

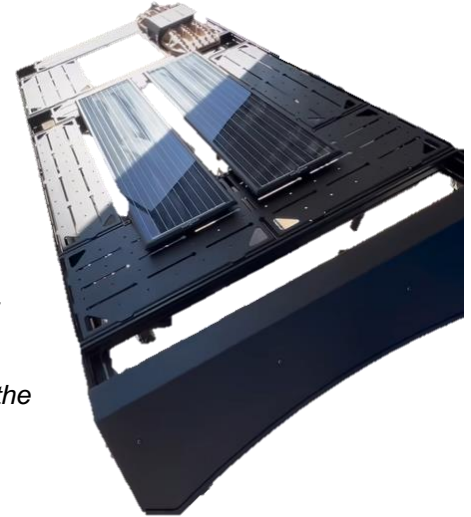


Recon Roof Rack Installation Instructions

P/Ns 210681: Dodge, Promaster, 14+ Recon Roof Rack, 159" WB, High Roof, Regular Body

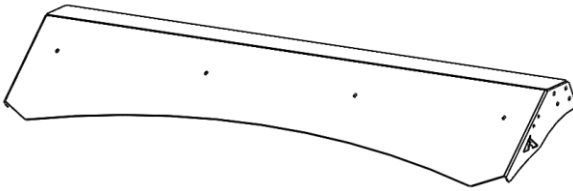
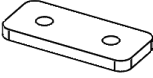
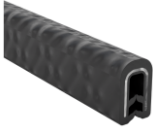


Before you begin:

- 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.

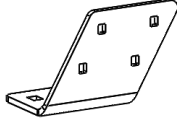
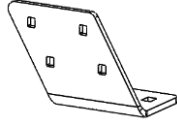
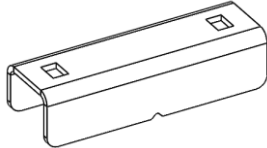





Required Tools:

- Standard wrench set

Subassembly	Qty.	PN	Components	Hardware
351120 (1X)	1	301376	 Air Dam, Promaster	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	
	56"	401008.1	 Rubber Trim, 3/32" Thickness	
351115 (2X)	2	301362	 Side Rail, Driver's Side, 6'	none
	2	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	
351123 (4X)	8	301379	 Promaster Mounting Bracket	16X – 70371 – 5/16”-18 x 1-3/4” carrg. 16X – 70345 – 5/16” ID Washer, Blk 16X – 70346 – 5/16”-18 Nylock Nut
	8	300669	 Promaster Roof Rack Mounting Clip	
	8	301310	 Promaster Roof Rack Mounting Gasket	
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 3 for more detail. Repeat for both driver and passenger sides.

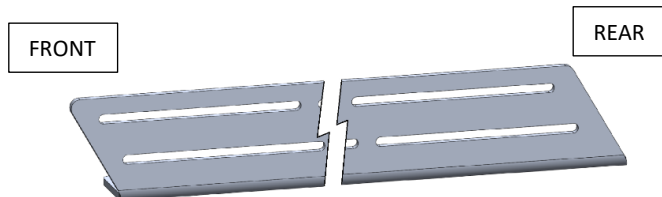


Figure 1: Side Rail Orientation



Figure 2: Side Rail Subassembly

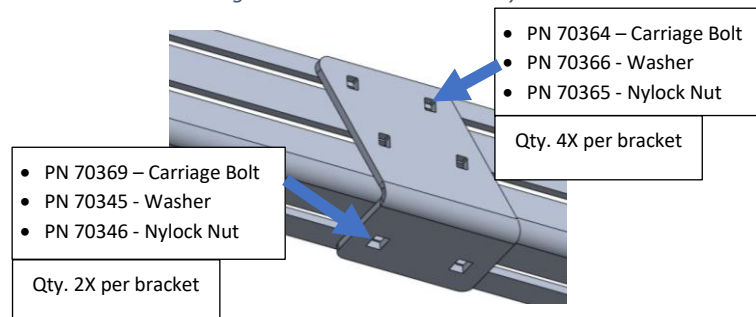


Figure 3: Side Rail Bracket Hardware Installation

- Determine desired vent location(s) and ensure that crossbar placement doesn't interfere.



3. Install at crossbars to connect the driver and passenger side rail subassemblies together. Use measurements of vents or flooring panels to correctly space crossbars. Crossbars can be installed **horizontally** or **vertically** (top & bottom slots) of the side rails. Reference Figure 4 & Figure 5.



