

# Installation Instructions

## Steel Service Body LADDER RACK Model 1503005

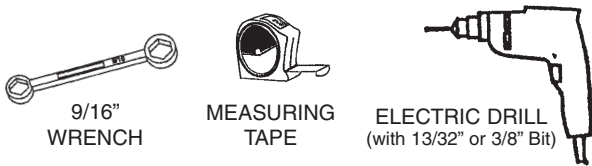
### Bill of Materials

QTY.	DESCRIPTION
2	Front Posts
2	Rear Posts
4	Siderails
1	Rear Cross Bar
1	Blank Cross Bar
1	Cross Bar with clamp
1	Cross Bar Ends
6	Clamps
5	3/8"-16 x 5/8" Hex Head Bolt
36	3/8"-16 x 1" Carriage Bolt
36	3/8"-Hex Nuts
36	3/8"-Lock Washer
36	3/8"-Flat Washer
2	Locking Pins

**NOTE: Front Posts have welded NUTS**  
**Rear Posts have through holes**



### Tools Needed for Assembly



9/16"  
WRENCH

MEASURING  
TAPE

ELECTRIC DRILL  
(with 13/32" or 3/8" Bit)

**READ ALL INSTRUCTIONS  
 BEFORE STARTING ANY  
 INSTALLATION**



CARRIAGE  
BOLT



5/8" HEX  
HEAD SET BOLT



NUT



CLAMP



LOCK  
WASHER



FLAT  
WASHER

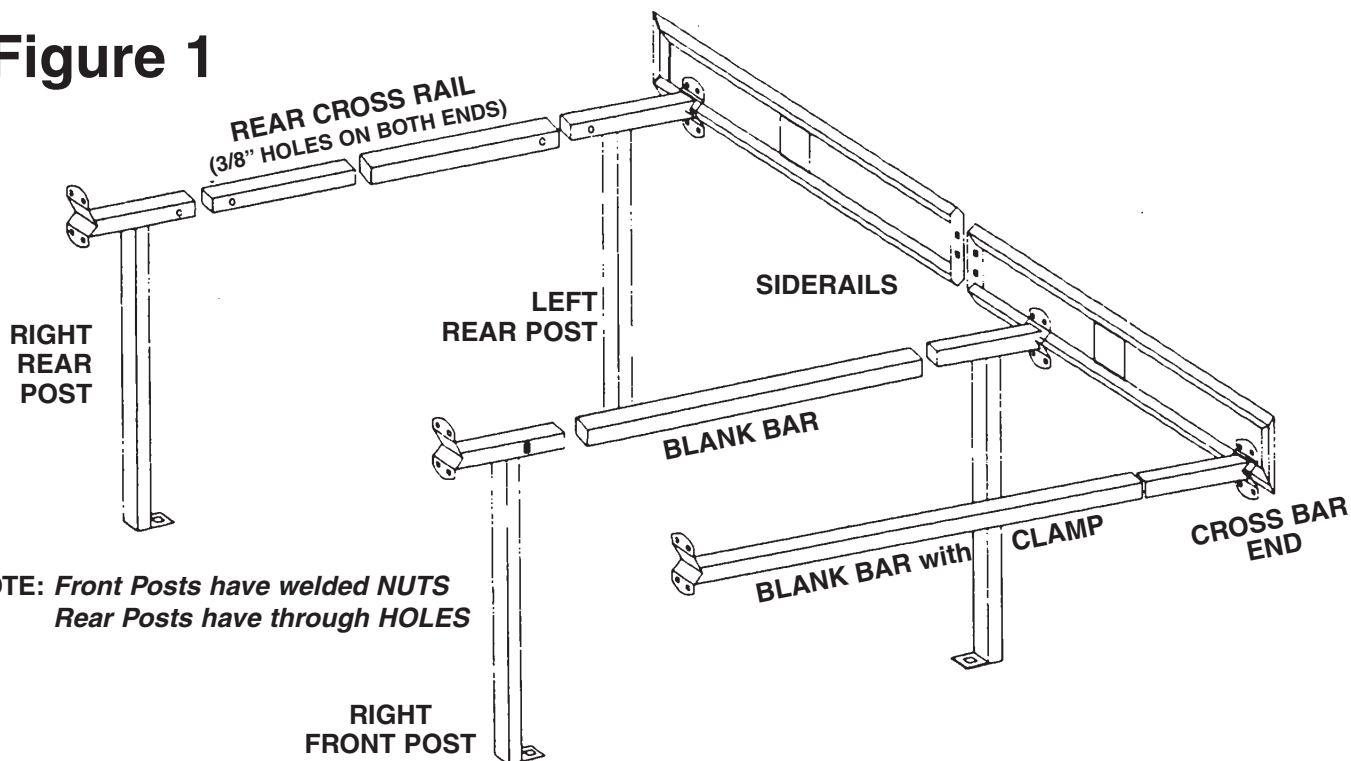


LOCKING  
PIN



**CAREFULLY INSPECT  
 AREAS TO BE  
 DRILLED ON  
 VEHICLE PRIOR TO  
 DRILLING ANY HOLES  
 FOR POSSIBLE  
 HAZARDS  
 AND OBSTRUCTIONS**

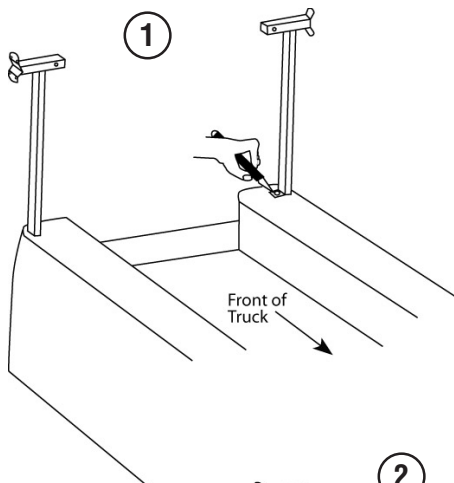
**Figure 1**



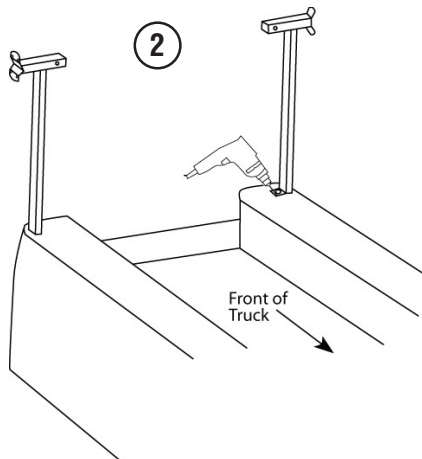
**NOTE: Front Posts have welded NUTS  
Rear Posts have through HOLES**

