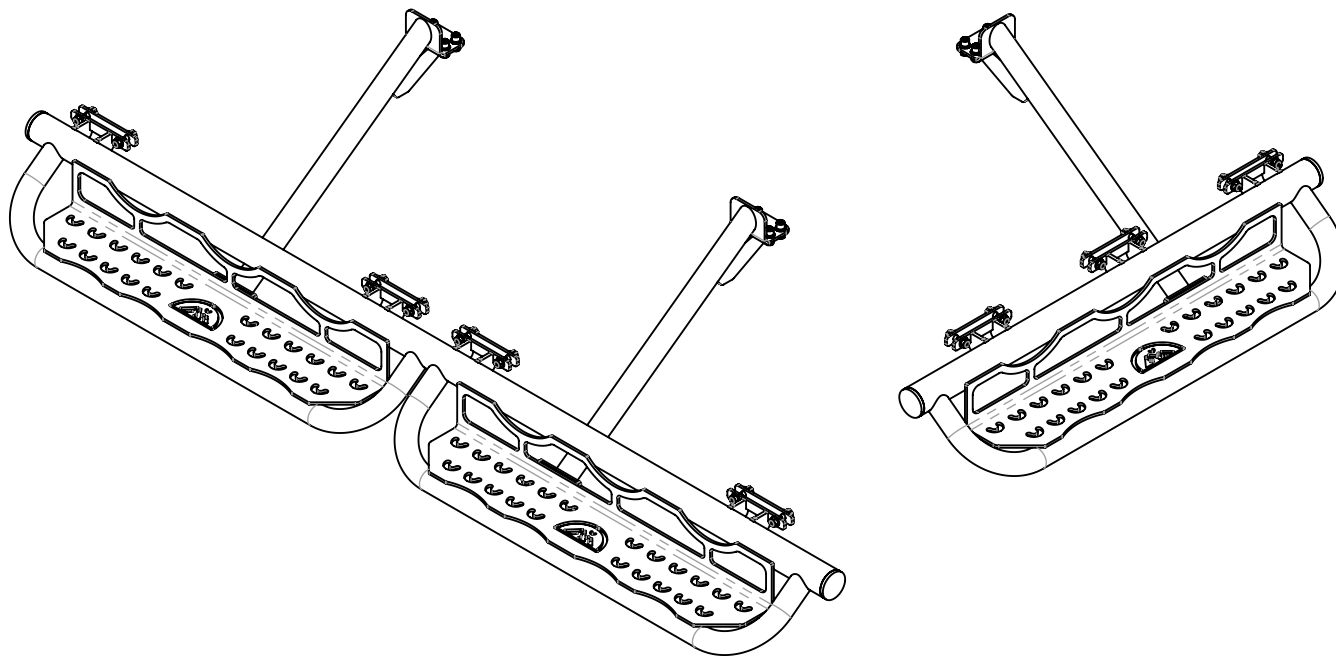




MERCEDES SPRINTER SIDE STEPS INSTALLATION INSTRUCTIONS



NOTES

- Initial Loose Fit: Due to manufacturing tolerances of the Sprinter vans and these steps, some hardware may need to be left loose initially to make installing the hardware easier. This is generally noted but, in some cases, other hardware may need to be loosened up so that all hardware can be installed, then tightened up.

