



Tire/Box Rack Installation

Instructions

P/N 210716: 2013+ Dodge Promaster Rear Door Tire/Box, Driver's Side

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*
- *This installation requires the license plate and license plate light to be relocated. Electrical connections must be made – Professional Installation Required*
- *Unless otherwise specified, refer to the general torque value at the end of the instructions for specified torque values.*

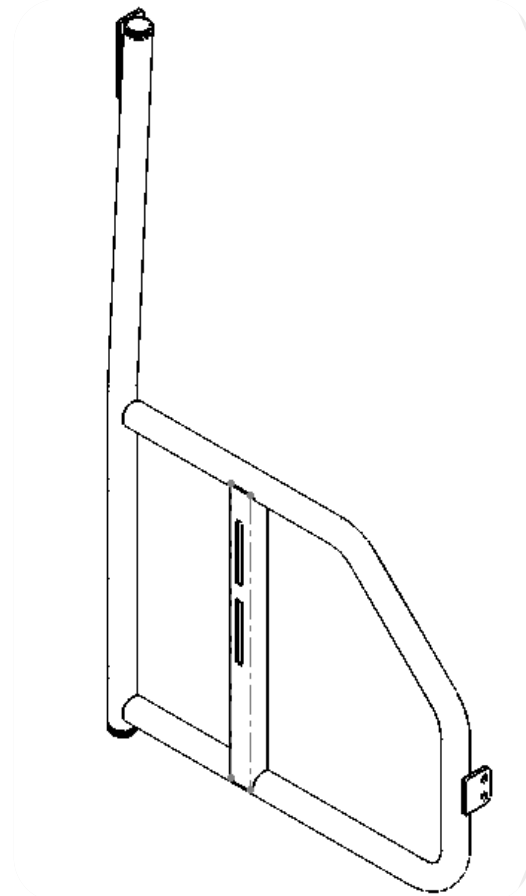
Required Tools:

- Standard and metric wrench set
- Standard and metric socket set
- Standard/Metric Allen Keys or Hex Sockets
- Torx bit set
- Breaker bar (*Strongly advised not to use an impact gun*)
- Tin-snips or Heavy Duty Cutting Pliers (*For cutting weather stripping*)
- Isopropyl Alcohol
- Baby Soap or Dish Soap
- Spray Bottle
- Clean Rag
- Squeegee (or old credit card)
- Vise grips
- Door panel plastic rivet puller or Flat Head Screw Driver
- Scissor/Floor Jack (Optional, for supporting door)

Included Hardware:

P/N	Description	Quantity
70344	5/16"-18 x 1" Button Head Bolt, BLACK OXIDE	6
70345	5/16" ID Washer, BLACK OXIDE	12
70346	5/16"-18 Nylon-Locking Nut, BLACK OXIDE	6
400999	Impact Resistant Protective Tape	14.5"
70462	Bolt, 6-32 x 1", Full Thread, Socket Cap, Black Oxide	2
70002	Washer, SAE Flat, SS, #8	2
70060	Bolt, Button Head, Socket Cap, SS, 1/4-20 x 1"	4
70120	1/4"-20 x 3" bolt	1
70009	Washer, 1/4" ID x 5/8" OD, Flat, SS	4
70008	Nut, 1/4"-20, Nylock, SS	5
401022	Webbing Anchor (<i>For door stop strap mounting</i>)	1
70079	Screw, Pan Head Phillips, SS, 10-32 x 1/2"	2
70005	Washer, #10, SAE Flat, SS	2

