



Rear Door Base Unit Installation Instructions

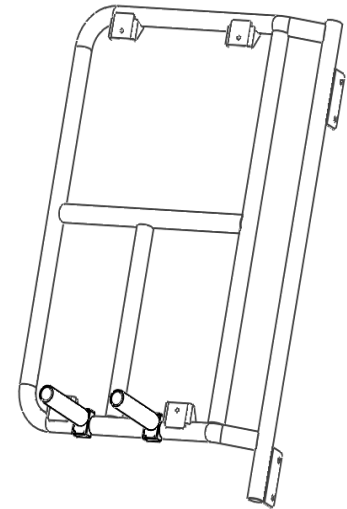
P/N 210579.1: 2015+ Ford Transit Rear Door Base Unit, LOW ROOF

Before you begin:

- *Stainless steel hardware may bind together when tightening — apply an anti-seize assembly lubricant to the threads of each bolt before assembly.*
- *This installation requires two or more people*
- *Unless otherwise specified, refer to the general torque value at the end of the instructions for specified torque values*

Required Tools:

- Standard and metric wrench set
- Standard and metric socket set
- Torx bit set
- Drill or impact driver
- Isopropyl Alcohol
- Baby Soap or Dish Soap
- Spray Bottle
- Clean Rag
- Squeegee (or old credit card)



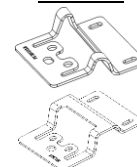
Included Hardware:

P/N	Description	Quantity
70344	5/16"-18 x 1" Button Head Bolt, BLACK OXIDE	4
70446	5/16"-18 x 1 1/4" Button Head Bolt, BLACK OXIDE	4
70448	3/8" ID Washer, 1/8" THK BLACK OXIDE	4
70345	5/16" ID Washer, BLACK OXIDE	16
70346	5/16"-18 Nylon-Locking Nut, BLACK OXIDE	8
70094	1/4"-20 x 3/4" Button Head Bolt	4
70008	1/4"-20 Nylon-Locking Nut	8
70009	1/4" ID Washer	12
70038	1/4"-20 X 2 3/4" Philips head screw, SS	4
70040	1/4" Countersunk Washer, SS	4
70039	1/4" X 1 Fender Washer, SS	4
70437	M6-1.0 x 16mm, Button Head Bolt	3
70246	Antiseize Bolt Lubricant Packet, 2g	1
400999	Impact Resistant Protective Tape	18"

Additional Parts:

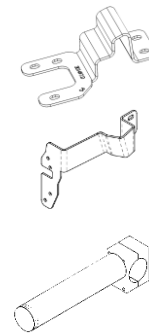
P/N	Description	Quantity
301513 / 350659	Upper Hinge Bracket, Low Roof , Passenger's Side	1 ea
301250 / 350657	Lower Hinge Bracket	1 ea

Picture





301497 / 350644	Inner Driver Door Bracket, Passenger	1 ea
301255 / 350648	Inner Passenger Door Bracket, Upper	1 ea
350662	8" Tire Support Post	2 ea



Base Unit Rack Installation:

1. Cut the supplied protective tape into one - 6" section and one - 3" section. Round all corners.

PRO TIP: Dry fit each bracket to verify shape and location of protective tape before cutting. Be sure to cut tape in correct orientation, with white backing towards vehicle.

2. Apply the protective tape to each location, one at a time, using the following wet application technique described below.
3. Prepare the surface for protective film application (wet application technique):
 - a. Clean the area around each hinge with isopropyl alcohol and rag.
 - b. Wash your hands thoroughly.
 - c. Do not apply in direct sunlight
 - d. Apply in temperatures above 60°F.
 - e. Create two separate wetting solutions:
 - i. Soap/water: ~95% water / ~5% soap
 - ii. Alcohol/water: ~75% water, ~25% isopropyl alcohol
4. Spray the surface thoroughly with soap/water solution and do not wipe down surface.
5. Remove the liner from the protective tape while spraying the adhesive side with soap/water solution.
6. Apply the protective tape to the outside of the door at each location where the brackets contact the vehicle (Figure 1). At each location, leave approximately 1/2" of tape overhanging to be wrapped around the edge of the door.



