

Box Rack Installation Instructions

P/N 210577: 2015+ Ford Transit Rear Door Box Rack

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 or more people*

Required Tools:

- Standard and metric wrench set
- Standard and metric socket set
- Torx bit set
- Drill or impact driver
- Isopropyl Alcohol
- Baby Soap or Dish Soap
- Spray Bottle
- Clean Rag
- Squeegee (or old credit card)

Included Hardware:

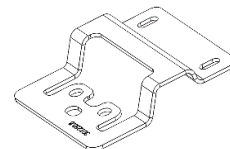
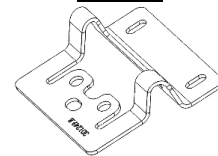
<i>P/N</i>	<i>Description</i>	<i>Quantity</i>
70344	5/16"-18 x 1" Button Head Bolt, BLACK OXIDE	4
70446	5/16"-18 x 1 ¼" Button Head Bolt, BLACK OXIDE	2
70448	3/8" ID Washer, 1/8" THK BLACK OXIDE	4
70345	5/16" ID Washer, BLACK OXIDE	12
70346	5/16"-18 Nylon-Locking Nut, BLACK OXIDE	6
70437	M6-1.0 x 16mm, Button Head Bolt	3
70009	¼" ID Washer SS	3
70246	Antiseize Bolt Lubricant Packet, 2g	1
400999	Impact Resistant Protective Tape	9"



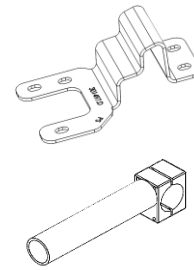
Additional Parts:

<u>PN</u>	<u>Description</u>	<u>Quantity</u>
301249/350656	Upper Hinge Bracket	1 ea
301250/350657	Lower Hinge Bracket	1 ea

Picture



301497/350644	Inner Driver Door Bracket, Passenger	1 ea
N/A	Bolt-On Box Supports (Pre-assembled)	2 ea



Box Rack Installation:

1. Cut the supplied protective tape into one - 6" section and one - 3" section. Round all corners.
2. Apply the protective tape to each location, one at a time, using the following wet application technique described below.
3. Prepare the surface for protective film application (wet application technique):
 - a. Clean the area around each hinge with isopropyl alcohol and rag.
 - b. Wash your hands thoroughly.
 - c. Do not apply in direct sunlight
 - d. Apply in temperatures above 60°F.
 - e. Create two separate wetting solutions:
 - i. Soap/water: ~95% water / ~5% soap
 - ii. Alcohol/water: ~75% water, ~25% isopropyl alcohol
4. Spray the surface thoroughly with soap/water solution and do not wipe down surface.
5. Remove the liner from the protective tape while spraying the adhesive side with soap/water solution.
6. Apply the protective tape to the outside of the door (Figure 1). At the upper or lower hinge location, leaving approximately 1/2" of tape overhanging to be wrapped around the edge of the door. Leave the tape overhanging for now.

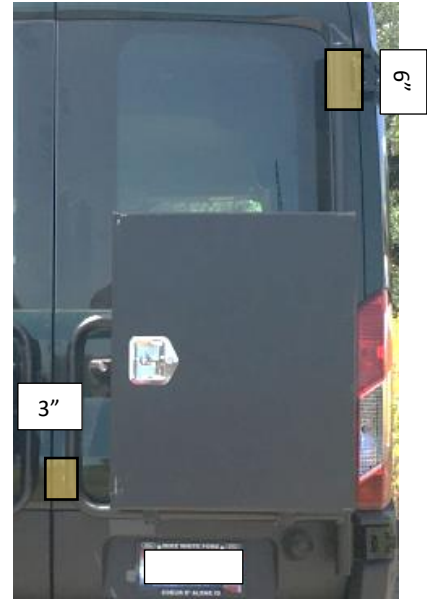


Figure 1: Locations of Protective Film Application

7. Use squeegee all air bubbles out starting at adhered edge.
8. Use the alcohol/water solution to speed up adhesion at one edge (lift section up and spray adhesive side) as needed.
9. Wrap remaining protective tape around the door underneath hinge if possible.
10. Install the upper hinge bracket by:
 - a. Have someone help support the weight of the door throughout the entire bracket installation.
 - b. Remove the three bolts connecting the hinge to the door.
 - c. Rotate hinge enough to allow the bracket to be installed around the hinge (Figure 2).