PREVENTATIVE MAINTENANCE

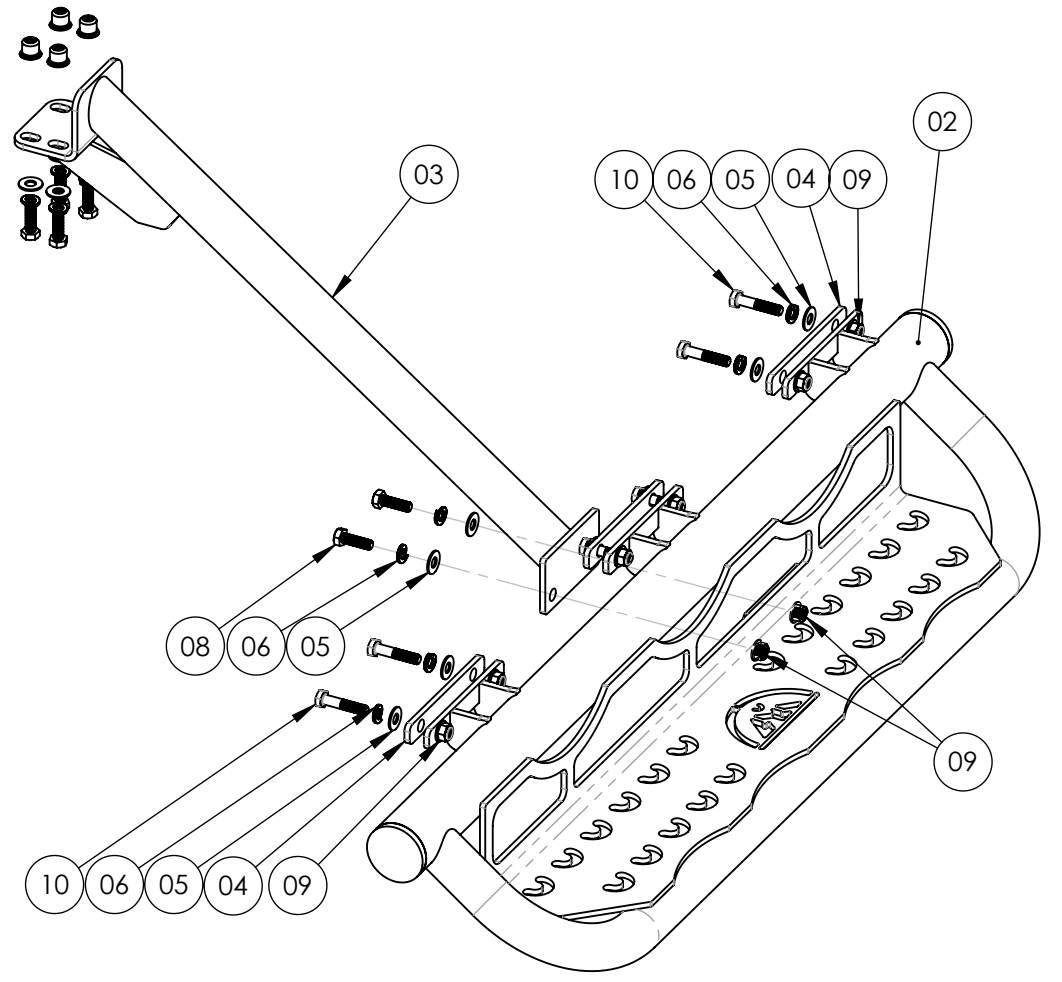
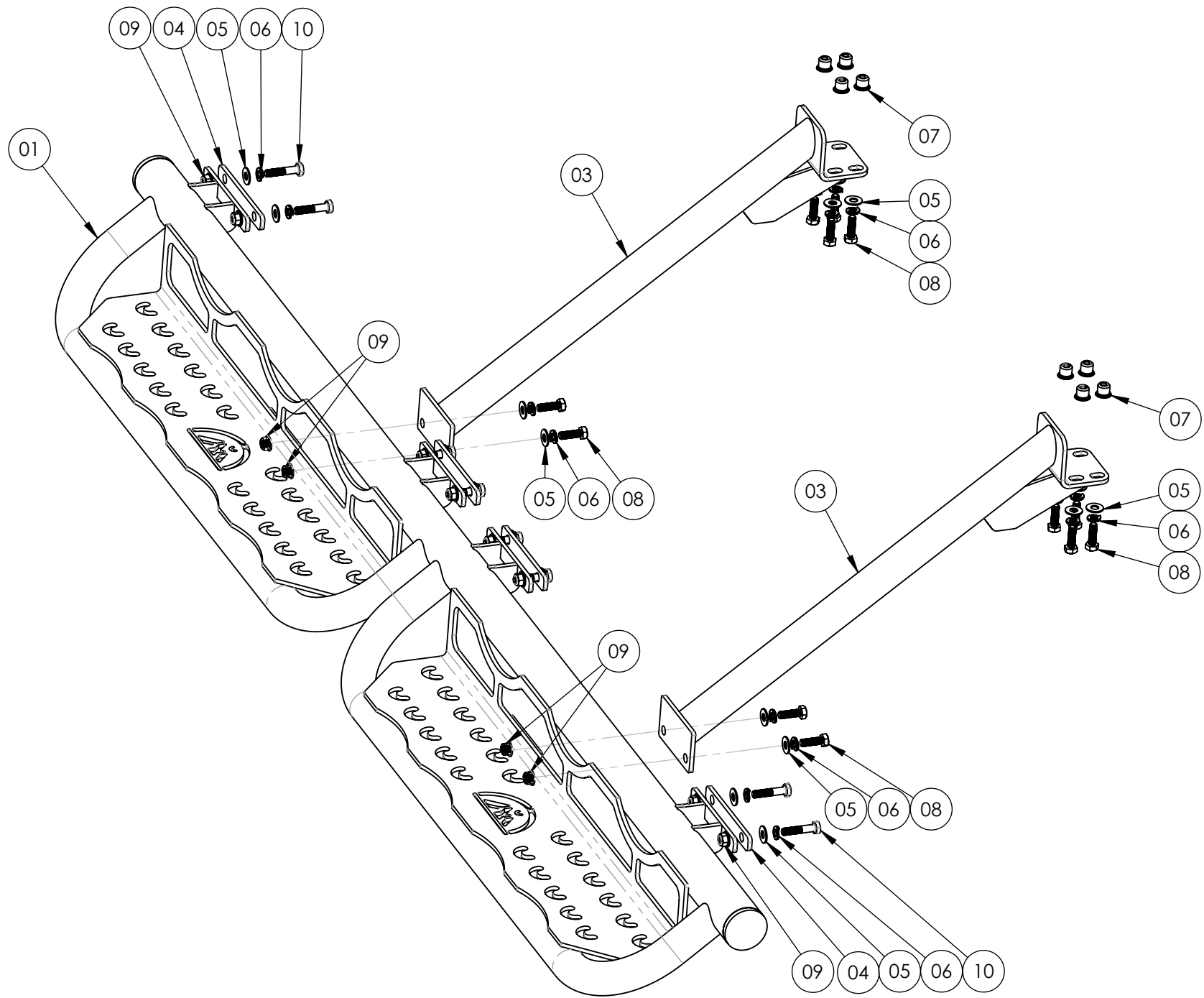
- Even though we do not expect any of the hardware to come loose, we recommend checking your side step hardware from time to time to minimize the chance of something coming loose over time. using the appropriate tools, perform re-tightening of the hardware over the following intervals:
 - Initial check after 4-7 days of moderate driving
 - Follow-up check one month after moderate driving
 - Routine checks every 3-4 months of moderate driving
 - Anytime after driving on harsh gravel or bumpy roads

