

Light Bar Installation Instructions

PN: 210623 Ford Transit, '15+, Light Bar

Please read before beginning:

- *Stainless steel hardware may bind together when tightening—It is recommended that you apply an anti-seize assembly lubricant to the threads of each bolt before assembly*

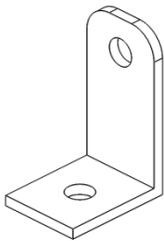
Required tools:

- Standard wrench set
- 3/16" Drill Bit with Drill
- Flat Head Screw Driver
- Dremel or Cut-Off Wheel
- Box Cutter
- Measuring Tape

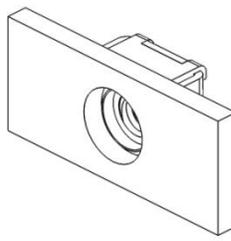


Included Hardware:

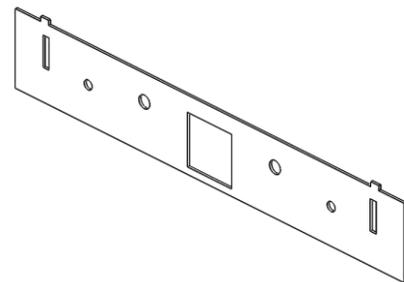
P/N	Description	Quantity
70024	5/16" -18 Nylon-Locking Nut, Black Oxide	2
70028	5/16" Washer, Black Oxide	4
70446	5/16" -18 x 1 1/4" Button Head Bolt, Black Oxide	2
70111	5/16" Lock washer	4
70124	M8 x 1.25 x 40mm bolt	4
70246	Antiseize Bolt Lubricant Packet, 2g	1
70347	Snap On Cap, 5/16" Hardware Cover, Plastic, Black	2



Attachment Bracket (Steel) Qty. 2



Attachment Bracket Nuts (Steel) Qty. 4



Cut Template Qty. 1

Installation Instructions

Stock Bumper Removal

1. Open hood and remove head lights. There are two (2) T30 Torx bolts holding in each head light in place that must be removed (reference Figure 1). Gently pull light forward (away from vehicle) and up to dislodge the light, being careful to not pull the attached electronics. Unclip wiring harness once dislodged.



1a – Forward Bolt



1b – Rear Bolt

Figure 1: Bolts Securing Headlights

2. Disconnect wire connections running to each of the headlights and turn signals. They are color coded for easy assembly later.
3. Underneath the headlights, remove the two (2) T25 Torx bolts holding the outside of the bumper to the fender flare (Figure 2).



Figure 2: Bolts Underneath the Headlights

4. Remove the plastic clips holding on the fender flare on the inside of each wheel-well (Figure 3). There's no need to remove the torx bolt at the bottom of the fender.

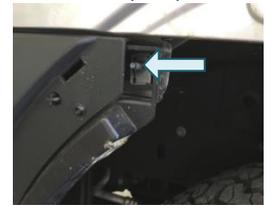


Figure 3: Fender Flare Plastic Rivets

5. Gently pull fender flares away and off of the vehicle to expose the plastic front bumper (Figure 4a). Remove the fender retaining bolt (10mm) to allow the bumper to be pulled away from the vehicle.



4a – Fender Flare Tabs



4b – Fender Retaining Bolt

Figure 4: Fender Flare Removal

6. Unbolt the four (4) 10mm bolts connecting the plastic front bumper to the plastic under carriage (reference Figure 5).

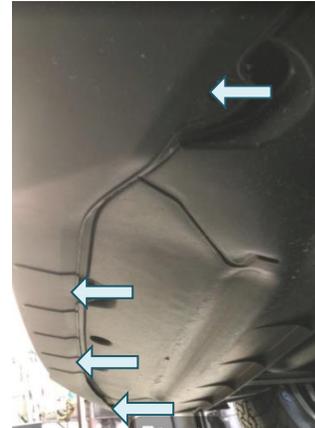


Figure 5: Plastic Under Carriage Forward Bolts

7. Unclip the plastic rivet holding a hose above the undercarriage from below (Figure 6).



Figure 6: Plastic Rivet Holding on Engine Hose (view from above)

8. Unbolt the rear bolts of the plastic under carriage and remove carriage from the vehicle (reference Figure 7a & b).



7a – Access to Rear Bolts



7b – Rear Bolts

Figure 7: Rear Bolt Removal for Undercarriage

9. Remove the license plate holder by drilling out the rivets attaching the holder to the front bumper.
10. Unbolt the two (2) 13mm bolts attaching the front bumper to the sub-frame underneath (Figure 8).