Hardware List Continued on Next Page



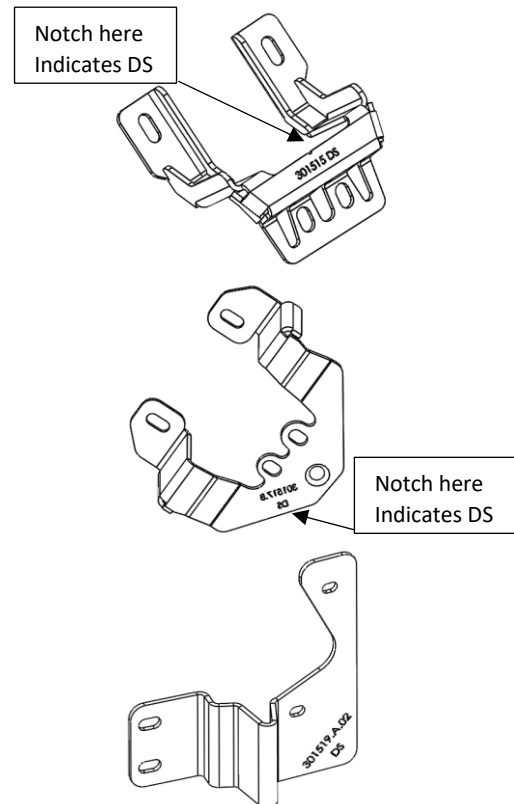


70004	Nut, Nylock, 10-32, SS	2
70477	Bolt, CS Flat Head, M8-1.0 X 30mm, SS	1
70437	Bolt, Button Head, M6-1.0 X 16mm, SS	4
70733	1-3/4" ID EPMD License Plate Hanger Clamp	2
70246	Antiseize Bolt Lubricant Packet, 2g	1
70480	3/8"-16 x 5" Hex Head Bolt, Fully Threaded, Zinc	1
70028	3/8" Washer	3
70024	3/8"-16 Nylock Locking Nut	2
70348	3/8"-16 x 1.25" Carriage Bolt, SS	2
70271	3/8 Internal Tooth Lock Washer, Zinc	1
70448	Washer, 5/16" ID x 3/4 OD, .125 thk	2
70461	Nut, Nylock, 6-32, SS	2
70478	Bolt, 1/4"-20 x 1/2", Tamper-Resistant, SS	4
70479	Bit, 5/32" hex, tamper-resistant	1
401132	1/4" Hex Bit Holder, Key Chain	1

Additional Parts:

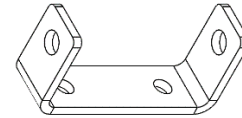
<u>PN</u>	<u>Description</u>	<u>Quantity</u>
350682	Upper Hinge Bracket	1 ea
350684	Lower Hinge Bracket	1 ea
350686	Inner Driver Door Bracket, Driver	1 ea

Picture

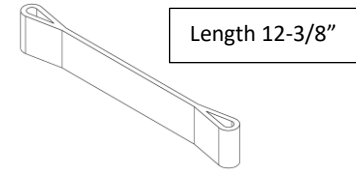




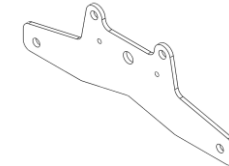
350688 Door Stop Channel 1 ea



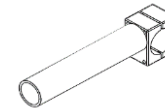
401035 Door Strap 1 ea



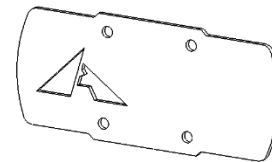
350749 License Plate Mount 1 ea



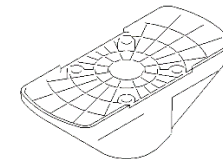
350662 Bolt-On Tire/Box Support (preassembled) 2 ea.



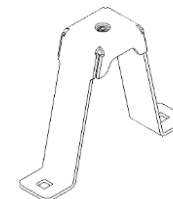
351648 Universal Tire Mount, Wheel Wedge Cover 1 ea



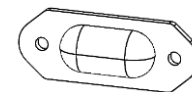
301629 Universal Tire Mount, Wheel Wedge 1 ea



351133 Universal Tire Mount, Bracket 1 ea



400508 LED Light 1 ea.



301258 M8 Machined Spacer 1 ea.





Pre-install Prep:

1. Cut the supplied protective tape into one – 4.5" section, 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 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 Bracket Installation:

10. Install the upper hinge bracket by:
 - a. Support the weight of the door by using a floor/scissor jack/piece of wood or recruit a helper to assist. (Figure 2)



Figure 2: Support Door Prior to Installation



- b. Remove the two bolts connecting the upper hinge to the door. (Figure 3)

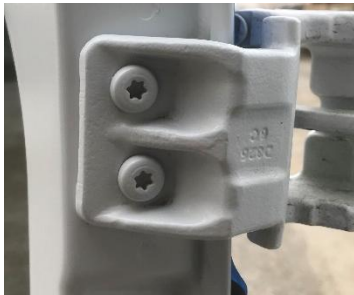


Figure 3: Top Hinge View

- c. Rotate hinge to allow the bracket to be installed around the hinge (Figure 4).



Figure 4: Upper Hinge Rotated Away from Door

- d. Install the bracket around the hinge in the correct orientation (Figure 5).



