



Rear Bumper No Swing Arm Installation

Instructions

P/N 210629: 2019+ Mercedes Sprinter Rear Bumper with no SA

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
- Flat head screwdriver
- Painter's Masking Tape

Included Hardware:

<i>P/N</i>	<i>Description</i>	<i>Quantity</i>
70033	Nut, 1/2"-13, Nylock, GR 8	8
70035	Washer, 1/2" ID x 5/8" OD, Flat, SS	32
70036	1/2"-13 x 1-1/2", GR 8, Hex Bolt	8
70028	3/8" ID x 7/8 OD	2
70056	Nut, 7/16"-14, Nylock, GR 8	8
70185	7/16-14 x 4-1/2 Hex Bolt	8
70246	Loctite Anti-Sieze Packet, 2g	1



Additional Parts:

Description

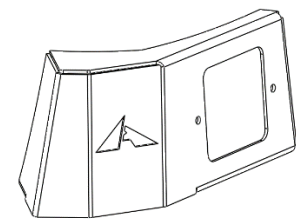
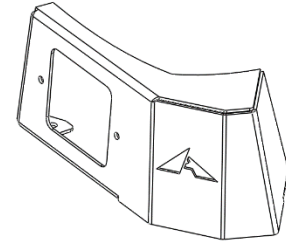
PN

Quantity Picture

Trim assembly, driver & passenger

350699
(301558.1 & 301558.2)

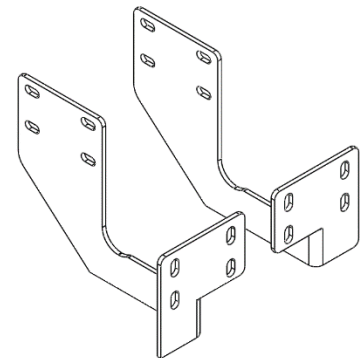
1 PAIR



Hitch Blade Mounting Brackets

350700
(301549)

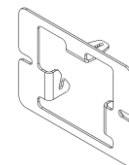
1 PAIR



Blindspot assist sensor brackets
(pre-installed onto trim)

301303

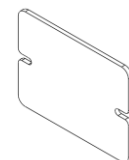
2



Blindspot assist sensor windows
(pre-installed onto trim)

350739

2





Stock Bumper Removal:

1. Support stock hitch and remove the eight (8) bolts underneath the vehicle. Disconnect any wiring connected onto the hitch before lowering (towing plug, parking sensor, etc...). Reference Figure 1.

CAUTION: Unbolting will allow the hitch to fall if not properly supported.



Figure 1: Four (4) of the Hitch Mounting Bolts

PRO TIP: The entire installation is much easier if you lower and remove the spare tire. Then replace once complete.

2. Remove the seven (7) torx bolts holding on the plastic rear bumper as indicated in Figure 2:



Figure 2: Torx Bolts on the Rear Bumper

3. Remove the two (2) plastic rivets holding on the plastic rear bumper from underneath the vehicle, close to the spare tire carriage. Reference Figure 3 and 4.



Figure 3: Plastic Rivets Underneath Bumper



Figure 4: Example of Plastic Rivet

4. Remove the side panel plastic by gently pulling away on the plastic from the vehicle to expose additional bumper attachment points. Start from the rear wheel well working towards the back of the vehicle. Reference Figure 5.

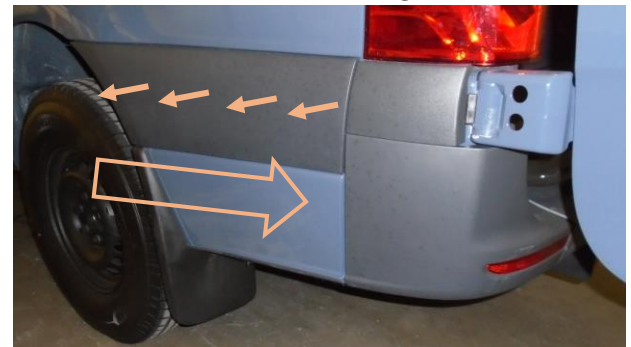


Figure 5: Side Panel Removal

5. Remove the plastic rivets anchoring the plastic rear bumper assembly on both sides of the vehicle (see Figure 6).



Figure 6: Plastic Rivets Underneath the Side Panel



6. Disconnect the tabs connecting the smaller plastic panel on top from the plastic rear bumper. Once disconnected, gently pull away from vehicle to remove. Retain small panel and repeat on opposite side. Reference Figures 7-8.