**Assembly**

**1.** Check the inside of the utility box for any possible obstructions and position the left and right rear corner post as desired, ideally as far back and as far out as possible. Mark where holes are to be drilled on the utility box.

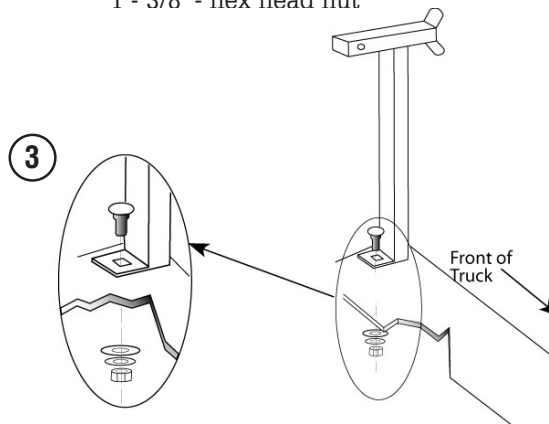


**2.** Using a 13/32" or 3/8" drill bit, drill holes (4) where marked.



**3.** Mount rear posts to utility box. Secure using (per hole):

- 1 - 3/8" - 16 x 1" carriage bolt
- 1 - 3/8" - flat washer
- 1 - 3/8" - lock washer
- 1 - 3/8" - hex head nut



**4.** After rear posts are secured and tightened with a 9/16" wrench, identify the Rear bar (telescoping tube with 3/8" pre-drilled holes on either end), and insert into left & right rear post making sure:

- A. Tubes are compatible and match.
- B. Pre-drilled holes match those on corner posts
- C. Welded nuts face down

**5.** Secure **Rear Bar to Rear Posts** using Locking pins, and hand tighten 3/8" hex head set bolts into the weld nuts on the underside of the bars & posts.

**6.** Position left front post as desired, ideally as far forward as possible and in line with the left rear post. Mark where the holes are to be drilled on the utility box.

**7.** Insert one end of the **Blank Bar** into installed front left post, and the other end into the right post. Secure right front post at this time. If Blank Bar is too long, you will need to trim it at this time.