Figure 2: Upper Hinge Rotated Away from Door

- d. Install the hinge around the hinge in the correct orientation (Figure 3).



Figure 3: Bracket Installed Over Factory Hinge

- e. Rotate the hinge and bracket back into position against the door.
- f. Use the factory hardware to reinstall the hinge/bracket (Figure 4).

PRO TIP: Be sure to center the bracket around the hinge and verify clearances around the hinge while opening and closing the door.



Figure 4: Inside View of Installed Upper Hinge Bracket

- 11. Install the lower hinge bracket by repeating the process detailed in Step 2 (reference Figure 5).



Figure 4: Inside View of Installed Lower Hinge Bracket

- 12. Remove the three (3) factory torx bolts holding on the passenger's side latch. NOTE: Prevent the latch from falling into the door by holding the inside latch (Figure 6).



Figure 5: Inside Latch on Passenger Door

- 13. Install the inner passenger door bracket using the provided M6-1.0 hardware and 1/4" ID washer (See Figure 7).

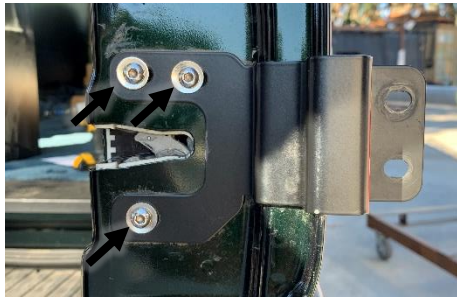


Figure 6: Installed Inner Passenger Door Bracket

14. Loosely install the rack onto the upper, lower, and inner brackets using the provided 5/16"-18 bolts, washers, and nuts. Use the 1" bolts for the outer brackets and the 1 1/4" bolts for the inner bracket.
 - a. Tighten the upper and lower **hinge** brackets first.
 - b. There should be a small gap at the center bracket before it is fully tightened (0-1/8"). If the gap is larger, than 1/8", use the provided 1/8" THK washers as shims (PN: 70448) to close the gap to $\leq 1/8"$ (See Figure 7).



Figure 7: Gap between bracket and product

15. Verify the hinge brackets and inner door brackets have appropriate clearances while opening and closing both rear doors.
16. Verify the hinge brackets and inner door brackets have appropriate clearances while slowly opening and closing both rear doors.

17. Loosely install the bolt-on tire/box supports onto the bottom crossmember of the rack as shown in Figure 8.



Figure 8: Bolt-On Supports Loosely Bolted to Lower Crossmember

18. Starting with support closest to tail light – sliding support as close to the tail light as possible and then rotate into desired position and tighten.

PRO TIP: Reference Figure 9 for suggested mounting orientation.

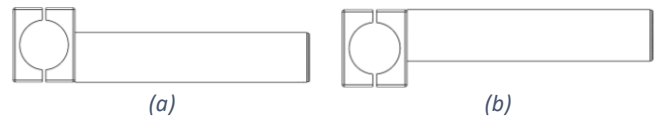


Figure 9: Suggested Orientation for Tire (a) and Box (b)

19. Repeat for the support opposite the center post, being sure that the spacing is equal from the center post, and the orientation is the same for both supports.
20. Follow the instructions included with the box to mount onto the box rack. Be sure to attach the box on the upper crossbar to maximize box support (Reference Figure 10).

21. Check mounting hardware after first 100 miles of driving and periodically after to verify hardware has not become loose from vibration.
22. Your new Aluminess Box Rack is now installed, enjoy!



Figure 10: Mounting Box to Upper Cross Bar



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