

# Rear Bumper No Swing Arm Install Instructions

P/N 210629: 2019-24 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*



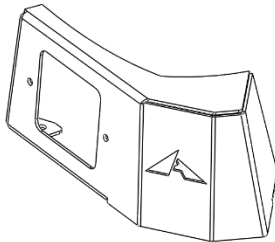
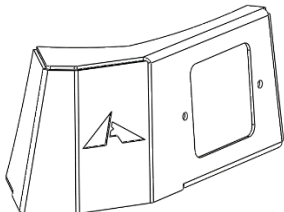
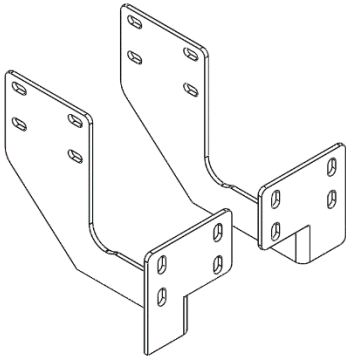
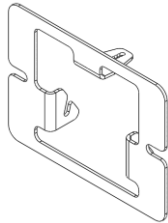
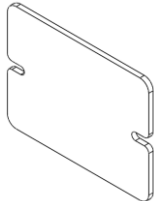
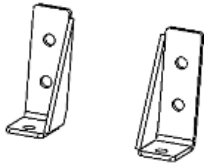
## **Required Tools:**

- Standard and metric wrench set
- Standard and metric socket set
- Flat head screwdriver
- Painter's Masking Tape

## **Included Hardware:**

| <b><i>P/N</i></b> | <b><i>Description</i></b>           | <b><i>Quantity</i></b> |
|-------------------|-------------------------------------|------------------------|
| 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-Seize Packet, 2g       | 1                      |
| 70008             | Nut, Nylock, SS, 1/4"               | 6                      |
| 70009             | Washer, SS, 1/4" x 5/8"             | 12                     |
| 70011             | Bolt, Hex, SS, 1/4" – 20x 3/4"      | 6                      |

**Additional Parts:**

| <i><b>Description</b></i>                                     | <i><b>PN</b></i> | <i><b>Quantity</b></i> | <i><b>Picture</b></i>                                                                 |
|---------------------------------------------------------------|------------------|------------------------|---------------------------------------------------------------------------------------|
| Trim Assembly, DRV/PAS                                        | 350699           | 1 PAIR                 |    |
|                                                               |                  |                        |    |
| Hitch Blade Mounting Brackets                                 | 350700           | 1 PAIR                 |   |
| Blindspot Assist Sensor Brackets<br>(pre-installed onto trim) | 301303           | 2                      |  |
| Blindspot Assist Sensor Windows<br>(pre-installed onto trim)  | 350739           | 2                      |  |
| Support Mounting Plates, PAS/DRV                              | 350263 / 350264  | 1 EACH                 |  |

### Stock Bumper Removal:

1. Support stock hitch and remove the eight (8) bolts underneath the vehicle. Disconnect any wiring connected onto the hitch (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 Figure 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).

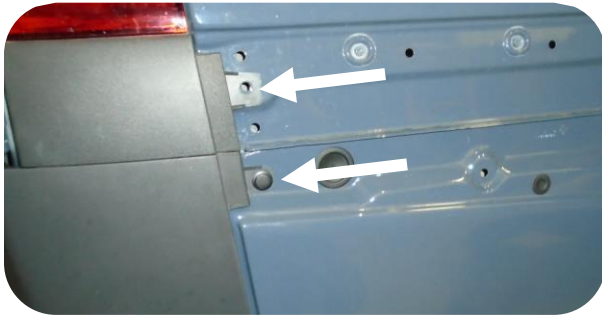


Figure 6: Plastic Rivets Underneath the Side Panel

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 Figure 7 and Figure 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. Remove the air pressure relief inserts from each side of the vehicle by squeezing each side and pulling away from the vehicle. Reference Figure 9



Figure 9: Removal of Air Pressure Relief Insert

10. Reinstall side panel plastics.

#### **Rear Bumper Installation:**

11. Pre-install wiring for the parking sensors if applicable into bumper.
12. Prepare bumper for install by mounting (PN 350700) hitch blade mounting brackets as shown in Figure 10 using provided ½"-13 hardware.