Figure 1: Locations of Protective Film Application

7. Use squeegee all air bubbles out starting at adhered edge.
8. Use the alcohol/water solution to speed up adhesion at one edge (lift section up and spray adhesive side) as needed.
9. Wrap remaining protective tape around the door underneath hinge if possible.
10. Install the upper hinge bracket by:
 - a. Have someone help support the weight of the door throughout the entire bracket installation.
 - b. Remove the three bolts connecting the hinge *to the door*.
 - c. Rotate hinge enough to allow the bracket to be installed around the hinge (Figure 2).



Figure 2: Upper Hinge Rotated Away from Door

- d. Install the hinge around the hinge in the correct orientation (Figure 3).



Figure 3: Bracket Installed Over Factory Hinge

- e. Rotate the hinge and bracket back into position against the door (Figure 4).



Figure 4: Hinge Placed Back into Position

- f. Use the factory hardware to reinstall the hinge/bracket (Figure 5).

PRO TIP: When reinstalling factory hardware, try to match up the location of the hinge to the door using the unpainted 'shadow' as a guide to ensure proper

alignment of the door on the van. Misalignment of the hinges can lead to fitment issues at the inner door latch.

PRO TIP: Be sure to center the bracket around the hinge and verify clearances around the hinge while opening and closing the door.



Figure 5: Inside View of Installed Upper Hinge

- 11. Install the lower hinge bracket by repeating the process detailed in Step 10 (reference Figure 6).



Figure 6: Inside View of Installed Lower Hinge Bracket

- 12. Remove the three (3) factory torx bolts holding on the passenger's side latch. NOTE: Prevent the latch from falling into the door by holding the inside latch (Figure 7 & 8).



Figure 7: Inside Latch on Passenger Door



Figure 10: Inner Door Liner Peeled Back for Access



Figure 8: Installed Inner Passenger Door Bracket

13. Install the inner passenger door bracket using the provided M6-1.0 hardware and ¼" ID washer (See Figure 8).
14. Determine if there is an upper handle present on the inside of the passenger door (Figure 9).



Figure 11: Dry Fit Bracket Up to Door

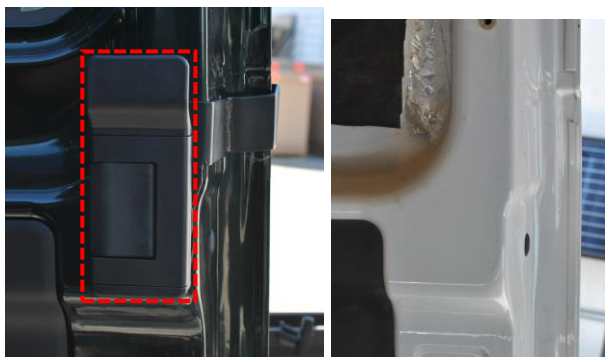


Figure 9: Inside Upper Handle - Present (left) or Not Present (right)

15. If there is an upper inside handle (2020+), skip to step 16. If there is no handle present (2015-2019), complete the following:
 - a. Remove any door plastic coverings to gain access to inside of the door.
 - b. Peel back inside door liner if applicable (Figure 10).

- c. Dry fit bracket to door (Figure 11).

NOTE: It may be helpful to loosely bolt on the rack at this point to confirm placement of upper inner bracket. Align the two sets of slotted holes. The jog of the sheet metal on the inside of the doorjamb can be used for rough alignment.

- d. Mark four (4) mounting hole locations. Measure twice, cut once!
- e. Drill a ¼" hole at the marked locations.
- f. Paint any exposed metal as desired.
- g. Install inside bracket with ¼"-20 hardware (Figure 12).



Figure 12: Installed Inside Upper Bracket without Factory Handle

- h. Reseal liner and replace plastic coverings.
- 16. If passenger door does have the upper inside handle, complete the following:
 - a. Remove the plastic cover by prying from the side with a flathead screwdriver (Figure 13).



Figure 13: Inside Upper Plastic Cover

- b. Remove the plastic handle by loosening the two (2) exposed bolts with a 7mm socket (Figure 14).

