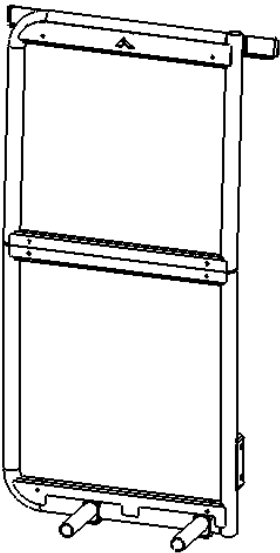



Base Unit Installation Instructions

P/N 210771: 2013+ Dodge Promaster Rear Door Base Unit



Before you begin:

- *Stainless steel (SS) hardware may bind together when tightening — apply an anti-seize assembly lubricant to the threads of each SS bolt before assembly.*
-  *Do NOT use an impact gun if this symbol is shown – doing so may strip or cross-thread bolts.*
- **Maximum load capacity is 200 lbs evenly distributed on base unit rack while travelling.**

Required Tools:

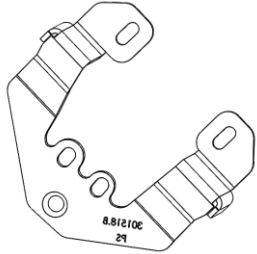
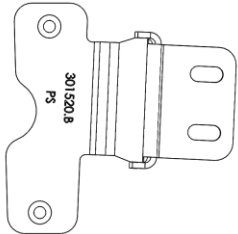
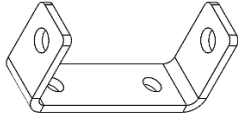
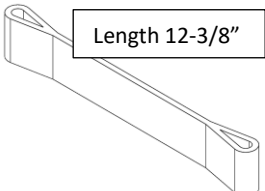
- Standard and metric wrench set
- Standard and metric socket set
- Torx bit set
- Isopropyl Alcohol
- Baby Soap or Dish Soap
- Clean Rag
- Tin Snips or Dremel Cut-Off Wheel
- Painter’s Tape (optional)
- Spray Bottle (optional)
- Heat Gun or Blow Dryer (optional)

Included Hardware:

P/N	Description	Quantity
70375	5/16" Washer, Split Black Oxide	4
70344	5/16"-18 x 1" Button Head Bolt, BLACK OXIDE	6
70345	5/16" ID Washer, BLACK OXIDE	10
70448	5/16" ID Washer, 1/8" Thick, BLACK OXIDE	4
70346	5/16"-18 Nylon-Locking Nut, BLACK OXIDE	4

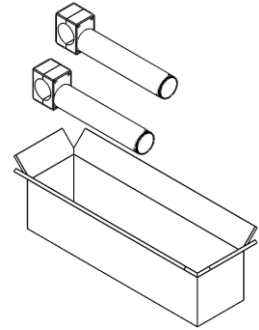
70020	5/16" Stainless washer	2
70021	5/16 x 3/4" Stainless hex head bolt	2
400999	Impact Resistant Protective Tape	14.5"
70120	1/4"-20 x 3" bolt	1
70008	Nut, 1/4"-20, Nylock, SS	5
70009	1/4" ID Washer	4
70038	1/4"-20 X 2 3/4" Philips head screw, SS	4
70040	1/4" Countersunk Washer, SS	4
70039	1/4" X 1 Fender Washer, SS	4
401022	Webbing Anchor (<i>For door stop strap mounting</i>)	1
70079	Screw, Pan Head Phillips, SS, 10-32 x 1/2"	2
70005	Washer, #10, SAE Flat, SS	2
70004	Nut, Nylock, 10-32, SS	2
70458	Bolt, CS Flat Head, M6-1.0 X 16mm, SS	2
70477	Bolt, CS Flat Head, M8-1.0 X 30mm, Countersunk, Torx Bolt, Zinc	1
70437	Bolt, Button Head, M6-1.0 X 16mm, SS	2
70246	Antiseize Bolt Lubricant Packet, 2g	1
401096	1/8 x 2 Foam Tape	26 1/2 inches

Additional Parts:

Part Number:	Description:	Quantity:	Picture:
350685	Lower Hinge Bracket, Passenger	1 ea	
350687	Inner Pass Door Bracket, Passenger	1 ea	
350688	Door Stop Channel	1 ea	
401035	Door Strap	1 ea	

