

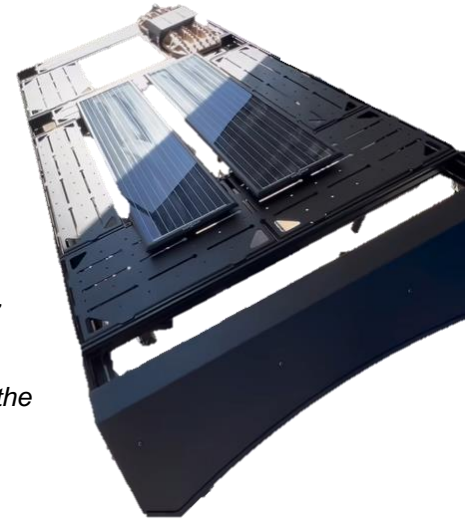


Recon Roof Rack Installation Instructions

P/Ns 210675: Ford, Transit, 2015+ Recon Roof Rack, 148" WB, Mid Roof, Regular Body

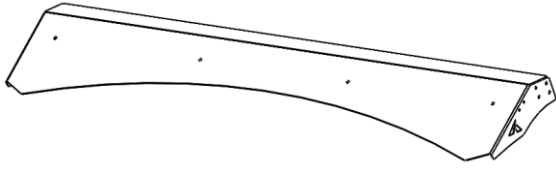
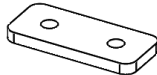
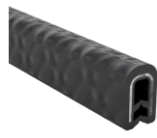
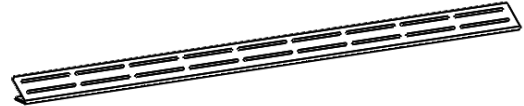
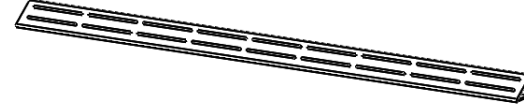
Before you begin:

- Read all instructions carefully before beginning installation/assembly
- Stainless steel hardware may bind together when tightening — apply the supplied anti-seize assembly lubricant to the threads **before** installation.
- Over tightening bolts can cause the hardware to break due to excessive force. When tightening, be sure to apply only the recommended torque.
- Installation requires two or more people to install the roof rack on top of the vehicle.
- Once installed, the maximum weight capacity of the roof rack is 200 lbs per panel, or 600lbs evenly distributed. Please refer to the vehicle manufacturer's recommended maximum weight rating before operating the vehicle.
- 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

Subassembly	Qty.	PN	Components	Hardware
351119 (1X)	1	301372	 Air Dam, Transit	8X – 70364 – ¼”-20 x ¾” Carriage Bolt 8X – 70365 – ¼”-20 Nylock Nut, Blk 4X – 70368 – ¼”-20 x ½” Buttonhead 4X – 70476 – ¼”-20 x 1” Buttonhead 8X – 70367 – ¼” ID Washer, Split, Blk 16X – 70366 – ¼” ID Washer, Blk 4X – 70370 – ¼”-20 Track Nut 4X – 70372 – .36”OD x ½” Spring 1X – 70246 – Bolt Lubricant
	2	301655	 Air Dam Spacer	
	57”	401008.1	 Rubber Trim, 3/32” Thickness	
351114 (1X)	1	301361	 Side Rail, Driver’s Side, 5’	none
	1	301383	 Side Rail, Passenger’s Side, 5’	



351115 (1X)	1	301362	 Side Rail, Driver's Side, 6'	none
	1	301384	 Side Rail, Passenger's Side, 6'	
351116 (1X)	1	301363	 Side Rail Bracket, Driver's Side	8X – 70364 – ¼"-20 x ¾" Carriage Bolt 8X – 70365 – ¼"-20 Nylock Nut, Blk 8X – 70366 – ¼" ID Washer, Blk 4X – 70369 – 5/16"-18 x 1" Carriage 4X – 70345 – 5/16" ID Washer, Blk 4X – 70346 – 5/16"-18 Nylock Nut, Blk
	1	301364	 Side Rail Bracket, Passenger's Side	
351122 (4X)	8	301330	 Transit Mounting Bracket	16X – 70369 – 5/16"-18 x 1" Carriage 16X – 70345 – 5/16" ID Washer, Blk 16X – 70346 – 5/16"-18 Nylock Nut 8X – 70219 – M8-1.25 x 40mm HH Bolt 8X – 70435 – 5/16" ID Washer, Split 8X – 70020 – 5/16" ID Washer 8X – 70027 – 3/8" ID Washer, 1/8" Thk
	8	301309	 Transit Rubber Mounting Pad	
351125 (1X)	6	301366	 Crossbar, Wide	24X – 70476 – ¼"-20 x 1" Buttonhead 24X – 70367 – ¼" ID Washer, Split, Blk 24X – 70366 – ¼" ID Washer, Blk

Roof Rack Assembly:

PRO TIP: Protect the powdercoating by lying down some blankets or towels before assembling the roof rack.