REQUIRED TOOLS

- Standard set of box wrenches
- Standard socket set
- Hand Drill WITH 13/32 BIT, 7/16 BIT, 17/32 BIT
- Metal file and or sandpaper (for cleaning holes in rib after drilling)
- Primer and paint (to protect holes after drilling)
- Torque Wrench
- Loctite 242 Threadlocker (Blue)
- Rivet installer



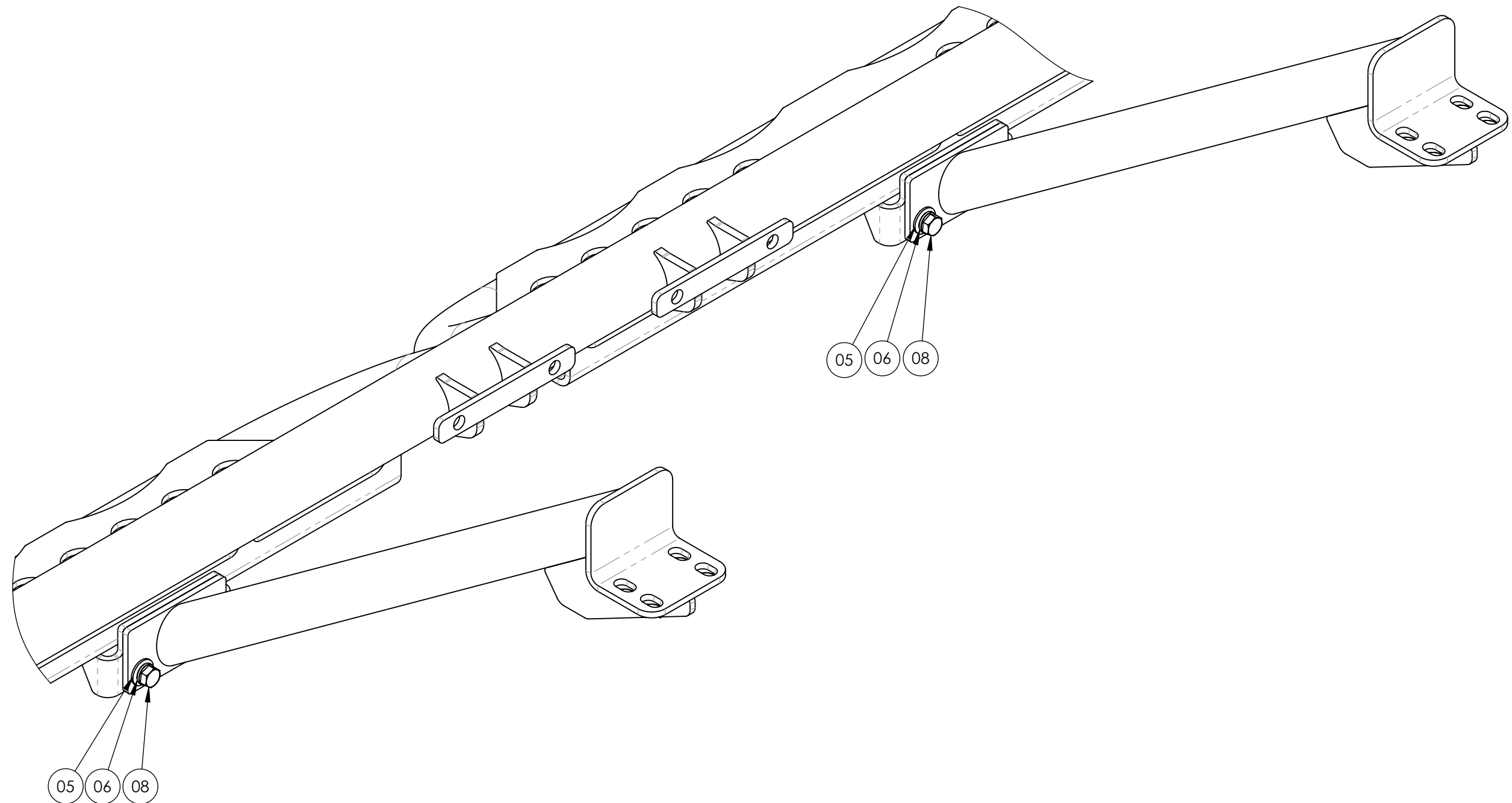
ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
01	1	---	SPRINTER PASSENGER STEP ASSEMBLY
02	1	---	SPRINTER DRIVER STEP ASSEMBLY
03	3	---	SPRINTER STEP SUPPORT BRACKET ASSEMBLY
04	7	---	PINCH WELD MOUNTING PLATE
05	32	92141A030	STAINLESS WASHER - 5/16in
06	32	92146A030	STAINLESS LOCK WASHER - 5/16in
07	12	97467A727	STAINLESS RIVET NUT - 5/16-18 THREAD
08	18	92240A583	STAINLESS HEX SCREW - 5/16-18 L=1in
09	20	94238A102	STAINLESS NYLON LOCKNUT - 5/16-18
10	14	92198A687	STAINLESS HEX SCREW - 5/16-18 L=1.5in



