

Quadratec® QR3 & QR4 Tubular Side Step Bars

Installation Manual for '19-Current JT Gladiator Vehicles
#12004.30X4



⚠ WARNING ⚠

TO REDUCE RISK OF SERIOUS INJURY OR PROPERTY DAMAGE: READ ALL SAFETY MESSAGES AND UNDERSTAND ALL INSTRUCTIONS AND PROCEDURE NOTICES BEFORE ATTEMPTING TO INSTALL OR USE THIS PRODUCT. FOLLOW ALL INSTRUCTIONS AND WARNINGS WITH PRODUCT & VEHICLE OWNERS MANUAL.

⚠ CAUTION ⚠

THIS PRODUCT IS INTENDED TO REDUCE RISK OF OFF-ROAD BODY PANEL DAMAGE AND ASSIST IN ENTRY/EXIT FROM VEHICLE. YOUR TUBE STEP IS NOT INTENDED TO INCREASE OCCUPANT PROTECTION OR REDUCE VEHICLE DAMAGE IN EVENT OF ACCIDENT.

⚠ CAUTION ⚠

PROPERLY TORQUE AND RECHECK FASTENERS AND SECURITY OF STEP TREAD AFTER 250 MILES AND FREQUENTLY THEREAFTER. INSPECT AND DO NOT USE TUBE STEP IF DAMAGED.

NOTICE

DO NOT USE TUBE STEP AS WINCH/SELF-RECOVERY ATTACHMENT POINT.

CHECK STATE AND LOCAL HIGHWAY SAFETY LAWS REGARDING PERMITTED ON-ROAD EQUIPMENT.

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A Few Words About Product Safety:

Your Side Tube Steps are designed to enhance the utility and enjoyment of your off road capable vehicle. Before installation, please take a moment to review the following safety information

and installation instructions. Important safety information is generally preceded by one of three signal words indicating the relative risk of injury.

The signal words mean:

⚠ WARNING ⚠	a hazardous situation which, if not avoided, could result in death or serious injury. You CAN be KILLED or SERIOUSLY HURT if you don't follow instructions.
⚠ CAUTION ⚠	a hazardous situation which, if not avoided, could result in minor or moderate injury. You CAN be moderately HURT and also may suffer property damage if you don't follow instructions.
NOTICE	Careful attention is required to this instruction or operation but does generally not relate to personal injury. Damage to your Quadratec® product or other property may result if you don't follow instructions.

Before You Begin Installation:

Congratulations on your purchase of the Quadratec Tubular Side Steps for your Jeep® Gladiator.

Due to the length and bulk of these steps, we strongly suggest you get the help of a friend for steps that involve lifting, locating or holding the side steps during installation.

When unpacking, check to make sure all parts are included and not damaged due to shipping. If any part is missing or broken, please call Customer Service at 800-745-6037 as soon as possible.

Thank you again for your purchase and let's start the installation process.

NOTICE	As you unpack your tube side steps, be careful not to scratch the finish with a knife or razor. We suggest placing the unpacked bumper back into the original box so it does not get scratched before the installation begins. It is highly recommended that a second person assist with the installation of these tube side steps.
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Product Care and Maintenance:

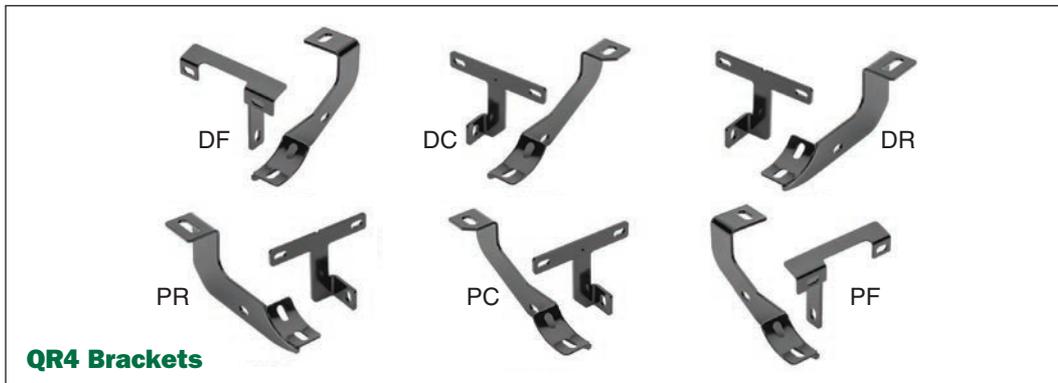
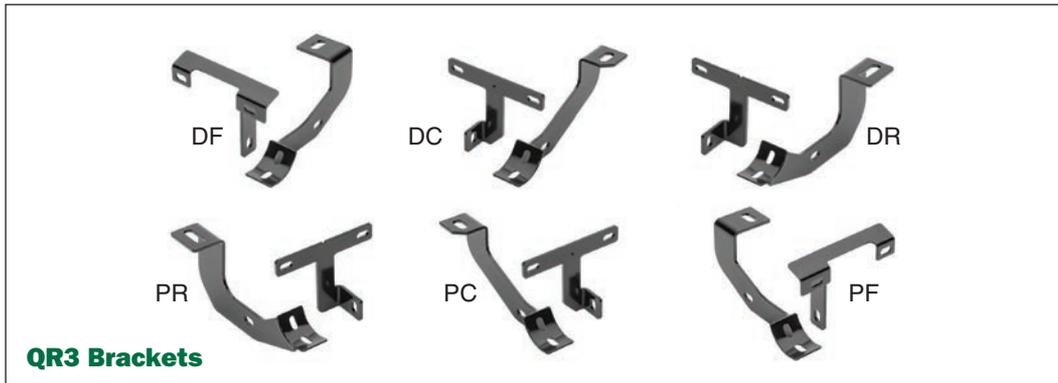
These custom fit steps have been designed for long life and great looks. With proper care, they are designed to provide years of use.

<p>REQUIRED TOOLS:</p> <p>Safety Glasses</p> <p>10mm, 13mm & 17mm Socket & Driver</p> <p>10mm & 16mm Wrenches</p> <p>Torque Wrench</p>

Please see page 7 in this instruction booklet for all suggested care for your Quadratec Side Tube Steps.



Installation Hardware:



PARTS LIST:

Driver (Left) Side Step	QTY 1
Passenger (Right) Side Step	QTY 1
Mounting Brackets: (see above)	
PF) Passenger Front:	QTY 1
PC) Passenger Center:	QTY 1
PR) Passenger Rear:	QTY 1
DF) Driver Front:	QTY 1
DC) Driver Center:	QTY 1
DR) Driver Rear:	QTY 1

Hex Bolts:

(A) 10 X 30mm bolt	QTY 6
(B) 8 X 35mm bolt	QTY 6
(C) 6 X 25mm bolt	QTY 12
(D) 8 X 25mm w/Captive Washer	QTY 12

Nylon Lock Nuts:

(E) 10mm nylock nut	QTY 6
(F) 6mm nylock nut	QTY 12

Flat Washers:

(G) 10mm flat washer	QTY 12
(H) 8mm flat washer	QTY 6
(I) 6mm flat washer	QTY 24

Lock Washers:

(J) 8mm lock washer	QTY 6
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Installation: QR3 or QR4 Mounting (Passenger side illustrated)

NOTICE

You must remove factory installed "Rock Rails", side steps or running boards before installation of your new Side Tube Steps.

NOTICE

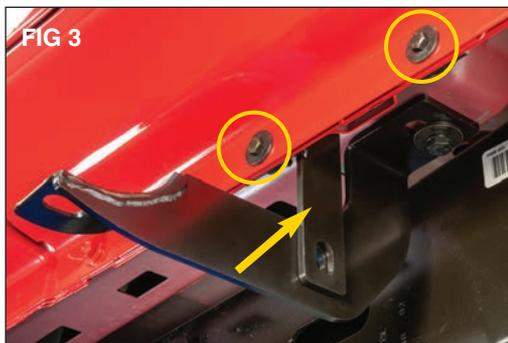
This instruction sheet covers the installation of both the 3" round tube steps as well as the 4" Oval Tube steps for Jeep Gladiator. Photos in this instruction booklet are shown on a JL Wrangler 4 Door. Installation is identical for Wrangler & Gladiator in both tube diameters.