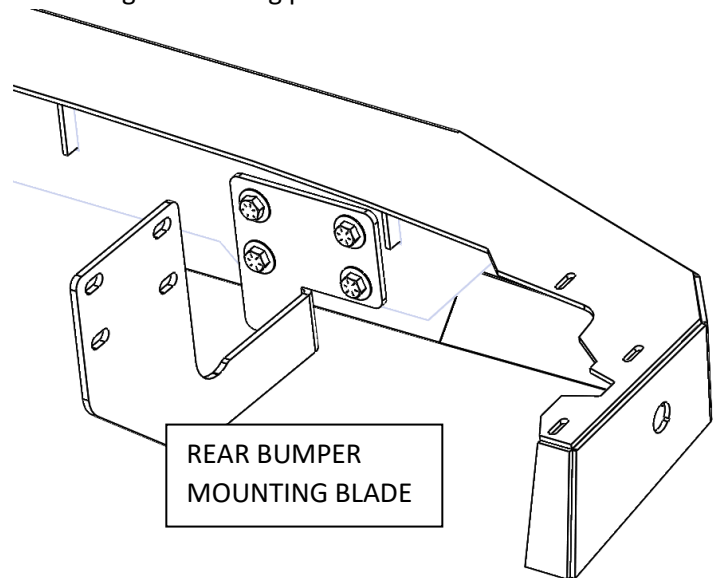


Figure 10: Mount Hitch Blade Brackets

13. 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 11.



*Figure 11: Bumper Mounted on Frame*

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

14. 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.

15. Once the rear bumper is installed it is time to install the bumper support brackets on to the wings.



*Figure 12: Support Bracket Installed*

16. Install the bumper support bracket on the driver and passenger side. Reference Figure 12.

17. Drill two 5/16 holes where the bracket will mount to the van. Use bolts (70011 Hex, SS, 1/4"-20 x 3/4") x 2, washer (70009, washer, SS, 1/4"-5/8") x2, and nuts (70008 Nut, Nylock, SS, 1/4") x2 for each side. Bolt the support bracket into the van loosely. Once the bracket is in place you now can bolt the support bracket to the bumper. Tighten all three bolts on the passenger / driver side.

**PRO TIP:** use Anti-Seize on every Stainless bolt.

18. After installing the support brackets re-install the air pressure relief inserts shown in Figure 13



Figure 13: Installed Air Pressure Relief Insert

19. Install blind spot assist into trim assemblies (if applicable) by inserting the sensor into the sensor bracket as shown in Figure 14 and Figure 15. Verify that sensor is at 0-degree position.

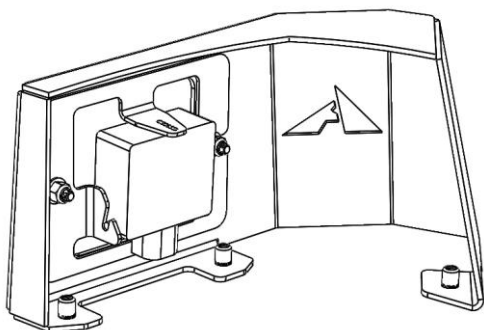


Figure 14: Sensor Mounted into Trim Piece

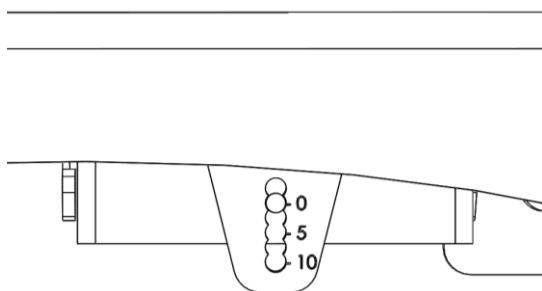


Figure 15: Set Sensor to 0 degrees

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

| TORQUE SPECIFICATIONS |         |                          |                           |
|-----------------------|---------|--------------------------|---------------------------|
| SIZE (SAE)            | 18-8 SS | GRADE 5<br>ZINC PLATED   | GRADE 8<br>ZINC PLATED    |
| 6-32 (IN-LBS)         | 9.6     | 15.3                     | 21.5                      |
| 8-32 (IN-LBS)         | 19.8    | 29.5                     | 41.7                      |
| 10-24 (IN-LBS)        | 22.8    | 47.0                     | 62.9                      |
| 10-32 (IN-LBS)        | 31.7    | 48.0                     | 68.0                      |
| 1/4-20 (IN-LBS)       | 75.2    | 91                       | 129                       |
| 5/16-18 (IN-LBS)      | 132     | 188                      | 265                       |
| 3/8-16 (FT-LBS)       | 20      | 28                       | 39                        |
| 7/16-14 (FT-LBS)      | 31      | 44                       | 63                        |
| 1/2-13 (FT-LBS)       | 43      | 68                       | 96                        |
| 9/16-12 (FT-LBS)      | 57      | 109                      | 226                       |
| SIZE (Metric)         | 18-8 SS | CLASS 8.8<br>ZINC PLATED | CLASS 10.9<br>ZINC PLATED |
| M5 X 0.8 (IN-LBS)     | 38.4    | 46.8                     | 66.0                      |
| M6 X 1.0 (IN-LBS)     | 57.6    | 79.2                     | 112.8                     |
| M8 X 1.25 (IN-LBS)    | 99.6    | 192.0                    | 274.8                     |
| M10 X 1.5 (FT-LBS)    | 13.8    | 31.6                     | 45.2                      |
| M12 X 1.75 (FT-LBS)   | 21.0    | 55.1                     | 78.9                      |
| M14 X 2.0 (FT-LBS)    | 29.4    | 88.1                     | 126.1                     |

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