Figure 8: Attachment Bolts to Sub Frame

11. Gently pry plastic front bumper away from vehicle's front grill with a plastic pry bar or tape-covered flathead screwdriver (Figure 9). Start from each fender and work to the center, removing the center last.



Figure 9: Prying Front Bumper from Grille

12. Gently, but firmly pull the bumper directly away from front of vehicle to remove the bumper from the vehicle disconnect all the sensors and radar to make sure they do not get damaged during installation. (Figure 10).



Figure 10: Front Bumper Removal

Light Bar Installation

13. Insert the attachment bracket nuts behind the front bumper sub-frame, aligning them with the intended holes (Reference Figure 11 & 12).



Figure 11: Holes to be Used for Installation



Figure 12: Attachment Bracket Holes Through Sub-Frame
(View from Back of Sub-Frame)

14. Attach the steel attachment bracket using the M8 hex head bolt, 5/16 lock washer, and 5/16 washer (reference Figure 13). DO NOT tight hardware yet, first align with light bar.



Figure 13: Attachment Brackets Attached to Sub-Frame

15. Align steel brackets to desired position by holding up the Aluminess light bar to the vehicle and tighten bracket bolts into place.
 - a. For safety, have another person hold the light bar while aligning and tightening the bolts through the frame to ease installation and help prevent damage.
16. Align the provided cut template to the stock plastic front bumper using the two bolts in the front of the bumper as reference points (Arrows in Figure 14).

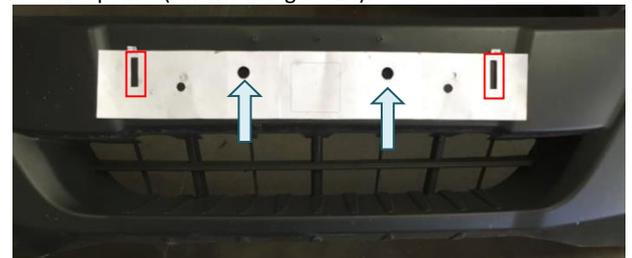


Figure 14: Cut Template on Stock Bumper

17. Mark the location of the rectangular holes required for the brackets to protrude through (Rectangles in Figure 14).
18. Cut the plastic bumper using the marked locations as guidelines. A Dremel or cut-off wheel can be used for the long sides and a box cutter can complete the rectangle.
 - a. MEASURE TWICE → CUT ONCE!
19. Fit the plastic bumper back onto the vehicle using the plastic attachment tabs on the grille and the two (2) 13mm bolts in the front for alignment.
20. Using a 3/8" drill, drill through the plastic bumper by using the holes in the bottom sub frame as a template. (Reference Figure 15).

NOTE: It is best to drill from the inside of the sub frame.



Figure 15: Front view of holes to use as a template

21. Attach the light bar to steel brackets on upper sub-frame bumper with provided 5/16" hardware. Confirm alignment of holes on bottom sub-frame through plastic bumper to Aluminess light bar. (Reference figure 16.)



Figure 16: Upper subframe attachment locations

22. Use the steel attachment brackets as used in step 13 for the bottom mounting locations. Use a 40mm bolt, locking washer and a bolt cover washer. (Reference Figure 17)

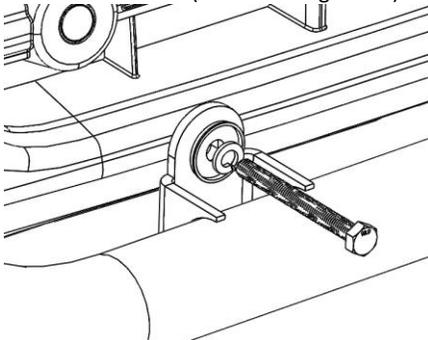


Figure 17: Wire Diagram of hardware for bottom mounting bracket

23. Once the lightbar is in a position you like, tighten down all the hardware and cap off the exposed the bottom 40 mm bolts.
24. Re-attach the plastic undercarriage using the four (4) 10mm bolts underneath and the two (2) 10mm onto the frame (Figures 5 & 7). Re-insert the plastic rivet through the engine hose connection (Figure 6).
25. Re-install all the bolts underneath the headlights attaching the front bumper at the wheel wells (Figure 2).
26. Re-install the headlights by attaching the wiring harness first and re-nesting the headlight back into place (Figure 1).
27. Reinstall fender flares and all plastic tabs (Figure 3 & 4).
28. Close the hood.
29. Enjoy your new Aluminess Light Bar!



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