



# RECON SIDE STEP INSTALLATION INSTRUCTIONS

P/N 210687: 2007+ Mercedes Sprinter 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*
- *Unless otherwise specified, refer to the general torque value at the end of the instructions for specified torque values.*



## Required Tools

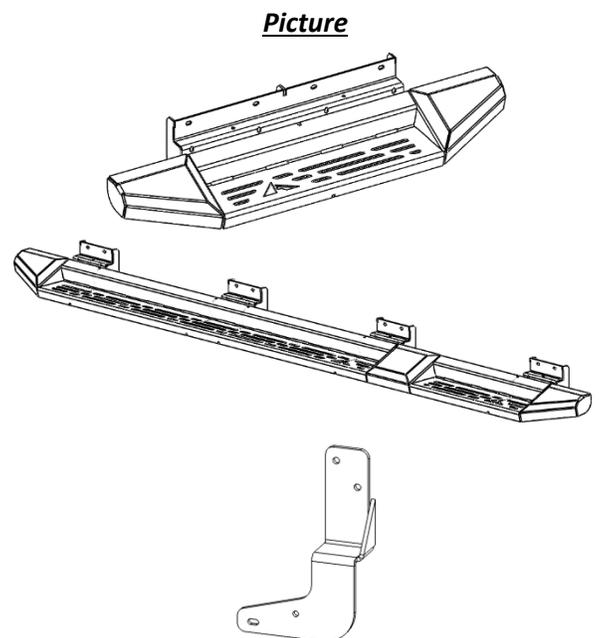
- *Drill with drill bits (3/16", 1/4", & 5/16")*
- *Standard wrench set*
- *Center punch or scribing tool*
- *Level*

## Included Hardware:

<u>P/N</u>	<u>Description</u>	<u>Quantity</u>
70008	¼"-20 Nylock Nuts SS	18
70009	¼" x 5/8 Washer SS (.03" Thick)	36
70060	¼"-20 x 1" Bolt, Button Head, Socket Cap, SS,	18
70231	Self-Tapping, SS #14 x 1 1/2" Bolt	22
70246	Antiseize Packet, 2g	1

## Included Parts:

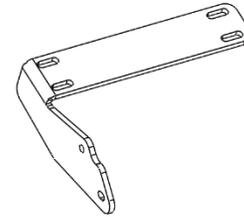
<u>PN</u>	<u>Description</u>	<u>Quantity</u>
N/A	Side Step, Driver's Side	1 ea
N/A	Side Step, Passenger's Side	1 ea
301757	Rear Most, Support Bracket	1 ea





301030.1 Driver's Side, 90 Degree Bracket

1 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 middle shroud is aligned with the body seam at the back of the B pillar (Figure 1)



Figure 1: Side Step Alignment with B-Pillar Seam

2. 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 2. 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 2: Step Bracket Installation Behind Pinch Weld

3. Ensure that the step is level (Figure 3).



Figure 3: Verification that the Step is Level

4. Mark the backside of the pinch weld on the van using the pre-cut holes on the step bracket as a template (Figure 4). 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 4: Marking Pinch Weld for Drilling

5. Use 1/4"-20 hardware to fasten each bracket to the pinch weld as shown in Figure 5.



Figure 5: Pinch Weld Fastener Installation

6. Grab the rear most support bracket and lay under the van at the end of the step. Bolt through the slot in the bracket and hole in the end cap using 1/4"-20 hardware as shown in Figure 6 below. Then drill a hole through the end cap using the second bracket hole as a guide.

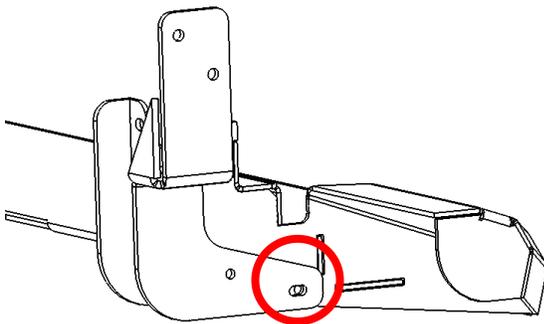


Figure 6: Rear Support Bracket Bottom Mounting

7. Now using the two holes on top of the bracket as guides, drill through the triangular sub frame flange as shown and bolt through using the 1/4"-20 hardware again. See Figure 7 below.



