

DODGE PROMASTER BASE UNIT INSTALLATION INSTRUCTIONS

SKU: 210771

IMPORTANT

- APPLY ANTISEIZE TO STAINLESS HARDWARE
 - Stainless steel hardware may bind together when tightening—MUST apply an **anti-seize** lubricant to the threads of each bolt before assembly.
- Maximum load capacity is 200 lbs evenly distributed on base unit rack.
- Installation requires two or more people.



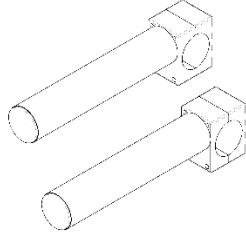
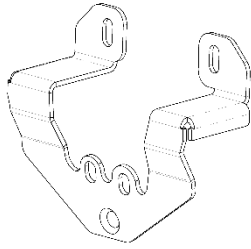
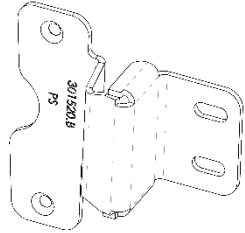
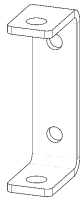
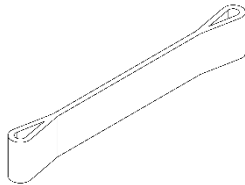
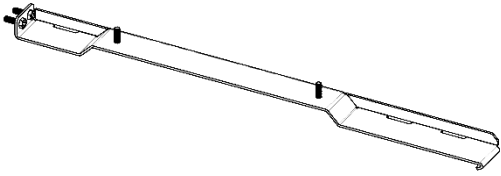
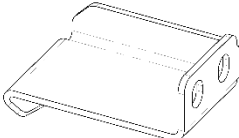
Required Tools

- Standard/Metric Wrenches
- Standard/ Metric Sockets
- Standard/Metric Allen Keys OR Hex Sockets
- Tin-Snips OR Heavy-Duty Cutting Pliers
- Isopropyl Alcohol
- Liquid Soap
- Spray Bottle
- Clean Rag
- Squeegee OR Plastic Card

Included Hardware

PN	DESCRIPTION	QUANTITY
70004	10-32 Nylock Nut, SS	2
70005	#10 Washer, SS	2
70008	1/4-20 Nylock Nut, SS	1
70079	10-32 X 1/2 Phillips Screw, SS	2
70246	Loctite Anti-Seize, 2g	1
70344	5/16-18 X 1 Button Head Bolt, SS, Black Oxide	4
70345	5/16 Washer, SS, Black Oxide	10
70346	5/16-18 Nylock Nut, SS, Black Oxide	10
70437	M6-1.0 X 16MM Button Head Bolt, SS	2
70447	1/4-20 X 3 1/4" Hex Head Bolt, SS, Zinc	1
70448	5/16 Thick Washer, SS, Black Oxide	4
70458	M6-1.0 X 16MM, Countersunk Bolt, SS, Zinc	2
70477	M8-1.0 X 30MM Countersunk Bolt, SS, Zinc	1
400999	Impact Resistant Protective Tape	14.5"
401022	Webbing Anchor	1

Included Parts/Subassemblies

PN	DESCRIPTION	QUANTITY	PICTURE
210618	8" Tire Support Post (Set of 2)	1	
350685	Lower Hinge Bracket, Passenger	1	
350687	Inner Door Bracket, Passenger	1	
350688	Door Stop Channel	1	
401035	Door Strap	1	
351104	Tension Bar Base	1	
351105	Tension Bar Bracket	1	

Install Instructions

Prep:

NOTE: Provided as additional paint protection.

1. Cut the supplied protective tape into 2X 2" section, a 3" section, and a 7" section. Round all corners.
2. Prepare to apply the protective tape **one at a time** to each location shown on the passenger door in Figure 1,
 - a. Upper inner door
 - b. Upper outer door
 - c. Lower hinge
 - d. Lower inner door, the tape is located at the same height as the latching mechanism

