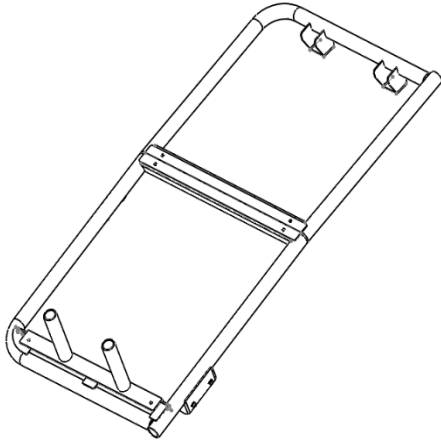



Base Unit Installation Instructions

P/N 210635: 2013+ Dodge Promaster Rear Door Base Unit



Before you begin:

- *Stainless steel (SS) hardware may bind together when tightening — apply an anti-seize assembly lubricant to the threads of each SS bolt before assembly.*
-  *Do NOT use an impact gun if this symbol is shown – doing so may strip or cross-thread bolts.*
- **Maximum load capacity is 200 lbs evenly distributed on base unit rack while travelling.**

Required Tools:

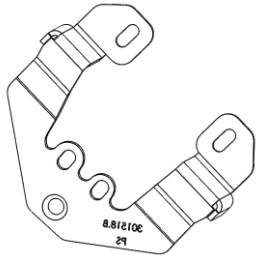
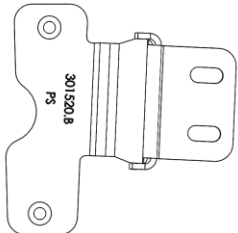
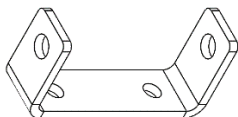
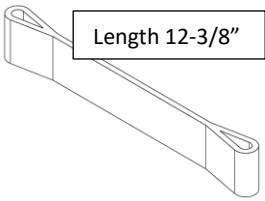
- Standard and metric wrench set
- Standard and metric socket set
- Torx bit set
- Isopropyl Alcohol
- Baby Soap or Dish Soap
- Clean Rag
- Tin Snips or Dremel Cut-Off Wheel
- Painter’s Tape (optional)
- Spray Bottle (optional)
- Heat Gun or Blow Dryer (optional)

Included Hardware:

P/N	Description	Quantity
70375	5/16" Washer, Split Black Oxide	4
70344	5/16"-18 x 1" Button Head Bolt, BLACK OXIDE	6
70345	5/16" ID Washer, BLACK OXIDE	12
70448	5/16" ID Washer, 1/8" Thick, BLACK OXIDE	4
70346	5/16"-18 Nylon-Locking Nut, BLACK OXIDE	6
70118	5/16" -18, THIN, Nylock Nut, SS	4
70019	5/16" Nylock nut	2
70020	5/16" Stainless washer	8

70021	5/16 x 3/4" Stainless hex head bolt	2
400999	Impact Resistant Protective Tape	14.5"
70120	1/4"-20 x 3" bolt	1
70008	Nut, 1/4"-20, Nylock, SS	5
70009	1/4" ID Washer	4
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
401022	Webbing Anchor (For door stop strap mounting)	1
70079	Screw, Pan Head Phillips, SS, 10-32 x 1/2"	4
70005	Washer, #10, SAE Flat, SS	4
70004	Nut, Nylock, 10-32, SS	4
70458	Bolt, CS Flat Head, M6-1.0 X 16mm, SS	2
70477	Bolt, CS Flat Head, M8-1.0 X 30mm, Countersunk, Torx Bolt, Zinc	1
70437	Bolt, Button Head, M6-1.0 X 16mm, SS	2
70246	Antiseize Bolt Lubricant Packet, 2g	1
401096	1/8 x 2 Foam Tape	26 1/2 inches

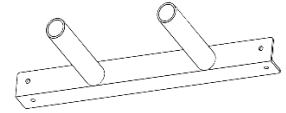
Additional Parts:

Part Number:	Description:	Quantity:	Picture:
350685	Lower Hinge Bracket, Passenger	1 ea	
350687	Inner Pass Door Bracket, Passenger	1 ea	
350688	Door Stop Channel	1 ea	
401035	Door Strap	1 ea	
210618.2	Promaster box post assembly	1 ea	

Length 12-3/8"

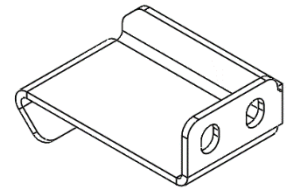
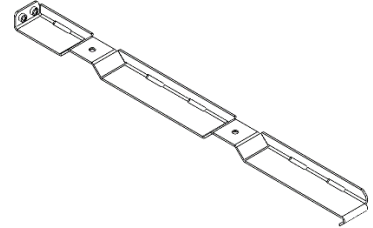
301648 Tension Bar Base

1 ea



301649 Tension Bar Bracket

1 ea



Protective Tape Application:

1. Cut the supplied protective tape into two – 2” sections, one - 3” section, and one -7” section. Round all corners.
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 (Figure 1). At the upper and lower hinge location, leaving approximately ½” of tape overhanging to be wrapped around the edge of the door. Leave the tape overhanging for now.