Figure 4: Crossbar Installation

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

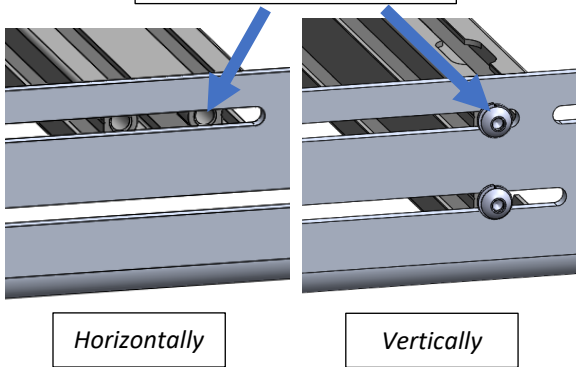


Figure 5: Crossbar Fastening to Side Rail Subassemblies

4. Install rubber trim along front edge of air dam (Figure 6).

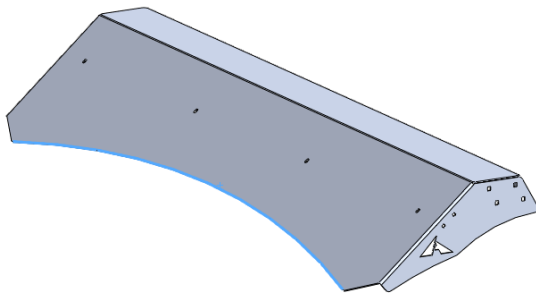


Figure 6: Rubber Trim Installation on Air Dam

5. Install spring onto track nut and insert into one of the crossbars as shown in Figure 7 & Figure 8.

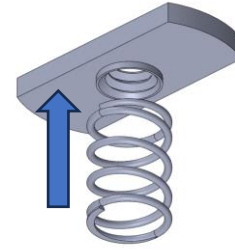


Figure 7: Combining the Spring with the Track Nut

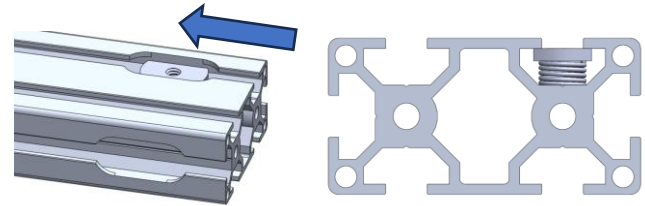


Figure 8: Installing Track Nut & Spring into Crossbar

6. 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 9.

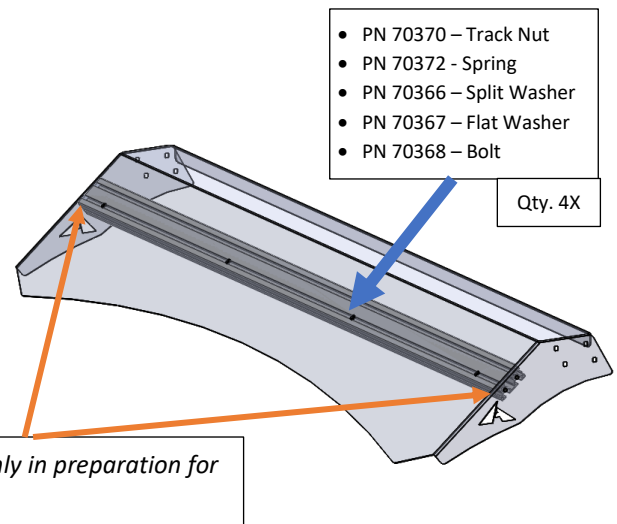


Figure 9: Crossbar Install onto Air Dam

7. Install air dam spacer between crossbar and air dam inside edge (Figure 10). Use ¼"-20 hardware to fasten together. Repeat for both driver and passenger side.

