



RECON SIDE STEP INSTALLATION INSTRUCTIONS

P/N 210692: 2015+ Ford Transit Recon 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*
- *Unless otherwise specified, refer to the general torque value at the end of the instructions for specified torque values.*



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:

<i>P/N</i>	<i>Description</i>	<i>Quantity</i>
70231	Self-tapping screw, #14 x 1-1/2", SS	28
70219	M8-1.5 x 40mm, Fully Threaded, SS, 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
70060	1/4"-20 x 1" Button Head Bolt, SS	2
70009	1/4" Flat Washer, SS	4
70008	1/4"-20 Nylock Nut, SS	2

Additional Parts:

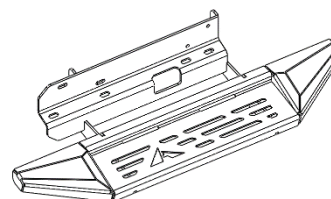
Description

Quantity

Picture

Transit Side Step, Driver's Side

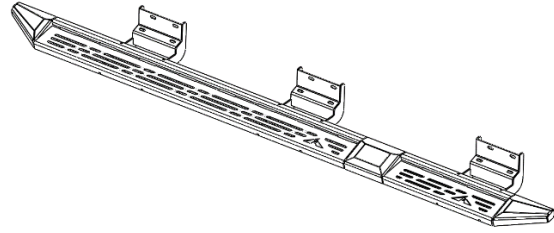
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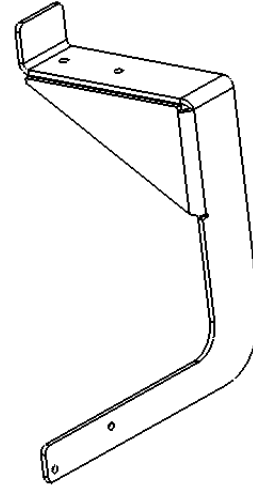
Transit Side Step, Passenger's Side

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Transit Side Steps, PS Rear Bracket

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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.

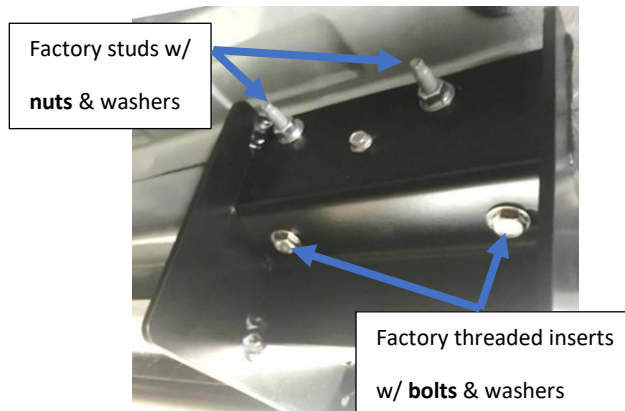


Figure 3: Hardware Installed Through Nerf Bar Brackets

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. Grab the passenger side rear bracket and head to the rear end cap on the passenger side. Bolt the bracket to the end cap, through the pre-existing holes using the 1/4"-20 hardware (70060, 70009, 70008)
8. Position the bracket as shown in figure 4 below and put the first self tapper (70231) into the small side flange, you may need to pinch or clamp the bracket to pull flush to that face.
9. Once the side is tightened, put two additional self tappers up into the bottom flange of the bracket.

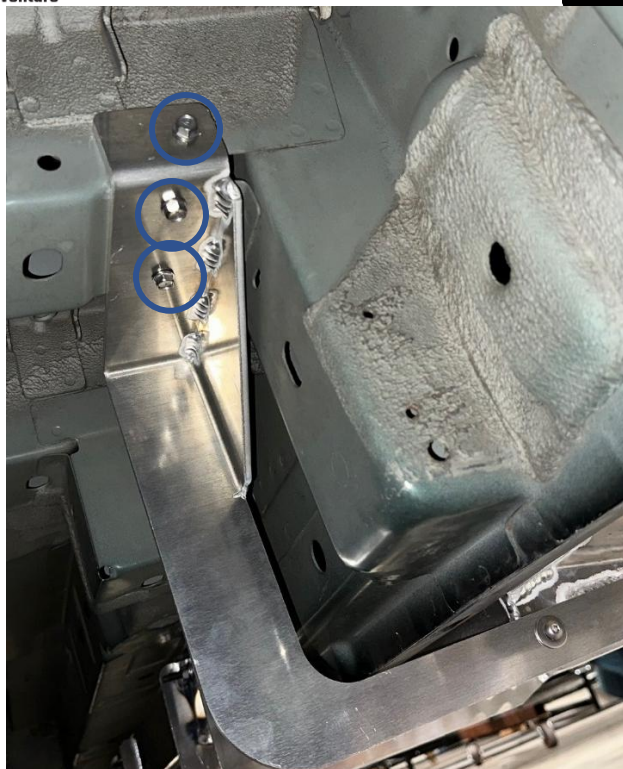


Figure 4: Passenger Side Support Bracket

10. Fully tighten all hardware. Start at the front-most attachment point and work towards the rear of the vehicle.
11. 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 **Error! Reference source not found.**

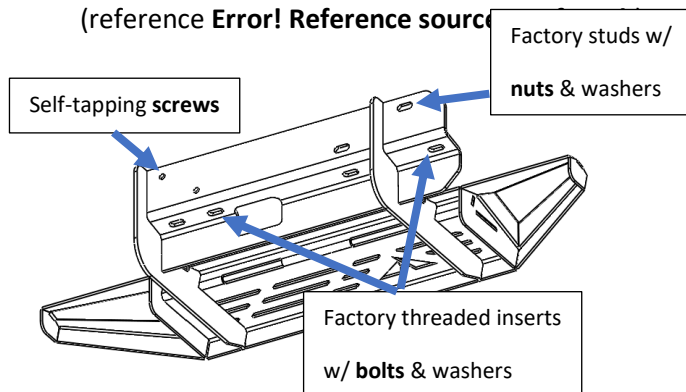


Figure 5: Driver's Side Step Installation

Self-Tapping Screws Installation:

12. 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 ½" 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 6: Driver's Side Middle Bracket

13. Using the hardware provided by Baja Designs, secure the rock lights to the rock light mounting tabs as shown in Figure 7. If the hardware doesn't fit through the Rock Light Mounting Tab hole, drill it out with a 11/64" drill bit.

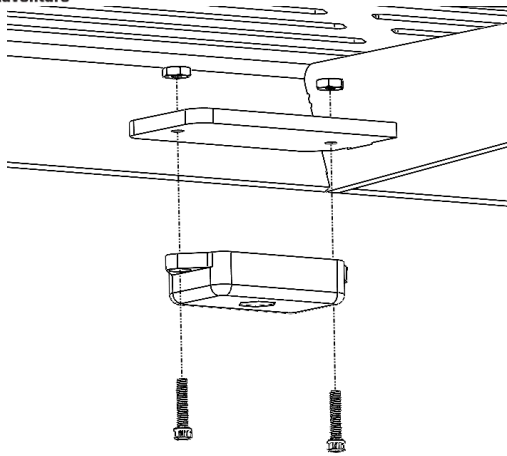


Figure 7: Rock Light Installation

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



General Torque Values			
Size	Stainless Steel	Zinc	Grade 8
#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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