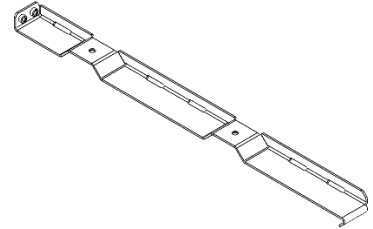
210618 8" Tire Support Post (Pair)

1 ea



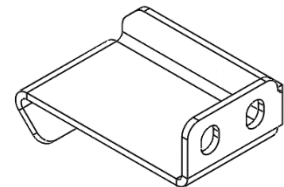
351104 Tension Bar Base

1 ea



351105 Tension Bar Bracket

1 ea



Protective Tape Application:

1. Cut the supplied protective tape into two – 2" sections, one - 3" section, and one -7" 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 and lower hinge location, leaving approximately ½" of tape overhanging to be wrapped around the edge of the door. Leave the tape overhanging for now.

bracket system, creating a firm mounting location. The desired gap is to be less than or equal to 1/8".

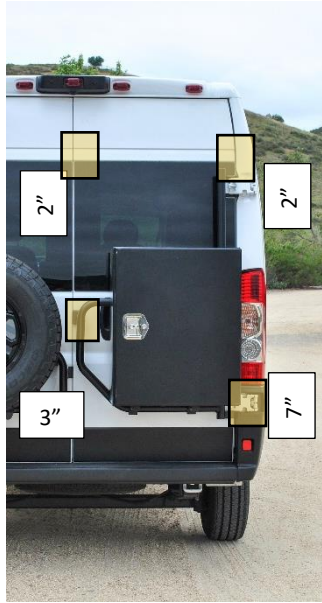


Figure 1: Locations of Protective Film Application

7. Use squeegee to get 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.

Upper Tension Bar Installation:

10. Before installation, put the foam tape on the back side of the tension Bar to protect your paint from scratches.

! WARNING: Follow Step 12-15 Carefully. Failure to do so may result in damage to the door!

11. Loosely bolt short hook bracket to tension bar using two (2) 5/16"-18 x 1" Button Head Bolt fasteners [PN 70344] (Figure 2 and 3).
 - a. There should be a small gap between the two tension bar brackets before it is fully tightened (0-1/8"). Use Table 1 to reduce the gap to the desired distance using provided thick washers (70448) to reduce gap as needed.
 - b. Do **NOT** eliminate the gap completely. A small gap creates tension on the

Gap (Figure 2)	Number of thick washers (70448) stacked per bolt	Total Used
0" to 1/8"	0	0
1/8" to 1/4"	1	2
Larger Than 1/4"	2	4

Table 1: Tension Bar Gap Thick Washer Specifications

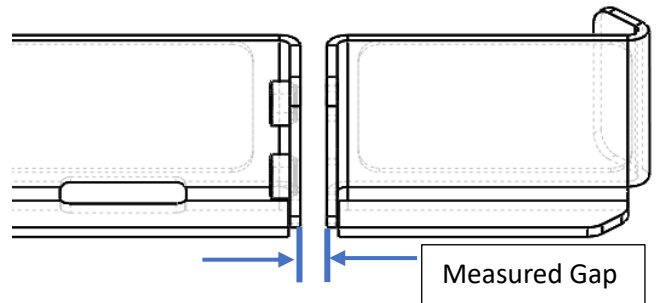


Figure 2: Tension Bar Gap

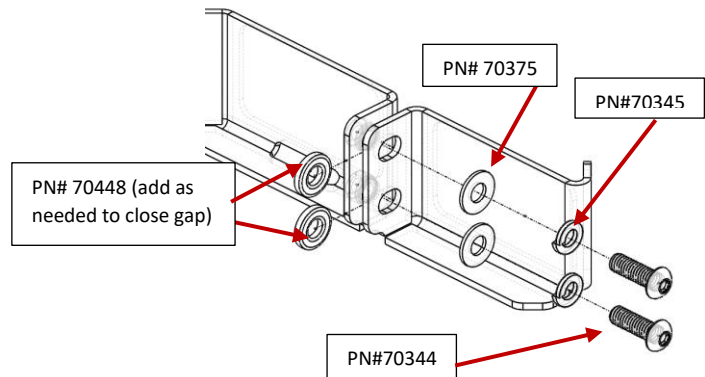


Figure 3: Tension Bar Bracket Hardware

12. Bolt tension bar to base unit through weld nuts using two (2) 5/16 x 3/4" Stainless hex head bolts [PN 70021] and 5/16" split washer [PN 70375] as shown (Figure 4).