Figure 5: Bracket Installed Over Factory Hinge

- e. Swing hinge and bracket back into position against the door. (Figure 6)



Figure 6: Bracket Installed Over Factory Hinge

- f. Confirm that bracket clears the rear door glass (if applicable) and use the factory hardware to reinstall the hinge/bracket (Figure 7).

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



Figure 7: Inside View of Installed Upper Hinge Bracket



Lower Bracket Installation:

11. Unbolt the two bolts closer to the outside of the door (Figure 8).



Figure 8: Inside View of Lower Hinge

12. Rotate hinge outwards to allow the bracket to be installed around the hinge.
13. Install the bracket around the hinge in the correct orientation. Reinstall the two bolts closer to the outside of the door through the hinge bracket, while leaving the third bolt tightened (Figure 8).



Figure 9: Bracket Installed Over Factory Hinge

14. After tightening the two bolts closer to the outside of the door, remove the third bolt, place in the Machined Spacer (301258) and reinstall through the spacer and bracket (Figure 10). Tighten hardware.



Figure 10: Bracket Fully Installed with Machined Spacer

15. Slowly close the door to confirm that bracket is clear from any obstructions during closure use.

Inner Bracket Installation:

16. Loosen the weather-stripping on the inside of the driver's side door starting from the top and peel towards bottom of the door.
17. Remove the driver's side inside handle by removing the factory socket head bolt (See Figure 11).



Figure 11: Driver's Side Inside Handle

18. Hold lever mounting post with clamp or vice during the installation to prevent the latch falling into the door (Figure 12). Once clamped remove the two factory torx screws.



Figure 12: Clamp Lever Mounting Post

19. Install the inner driver door bracket using the supplied M6-1X16mm hardware. (See Figure 13).



Figure 13: Inner Driver Door Bracket Installed

20. Reinstall the inside door handle over the bracket using the factory bolt.
21. Verify the inside door handle operates as desired. Repeat Steps 20-21 as needed.
22. Reinstall weather stripping over installed inner bracket and mark where strip overlaps bracket. Peel back weather-stripping again and proceed to cut marked region to fit around inner door bracket. (Refer to figure 14 and 15) On the weather-stripping, cut the channel (attachment to the folded sheet metal) and not the bulb (hollow tube).

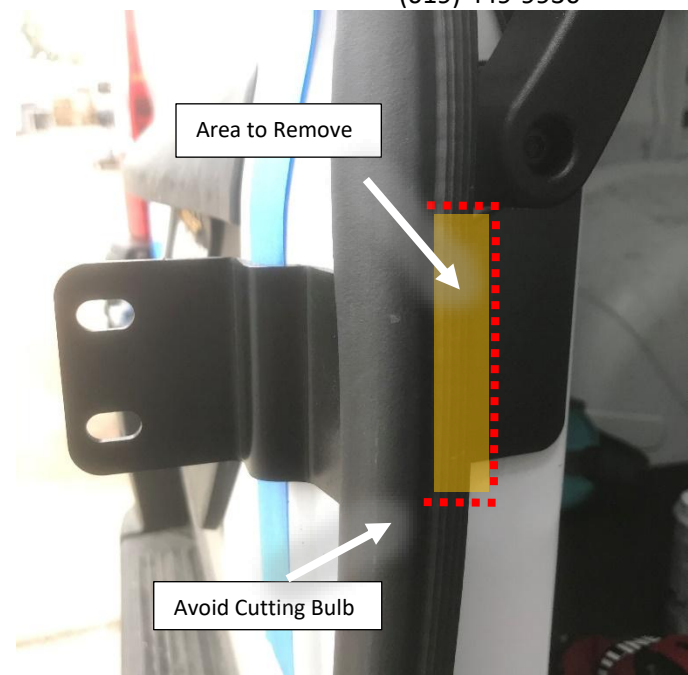


Figure 14: Weather-Stripping Cut to Shape



Figure 15: Cut Weather-Stripping

23. Reinstall weather-stripping over the bracket ensuring cut section lines up with bracket as shown in figure 16.



70448) to close the gap to $\leq 1/8"$ (See Figure 17).



