

# TOURING SIDE STEP INSTALLATION INSTRUCTIONS

P/N 210687: 2007+ Mercedes Sprinter Touring 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**

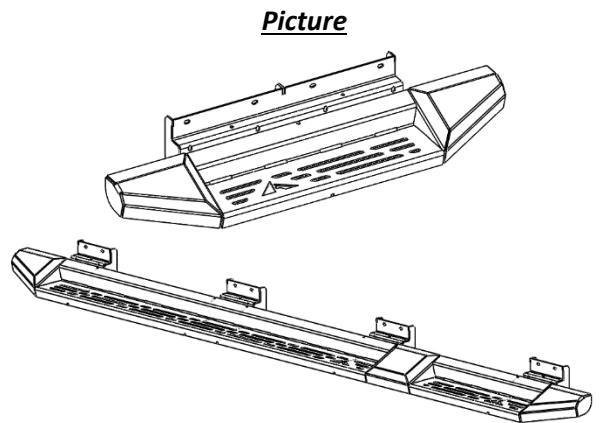
- *Drill with drill bits (3/16", 1/4", & 5/16")*
- *Standard wrench set*
- *Center punch or scribing tool*
- *Level*

**Included Hardware:**

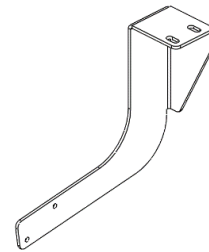
<u>P/N</u>	<u>Description</u>	<u>Quantity</u>
70008	¼"-20 Nylock Nuts SS	14
70009	¼" x 5/8 Washer SS (.03" Thick)	28
70060	¼"-20 x 1" Bolt, Button Head, Socket Cap, SS,	14
70024	3/8"-18 Nylock Nut, SS	1
70028	3/8" ID Flat Washer	2
70029	3/8"-16 x 1-1/4" Hex Head Bolt, SS	1
70231	Self-Tapping, SS #14 x 1 1/2" Bolt	22
70246	Antiseize Packet, 2g	1

**Included Parts:**

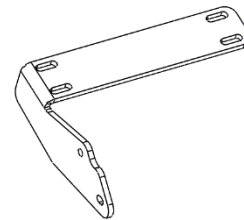
<u>PN</u>	<u>Description</u>	<u>Quantity</u>
N/A	Side Step, Driver's Side	1 ea
N/A	Side Step, Passenger's Side	1 ea



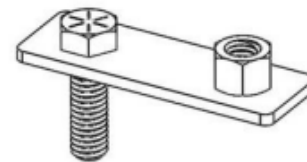
301620 Middle Step 'J' Bracket 1 ea



301030.1 Driver's Side, 90 Degree Bracket 1 ea



N/A Welded Bolt Plate 1 ea



**Installation Instructions:**

1. Located the second 'U'-shaped opening in the structural member on the underside of the van (located at the approximate middle of the slider door) as shown in Figure 1. Install bolt plate through this opening in the flooring structure. The nut should slide in first leaving the bolt exposed in the opening (Figure 2).



Figure 1: Flooring Structure on Underside of Van

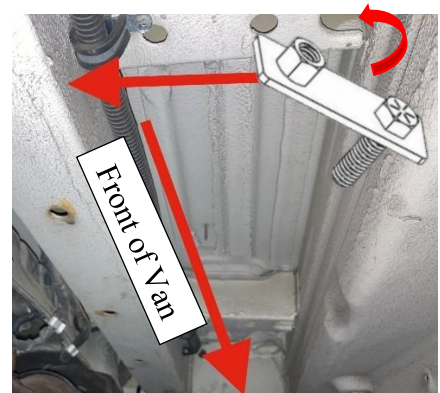


Figure 2: Bolt Plate Installation

2. Loosely fasten the 'J' bracket onto the bolt plate using the 3/8"-16 hardware (Figure 3).



Figure 3: 'J' Bracket Installed onto Bolt Plate

3. 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. Slide the side steps forward or backwards until the middle brackets contacts the 'J' bracket and the middle shroud is aligned with the body seam at the back of the B pillar (Figure 4 & Figure 5).



Figure 4: Side Step Alignment with B-Pillar Seam

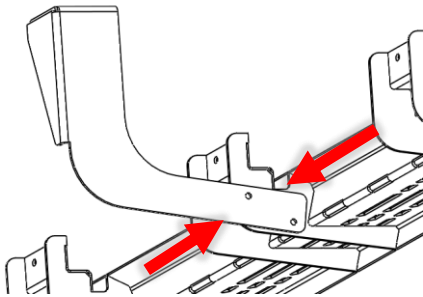


Figure 5: 'J' Bracket Locating on Middle Step Bracket

4. 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 6. 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 per bracket; one (1) vertically and two (2) horizontally installed.

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



Figure 6: Step Bracket Installation Behind Pinch Weld

5. Ensure that the step is level (Figure 7).



Figure 7: Verification that the Step is Level

6. 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.