- Using the associated carriage bolts and side rail brackets, connect the front and rear side rails together. Reference Figure 1 & Figure 2 for more detail. Repeat for both driver and passenger sides.

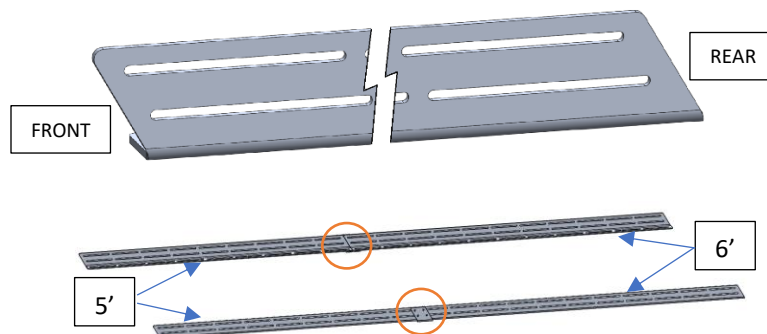


Figure 1: Side Rail Subassembly

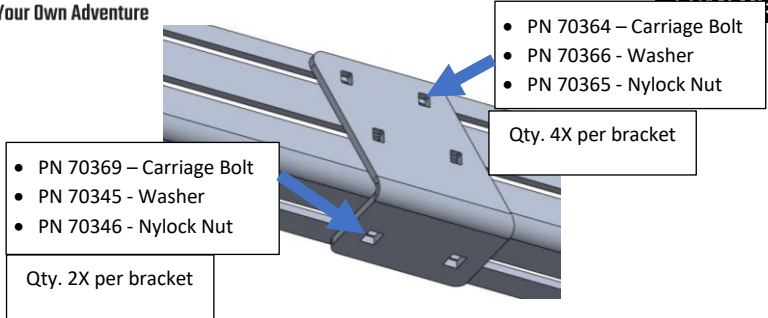


Figure 2: Side Rail Bracket Hardware Installation

2. Fasten mounting brackets to side rail subassemblies completed in Step 1 at the following locations referenced in Figure 3. Use the 5/16" hardware and reference Figure 4 for proper placement.

- Back edge to center of mounting hole: **14-7/8"**
- Center-to-center, #1 to #2: **20-1/2"**
- Center-to-center, #2 to #3: **39"**
- Center-to-center, #3 to #4: **28-15/16"**

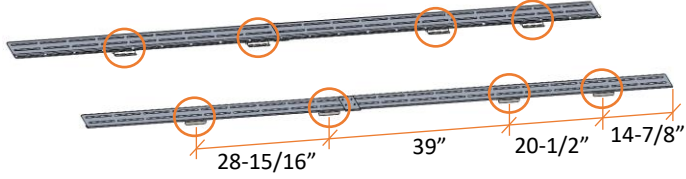
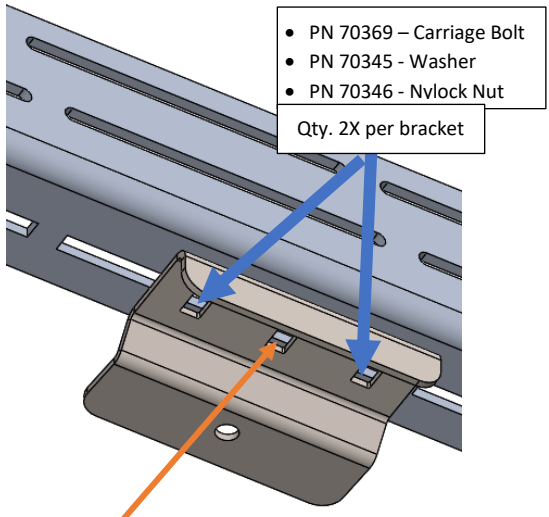


Figure 3: Mounting Bracket Locations



ONLY use center slot if one of the outer slots is covered

Figure 4: Fastening Transit Mounting Bracket (Underside)

- Determine desired vent location(s) and ensure that crossbar placement doesn't interfere.
- Install at crossbars to connect the driver and passenger side rail subassemblies together. Use measurements of vents or flooring panels to correctly space crossbars. Due to the constraints of the vehicle, crossbars can be **only** be installed **horizontally**, on the **top slots** of the side rails. Reference Figure 5 - Figure 7.