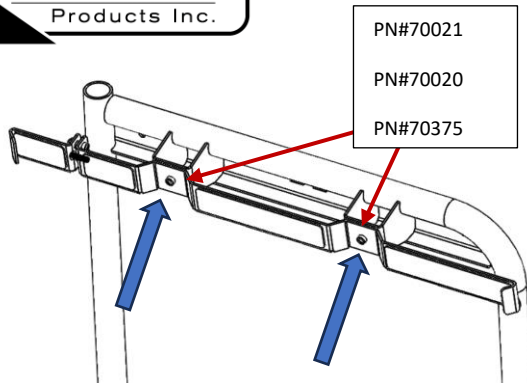


Figure 4: Tension Bar Installed on Base Unit

13. Loosely hook the fixed end of the longer tension bar bracket around the door's pinch weld, just above the window location (Figure 4). The long hook end should be on the inside seam with the mounting holes towards the taillight.

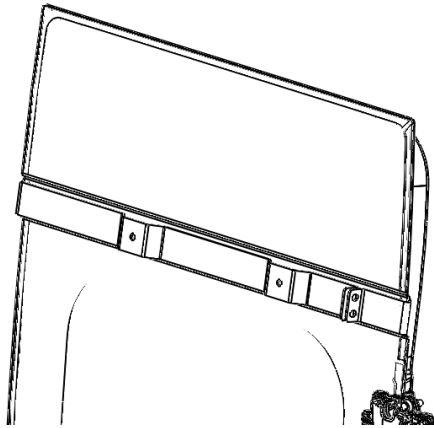


Figure 5: Tension Bar Installed on Rear Door

14. While holding the longer tension bar bracket in place, tighten the shorter bracket around the door along the opposite sides pinch weld.

Lower Bracket Installation:

15. Remove all three bolts connecting the lower hinge to the door (Figure 6).

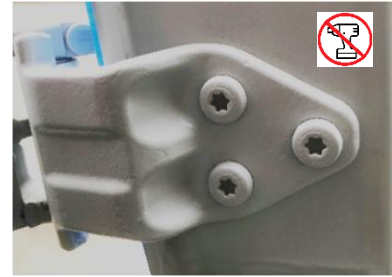


Figure 6: Top Hinge View

16. Rotate hinge outwards to allow the bracket to be installed around the hinge.
17. Install the bracket around the hinge in the correct orientation (Figure 6).

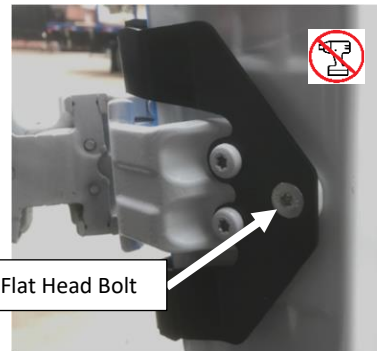


Figure 7: Bracket Installed Over Factory Hinge

18. Tightening the bracket down using the factory hardware and the M8 countersunk bolt (70477) to reinstall the hinge/bracket (Figure 7).
19. Slowly close the door to confirm that bracket is clear from any obstructions during closure use

Inner Bracket Installation:

20. Remove two factory torx screws that hold door latch in place. Set this hardware aside. (Figure 8)

Door Stop Installation:

23. Remove plug grommet on door (if applicable) to expose mounting point (Figure 10).

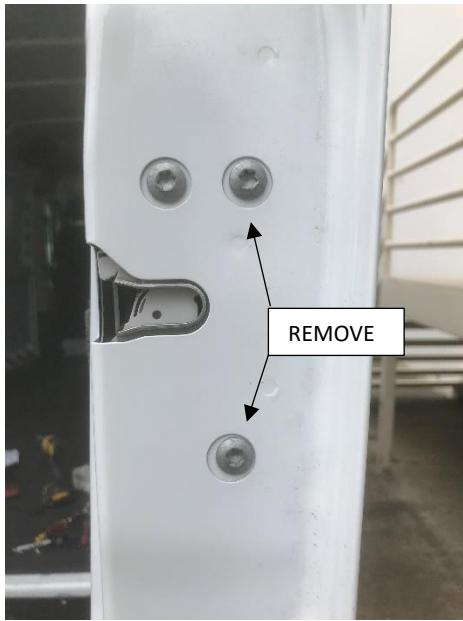


Figure 8: Inner Passenger Door Latch



Figure 10: Remove Rubber Door Grommet

21. Install inner door bracket using provided countersunk hardware [PN 70458] (Figure 9).

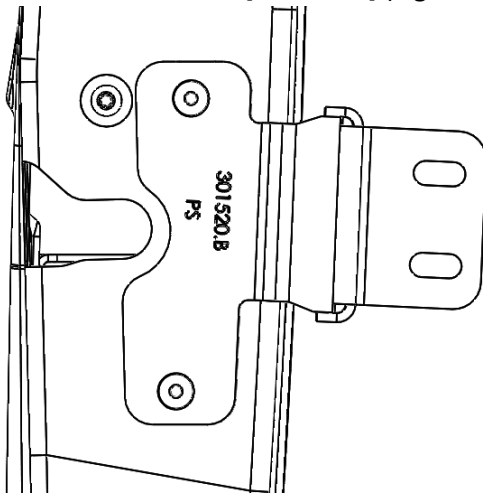


Figure 9: Inner Passenger Door Latch Installed

22. Loosely install the rack onto the tension bar, lower, and inner brackets using the provided 5/16"-18 bolts, washers, and nuts.
- Tighten the upper tension bar mounting locations first
 - Then tighten the lower hinge brackets.
 - Proceed to tighten the inner bracket last.

24. Partially remove door panel cover by carefully prying out push fasteners. This will give you access to the back of the mounting point. (See Figure 11)



Figure 11: Remove Plastic Door Rivets

PRO TIP: A door panel rivet puller like the one shown in Figure 12 makes this part of the install a breeze. A flathead screwdriver with some

protective tape wrapped around the blade will work also.



Figure 12: Door panel plastic rivet puller

25. Thread webbing anchor into door strap and mount webbing anchor as shown in Figure 13 and Figure 14.



Figure 13: Backside View of Door Stop Mounting

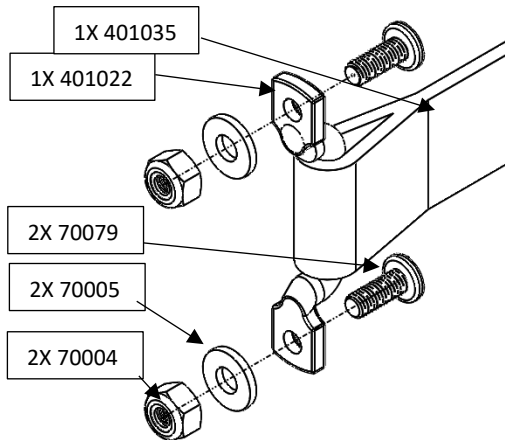


Figure 14: Door Stop Bracket Install

26. Install door stop channel bracket [PN 350688] into factory threaded holes on the inside of the rear door trim using two [PN 70437] M6-1X16mm Button Head screws. (Figure 15:

Factory Threaded Holes on Inside of Door Jam)



Figure 15: Factory Threaded Holes on Inside of Door Jam

27. Thread the other side of the door stop strap into door jam bracket (installed in step **Error! Reference source not found.**) using $\frac{1}{4}$ "-20 x 3" bolt and $\frac{1}{4}$ "-20 nylock nut (Figure 16).

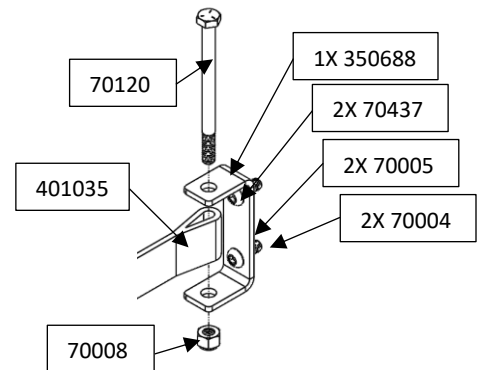


Figure 16: Complete Door Stop Install

28. Verify door hard stop strap install has been completed. See figure 18 below.



Figure 18: Completed Door Strap Installation



info@aluminess
(619) 449-9930

29. Congratulations! You have completed the installation of your new Aluminess Rear Door Base Unit. Check mounting hardware on entire assembly after the first 100 miles of driving and periodically thereafter. Enjoy!



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