the 3/8" Hex Head Bolt.

**NOTE: Tighten the Stover Nut to 12-16 ft. lbs. of torque for proper step operation.**

### **INSTALL FLAT WASHER / NUT**



9. Refinish Paint - Refinish painted surface at the repaired areas of the step, as needed.



## RV QUAD STEP 24” x 8 x 8 - Hinge Point Rivet Replacement #55 @ 2nd & 3rd Step & Top Tread Mount Rivet #08 @ Inboard Mounting Position, LH & RH

### ACTION:

This Appendix Addresses Step Configuration B:

HSM has determined that the rivet marked as #55, which connects the 2nd and 3rd step at the hinge point (2nd and 3rd step, defined as the 2nd step from the ground level and the 3rd step from the ground level) of the Quad step, may shear or pull out under load.

HSM has further determined that the inboard rivets marked as #08, which connect the Top Step Tread (top step, defined as the 4th step from the ground level) to the upper hinge bracket of the Quad step, may shear or pull out under load.

Please note, these rivet numbers may be utilized at other locations within the step assembly. These other rivet locations are not affected by this recall and should be considered safe under continued use.

The affected population of potentially defective products shipped to HSM customers between the dates of February 16th, 2014 and January 9th, 2015.

### TOOLS REQUIRED: (Configuration “B”)

- (1EA.) - SAFETY GLASSES
- (1PR.) - MECHANICS GLOVES
- (1EA.) - AIR DRILL, 1/2” CHUCK
- (1EA.) - DRILL BIT, METAL- 3/8”
- (1EA.) - DRILL BIT, METAL- 7/16”
- (1EA.) - AIR RATCHET WRENCH, SQ DRIVE 3/8”
- (1EA.) - TORQUE WRENCH 3/8” DRIVE
- (1EA.) - 9/16” SOCKET, 3/8” DRIVE
- (2EA.) - 9/16” WRENCH, BOXED END
- (1EA.) - 5/8” SOCKET, 3/8” DRIVE
- (1EA.) - 11/16” WRENCH, BOXED END

### PARTS REQUIRED: HSM KIT # 185405

#### **2nd & 3rd STEP HARDWARE REQ'D: # 55 RIVET KIT**

- (2EA.) - SCREW, CAP HEX HD G5 7/16-14 UNC 1.00 GRIP LGTH = 0.58
- (2EA.) - WASHER, 1.00 OD X .440 ID x .00 THK 660 NYLON
- (2EA.) - STEEL FLAT WASHER, 7/16 TYPE A—WIDE
- (2EA.) - STOVER NUT, 7/16-14

#### **TOP STEP HARDWARE REQ'D: # 08/80 RIVET KIT**

- (2EA.) - SCREW, CAP HEX HD G5 3/8-16 UNC 1.25 GRIP LGTH = 0.64
- (2EA.) - SPACER, 1.00 OD x .390 ID x .395 THK 660 NYLON
- (2EA.) - STEEL FLAT WASHER, 3/8 TYPE A—WIDE
- (2EA.) - STOVER NUT, 3/8-16

- (1EA.) - Paint, Rust-Oleum Protective Enamel Spray Gloss Black

**NOTE:** The HSM Parts Kit # 185405 contains parts to service all step configurations. Part utilization is dependent upon the step configuration; therefore there will be unused parts upon completion of the service work.

### SERVICE REPAIR PROCEDURE:

#### **“ATTENTION”**

**“DO NOT USE THE RV STEP DURING THE REPAIR PROCESS”**

**“MAKE SURE THE ENTRY DOOR IS IN THE CLOSED POSITION DURING THIS PROCEDURE”**

**SAFETY GLASSES MUST BE WORN AT ALL TIMES DURING THIS REPAIR PROCEDURE.**

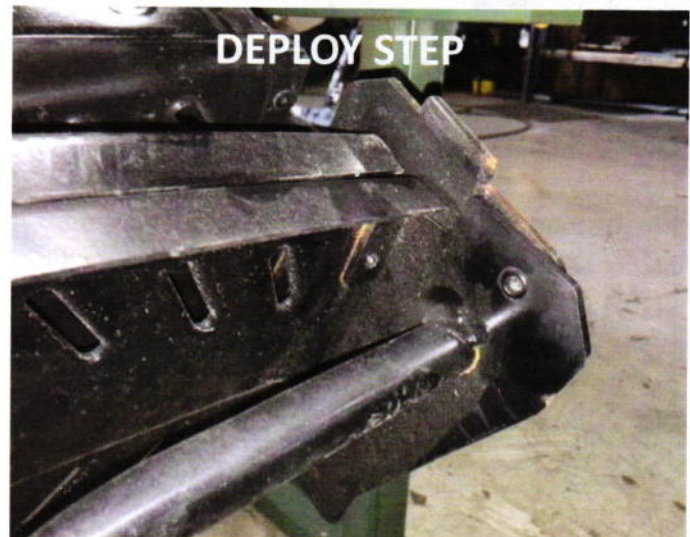
1. Vehicle Staging - Stage the vehicle in a level, clean and dry area.
2. Secure for Service - Place wheel chocks at each axle to ensure that the vehicle can not move during the service procedure.