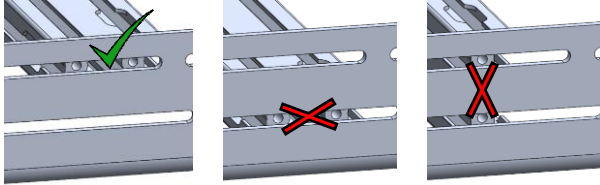
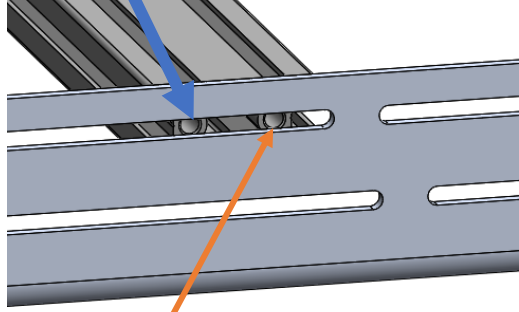


Figure 5: Crossbar Orientation



Figure 6: Crossbar Installation

- PN 70476 - Bolt
 - PN 70366 - Split Washer
 - PN 70367 - Flat Washer
- Qty. 2X per side, 4X per crossbar



MUST install horizontally and on top slot for proper fitment

Figure 7: Crossbar Fastening to Side Rail Subassemblies

- Install rubber trim along front edge of air dam (Figure 8).

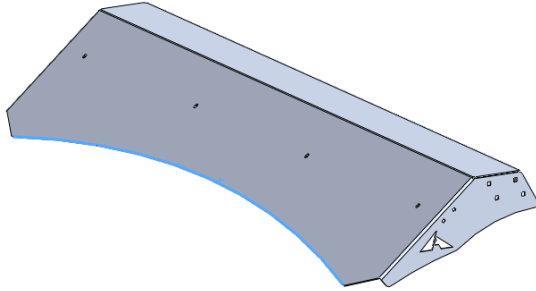


Figure 8: Rubber Trim Installation on Air Dam

6. Install spring onto track nut and insert into one of the crossbars as shown in Figure 9 & Figure 10.

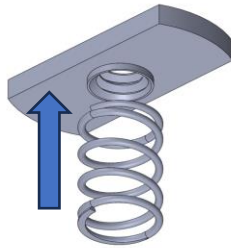


Figure 9: Combining the Spring with the Track Nut

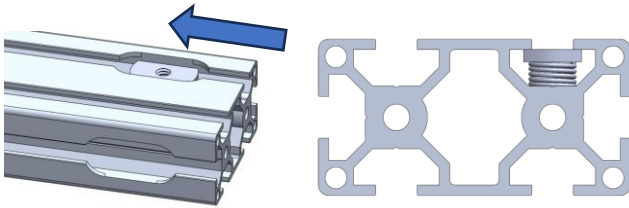
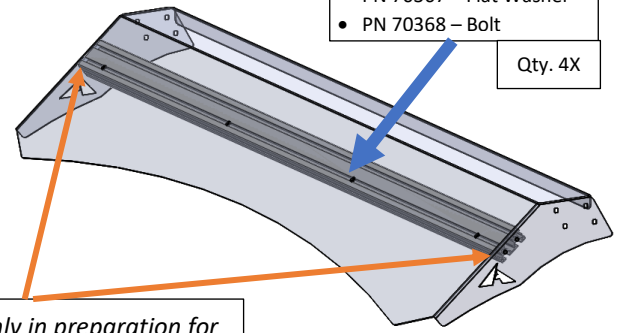


Figure 10: Installing Track Nut & Spring into Crossbar

7. Slide track nuts into position to match the air dam. Use the air dam as a template for spacing, and bolt the air dam to the crossbar. Reference Figure 11.



