



RECON SIDE STEPS INSTALLATION INSTRUCTIONS

P/N 210729: 2014+ RAM Promaster Recon Side Steps

Please read before beginning

- *Stainless steel hardware may bind together when tightening—it is recommended that you apply an anti-seize assembly lubricant to the threads of each bolt before assembly*
- *This installation requires two people*

Required Tools

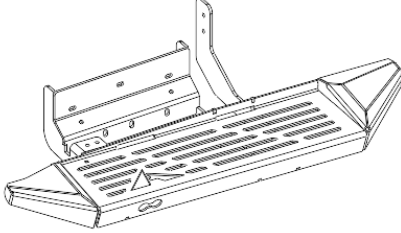
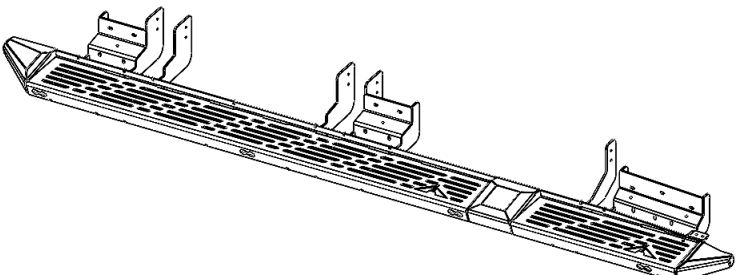
- *Drill with drill bits (3/16", 1/4", & 5/16")*
- *Standard wrench set*
- *Center punch or scribing tool*
- *Level*



Included Hardware:

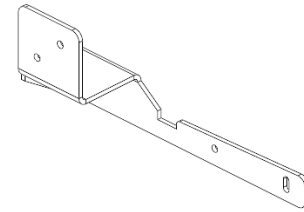
<u>P/N</u>	<u>Description</u>	<u>Quantity</u>
70060	¼"-20 x 1" Bolt, Button Head, Socket Cap, SS,	10
70008	¼"-20 Nylock Nuts SS	14
70009	¼" x 5/8 Washer SS (.03" Thick)	24
70231	Self-Tapping, SS #14 x 1 1/2" Bolt	38
70246	Antiseize Packet, 2g	1

Included Parts:

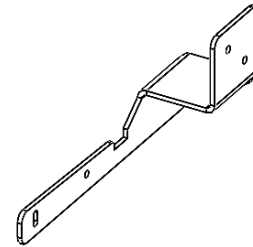
<u>PN</u>	<u>Description</u>	<u>Quantity</u>	<u>Picture</u>
351644	Recon Side Step, Driver's Side	1 ea	
351645	Recon Side Step, Passenger's Side	1 ea	



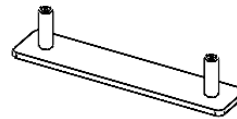
351646 Front Support Bracket, Driver's Side 1 ea



351647 Front Support Bracket, Passenger's Side 1 ea.



350484 Threaded Insert 2 ea.



Installation Instructions:

1. Hold up the passenger side step to the backside of the pinch weld with help from a second installer to verify that there are no obstructions on the mounting surfaces of the pinch. Slide the side steps forward or backwards until the brackets align onto the unibody supports on the underside of the vehicle (**Figure 1 & Figure 2**) – verify by checking alignment of middle shroud with the body seam at the back of the B pillar and front shroud aligns with fender flare (**Figure 3**).