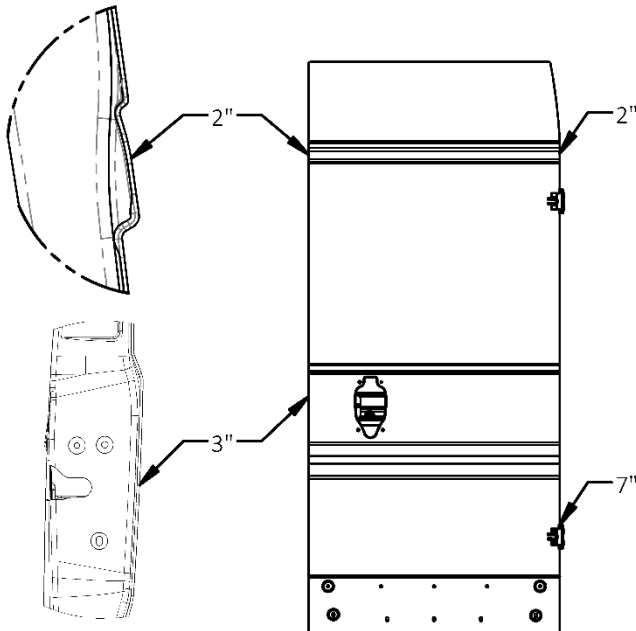


Figure 1: Protective Tape Location

IMPORTANT: Do not apply in direct sunlight, temperature must be above 60 °F, and wash your hands thoroughly before application.

- e. Clean the area around each hinge with isopropyl alcohol and rag.
- f. Create two separate wetting solutions in spray bottles:
 - i. Soap and water: 95% water and 5% soap
 - ii. Alcohol and water: 75% water and 25% isopropyl alcohol
3. Spray the taping location thoroughly with soap/water solution and do **not** wipe down surface.

4. Remove the liner from the protective tape while spraying the **adhesive side** with soap/water solution.
5. Apply the protective tape to the outside of the door. At the upper and lower hinge location, leaving approximately a ½" of tape overhanging to be wrapped around the edge of the door. Do **not** attach the overhang yet.
6. Use a squeegee or card to press all air bubbles out starting at adhered edge.
7. Use the alcohol/water solution to speed up adhesion at one edge by lifting a section up and spraying the adhesive side as needed.
8. Wrap remaining protective tape around the door underneath hinge as best as possible else, finish wrapping at Step 11.

Tension Bar and Bracket Install:

9. Loosely bolt the tension bar base and the tension bar bracket to the vehicle as shown in Figure 2 using the two 5/16" washers (70345) and two 5/16" nylock nuts (70346). Do **not** tighten.
 - a. NOTE: The small bracket should be on the right side towards the door hinges.
 - b. There should be a gap of less than 1/8" but greater than 0", if the gap is larger than 1/8", add 5/16 thick washers (70448) in the gap between the tension bar components. Add washers according to Table 1.

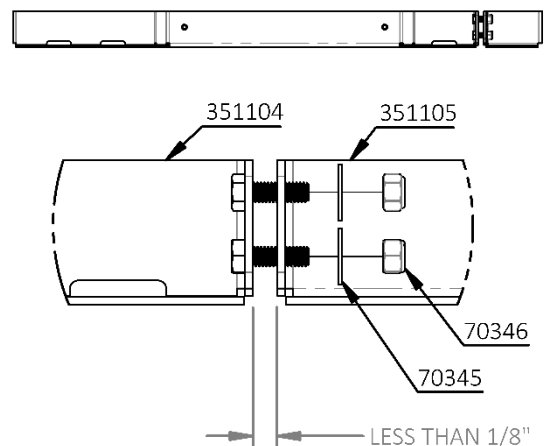


Figure 2: Tension Bar Spacing and Hardware

Table 1: Tension Bar Thick Washer Specification

Gap	Washer Quantity per Bolt	Total Washers
Less than 1/8"	0	0
1/8" to 1/4"	1	2
Larger than 1/4"	2	4

10. Remove the three factory bolts connecting the lower hinge to the door as seen in Figure 3. Keep the bolts to reinstall.