Figure 7: Rear Support Bracket Upper Mounting

8. Before installing the driver side step, make sure any of the protruding rubber coating on the underside of the vehicle is removed. You want the mounting surfaces to be relatively flat.
9. Repeat Step 0 through Step 5 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 8, arrow).
  - b. Position the front of the step and secure first, then move towards the rear, checking the step or level as you go.
  - c. Use six (6) self-tapping screws total for the upper vertical and horizontal flanges of the step brackets (Figure 8).
  - d. Use four (4) 1/4"-20 bolts total for the pinch weld fasteners (Figure 8, circles).

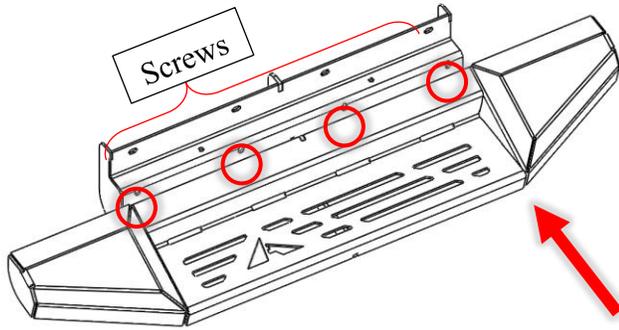


Figure 8: Driver's Side Step Install

10. 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 9).

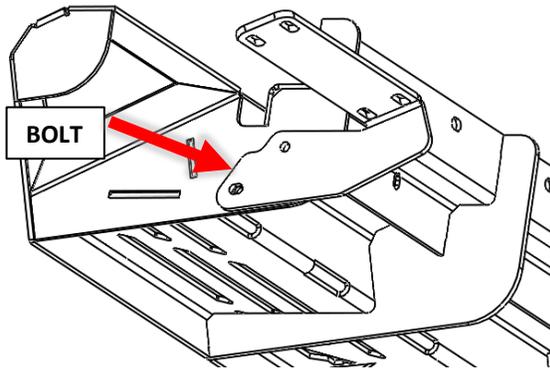


Figure 9: Installation of 90 Degree Bracket

11. 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 10 (four screws total).



Figure 10: 90 Degree Bracket Installation onto Van

12. 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 11). Use a 1/4" drill bit and 1/4"-20 hardware to fasten together.

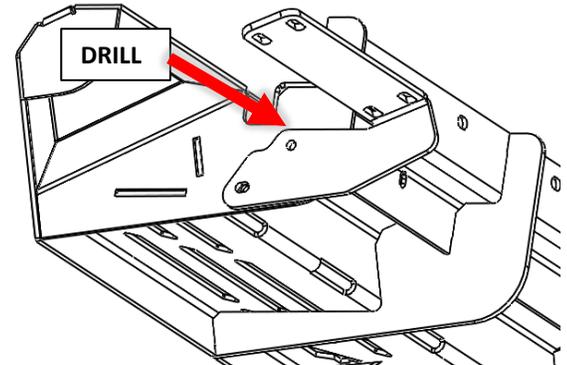


Figure 11: Drilled Hole to Lock Rotation of Step

13. Double check that all mounting bracket fasteners are tight throughout the entire installation.
14. Using the hardware provided by Baja Designs, secure the rock lights to the rock light mounting tabs as shown in Figure 12. If the hardware doesn't fit through the Rock Light Mounting Tab hole, drill it out with a 11/64" drill bit.

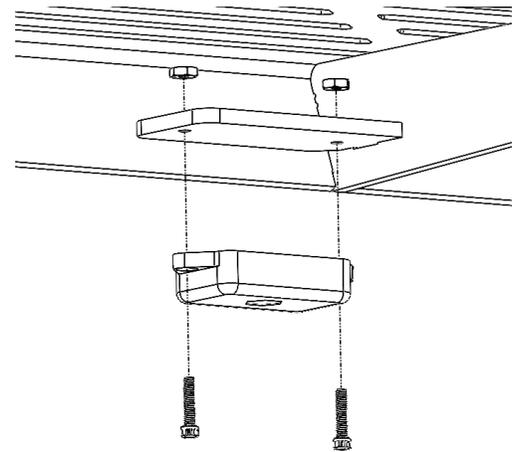


Figure 12: Rock Light Installation

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

<b>General Torque Values</b>			
<b>Size</b>	<b>Stainless Steel</b>	<b>Zinc</b>	<b>Grade 8</b>
#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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