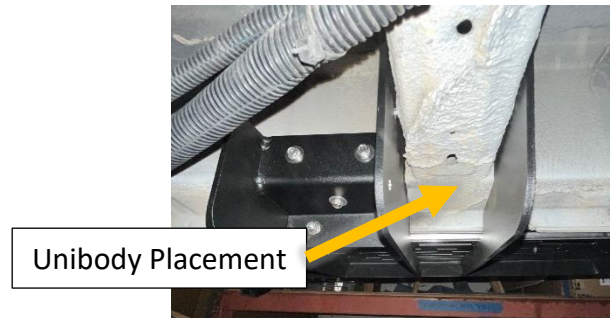


Figure 2: Unibody Placement Example

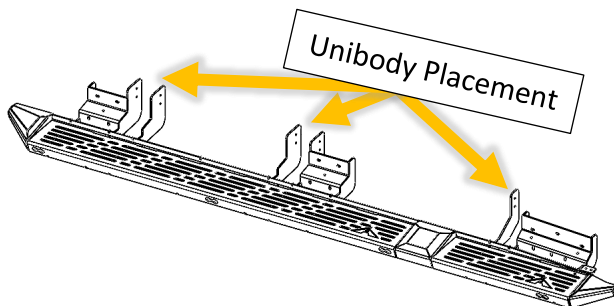


Figure 1: Unibody Placement on Passenger Step



Figure 3: Side Step Alignment with B-Pillar Seam and Front Fender Flare



- Once the correct placement along the van has been located, fasten the upper vertical and horizontal flanges of the step brackets to the vehicle using the self-tapping hardware as shown in **Figure 4**. Place firm pressure on the step against the pinch weld and mating vehicle features to ensure that the steps are properly seated as they're fastened. There are five (5) self-tapping screws on the front bracket and three (3) per bracket on the rear brackets that should be installed horizontally as shown in **Figure 4** for a total of 11 screws.

PRO TIP: If the screws are having a hard time getting started, a 5/32" or 3/16" pilot hole can be drilled first to help get them started.

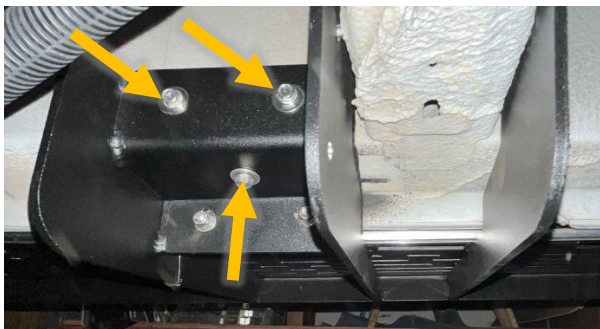


Figure 4: Step Bracket Installation Behind Pinch Weld

- Ensure that the step is level (Figure 5).



Figure 5: Verification that the Step is Level

- While ensuring the step is level, install the ten (10) self-tapping screws into the unibody mounts going front-to-back in the locations and as shown in **Figure 6 & Figure 7**.

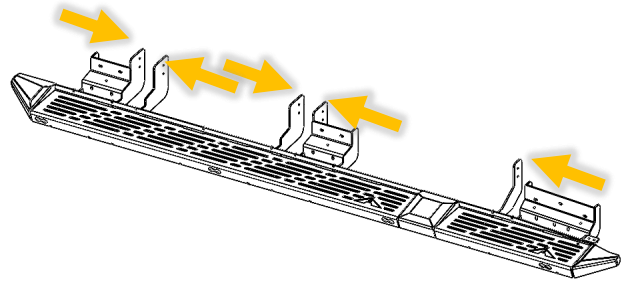


Figure 6: Unibody Self-Tapping Screw Locations



Figure 7: Unibody Self-Tapping Screw Example

NOTE: The unibody is reinforced in this area. It is highly advised to drill a 5/32" or 3/16" pilot hole before trying to install the self-tapping screws.

- Mark the backside of the pinch weld on the van using the pre-cut holes on the step bracket as a template (**Figure 8**). Use a center punch to center the drilled hole in the slotted hole of the bracket. Drill through pinch weld using a 1/4" drill. There are three (3) bolts in the front bracket, and two (2) bolts in middle and rear bracket for a total of seven (7) bolts.

PRO TIP: Using a 1/4" drill for 1/4" bolt can make for a tight connection. Drill first, then test hardware for fitment. Opening the hole slightly may be necessary by either slightly angling the drill while drilling in a circular motion, or going up to a 5/16" drill size.

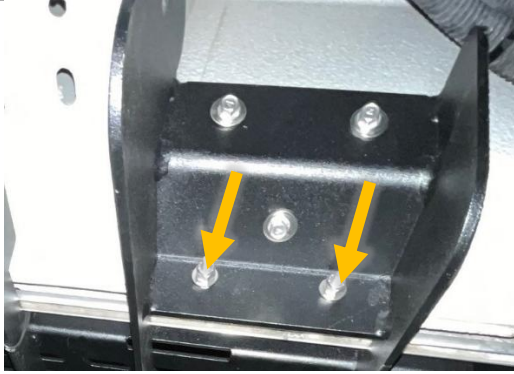


Figure 8: Pinch Weld Bolting Location

6. Use ¼"-20 hardware to fasten each bracket to the pinch weld as shown in **Figure 8**.
7. Slide threaded insert (PN 350484) into open channel at the front of the passenger side step as shown in **Figure 9**. Pull the threads through the holes to align the insert into channel.