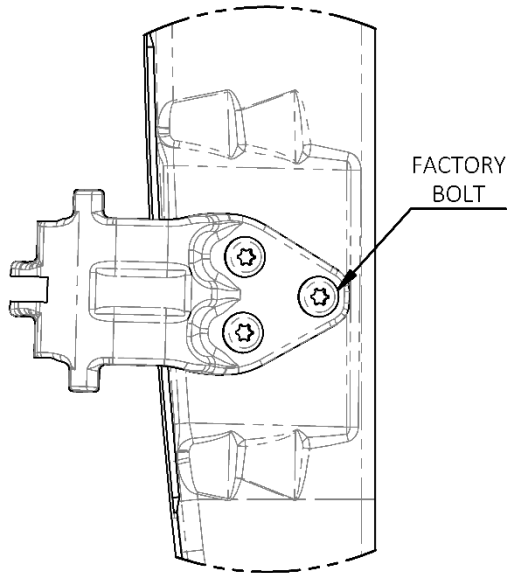


Figure 3: Lower Hinge

11. Rotate the hinge away from the door. Install the lower hinge bracket (350685) onto the hinge such that the bracket can wrap towards the outside of the door. Rotate the bracket and hinge back to the door. See Figure 4 for reference.

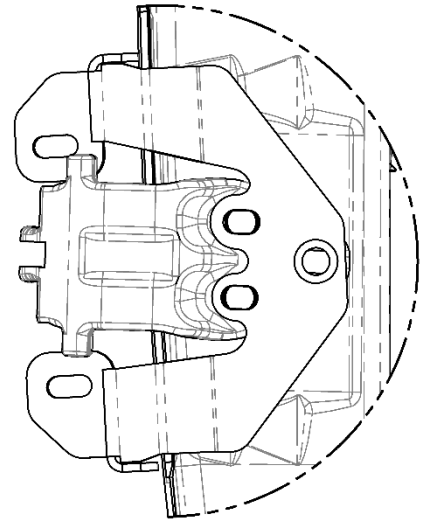


Figure 4: Lower Hinge Bracket Orientation

12. Reinstall 2 of the factory bolts and the provided countersunk M8-1.0 X 30mm bolt (70477) to attach the bracket to the door as seen in Figure 5.

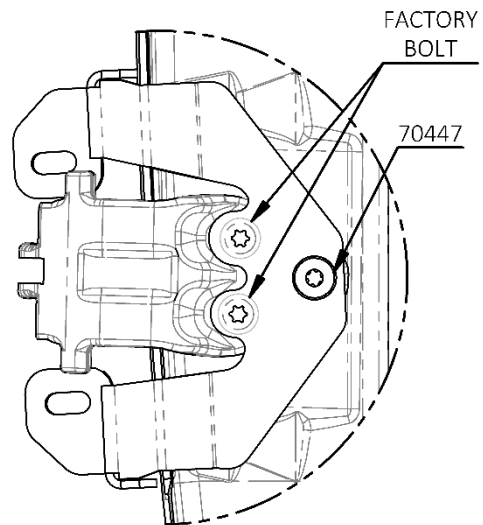


Figure 5: Lower Bracket Installed

13. Remove the two factory bolts that hold the door latch in place, shown in Figure 6.

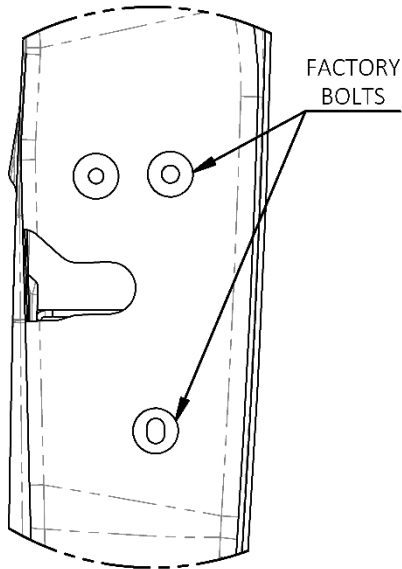


Figure 6: Inner Door Latch

14. Install the inner door bracket (350697) as shown in Figure 7 using the provided two countersunk M6-1.0 X 16mm bolts (70458).

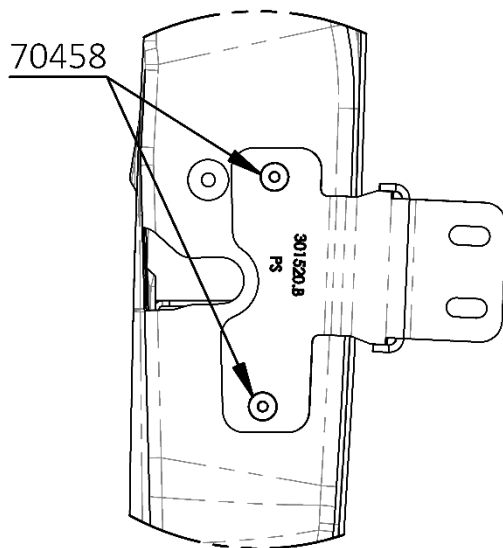


Figure 7: Inner Bracket Installed

Base Unit Install:



WARNING: Follow Step 15-18 Carefully. Failure to do so may result in damage to the door!