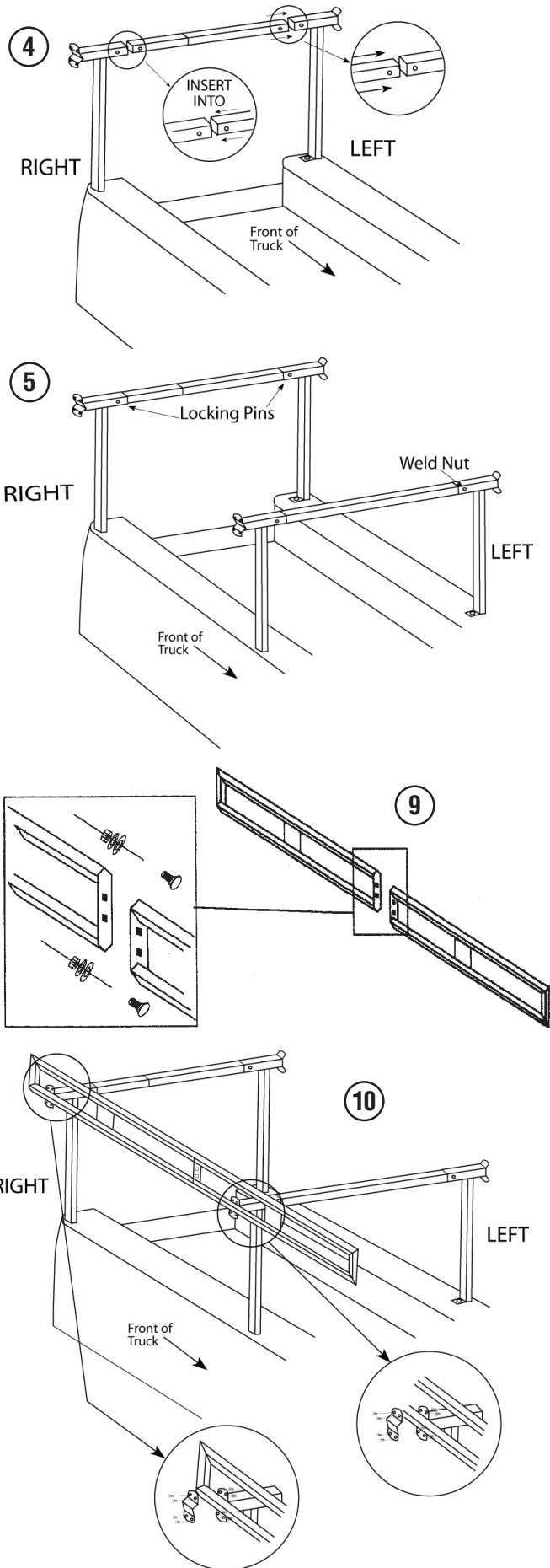
**8.** Insert hex head set bolt into all weld nuts and hand tighten at this time.

**9.** Bolt two Side Rails together to make a full length side rail assembly. Repeat for the second rail. Please note the direction of the labels and assemble rails so they face the same way. (see below)

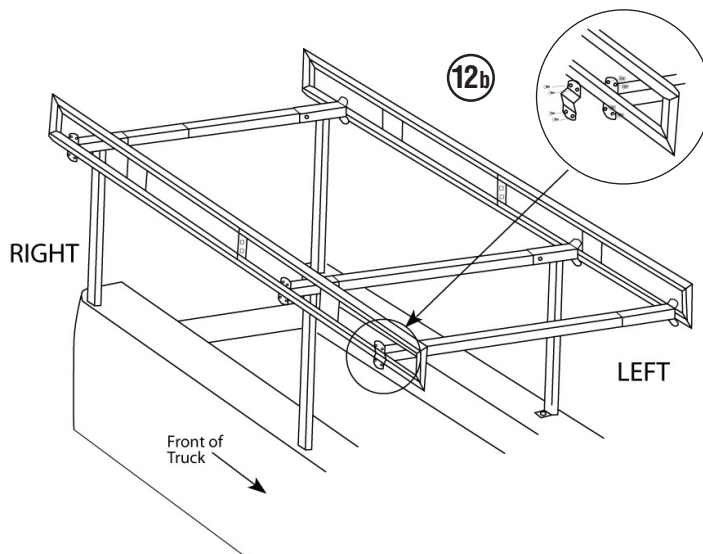
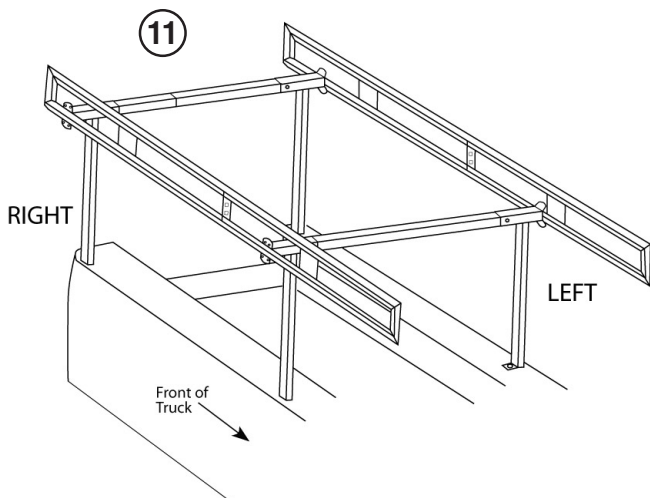
- Secure with the following: (per side)
- 2-3/8" - 16x1" Carriage bolt
  - 2-3/8" - flat washer
  - 2-3/8" - lock washer
  - 2-3/8" - hex head nut