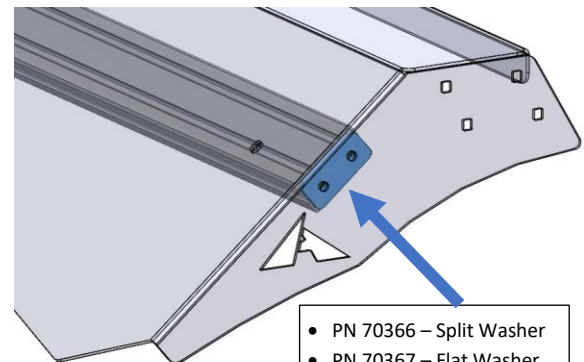
- PN 70370 – Track Nut
- PN 70372 - Spring
- PN 70366 – Split Washer
- PN 70367 – Flat Washer
- PN 70368 – Bolt

Qty. 4X

Space evenly in preparation for next step

Figure 11: Crossbar Install onto Air Dam

8. Install air dam spacer between crossbar and air dam inside edge (Figure 12). Use ¼”-20 hardware to fasten together. Repeat for both driver and passenger side.



- PN 70366 – Split Washer
- PN 70367 – Flat Washer
- PN 70476 – Bolt

Qty. 2X per side

Figure 12: Air Dam Spacer Installation

9. Install air dam subassembly onto roof rack using appropriate carriage bolts and hardware shown in Figure 13.

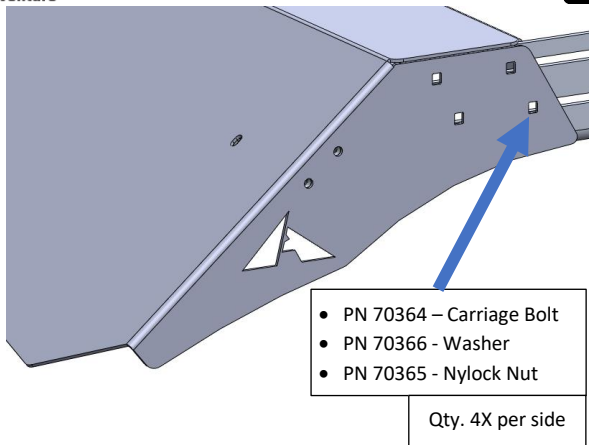


Figure 13: Air Dam Subassembly Installation

- Remove all painted plugs from mounting locations along roof (Figure 14). There should be eight in total and will require a razor blade to cut through the paint.



Figure 14: Roof Rack Mounting Point Plug Removal

- Verify the threaded hole in the roof underneath each plug is clear and ready to receive the hardware. These threaded inserts are not necessarily in the center of the plug and therefore, some of the sheet metal on the roof may need to be opened up with a Dremel to provide clearance. Additionally, there may be overspray in the threads. If so, run a M8 x 1.25 tap through them to clear the threads.
- 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. Apply a liberal amount of silicone to the bottom of the mounting pad and to the threads of the M8 x 1.25 hardware. Reference Figure 15 & Figure 16.



Figure 15: Silicone Sealant Applied to the Bottom of Mounting Pad



Figure 16: Silicone Sealant Applied to the M8 Mounting Hardware

- Place the mounting pad onto each mounting location with the silicone sealant face down, creating a seal around the threaded insert hole on the van's roof.
- Place the roof rack onto the mounting pads, verifying and aligning the mounting brackets are securely located on the mounting pads.
- Install the M8 hardware (with silicone sealant on the threads) through each mounting bracket, mounting pad, and into the threaded insert on the van.
- Reposition the roof rack and/or mounting brackets as needed to finalize location.
- Tighten all hardware.
- Apply a liberal amount of silicone sealant around the bolts at each mounting location as a final seal (Figure 17).

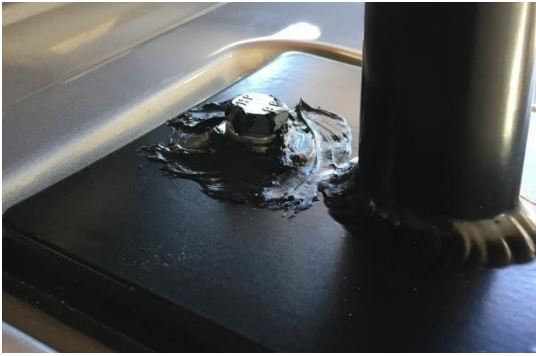


Figure 17: Silicone Sealant Applied to the Mounting Hardware

19. Your new Aluminess roof rack is now installed!
Be sure to check all bolts after the first 100 miles of driving and periodically thereafter.