15. Loosely bolt the base unit to the tension bar using two 5/16" washers (70345) and two 5/16" nylock nuts (70346) as seen in Figure 8.
- NOTE: Ensure that the base unit does not hit the door.

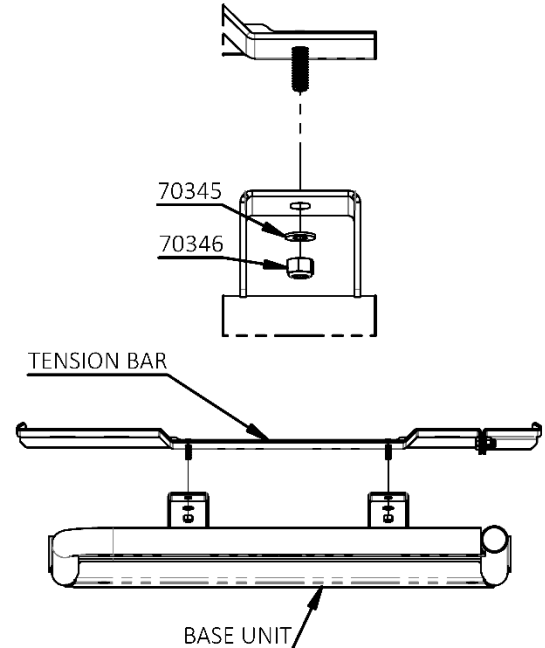


Figure 8: Base Unit and Tension Bar Hardware

16. Loosely bolt the base unit to the lower hinge bracket using two 5/16"-18 X 1" button head bolts (70344), two 5/16" washers (70345) and two 5/16" nylock nuts (70346) as seen in Figure 9.

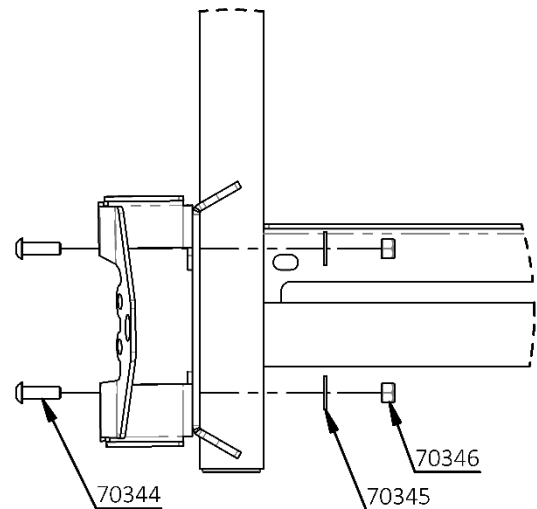


Figure 9: Lower Hinge Mounting Hardware

17. Loosely bolt the base unit to the inner door bracket using two 5/16"-18 X 1" button head bolts (70344), two 5/16" washers (70345) and two 5/16" nylock nuts (70346) as seen in Figure 10.

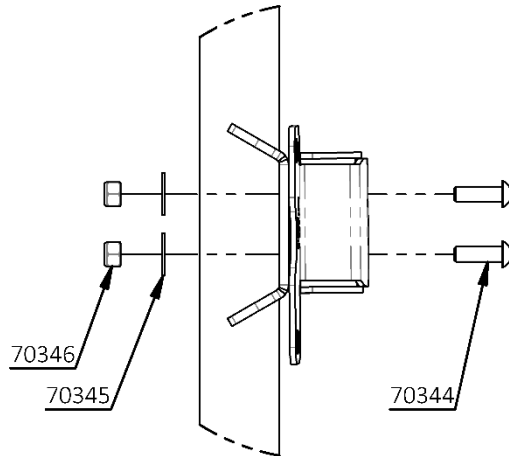


Figure 10: Inner Door Mounting Hardware

18. Tighten the 5/16" hardware for the tension bar, then the lower hinge bracket, and lastly tighten the inner door bracket.
 - a. NOTE: Do NOT overtighten the tension bar, can cause damage to your door.

