

Quadratec® QR3 & QR4 Tubular Side Step Bars

Installation Manual for '07-Current JK Wrangler Vehicles

#12004.30XX & #12004.31XX - All Finishes



3" Side Tube Step



4" Oval Side Tube Step



4" Oval in Stainless



3" Round Detail

⚠ 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.

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

NOTICE

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® Wrangler.

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.

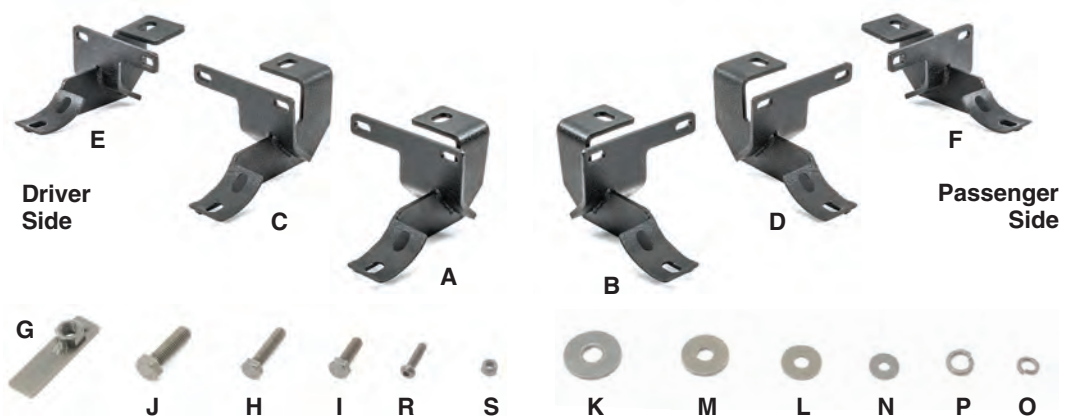
Please see page 8 in this instruction booklet for all suggested care for your Quadratec Side Tube Steps.

<p>REQUIRED TOOLS:</p> <ul style="list-style-type: none"> Safety Glasses 10mm Socket and Driver 13mm Socket and Driver 16mm Socket 4mm Allen Wrench Torque Wrench



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Installation Hardware:



PARTS LIST:

Driver (Left) Side Tube Step QTY 1
 Passenger (Right) Side Tube Step QTY 1

Mounting Brackets: (length)

A) Driver (Left) Front: (medium) QTY 1
 B) Pass (Right) Front: (medium) QTY 1
 C) Driver (Left) Center (4dr): (long) QTY 1
 D) Pass (Right) Center (4dr): (long) QTY 1
 E) Driver (Left) Rear: (short) QTY 1
 F) Pass (Right) Rear: (short) QTY 1

Nut Plates:

G) 10mm Length: QTY 6 (4dr) QTY 4 (2dr)

Hex Bolts:

H) 8mm x 35mm: QTY 6 (4dr) QTY 4 (2dr)
 I) 8mm x 25mm: QTY 12 (4dr) QTY 8 (2dr)
 J) 10mm x 35mm: QTY 6 (4dr) QTY 4 (2dr)

Flat Washers:

K) 10mm ID x 34mm OD x 3mm:
 QTY 6 (4dr) QTY 4 (2dr)
 L) 8mm x 24mm OD x 2mm:
 QTY 12 (4dr) QTY 8 (2dr)
 M) 8mm x 28mm OD x 3mm:
 QTY 6 (4dr) QTY 4 (2dr)
 N) 6mm ID x 18mm OD x 1.6mm:
 QTY 24 (4dr) QTY 16 (2dr)

Lock Washers:

O) 8mm: QTY 18 (4dr) QTY 12 (2dr)
 P) 10mm: QTY 6 (4dr) QTY 4 (2dr)

Button Head Bolts:

R) 6mm x 25mm: QTY 12 (4dr) QTY 8 (2dr)

Nylon Lock Nuts:

S) 6mm: QTY 12 (4dr) QTY 8 (2dr)

NOTICE

Brackets will be marked with positions, DF = Drivers Front, DC = Drivers Center & DR = Drivers Rear, same will apply to the passenger side brackets. Two Door Models will only use a Front and Rear Bracket.

NOTICE

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

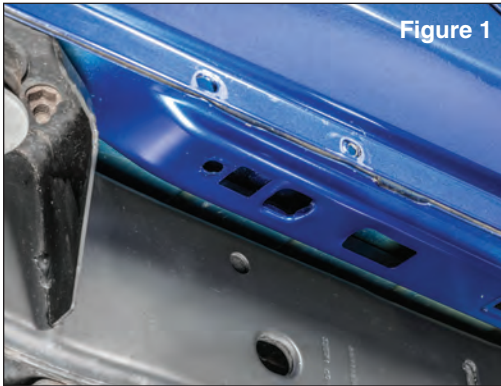
NOTICE

This instruction sheet covers the installation of both the 3" round tube steps as well as the 4" Oval Tube steps for 2 & 4 Door Jeep Wrangler. Pictures in this instruction booklet may not show your specific model but installation is identical for both tube diameters.