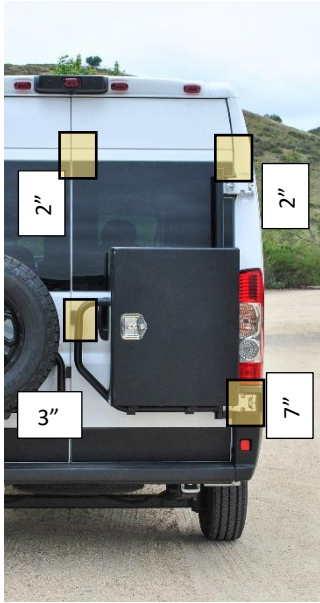


Figure 1: Locations of Protective Film Application

7. Use squeegee to get 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.

Upper Tension Bar Installation:

10. Before installation, put the foam tape on the back side of the tension Bar to protect your paint from scratches.
11. Loosely bolt short hook bracket to tension bar using two (2) 5/16"-18 x 1" Button Head Bolt fasteners [PN 70344] (Figure 2 and 3).
 - a. There should be a small gap between the two tension bar brackets 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 $\leq 1/8"$ ().

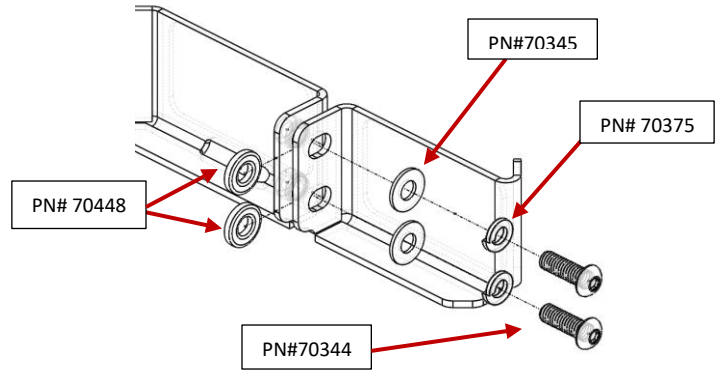


Figure 2: Tension Bar Bracket Hardware

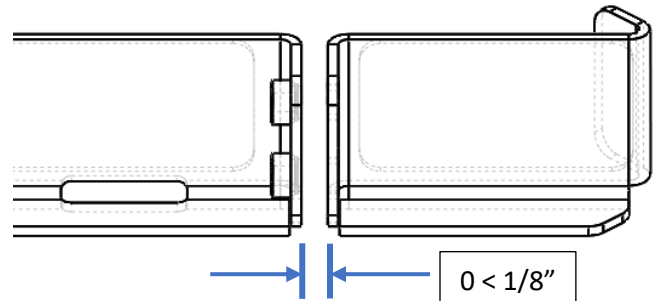


Figure 3: Tension Bar Gap

12. Bolt tension bar to base unit through weld nuts using two (2) 5/16 x 3/4" Stainless hex head bolts [PN 70021] and 5/16" split washer [PN 70375] as shown (Figure 4).

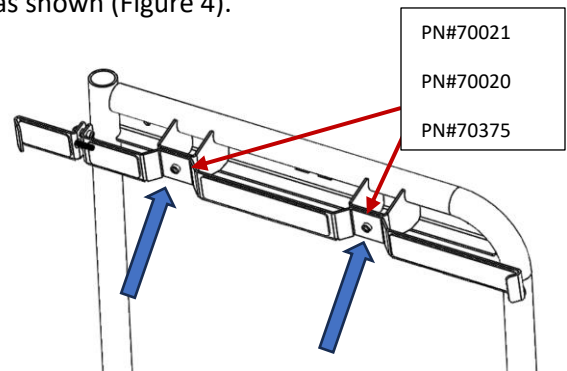


Figure 4: Tension Bar Installed on Base Unit

13. Loosely hook the fixed end of the longer tension bar bracket around the door's pinch weld, just above the window location (Figure 4). The long hook end should be on the inside seam with the mounting holes towards the taillight.