Figure 16: Installed Weather Stripping After Modification

24. Loosely install the rack onto the upper, lower, and inner brackets using the provided 5/16"-18 bolts, washers, and nuts.
 - a. Tighten the upper and lower hinge brackets first.
 - b. There should be a small gap at the center bracket before tightening (0-1/8"). If the gap is larger than 1/8", use the provided 1/8" washers as shims (PN

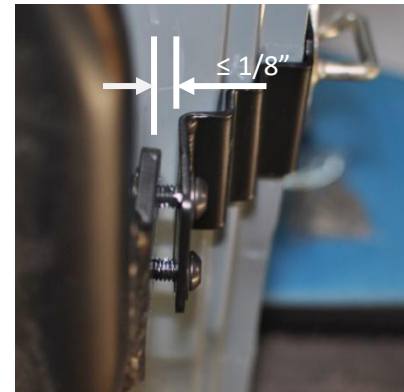


Figure 17: Installed Weather Stripping After Modification

25. Verify the hinge brackets and inner door brackets have appropriate clearances while slowly opening and closing both rear doors.

Door Stop Installation:

26. Install Door Stop Channel Bracket [PN 350688] into factory threaded holes on the inside of the rear door trim using two M6-1X16mm Button Head screws. (Figure 18 and Parts List)



Figure 18: Factory Threaded Holes

27. Remove plug grommet on door (if applicable) to expose mounting point. (Figure 19)



Figure 19: Remove Rubber Door Grommet



28. 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 20)



Figure 20: Remove Plastic Door Fasteners

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



Figure 21: Door panel plastic rivet puller

29. Thread webbing anchor into door strap and mount webbing anchor as shown in figure 22 and 23.



Figure 22: Backside View of Door Stop Mounting

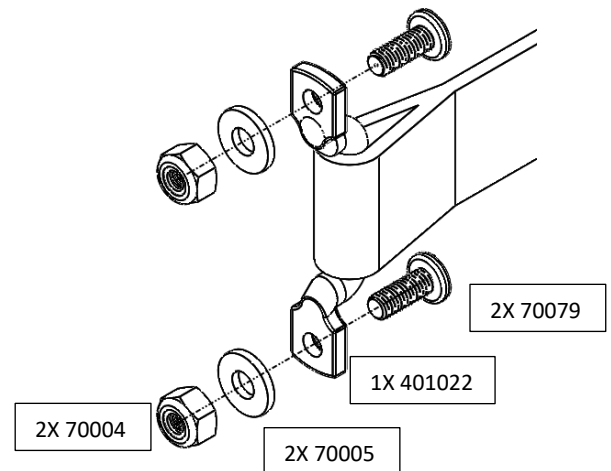


Figure 23: Door Stop Anchor Hardware

30. Thread other side of door stop strap into bracket installed on STEP 26 using $\frac{1}{4}$ -20x3" bolt and $\frac{1}{4}$ -20 nylock nut. (Figure 23) Refer to Figure 24 for complete door stop install.



License Plate Mount Installation:

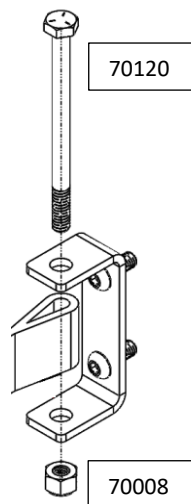


Figure 24: Complete door stop install

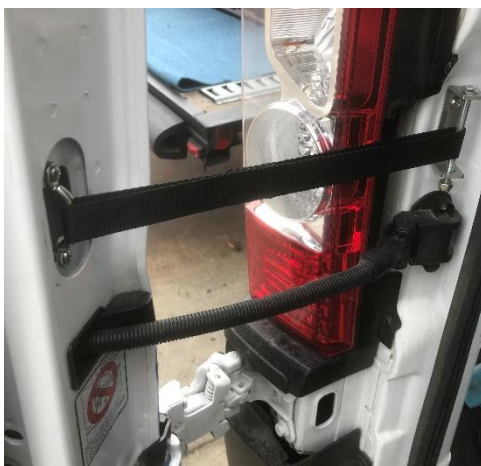


Figure 25: Complete Door Stop Install

31. Reinstall plastic door panel from Step 28.

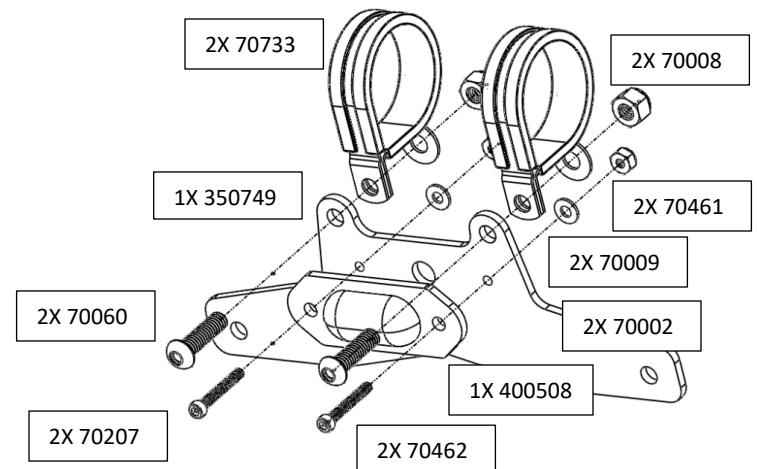


Figure 26: License Plate Mounting Hardware

33. Partially assemble license plate mount without nuts and washers. Wrap clamps around pipe and grasp firmly together. Insert bolts/washers/nuts and hand-tighten nuts onto screws. (See figure 27)

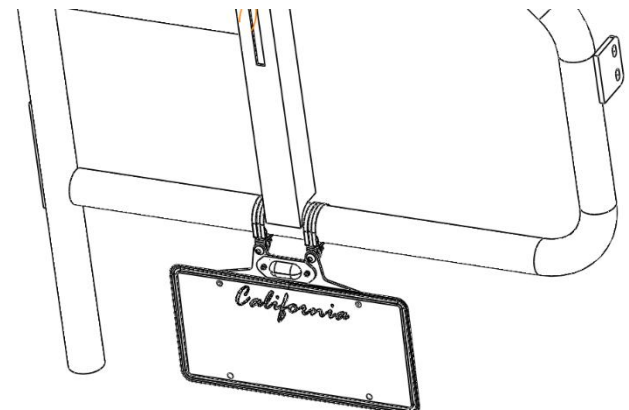


Figure 27: License Plate Mount Installation

34. Verify that position is correct. Proceed to tighten nuts.

35. Install license plate onto mount using (70060) ¼-20 bolts and ¼-20 Nylock washers.



36. For bolt-on LED wiring (PN 400508), please consult a certified automotive electrician to perform installation.

Tire Rack Installation:

37. Install your vans Aluminess Rear Door Ladder per the separately provided installation instructions.
38. Loosely install the bolt-on tire/box supports onto the bottom crossmember of the rack as shown in Figure 28.



Figure 28: Bolt-On Supports Loosely Bolted to Lower Crossmember

39. Starting with support closest to tail light – sliding support as close to the tail light as possible and then rotate into desired position and tighten.

PRO TIP: Reference Figure 29 for suggested mounting orientation.

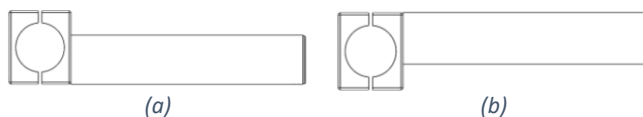


Figure 19: Suggested Orientation for Tire (a) and Box (b)

40. Repeat for the support opposite the center post, being sure that the spacing is equal from the center post, and the orientation is the same for both supports.
41. Loosely fasten the Tire Mount Bracket to the slotted channel, going through the bracket first, using the 3/8" carriage head bolts, washer, and nuts to mount. Reference Figure 30.

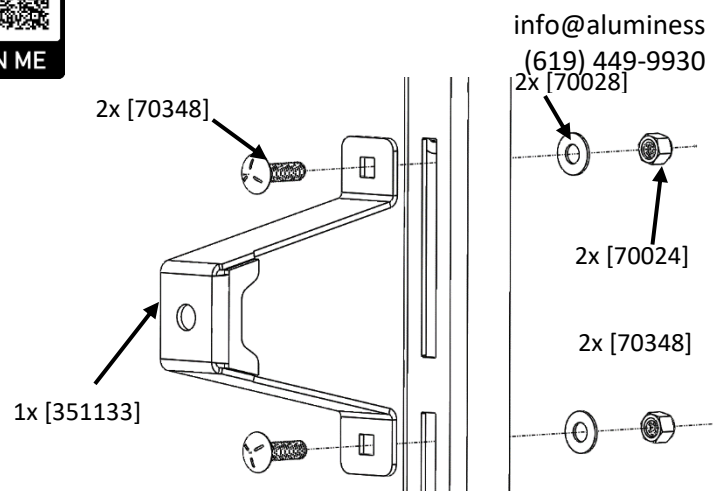


Figure 20: Mounting Tire Bracket

42. Place the mounting bracket in the correct location by placing your tire on the tire supports and then adjusting the bracket vertically until the center hub aligns with the center of the bracket.
43. Once the bracket is in place remove the tire and tighten the hardware holding the bracket in place.
44. Place the tire on the support stands and mount the wheel wedge, using the 5" hex head bolt, washer and star washer. Reference Figure 31 and 32.