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Pre-Install: Mounting Style Definition



Differences in Mounting Styles

Body Style "A" (Fig 1) Will use the supplied 10mm Nut Plates (inserted into the body), 10mm bolts, lock washers & flat washers.

Style "B" (Fig 2) will use the supplied 8mm x 35mm bolts (threaded into body), lock washers and 8mm x 28mm OD x 3mm thick Larger Flat washers.

Step One: Mounting Brackets Style A:



Install Mounting Brackets Style A

Put on safety glasses. Use these steps if your vehicle is equipped for Style A. Locate the front, center (required for 4 door) and rear mounting brackets for one side of vehicle. On the underside of your Jeep® will be holes in the pinch welds and either square holes or threaded holes per the installation tip explained above. Select the appropriate mounting brackets per the desired

location. Take each bracket and line them up with the pinch weld and lower body mounting holes in the bracket as shown (Fig 3). Loosely install (2) 6mm x 25mm Button Head Bolts, (4) 6mm Flat Washers and (2) 6mm Nylon Lock Nuts through the pinch weld and bracket (Fig 4 & 5), which will make it easier for you to do step two. See Figure 5 at the top of the next page.



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Step Two: Install Underside 10mm Bolts



Figure 5



Figure 6

Installing Underside 10mm Bolts

Under the body just under where you mounted the bracket to the pinch welds above, insert a nut plate into the opening with the nut facing upwards (Fig 6). Line up the nut on the Nut Plate with

the hole in the Bracket. Bolt the Bracket to the Nut Plate with (1) 10mm x 35mm Hex Bolt, (1) 10mm Lock Washer and (1) 10mm Flat Washer, (Fig 8 & 9).



Figure 7



Figure 8



Figure 9

Use the 10mm socket, extension and ratchet to tighten up the 10mm bolt as shown in Figure 9.



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Step One: Mounting Brackets Style B:



Figure 10

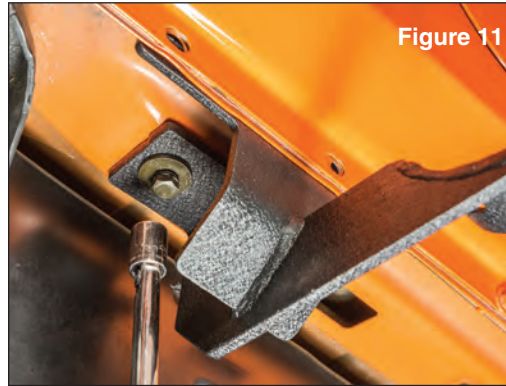


Figure 11

Install Mounting Brackets Style B

Put on safety glasses. Use these steps if your vehicle is equipped for Style B. Select the appropriate mounting brackets per the desired location. Take each bracket and line them up with the pinch weld and lower body mounting holes in

the bracket as shown (Fig 10). Loosely install a (1) 8mm x 35mm bolt, (1) lock washer and (1) 8mm x 28mm OD x 3mm thick flat washer (Fig 11) to hold bracket in place which will make it easier for you to do the next step.



Figure 12



Figure 13



Figure 14

Step Two: Pinch Weld Bolts

Install Pinch Weld Bolts

Take (2) 6mm x 25mm Button Head Bolts, (4) 6mm Flat Washers and (2) 6mm Nylon Lock Nuts and install them through pinch weld on body and bracket (Fig 12, 13 & 14).

Do not tighten hardware at this time.



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Step Three: Install Steps to Brackets (Either Style A or B)

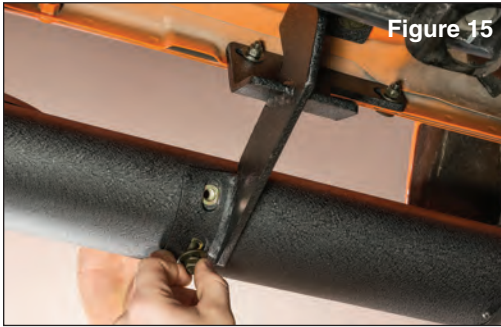


Figure 15

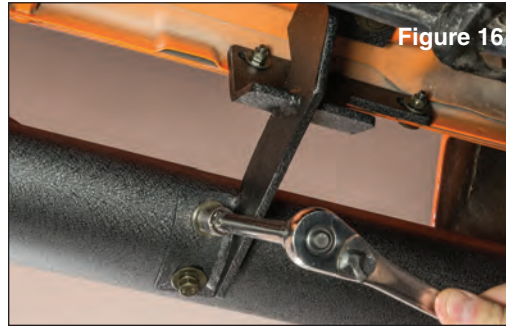


Figure 16

Install Steps to Mounting Brackets

With the three mounting brackets installed, locate the Drivers side tube step for installation to the mounting brackets. Line up the nut attachments to the mounting bracket slotted holes (Fig 15) so the step pads line up with the front and rear doors. These holes in the tube step "cradle" should line up.