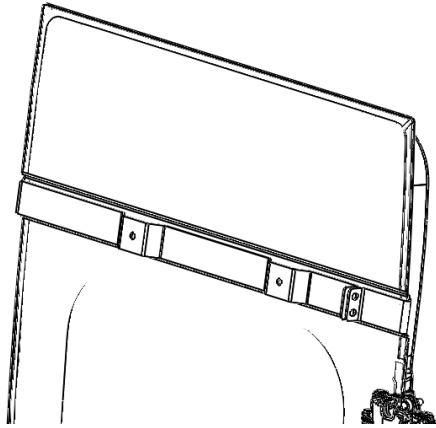


Figure 5: Tension Bar Installed on Rear Door

14. While holding the longer tension bar bracket in place, tighten the shorter bracket around the door along the opposite sides pinch weld.

Lower Bracket Installation:

15. Remove all three bolts connecting the lower hinge to the door (Figure 6).



Figure 6: Top Hinge View

16. Rotate hinge outwards to allow the bracket to be installed around the hinge.
17. Install the bracket around the hinge in the correct orientation (Figure 6).

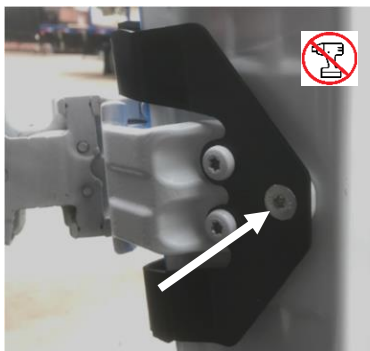


Figure 7: Bracket Installed Over Factory Hinge

18. Tightening the bracket down using the factory hardware and the M8 countersunk bolt to reinstall the hinge/bracket (Figure 7).
19. Slowly close the door to confirm that bracket is clear from any obstructions during closure use

Inner Bracket Installation:

20. Remove two factory torx screws that hold door latch in place. Set this hardware aside. (Figure 8)



Figure 8: Inner Passenger Door Latch

21. Install inner door bracket using provided countersunk hardware [PN 70458] (Figure 9).

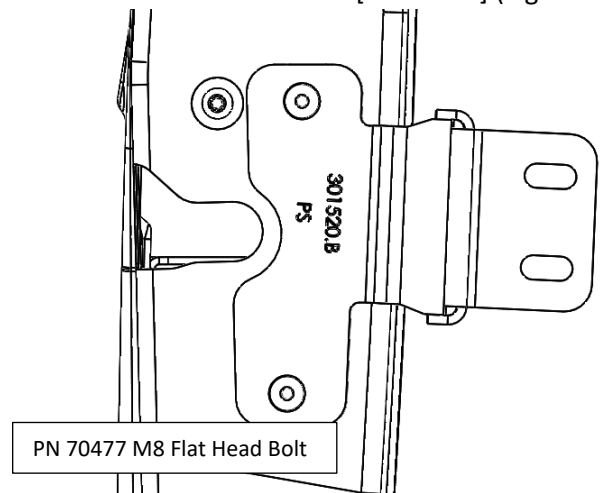


Figure 9: Inner Passenger Door Latch Installed

22. Loosely install the rack onto the tension bar, lower, and inner brackets using the provided 5/16"-18 bolts, washers, and nuts.
 - a. Tighten the upper tension bar mounting locations first
 - b. Then tighten the lower hinge brackets.
 - c. Proceed to tighten the inner bracket last.

Door Stop Installation:

23. Install Door Stop Channel Bracket [PN 350688] into factory threaded holes on the inside of the rear door trim using two [PN 70437] M6-1X16mm Button Head screws. (Figure 10)



Figure 10: Factory Threaded Holes on Inside of Door Jam

24. Remove plug grommet on door (if applicable) to expose mounting point (Figure 11).



Figure 11: Remove Rubber Door Grommet

25. Partially remove door panel cover by carefully prying out push fasteners. This will give you access to the back of the mounting point. (See Figure 12)



Figure 12: Remove Plastic Door Rivets

PRO TIP: A door panel rivet puller like the one shown in Figure 13 makes this part of the install a breeze. A flathead screwdriver with some protective tape wrapped around the blade will work also.