NOTE: Do not overtighten this bolt. If the security plate does not fit in step 9, you must loosen the hex head bolt.

Note: Preferred torque is 70 inch pounds.



45. [Optional] If desired, you can mount a Rotopax to the wheel wedge. After installing the cover [Step 46], bolt the rotopax mount through the wheel wedge cover to the wheel wedge using the security bolts [70478], as shown below in figure 33. Then simply install the rotopax onto the mount.

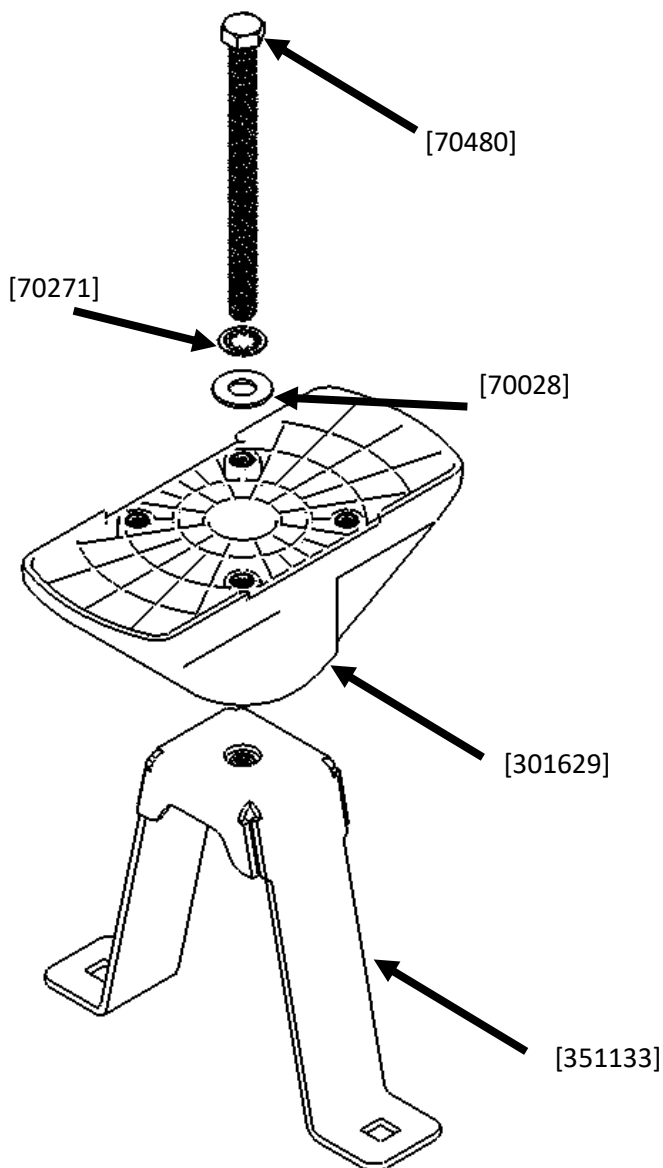


Figure 31: Wheel Wedge Assembly



Figure 32: Tire Mount Assembled



Figure 33: Rotopax Mount

46. Once everything is securely fastened, bolt the cover to the wheel wedge using the included special bit [70479], and bolts [70478]. Reference Figure 34.

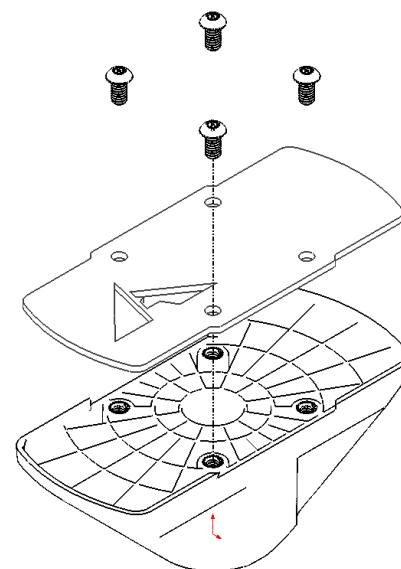


Figure 34: Wheel Wedge Cover Mounting

47. Check mounting hardware after first 100 miles of driving and periodically after to verify hardware has not become loose from vibration.
48. Your new Aluminess tire rack 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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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.
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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.
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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.