If they do not, you have the wrong side tube. With tube step lined up on the mounting brackets, secure each bracket in your version with (2) 8mm x 25mm Hex Bolts, (2) 8mm Lock Washers and (2) 8mm Flat Washers. Snug all the hardware but do not tighten at this time.



Figure 17



Figure 18

Install Tube Steps to Mounting Brackets

Ensuring that the tube step is level, slowly tighten all the bolts on the front, center and rear of tube step (Fig 16) and mounting brackets (Fig 17 & 18). Repeat steps one through three on the opposite

*side of the vehicle making sure all lock washers and flat washers are installed correctly and that Each bolt is tightened to the Torque Specs shown below. **Congratulations, Install complete!***

NOTICE

Torque for 6mm Button Head Bolt (hardware R) = 8 ft-Lbs
Torque for 8mm Hex Head Bolt (hardware H & I) = 16 ft-Lbs
Torque for 10mm Hex Head Bolt (hardware J) = 37 ft-Lbs



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Product Care and Maintenance:

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 portions of the 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.

To further protect your stainless tube steps we recommend using a non-abrasive car wax on the part on a regular basis. This will protect the finish and keep your product looking like new.

Micro scratches can occur from daily use. To remove these scratches we recommend a mild aluminum polish. However, before using any polish, try a test area on the back side of the step before using it on the front, exposed surface to test abrasive level of the polish. If it causes more scratches, STOP and use a milder polish.



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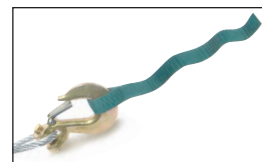
**Q11000 Shown in
BLACK Finish with Solenoid
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with Solenoid
in Top mount
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1. Fabric: Tough 23 ounce mildew and UV resistant vinyl coated polyester and cotton fabric provides lasting durability and is backed by a limited three year warranty. QuadraTops are available in factory original colors and textures to keep your Jeep® looking showroom new!

2. Stitching: Our QuadraTop panels are sewn together with marine grade 135 gauge bonded Anefil® polyester thread that's super strong and UV protected. This rot resistant thread will provide years of worry free durability.

3. Seams: All exposed QuadraTop seams feature heat tape seals over double stitching to keep moisture out.

4. Windows: QuadraTops are available with your choice of zip out crystal clear windows or rear and quarter windows with a dark 31% tint keeping interiors much cooler in hot summer months. Our glass panels are 30mil thick and DOT approved for the ultimate in clarity and durability and feature leak proof heat seals. All windows are completely removable for open air enjoyment.

5. Zippers: QuadraTop window zippers are stitched in place like the original tops and feature jam resistant technology and heavy duty plastic teeth. Side quarter windows feature single metal pulls while rear glass zippers have user friendly double pulls.

6. Hook & Loop Attachment: Our patterns are fully tested to ensure a tight and wrinkle free fit like the originals. All necessary snaps and Heavy Duty Hook & Loop strips are in place to install over the factory bows and there's never any drilling or modifications required!

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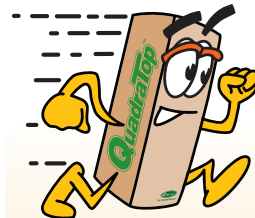
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Applications for '07- Current JK Wrangler Vehicles:
 For '07-'09 Wrangler 2 Door without Doors #11000.0835
 For '10 - Current Wrangler 2 Door without Doors #11000.0935
 For '07-'09 Wrangler 4 Door without Doors #11000.1035
 For '10 - Current Wrangler 4 Door without Doors #11000.1135
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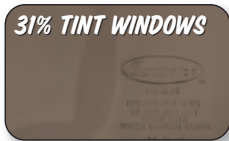
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Quadrtec® Exclusive Three Year Limited Warranty

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

This **Limited Warranty** is the only warranty made in connection with your purchase. Quadrtec 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 Quadrtec 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 Quadrtec branded accessories first sold in the United States, Quadrtec warrants to the initial retail purchaser only that your Quadrtec 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 Quadrtec 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. Quadrtec 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 Quadrtec **Limited Warranty** does not cover products or parts Quadrtec 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 Quadrtec inspection and at Quadrtec'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 Quadrtec 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 Quadrtec nor any independent Quadrtec 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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