Figure 13: Door panel plastic rivet puller

26. Thread webbing anchor into door strap and mount webbing anchor as shown in Figure 14 and Figure 15.



Figure 14: Backside View of Door Stop Mounting

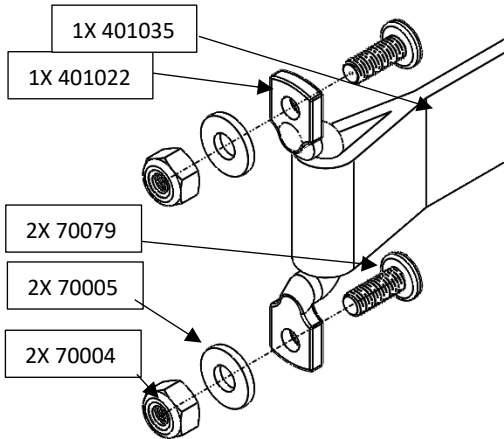


Figure 15: Door Stop Bracket Install

27. Thread the other side of the door stop strap into door jam bracket (installed in step 23) using 1/4"-20 x 3" bolt and 1/4"-20 nylock nut (Figure 16).

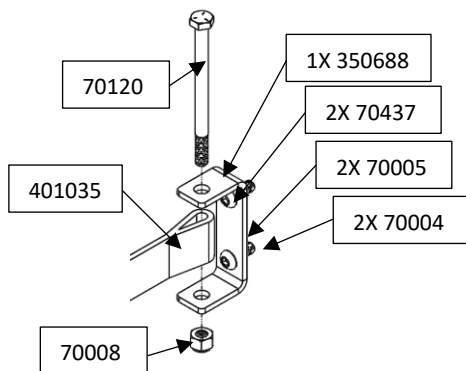


Figure 16: Complete Door Stop Install

28. Verify door hard stop strap install has been completed. See figure 17 below.



Figure 17: Completed Door Strap Installation

29. If mounting a box is desired, grab your included box post assembly (210618.2) and bolt this part to the bottom flange of the base unit using the (70021,70020,70118) hardware . shown in figure 18.

30. 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 into the support posts. Secure box to rail using the hardware shown in figures 19 and 20 below.

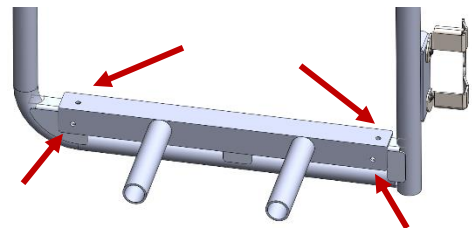


Figure 18: box post assembly

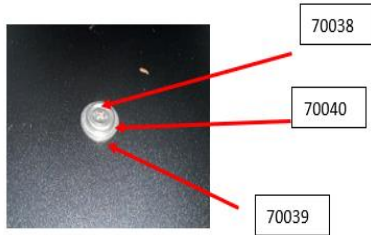


Figure 19: Mounting Hardware Inside Box

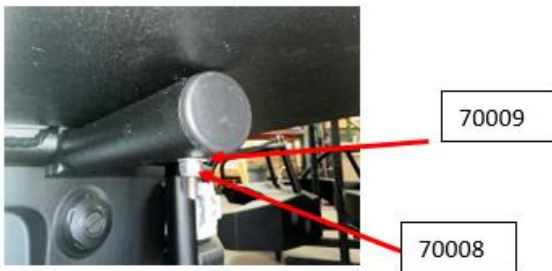


Figure 20: Mounting Hardware Outside Box

31. Congratulations! You have completed the installation of your new Aluminess Rear Door Base Unit. Check mounting hardware on entire assembly after the first 100 miles of driving and periodically thereafter. Enjoy!



Aluminess Products, Inc. (Aluminess) Warranty

1. Lifetime Warranty. Aluminess provides a lifetime warranty of its products to the original retail purchaser provided such products are installed correctly according to the official Aluminess installation instructions. Any modification to the original product design, function or use of any Aluminess products will void the Aluminess warranty. Aluminess will have sole discretion to determine warranty eligibility for any and all Aluminess products sold to any purchaser.

2. Limited Remedies. Subject to any limitations and exclusions described herein, and subject to Aluminess' determination of warranty eligibility, Aluminess will remedy defects in product materials and/or workmanship of any product by repairing or replacing such defective product, which shall be within Aluminess' sole discretion, without charge for parts or labor. Aluminess may elect in its sole discretion not to replace a defective product and issue the purchaser a refund equal to the purchase price of any defective product or purchaser may elect to receive a credit (equal to such refund) toward the purchase of new Aluminess products. Repair or replacement of a defective product or providing a refund or credit to purchaser will be purchaser's exclusive remedy under this warranty. Damage to a purchaser's vehicle, cargo and/or any other person or property is expressly excluded from the Aluminess warranty.