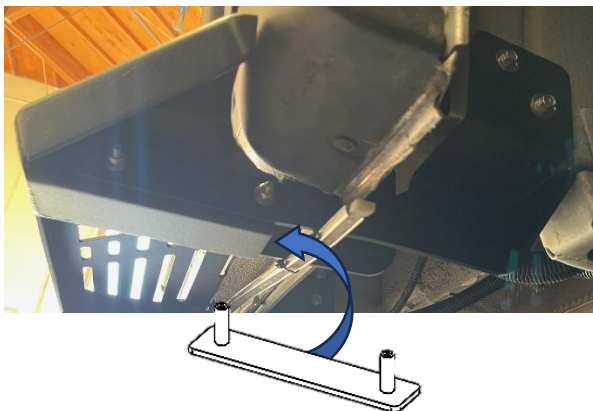


Figure 9: Installation of Threaded Insert

8. Install passenger's side front mounting bracket (PN 351647) over threaded insert and up against the front most unibody support gusset on the vehicle as shown in **Figure 10**. Use two (2) self-tapping screws to fasten the bracket to the vehicle and tighten steps to bracket using ¼"-20 nuts and washers.



Figure 10: Installation of Front Passenger Mounting Bracket

9. Hold up the driver side step to the backside of the pinch weld to verify that there are no obstructions on the mounting surfaces of the pinch. Slide the side steps forward or backwards until the brackets align onto the unibody supports on the underside of the vehicle (**Figure 11**) – verify by checking alignment of middle shroud with the body seam at the back of the B pillar and front shroud aligns with fender flare (**Figure 12**).

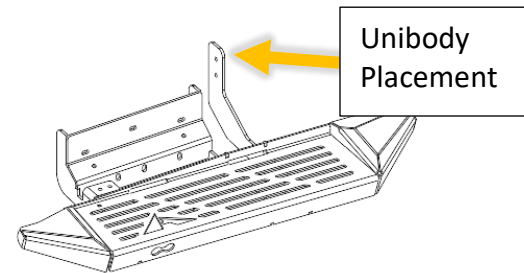


Figure 11: Driver Side Step Mounting Location



Figure 12: Driver's Side Step Vehicle Reference

10. Once the correct placement along the van has been located, fasten the upper vertical and horizontal flanges of the step brackets to the vehicle using the self-tapping hardware as shown in **Figure 13**. Place firm pressure on the step against the pinch weld and mating vehicle features to ensure that the steps are properly seated as they're fastened. There are three (3)



self-tapping screws on the top of the bracket and two (2) on the down angle of the bracket for a total of five (5) screws.

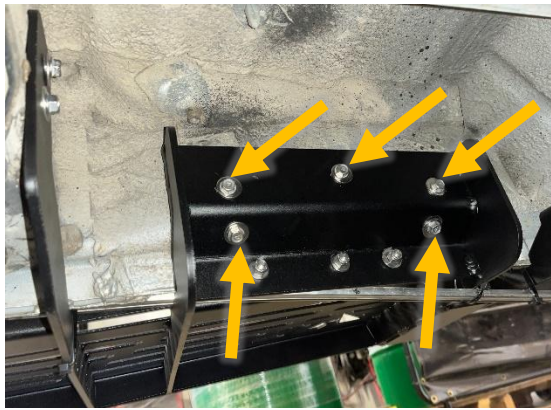


Figure 13: Driver's Side Self-Tapping Fastener Location

11. Ensure the step is level as done in Step 3 (reference **Figure 5**) and install the two (2) self-tapping screws into the corresponding unibody mounts as shown in **Figure 14**.



Figure 14: Driver's Side Unibody Mount

NOTE: The unibody is reinforced in this area. It is highly advised to drill a 5/32" or 3/16" pilot hole before trying to install the self-tapping screws.

12. Mark the backside of the pinch weld on the van using the pre-cut holes on the step bracket as a template (**Figure 15**). Use a center punch to center the drilled hole in the slotted hole of the bracket. Drill through pinch weld using a 1/4" drill. There are three (3) bolts on the pinch weld that will use 1/4"-20 bolts, nuts, and washers.

PRO TIP: Using a 1/4" drill for 1/4" bolt can make for a tight connection. Drill first, then test hardware for fitment. Opening the hole slightly may be necessary by either slightly angling the drill while drilling in a circular motion, or going up to a 5/16" drill size.