Door Stop Install:

19. On the door trim next to the taillight, install the door stop channel bracket (350688) into the factory threaded holes using two M6-1.0 X 16mm button head screws (70437) as seen in Figure 11.



Figure 11: Factory Threads on Door Trim

20. Remove the plug grommet located on the of the door as seen in Figure 12.



Figure 12: Rubber Door Grommet

21. Partially remove door panel cover by carefully prying out push fastener using a plastic rivet puller or a flat head screw driver (recommend wrapping the flat head with tape to protect the paint). See Figure 13.



Figure 13: Plastic Door Rivets

22. Thread the door strap (401035) into the door stop channel (Step 19) as shown in Figure 14.

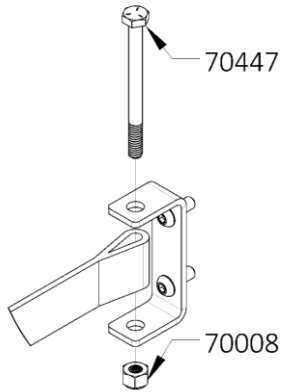


Figure 14: Door Stop Channel Hardware

23. Thread the other end of the door strap (401035) into the webbing anchor (401022) as shown in Figure 15. Install the webbing anchor to the door where the rubber grommet was removed.

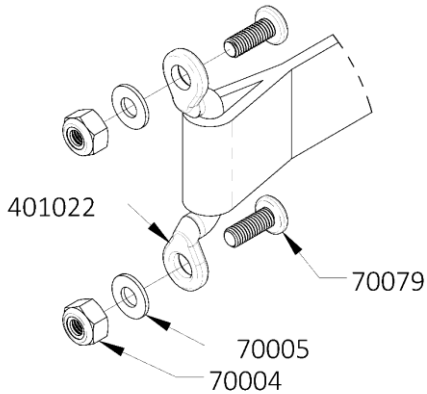


Figure 15: Webbing Anchor Hardware

24. Door strap should now look like Figure 16.

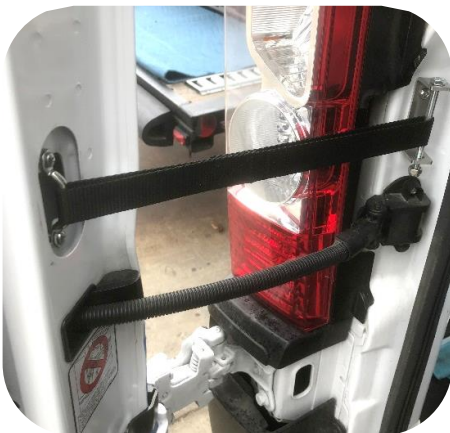


Figure 16: Installed Door Stop

25. Reinstall the door panel from Step 21.

Support Post Install:

26. If mounting a box or bike is desired, grab your included 8" support posts (350662). Unscrew the bolts holding the pipe clamp together and place the posts facing out on the bottom of the pipe of the base unit. Adjust the posts so that they are level with the van and evenly spaced over. Tighten the pipe clamp support posts down. See Figure 17 for reference.

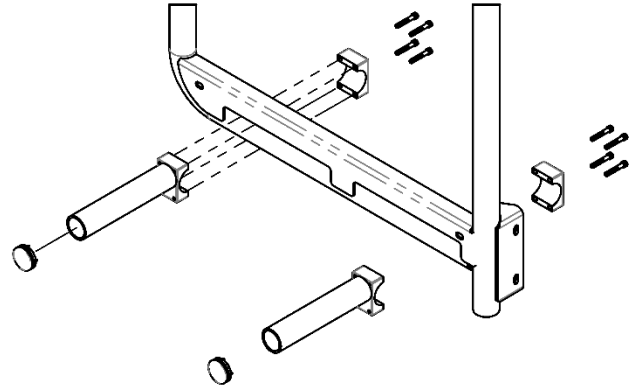


Figure 17: Support Post Installation

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!

TORQUE SPECIFICATIONS			
SIZE (SAE)	18-8 SS	GRADE 5 ZINC PLATED	GRADE 8 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 ZINC PLATED	CLASS 10.9 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



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.
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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.