**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.

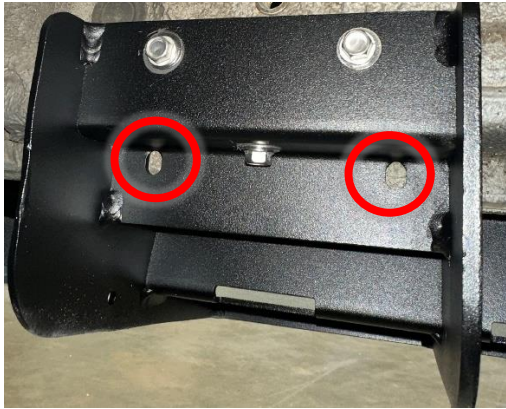


Figure 8: Marking Pinch Weld for Drilling

7. Use ¼"-20 hardware to fasten each bracket to the pinch weld as shown in Figure 9.



Figure 9: Pinch Weld Fastener Installation

8. Using the bottom of the 'J' bracket as a template, drill two ¼" holes through the rear face of the middle step bracing (Figure 10). Ensure the step has remained level prior to drilling.

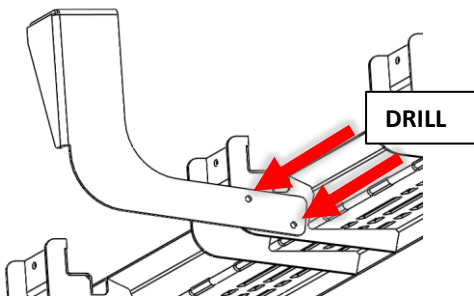


Figure 10: 'J' Bracket Installation

9. Fasten the 'J' bracket onto the slider step using ¼" hardware and tighten the 3/8" hardware at the bolt plate on the vehicle flooring structure.

10. Repeat Step 3 through Step 7 for the driver's side step with the following changes:
  - a. Line up the B-pillar seam with the inside of the rear shroud (Figure 11, arrow).
  - b. Use six (6) self-tapping screws total for the upper vertical and horizontal flanges of the step brackets (Figure 11).
  - c. Use four (4) ¼"-20 bolts total for the pinch weld fasteners (Figure 11, circles).

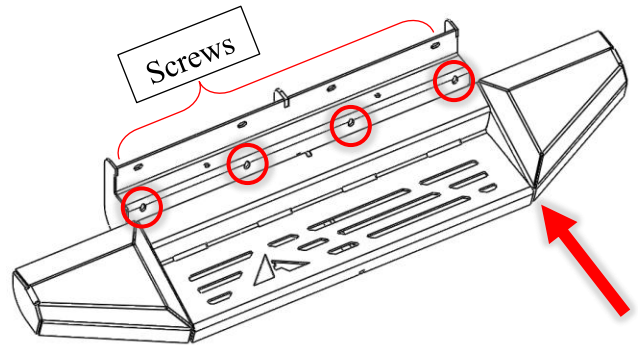


Figure 11: Driver's Side Step Install

11. Loosely install the 90 degree bracket to the back of the rear bracing on the rear shroud. Use the pre-cut hole on the shroud bracing and the lower, slotted hole on the 90 degree bracket to loosely connect (Figure 12).

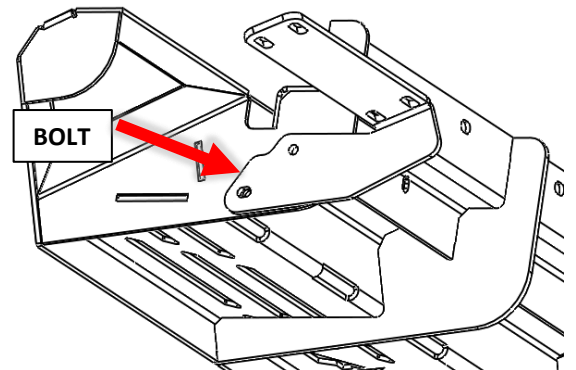


Figure 12: Installation of 90 Degree Bracket

12. Align the slots on the 90 degree bracket with the underside of the angled, B-pillar bracing on the vehicle and fasten using self-tapping bolts into the van as shown in Figure 13 (four screws total).



Figure 13: 90 Degree Bracket Installation onto Van

13. Once the 90 degree bracket is bolted firmly onto the van, drill the second hole into the rear shroud bracing to permanently lock the rotation (Figure 14). Use a  $\frac{1}{4}$ " drill bit and  $\frac{1}{4}$ "-20 hardware to fasten together.

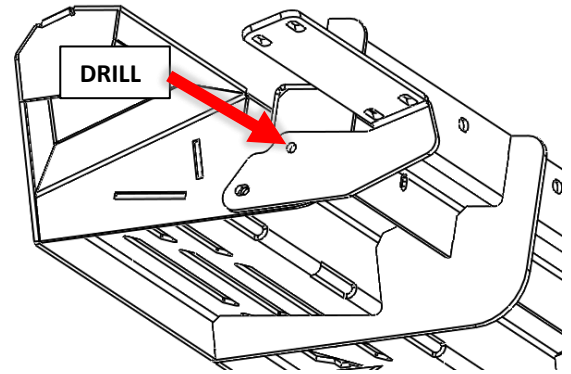


Figure 14: Drilled Hole to Lock Rotation of Step

14. Double check that all mounting bracket fasteners are tight throughout the entire installation.
15. Congratulations, you've completed the installation! Verify all mounting hardware remains tight after 100 miles and periodically thereafter. Enjoy!



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