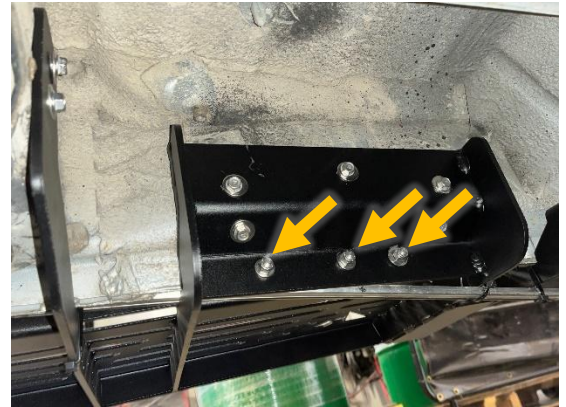


Figure 15: Pinch Weld Mounting Location

13. Install two (2) self-tapping screws from the body into the body as shown in **Figure 16** & **Figure 17**.

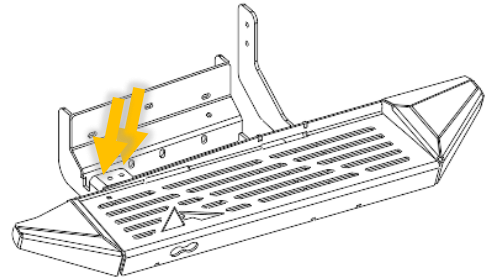


Figure 16: Driver's Side Front Mount Location



Figure 17: Driver's Side Front Mount Example



NOTE: The passenger side steps also have holes for the screws used in Step 13, however they're not needed on the passenger side – the additional bracketry in the rear of the passenger step sufficiently supports that side.

- Slide threaded insert (PN 350484) into open channel at the front of the driver side step as shown in **Figure 18**. Pull the threads through the holes to align the insert into channel.

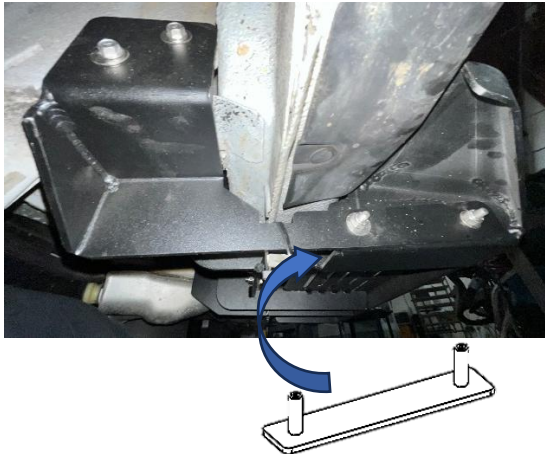


Figure 18: Installation of Threaded Insert

- Install passenger's side front mounting bracket (PN 351647) over threaded insert and up against the front most unibody support gusset on the vehicle as shown in **Figure 10**. Use two (2) self-tapping screws to fasten the bracket to the vehicle and tighten steps to bracket using $\frac{1}{4}$ "-20 nuts and washers.



Figure 19: Installation of Front Passenger Mounting Bracket

- Double check that all mounting bracket fasteners are tight throughout the entire installation.

NOTE: There are four (4) additional self-tapping screws (PN 70231) provided along with the hardware kit in case the drill tip does not work correctly.

Baja Designs Rock Light Installation

- Using the hardware provided by Baja Designs, secure the rock lights to the rock light mounting tabs as shown in **Figure 20**. If the hardware doesn't fit through the Rock Light Mounting Tab hole, drill it out with a $\frac{11}{64}$ " drill bit.

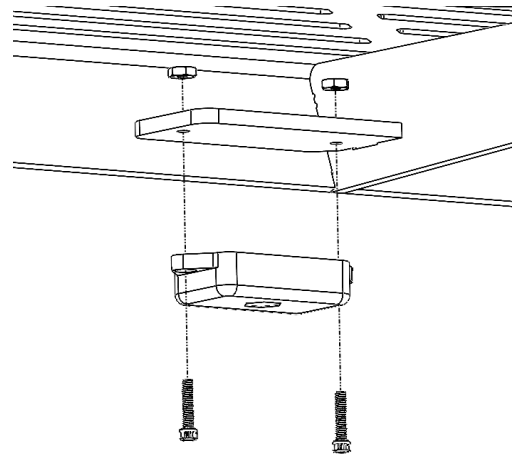


Figure 20: Rock Light Installation

- Congratulations, you've completed the installation! Verify all mounting hardware remains tight after 100 miles and periodically thereafter. Enjoy!



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