### RIVET REMOVAL @ 2nd & 3rd STEP

3. In accordance with the following procedures, remove the RH Rivet first and then repeat steps 4.1 thru 4.4 for the LH Rivet.

- 3.1 Deploy the RV Step - Partially deploy the RV Step from the stowed position, extending it outward approximately 6”. This will position the hinge rivet in the best position for removal.

**NOTE:** “Do not unfold any of the step treads from their stowed position”.



# SRP 1502 – 0001

# APPENDIX “B” (CONTINUED)

4.1 Drill The Rivet - Using a 7/16” drill bit, drill out the hinge rivet on the inner side of the step.

## DRILL RIVET



4.2 Remove Rivet - Remove the hinge rivet from the step bracket. If necessary use the 1/4” Drift Punch and Ballpeen Hammer to drive the Rivet from the mounting hole.

## REMOVE RIVET



4.3 Disconnect Step - With the rivet now removed, disconnect the lower step (step treads 1 and 2) from the step assembly.

## DISCONNECT STEP



4.4 Enlarge hole of the inner bracket using 7/16” drill bit. This hole must be enlarged for the 7/16” hex head bolt.

## ENLARGE HOLE



# SRP 1502 – 0001

# APPENDIX “B” (CONTINUED)

## RV STEP REASSEMBLY @ HINGE POINT 2 & 3 STEP

5. In accordance with the following procedures, reassemble the RH Bolt first and then repeat steps 5.1 thru 5.4 for the LH Rivet.

### **REQUIRED FASTENERS FOR 2nd & 3rd STEP HINGE JOINT**

- 2nd & 3rd STEP HARDWARE REQ'D: # 55 RIVET KIT
- (2EA.) - SCREW, CAP HEX HD G5 7/16-14 UNC 1.00 GRIP LGTH = 0.58
- (2EA.) - WASHER, 1.00 OD X .440 ID x .0.0 THK 660 NYLON
- (2EA.) - STEEL FLAT WASHER, 7/16 TYPE A—WIDE
- (2EA.) - STOVER NUT, 7/16-14
- (1EA.) - Paint, Rust-Oleum Protective Enamel Spray Gloss Black  
(Not Included W/ Parts Kit)

5.1 Align The Step - Align the step mounting hole at the RH side of the step. If necessary insert the 1/4” Drift Punch through the hinge hole as an alignment guide.

5.2 Insert Nylon Washer - Insert Nylon Washer between the lower step hinge bracket and the upper step hinge bracket.

5.3 Insert Bolt (7/16” x 1” long bolt to replace 55 rivet) - From outside of the lower step hinge bracket, insert bolt through the hinge bracket hole, the Nylon Washer and the upper step hinge bracket hole. This should place the threaded end of the bolt toward the interior of the step assembly.

*Note: Make sure the Nylon washer is located between the inner and outer brackets.*

5.4 Install Flat Washer and Stover Nut onto end of bolt. Install to 12-16 ft. lbs. of torque for proper step operation.

## **INSERT NUT & WASHER**



## RIVET REMOVAL @ TOP STEP TREAD MOUNT

6. In accordance with the following procedures, remove the RH Rivet first and then repeat steps 7.1 thru 7.3 for the LH Rivet.

6.1 Deploy the RV Step - Deploy the RV Step from the stowed position, extending it outward to a resting position. This will position the Top Tread rivet in the best position for removal.

## **INSERT BOLT & WASHER**



## **DEPLOY STEP**

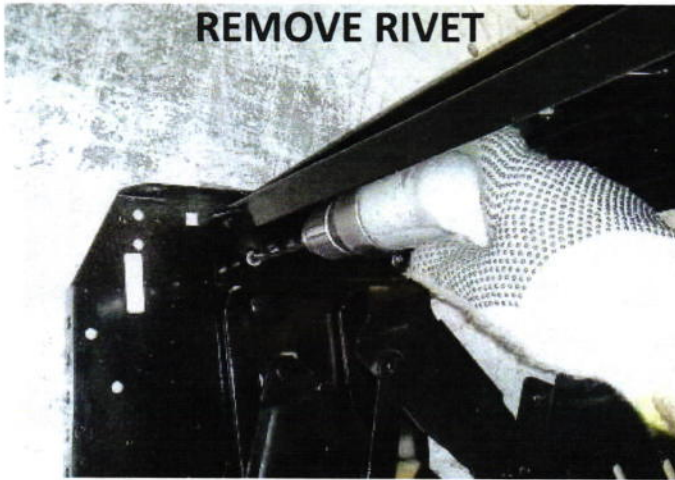


# SRP 1502 – 0001

# APPENDIX “B” (CONTINUED)

*NOTE: “Do not unfold any of the step treads from their stowed position”.*

7.1 Drill The Rivet - Position yourself below the step, then using an air drill with a 3/8” drill bit, drill through the flange area of the Top Tread inboard rivet.