**Step 10 may require the help of another person to lift side rail and secure to posts.**

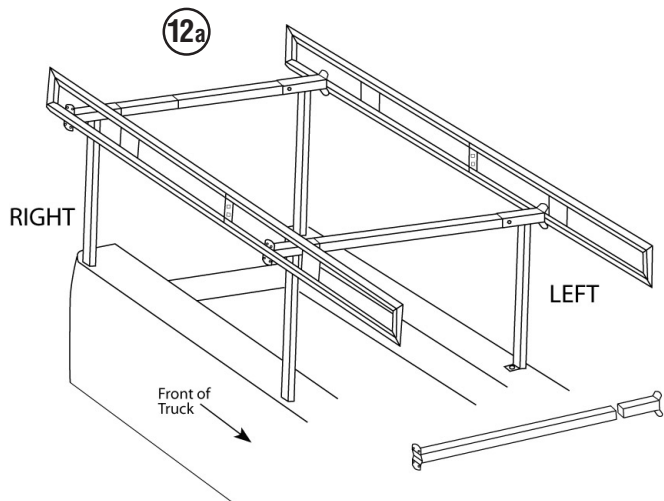
**10.** Install side rail assembly to front and Rear Posts securing with Clamp, 4 Carriage bolts, 4 lock washers, 4 flat washers and 4 nuts. Tighten with 9/16" wrench.



**11.** Repeat on opposite side.



**12.** Install Cross Bar with Clamp in the front of the rack by inserting Crossbar end and telescoping tubes until they are extended to secure to side rails. Secure the Cross Bar end with a clamp and 4 Carriage Bolts, 4 lock washers, 4 flat washers and 4 nuts.



**13.** Secure the opposite end to side rail in the same fashion.

**14.** Locate weld nut on the Cross Bar with Clamp, and insert a set bolt into weld nut to set bar length and stabilize rack.

**15.** Insert remaining set bolts into any vacant welded nuts.

**16. BE SURE TO TIGHTEN EVERY ASSEMBLY WITH A 9/16" WRENCH TO ENSURE RACK IS SECURED.**

**17. PERIODICALLY CHECK ALL HARDWARE FOR TIGHTNESS.**

**18. WE RECOMMEND CAULKING GAPS WHERE TUBES TELESCOPE WITH A CLEAR SILICONE TO ELIMINATE WIND NOISE AND PROLONG THE APPEARANCE OF YOUR RACK.**

**19. AS WITH ANY RACK WHICH EXTENDS OVER PASSENGER DOORS, EXERCISE CAUTION WHEN ENTERING & EXITING VEHICLE TO AVOID HEAD INJURIES.**

### Warranty Information

Buyers Products warrants all truck/trailer hardware manufactured or distributed by it, to be free from defects in material and workmanship for a period of one year from date of shipment. Parts must be properly installed and used under normal conditions. Any product which has been altered, including modification, misuse, accident or lack of maintenance will not be considered under warranty. Normal wear is excluded. The sole responsibility of Buyers products under this warranty is limited to repairing or replacing any part or parts which are returned, prepaid, and are found to be defective by Buyers Products. Authorization from Buyers Products must be obtained before returning any part. No charges for transportation or labor performed on Buyers' products will be allowed under this warranty.