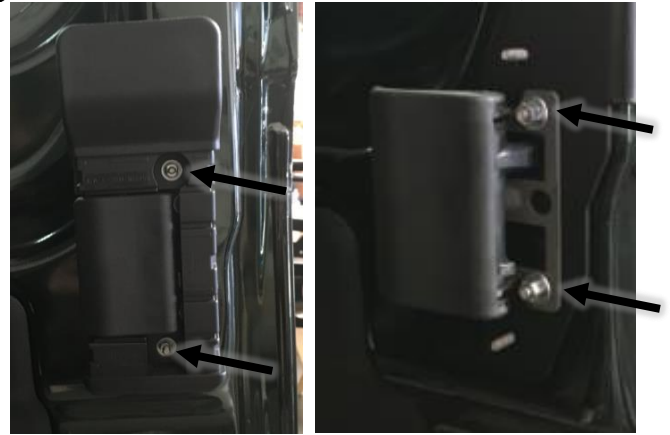


Figure 14: Plastic Handle (left) and Latch Handle (right)

- c. Remove the latch handle by loosening the two (2) remaining 7mm nuts (Figure 14).
 - d. Install Upper, Inner Passenger's Side Door Bracket and reuse factory hardware to reinstall handle and covers. Sandwich the bracket between the door and the latch handle (Figure 15).



Figure 15: Upper Inner Passenger's Side Bracket Installed

- 17. Loosely install the base unit onto the upper, lower, and inner brackets using the provided 5/16"-18 bolts, washers, and nuts. Use the 1" bolts for the outer brackets and the 1 1/4" bolts for the inner brackets.
 - a. Tighten the upper and lower **hinge** brackets first.
 - b. There should be a small gap at the center bracket before it is fully tightened (0-1/8"). If the gap is larger,



than 1/8", use the provided 1/8" THK washers as shims (PN: 70448) to close the gap to $\leq 1/8$ " (See Figure 16).

into the support posts. Secure box to rail using the hardware shown in figures 17 and 18 below.



Figure 16: Example of gap between bracket and product

18. Verify the hinge brackets and inner door brackets have appropriate clearances while slowly opening and closing both rear doors. Adjust as needed.
19. If mounting a box is desired, grab your included 8" support posts [350662]. Unscrew the bolts holding the pipe clamp together, and place the posts facing out on the bottom of the pipe of the base unit. Adjust the posts so that they are level with the van and evenly spaced over where you want the box to sit. Tighten the pipe clamp support posts down.
20. Mark and drill 5/16" holes through the back of your box into the cross pipe in the middle of the base unit, and through the bottom of the box

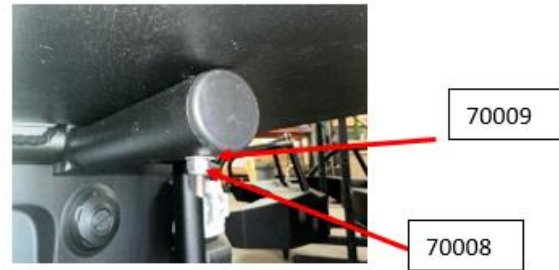


Figure 17: Mounting Hardware Under Box

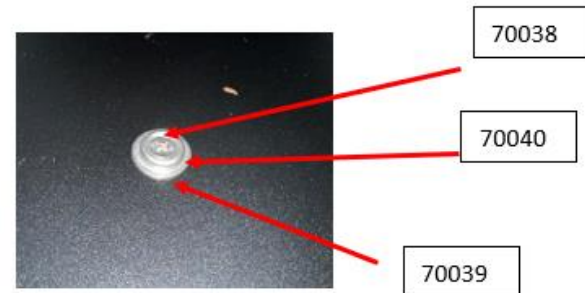


Figure 18: Mounting Hardware Inside Box

21. Your new Aluminess Base Unit Rack is now installed, enjoy!
22. PRO TIP: If your inner door brackets are crashing into each other, watch this video on how to easily adjust your hinges:





General Torque Values			
Size	Stainless Steel	Zinc	Grade 8
#6-32	10 lb-ft	--	--
#8-32	18.4 lb-ft	--	--
#10-32	26.6 lb-ft	--	--
1/4"-20	5.3 lb-ft	7.8 lb-ft	9 lb-ft
5/16"-18	10.9 lb-ft	16 lb-ft	18 lb-ft
3/8"-16	19.4 lb-ft	28.3 lb-ft	33 lb-ft
7/16"-14	31 lb-ft	45 lb-ft	52 lb-ft
1/2"-13	47 lb-ft	69 lb-ft	80 lb-ft
M6	4.7 lb-ft	5.8 lb-ft	--
M8	11.3 lb-ft	14.1 lb-ft	--
M10	22.3 lb-ft	27.9 lb-ft	--
M12	38.9 lb-ft	48.7 lb-ft	--



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