Put on safety glasses. Starting at the front of vehicle locate the vertical threaded hole behind the pinch weld. (FIG 1)



Align the hole in the step mounting bracket (PF) and loosely install using a 8 x 35mm bolt (B), lock washer (J) and flat washer (H). (FIG 2)



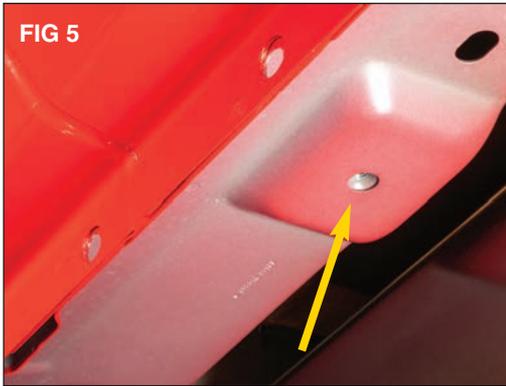
Locate and loosely install the front support bracket (in front) using 6mm hex head bolts (B) through the pinch weld with washers (I) on both sides and secure with a 6mm nylock nut (F) using a 10mm hex wrench and a 10mm socket. (FIG 3)



Next align the mounting slots between the two brackets and loosely install a 10mm bolt (A) with washers (G) on both sides and secure with a 10mm nylock nut (E) using a 16mm hex wrench and a 17mm socket. (FIG 4)

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Installation: QR3 or QR4 Mounting (Passenger side illustrated)



At the center of vehicle locate the vertical threaded hole behind the pinch weld. (FIG 5)



Align the hole in the step mounting bracket (PM) and loosely install using a 8 x 35mm bolt (B), lock washer (J) and flat washer (H). (FIG 6)

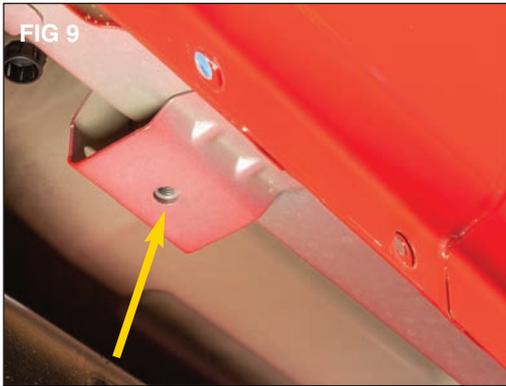


Locate and loosely install the center support bracket using 6mm hex head bolts (B) through the pinch weld with washers (I) on both sides and secure with a 6mm nylock nut (F) using a 10mm hex wrench and a 10mm socket. (FIG 7)



Next align the mounting slots between the two brackets and loosely install a 10mm bolt (A) with washers (G) on both sides and secure with a 10mm nylock nut (E) using a 16mm hex wrench and a 17mm socket. (FIG 8)

Installation: QR3 or QR4 Mounting (Passenger side illustrated)



At the rear of vehicle locate the vertical threaded hole behind the pinch weld. (FIG 9)



Align the hole in the step mounting bracket (PR) and loosely install using a 8 x 35mm bolt (B), lock washer (J) and flat washer (H). (FIG 10)



Locate and loosely install the rear support bracket using 6mm hex head bolts (B) through the pinch weld with washers (I) on both sides and secure with a 6mm nylock nut (F) using a 10mm hex wrench and a 10mm socket. (FIG 11)



Next align the mounting slots between the two brackets and loosely install a 10mm bolt (A) with washers (G) on both sides and secure with a 10mm nylock nut (E) using a 16mm hex wrench and a 17mm socket. (FIG 12)

Installation: QR3 or QR4 Mounting (Passenger side illustrated)



Now align the step with mounting bracket holes as shown. (FIG 13)



Loosely install the 8mm bolt with captive washer (D) using a 13mm socket. (FIG 14)

Ensuring that the step is level to the body, slowly tighten the 8mm bolts behind pinch weld on the front and rear mounting brackets. Next, tighten all 6mm hardware so the support brackets are on center with pinch weld holes.