3. Modification. Aluminess products are designed to be mounted to factory equipped vehicles. Aftermarket additions to such vehicle may or may not require modification of an Aluminess product. The Aluminess warranty does not extend to any Aluminess products that are modified to fit around other otherwise accommodate or be compatible with any aftermarket vehicle accessories or alterations. Aluminess does not guarantee fitment with any other aftermarket accessories or modified vehicle, and it is up to purchaser to determine fitment prior to purchasing any Aluminess product.

4. Damage. Damage to Aluminess products due to normal wear and tear, including, but not limited to, cosmetic issues and superficial scratches, or structural damage to an Aluminess product in connection with any vehicle collisions or other structural degradation in connection with the use of such vehicle (on road or off road) will not be covered by the Aluminess warranty. Additionally, any product user's misuse, neglect, overloading, improper maintenance or improper installation or repair of any Aluminess products are not covered under the Aluminess warranty.

5. Use of the Products. Aluminess products are designed for off road vehicle use. Installing Aluminess products on a vehicle may exceed the factory designed capabilities of such vehicle and could potentially lead to vehicle damage. Aluminess will not be responsible for any damage caused to a purchaser or user's vehicle or any vehicle accessories caused by the use of any Aluminess products. It is to the sole responsibility of purchaser to inspect and ensure that the intended vehicle and Aluminess products are suitable and compatible for travel on road and off road. No seller nor any manufacturer of Aluminess products will be liable for any loss, damage or injury directly or indirectly arising from the use of any Aluminess products. Before using any Aluminess products, the purchaser or user will determine the suitability of the product(s) for their intended use(s) and the purchaser or user shall assume all responsibility and risk in connection therewith.

6. DISCLAIMER. THE ALUMINESS WARRANTY IS EXPRESSLY MADE IN LIEU OF ANY AND ALL OTHER WARRANTIES, AND EXCEPT FOR THE ALUMINESS WARRANTY SET FORTH HEREIN, ALUMINESS MAKES NO WARRANTY WHATSOEVER WITH RESPECT TO ANY ALUMINESS PRODUCT, INCLUDING ANY WARRANTY OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, WHETHER EXPRESS OR IMPLIED BY LAW, COURSE OF DEALING, COURSE OF PERFORMANCE, USAGE OF TRADE, OR OTHERWISE.

EXCEPT FOR PURCHASER'S LIMITED REMEDIES SET FORTH HEREIN, IN NO EVENT WILL ALUMINESS BE LIABLE FOR ANY LOST PROFITS, LOST SALES, OR FOR ANY CONSEQUENTIAL, DIRECT, INDIRECT, INCIDENTAL, SPECIAL, EXEMPLARY OR PUNITIVE DAMAGES OR FOR ANY OTHER DAMAGES OF ANY KIND OR NATURE.

7. Compliance. Aluminess cannot guarantee that its products comply with all Federal, State, and/or local laws. Purchaser is advised to review local vehicle codes for compatibility prior to purchase to ensure that the installation and use of any Aluminess products does not violate any applicable laws.

8. Warranty Claim Submission. Purchaser will responsible for returning any defective product to Aluminess for warranty consideration and purchaser may be responsible for all costs associated with shipping the product to and from Aluminess. Prior to returning any product for warranty, purchaser must contact Aluminess Products Inc. for proper authorization.

REVISION TABLE:

Revision:	Description	Changed By:	Date:
A	Initial Release – taken from 210566; Rev. B	K. Cabaniss	5/8/23
B	Added Support posts and updated installation instructions, Added box mounting info and hardware	E. Isacowitz	7/14/23
C	Added foam tape to the pull list	M.Jansen	7/25/23
D	Added new picture to show the small post	M.Jansen	8/2/23
E	Changed 70459 to 70477 for hardware and description	E.Isacowitz	8/2/23
F	Added tension bar Brackets to included parts	K.Mesch	8/2/23
G	Updated Fig 5 with correct PN, changed quantity of 70079, 70005, and 70004 from 2 to 4. Added mounting hardware for upper tension bar (70019, 70020, 70021).	E. Isacowitz	8/17/23
H	Corrected description for hardware 70021	E. Isacowitz	8/17/23
I	Corrected procedure for attaching upper tension bar to base unit and van	E. Isacowitz	8/24/223
J	Changed out the support post for the box post assembly and changed the hard wear quantity for this part	M.Jansen	11/8/23
K	Removed Figure reference error	K.Mesch	1/30/24
L	Added thick washers as shims for tension bar bracket	K. Cabaniss	3/4/24
M	Corrected hardware for box mounting and restructured images	K.Mesch	3/7/24
N	Added 5/16 split washer to the hardware list	M.Jansen	5/17/24