Figure 7: Removing Small Plastic Panel from Rear Bumper



Figure 8: Small Plastic Panel Removed

7. Remove the plastic rear bumper from the rear of the vehicle, disconnecting any wiring that has not been done so already.
8. Remove blind spot assist sensor from plastic rear bumper if applicable.
9. Reinstall side panel plastics.

Rear Bumper Installation:

10. Pre-install wiring sensor if applicable into bumper.
11. Prepare bumper for install by mounting [PN350700] hitch blade mounting brackets as shown in FIGURE 9 using provided 1/2"-13 hardware.

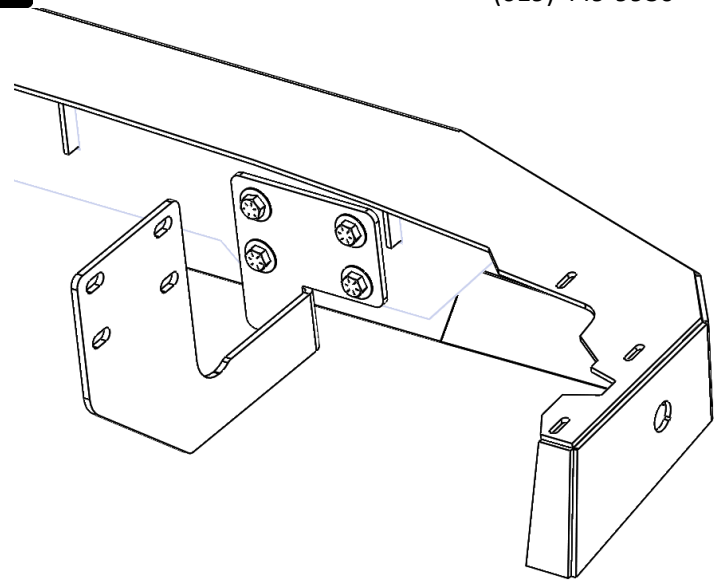


Figure 9: Mount Hitch Blade Brackets

12. Bumper mounting blades are positioned outside of frame rails. Install new rear bumper by lifting up to vehicle and inserting 7/16" hardware through the rear bumper blade, frame, and through the stock hitch. Finger tighten hardware to secure bolts. Do not fully tighten hardware yet as you will likely want to verify/adjust the position. Reference Figure 10.





Figure 10: Install bumper outboard of frame.

PRO TIP: While lifting the bumper into place, shift the exhaust to allow the bumper to pass with ease.

13. Position rear bumper into desired position front-to-back. Tighten the 7/16" mounting hardware to fix hitch into position. Tighten all bolts to 63 ft-lbs of torque.

PRO TIP: Mounting from the vehicle to the hitch and from the hitch to the aluminum bumper are both adjustable. Loosen associated bolts, position, and re-tighten into desired location on vehicle.

14. Install blind spot assist into trim assemblies (if applicable) by inserting the sensor into the sensor bracket as shown in Figure 10 and 11. Verify that sensor is at 0 degree position.

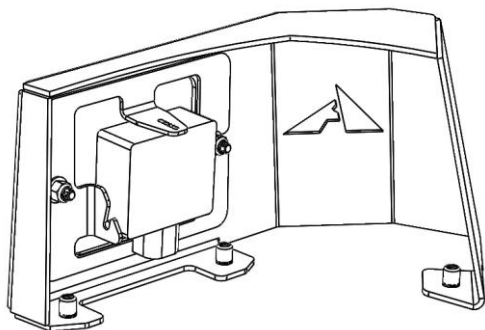


Figure 10: Sensor Mounted into Trim Piece

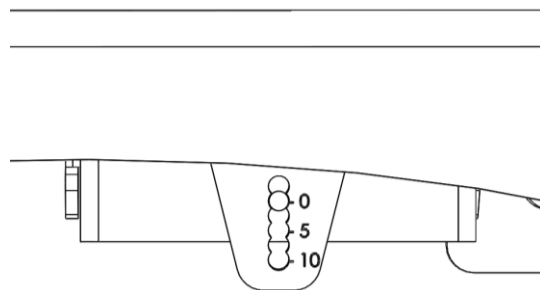


Figure 11: Set Sensor to 0 degrees

15. Check mounting hardware after first 100 miles of driving and periodically after to verify hardware has not become loose from vibration.
16. Your new Aluminess bumper is now installed, enjoy!



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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