

TOURING SIDE STEP INSTALLATION INSTRUCTIONS

P/N 210692: 2015+ Ford Transit Touring Side Steps

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 may require two people*



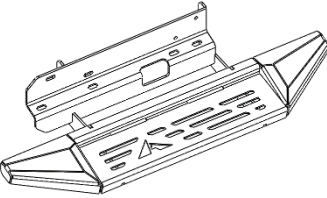
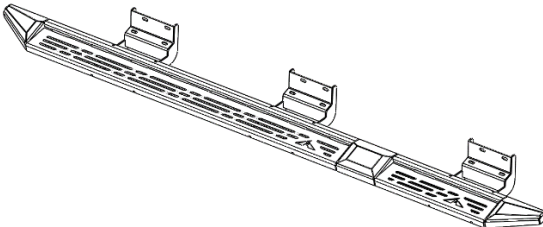
Required Tools:

- Standard and metric wrench set
- Standard and metric socket set
- Drill or impact driver
- Wire brush
- M8-1.25 tap (optional)
- M8-1.25 die (optional)

Included Hardware:

P/N	Description	Quantity
70231	Self-tapping screw, #14 x 1-1/2", SS	24
70124	M8-1.25 x 40mm hex head bolt	10
70101	M8-1.25 hex nut	8
70435	5/16" ID split washer, SS	18
70020	5/16" ID flat washer, SS	18
70246	Anti-Seize packet	1

Additional Parts:

Description	Quantity	Picture
Transit Side Step, Driver's Side	1 ea	
Transit Side Step, Passenger's Side	1 ea	

Nerf Bar Installation:

1. Remove any factory running boards if applicable.
2. There are two installation methods described below:
 - a. Using factory studs/threads (*preferred*)
 - b. Self-tapping screws only

Factory Studs/Threads Installation:

3. Clean off all factory studs and threads with wire brush. If necessary, use M8 tap/die to chase out threads. If holes are not pre-threaded, either create the M8 threads by tapping the hole (*preferred*) or switch to the self-tapping screw method. A hybrid of both fastening techniques may be used. Reference Figure 1 & Figure 2.



Figure 1: Example of Factory Studs



Figure 2: Example of Factory Threads

4. Starting with the passenger's side step, install the step against the body of the vehicle over the factory installed studs.
5. Loosely install 5/16" split washers, 5/16" flat washers, and M8 nuts over the studs to hold the side step up to the body (reference Figure 3). Start with the front-most attachment point and work towards the rear of the vehicle.

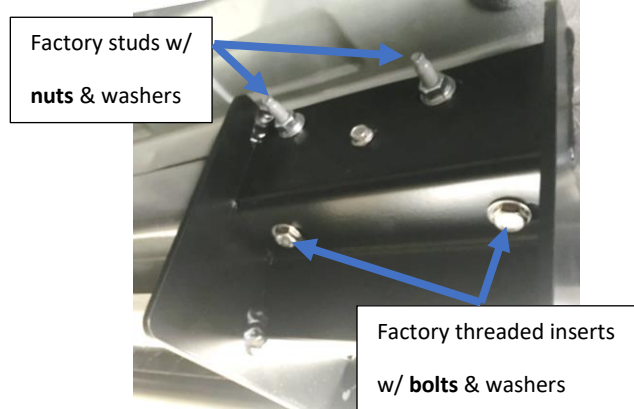


Figure 3: Hardware Installed Through Nerf Bar Brackets

6. Loosely install the M8-1.25 x 40 mm bolts, 5/16" split washer, and 5/16" flat washers vertically into the factory threaded inserts through the side step brackets (Figure 3).
7. Fully tighten all hardware. Start at the front-most attachment point and work towards the rear of the vehicle.
8. Repeat the same installation steps for the driver's side with the exception of the rear mounting points – no factory studs are available. Use the self-tapping screws to secure the driver's side bracket at the rear – there are pre-cut holes on the bracket for the screws (reference Figure 4).

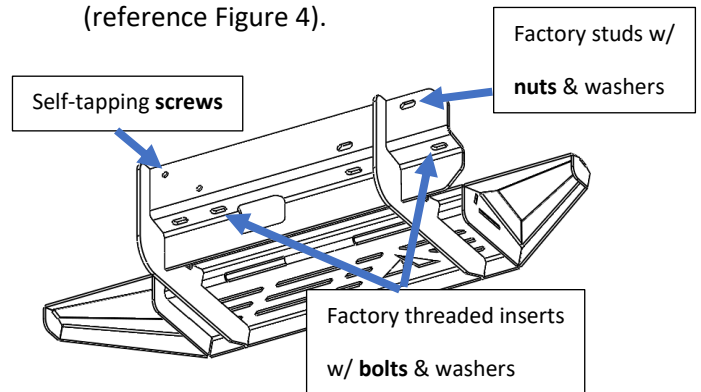


Figure 4: Driver's Side Step Installation

Self-Tapping Screws Installation:

9. Use the provided self-tapping screws to secure each bracket by drilling **through** each bracket into the sheet metal of the van.
 - a. On the passenger side, drill two in the vertical direction (bottom towards top) and three (3) in the horizontal direction (inside towards outside van) for a total of five (5) screws per bracket.
 - b. On the driver's side, drill four (4) in vertical direction (bottom towards top) and five (5) in the horizontal direction (inside towards outside van) for a total of nine (9) screws for this side.
 - c. Leave at least $\frac{1}{2}$ " of material from screw drill position to the closest feature (slots, edges, etc...). Spread the bolt positions across the bracket to help

better secure the side steps. Reference Figure 6 for the suggested screw pattern.



Figure 5: Driver's Side Middle Bracket

10. Your new Aluminess Side Steps are now installed! Verify all hardware remains tight after the first 100 miles of driving and periodically thereafter. Enjoy!



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