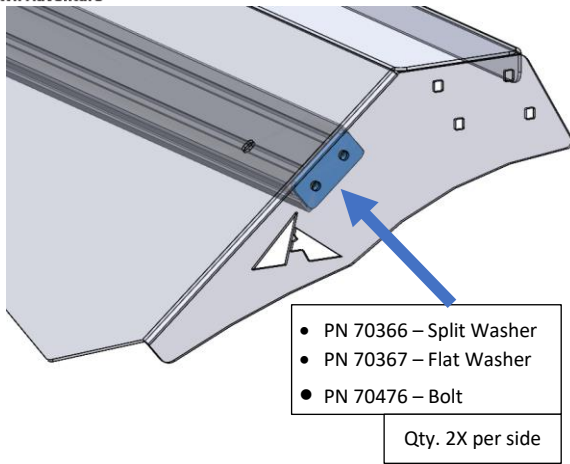


Figure 10: Air Dam Spacer Installation

8. Install air dam subassembly onto roof rack using appropriate carriage bolts and hardware shown in Figure 11.

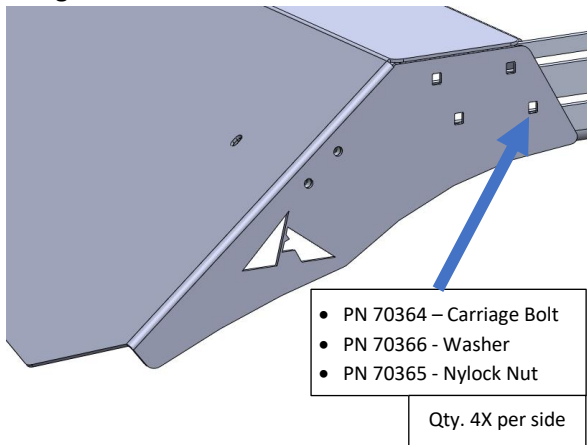


Figure 11: Air Dam Subassembly Installation

9. Insert 5/16" carriage bolts into the roof rack clip and install onto all studs on the top of the roof as shown in Figure 12. Repeat as necessary. The roof rack mounting gasket (rubber) should be placed around each clip in preparation for the mounting bracket.

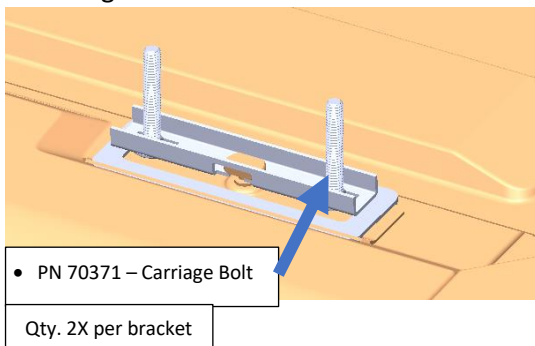
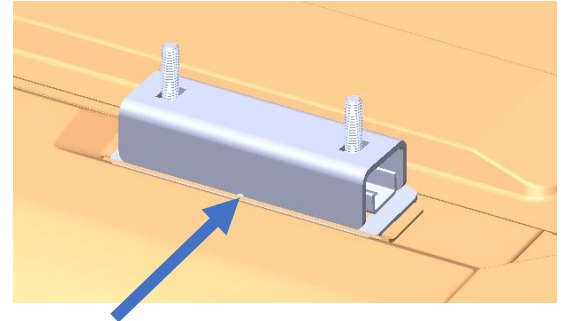


Figure 12: Roof Rack Clip Installation

10. Install mounting brackets over the carriage bolts and roof rack clips as shown in Figure 13. Be sure to align the edges of the bracket to be centered on the mounting gasket to protect the roof from scratches.



NOTE: Install mounting bracket with notch facing the outer sides of the van (outboard)

Figure 13: Mounting Bracket Installation

11. Lift your rack onto the roof track system while aligning the carriage bolts onto the slot of the side rails on the roof rack. Use the air dam as a guide to locate the roof rack front-to-back.
12. Apply anti-seize to all studs.
13. Fasten roof rack to mounting brackets using the 5/16" hardware and referencing Figure 14 for more detail.

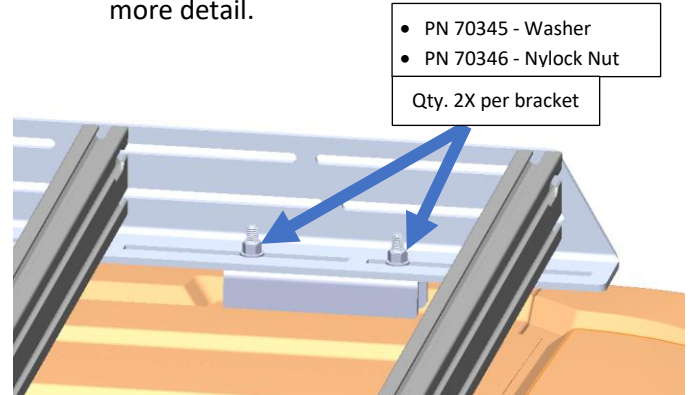


Figure 14: Fastening Transit Mounting Bracket (Underside)

14. 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	--



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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.
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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.
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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.