



# Roof Rack Installation Instructions

Ford, Transit, 15+ Roof Rack P/Ns : 210412; 210412.1; 210413.1; 210413.2; 210413.3; 210413.4; 210413.5; 210414; 210414.1; 210414.2; 210414.3; 210414.4; 210414.5

## 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 requires two people.*
- *Unless otherwise specified, refer to the general torque value at the end of the instructions for specified torque values*



## Required tools:

- Standard wrench set
- M8 x 1.25 tap (recommended)
- Silicone sealant

## Included Hardware:

**PRE-PACKED KIT: 350690.1 (8-Foot)**

PN	Description	Qty.	Picture
350503	Roof Rack Mounting Brackets	8	
301309	Pre-Cut Rubber Pads	8	
70219	Bolt, Hex, SS M8 x 1.25 x 40mm	8	
70435	5/16" ID SS Lock Washer	8	
70020	5/16" ID SS Flat Washer	8	
70027	3/8" ID SS Washer (Thick)	8	
70008	1/4"-20 SS Nylock Nut	16	
70009	1/4" ID SS Flat Washer	32	
70318	1/4"-20 x 1" SS Hex Head Bolt	16	
70246	Antiseize Packet, 2g	1	



**Installation Instructions:**

1. Begin by removing the rubber plugs from the roof of the vehicle. Ford sometimes paints over these so it may take some prying to get them off. (Reference Figure #1)



**Figure 1: Factory Plug**

2. There is a threaded hole in the roof underneath each of these rubber plugs. They are not necessarily in the center of the plug. If there is overspray in the threads, they must be cleaned out by running a tap through them (M8 x 1.25 tap).
3. Position the provided rubber insulating pads onto each mounting bracket (Reference Figure #2)



**Figure 2: Rubber Pad**

4. Insert the 5/16" lock washer, 5/16" flat washer, and the 3/8" thick washer onto each of the M8 x 1.25 bolts.
5. Run a bead of silicone around the hole of the bracket on the bottom of the rubber pad (Reference Figure 3A) . In addition, place a small dab of silicone on the threads of the provided M8 x 1.25 hardware. Be sure to place the necessary washers onto the bolt prior to applying the silicone. (Reference Figure 3B for washer position/orientation)



(A)



(B)

**Figure 3: Silicone Application on Pad (A) and on Bolt (B)**

6. Place the bolt with the dab of silicone through the mounting bracket with the rubber insulation pad facing down (Reference Figure #4A) . Keep the bracket exactly on the center of the hole and firmly place the mounting bracket onto the roof to ensure a good seal. (Reference Figure #4B) Note: If the threads are slightly off center, it's OK because the hole in the mount is the same size.



(A)



(B)

**Figure 4: Installation onto Roof: Silicone Bead Underneath (A) and Bolt Installation (B)**

7. The mounting bracket is built with an angle to it to accommodate for the roof angle. Make sure to install the mount so that the top plate of the bracket is level.
8. Do not completely tighten the mounting bracket to the roof at this time – this will assist in locating all the bolts.
9. Repeat the mounting bracket installation process for the remaining mounting points on the vehicle.
10. Have some friends help you lift the rack on top of the vehicle and set the roof rack feet on to the mounting brackets.
11. You can now use the 1/4"-20 bolts, washer, and nuts to loosely fasten the roof rack feet to the mounts already installed in the previous steps.
12. Once all of the hardware is in place, you can make minor adjustments to the rack so it sits on the roof to your liking.
13. Once the rack is in a spot where you like it you can tighten all of the hardware.
14. As a final seal, run another bead of silicone around the mounting bolts on each foot to ensure water cannot get into the roof. (Reference Figure #5)



**Figure 5: Final Silicone Seal**

15. Your roof rack is now installed. Check all fasteners for fitment after 50 miles of driving, 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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