Now tighten the 10mm hardware securing the brackets to each other. Lastly tighten the 8mm captive washer bolts to tube step. Each bolt is tightened to the Torque Specs shown below.

NOTICE

Torque for 6mm Button Head Bolt (hardware C & F) = 8 ft-Lbs
Torque for 8mm Hex Head Bolt (hardware B) = 16 ft-Lbs
Torque for 10mm Hex Head Bolt (hardware A & E) = 37 ft-Lbs

Repeat steps on the driver side. Installation is now complete.

Your Tube Steps have been designed and manufactured to provide years of use. However, like any product, general maintenance is required to keep it looking new. Because the steps are located

on the underside of the vehicle, they are subject to potential rock chips and other debris potentially causing paint to chip off. For touch ups, we recommend using a textured black spray paint sprayed on a piece of cardboard and cotton swab to gently fill in these chips. This will prevent any rust from forming.

Quadratec® Exclusive Three Year Limited Warranty

Your Quadratec® branded accessories are covered by the following Limited Warranty provided exclusively by Quadratec, Inc., 1028 Saunders Lane, West Chester PA 19380.

This Limited Warranty is the only warranty made in connection with your purchase. Quadratec neither assumes nor authorizes any vendor, retailer or other person or entity to assume for it any other obligation or liability in connection with this product or Limited Warranty. This Limited Warranty does not apply and is not cumulative to any accessory or part distributed by Quadratec for which the Manufacturer provides a separate written warranty.

What is Covered: Subject to the terms, exclusions and limitations herein and with respect only to Quadratec branded accessories first sold in the United States, Quadratec warrants to the initial retail purchaser only that your Quadratec accessory shall be free of defects in material and workmanship: for a period of three (3) years from date of retail purchase.

This Limited Warranty is not assignable and shall terminate upon sale of the vehicle upon which the Quadratec accessory is installed or other transfer third persons.

All other warranties are hereby disclaimed, except to the extent prohibited by applicable law in which case any implied warranty of merchantability or fitness for a particular purpose on this product is limited to 3 year from date of initial retail sale. Quadratec reserves the rights to: (a.) require invoice or other proof your accessory is within the terms of this Limited Warranty as a condition of warranty service and, (b.) make future revisions to this product and Limited Warranty without prior notice or obligation to upgrade your product.

What is Not Covered:
Your Quadratec Limited Warranty does not cover products or parts Quadratec determines to have been damaged by or subjected to:

(a.) installation damage, alteration, modification, combination with other parts, failure to maintain or improper repair or service, (b.) normal wear & tear, cosmetic damage or damage from moisture or water immersion, (c.) Acts of God, accidents, misuse, negligence, inadequate mounting or impact with vehicle(s), obstacles or other aspects of the environment, (d.) theft, vandalism or other intentional damage.

Remedy Limited to Repair/Replacement:
The exclusive remedy provided hereunder shall, upon Quadratec inspection and at Quadratec's option, be either repair or replacement of product or parts (new or refurbished) covered under this Limited Warranty. Customers requesting warranty consideration should first contact Quadratec to obtain a RGA number (610-701-3336). All labor, removal, shipping and installation costs are customer's responsibility.

Other Limitations - Exclusion of Damages - Your Rights Under State Law:
In consideration of the purchase price paid, neither Quadratec nor any independent Quadratec distributor/licensee are responsible for any time loss, rental costs, or for any incidental, consequential, punitive or other damages you may have or incur in connection with any part or product purchased. Your exclusive remedy hereunder for covered parts is repair/replacement as described above.

This Limited Warranty gives you specific rights. You may also have other rights that vary from state to state. For example, some states do not allow limitations of how long an implied warranty lasts and /or do not allow the exclusion or limitation of incidental or consequential damages, so the limitations and exclusions herein may not apply to you.

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