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	--



Aluminess Products, Inc. (Aluminess) Warranty

1. Lifetime Warranty. Aluminess provides a lifetime warranty of its products to the original retail purchaser provided such products are installed correctly according to the official Aluminess installation instructions. Any modification to the original product design, function or use of any Aluminess products will void the Aluminess warranty. Aluminess will have sole discretion to determine warranty eligibility for any and all Aluminess products sold to any purchaser.
2. Limited Remedies. Subject to any limitations and exclusions described herein, and subject to Aluminess' determination of warranty eligibility, Aluminess will remedy defects in product materials and/or workmanship of any product by repairing or replacing such defective product, which shall be within Aluminess' sole discretion, without charge for parts or labor. Aluminess may elect in its sole discretion not to replace a defective product and issue the purchaser a refund equal to the purchase price of any defective product or purchaser may elect to receive a credit (equal to such refund) toward the purchase of new Aluminess products. Repair or replacement of a defective product or providing a refund or credit to purchaser will be purchaser's exclusive remedy under this warranty. Damage to a purchaser's vehicle, cargo and/or any other person or property is expressly excluded from the Aluminess warranty.
3. Modification. Aluminess products are designed to be mounted to factory equipped vehicles. Aftermarket additions to such vehicle may or may not require modification of an Aluminess product. The Aluminess warranty does not extend to any Aluminess products that are modified to fit around other otherwise accommodate or be compatible with any aftermarket vehicle accessories or alterations. Aluminess does not guarantee fitment with any other aftermarket accessories or modified vehicle, and it is up to purchaser to determine fitment prior to purchasing any Aluminess product.
4. Damage. Damage to Aluminess products due to normal wear and tear, including, but not limited to, cosmetic issues and superficial scratches, or structural damage to an Aluminess product in connection with any vehicle collisions or other structural degradation in connection with the use of such vehicle (on road or off road) will not be covered by the Aluminess warranty. Additionally, any product user's misuse, neglect, overloading, improper maintenance or improper installation or repair of any Aluminess products are not covered under the Aluminess warranty.
5. Use of the Products. Aluminess products are designed for off road vehicle use. Installing Aluminess products on a vehicle may exceed the factory designed capabilities of such vehicle and could potentially lead to vehicle damage. Aluminess will not be responsible for any damage caused to a purchaser or user's vehicle or any vehicle accessories caused by the use of any Aluminess products. It is to the sole responsibility of purchaser to inspect and ensure that the intended vehicle and Aluminess products are suitable and compatible for travel on road and off road. No seller nor any manufacturer of Aluminess products will be liable for any loss, damage or injury directly or indirectly arising from the use of any Aluminess products. Before using any Aluminess products, the purchaser or user will determine the suitability of the product(s) for their intended use(s) and the purchaser or user shall assume all responsibility and risk in connection therewith.
6. DISCLAIMER. THE ALUMINESS WARRANTY IS EXPRESSLY MADE IN LIEU OF ANY AND ALL OTHER WARRANTIES, AND EXCEPT FOR THE ALUMINESS WARRANTY SET FORTH HEREIN, ALUMINESS MAKES NO WARRANTY WHATSOEVER WITH RESPECT TO ANY ALUMINESS PRODUCT, INCLUDING ANY WARRANTY OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, WHETHER EXPRESS OR IMPLIED BY LAW, COURSE OF DEALING, COURSE OF PERFORMANCE, USAGE OF TRADE, OR OTHERWISE.

EXCEPT FOR PURCHASER'S LIMITED REMEDIES SET FORTH HEREIN, IN NO EVENT WILL ALUMINESS BE LIABLE FOR ANY LOST PROFITS, LOST SALES, OR FOR ANY CONSEQUENTIAL, DIRECT, INDIRECT, INCIDENTAL, SPECIAL, EXEMPLARY OR PUNITIVE DAMAGES OR FOR ANY OTHER DAMAGES OF ANY KIND OR NATURE.
7. Compliance. Aluminess cannot guarantee that its products comply with all Federal, State, and/or local laws. Purchaser is advised to review local vehicle codes for compatibility prior to purchase to ensure that the installation and use of any Aluminess products does not violate any applicable laws.
8. Warranty Claim Submission. Purchaser will responsible for returning any defective product to Aluminess for warranty consideration and purchaser may be responsible for all costs associated with shipping the product to and from Aluminess. Prior to returning any product for warranty, purchaser must contact Aluminess Products Inc. for proper authorization.