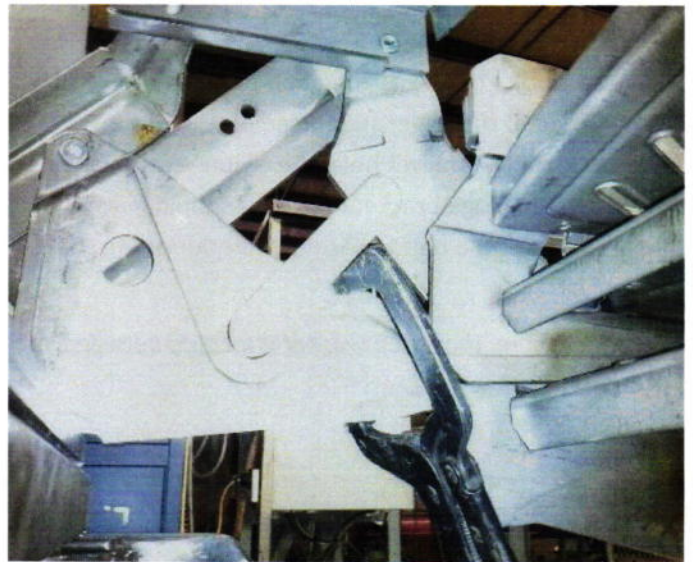
7.2 Remove Rivet - Remove the mounting rivet from the step bracket. If necessary use the 1/4” Drift Punch and Ballpeen Hammer to drive the Rivet from the mounting hole.

7.3 Enlarge hole of step plate assembly using a 3/8” drill bit. The linkage arm can be used as a guide by lifting up steps with one hand to line up holes of linkage arm and step plate assembly.

## ENLARGE HOLE



7.3.1 (Optional) Clamps can also be used as shown below to clamp step in position .



# SRP 1502 – 0001

# APPENDIX “B” (CONTINUED)

## TOP STEP TREAD REASSEMBLY

8. In accordance with the following procedures, reassemble the RH Bolt first and then repeat steps 8.1 thru 8.4 for the LH Rivet.

### **REQUIRED FASTENERS FOR THE TOP STEP TREAD MOUNT - TOP STEP HARDWARE REQ'D: # 08/80 RIVET KIT**

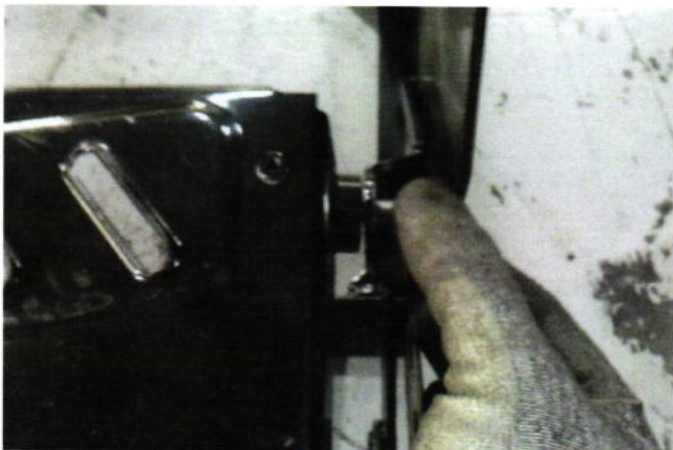
- (2EA.) - SCREW, CAP HEX HD G5 3/8-16 UNC 1.25 GRIP LGTH = 0.64
- (2EA.) - SPACER, 1.00 OD x .390 ID x .395 THK 660 NYLON
- (2EA.) - STEEL FLAT WASHER, 3/8 TYPE A—WIDE
- (2EA.) - STOVER NUT, 3/8-16
- (1EA.) - Paint, Rust-Oleum Protective Enamel Spray Gloss Black (Not Included W/ Parts Kit)

8.1 Align The Step - Align the step mounting hole at the RH side of the step. If necessary insert the 1/4" Drift Punch through the linkage hole as an alignment guide.

8.2 Insert Spacer - Insert Nylon Spacer between linkage arm and the upper step plate assembly.

8.3 Insert Bolt (3/8" x 1.25" long bolt to replace 08 rivet) - From outside of the linkage arm, insert the 3/8" Hex Head Bolt through the linkage arm hole, the Nylon Spacer and the upper step plate assembly hole. This should place the threaded end of the bolt toward the interior of the step assembly.

## **INSERT WASHER / BOLT**



- 8.4 Install Flat Washer and Lock Nut - Install the 3/8" Flat Washer and 3/8" Stover Nut onto the end of the 3/8" Hex Head Bolt. Tighten the Stover Nut to 12-16 ft. lbs. of torque for proper step operation.

## **INSTALL FLAT WASHER / NUT**



9. Refinish Paint - Refinish painted surface at the repaired areas of the step, as needed.