STEP 1

ASSEMBLE THE PASSENGER SUPPORT BARS TO THE PASSENGER STEPS

- USING THE SUPPLIED HARDWARE, ATTACH THE SUPPORT BARS TO THE SIDE STEPS
- HARDWARE WILL BE HAND TIGHT FOR THIS STEP



STEP 2

LINE UP PASSENGER STEP FOR BODY HOLE DRILLING

- USING EXTRA HELPING HANDS OR A LARGE JACK AND SOME FLAT WOOD, RAISE THE SIDE STEPS UP AND UNDER THE VAN
- THE FRONT END OF THE STEPS WILL BE JUST BEHIND THE WHEEL WELL FENDER LINER
- THERE IS A TOLERANCE OF POSITION BY ABOUT AN INCH IN FORWARD OR BACKWARD DIRECTION
- WHEN PROPERLY PLACED, THE SUPPORT BRACKET HOLES WILL NOT OVERLAP WITH ANY HOLES ON THE SPRINTER FRAME
- MOVE THE STEPS TO YOUR PREFERRED POSITION AND MAKE HARDWARE HAND TIGHT



STEP 3

MARK HOLES FOR DRILLING IN PINCH WELD AND FRAME

- MAKING SURE THE ASSEMBLY HAS NOT MOVED, THE PINCH WELD DRILLING LOCATIONS MUST BE MARKED AND FRAME HOLES MARKED WITH BRACKETS IN PLACE.
- MARK THE HOLES ON THE PINCH WELDS BY USING THE PINCH WELD PLATES AND LINING THEM UP VISUALLY WITH THE WELDED PLATES ON THE STEPS
- LOOKING AT THE PICTURE ON THE RIGHT, SOME AREAS OF THE PINCH WELD HAVE THICKER MATERIAL BUILD UP. GRINDING FLAT MAY BE NECESSARY.



STEP 4

DRILL HOLES / RUST PROTECTION

- WITH THE STEPS AND SUPPORT BARS REMOVED, DRILL HOLES
- USE 13/32 TO 7/16 DRILL BIT FOR PINCH WELD HOLES
- USE 17/32 DRILL BIT FOR FRAME HOLES FOR RIVET NUT
- AFTER ALL HOLES ARE DRILLED, GRIND FLAT AS SHOWN BELOW
- COAT WITH RUSTOLEUM PAINT OR EQUIVALENT PAINT PROTECTION



STEP 5

INSTALL RIVET NUTS

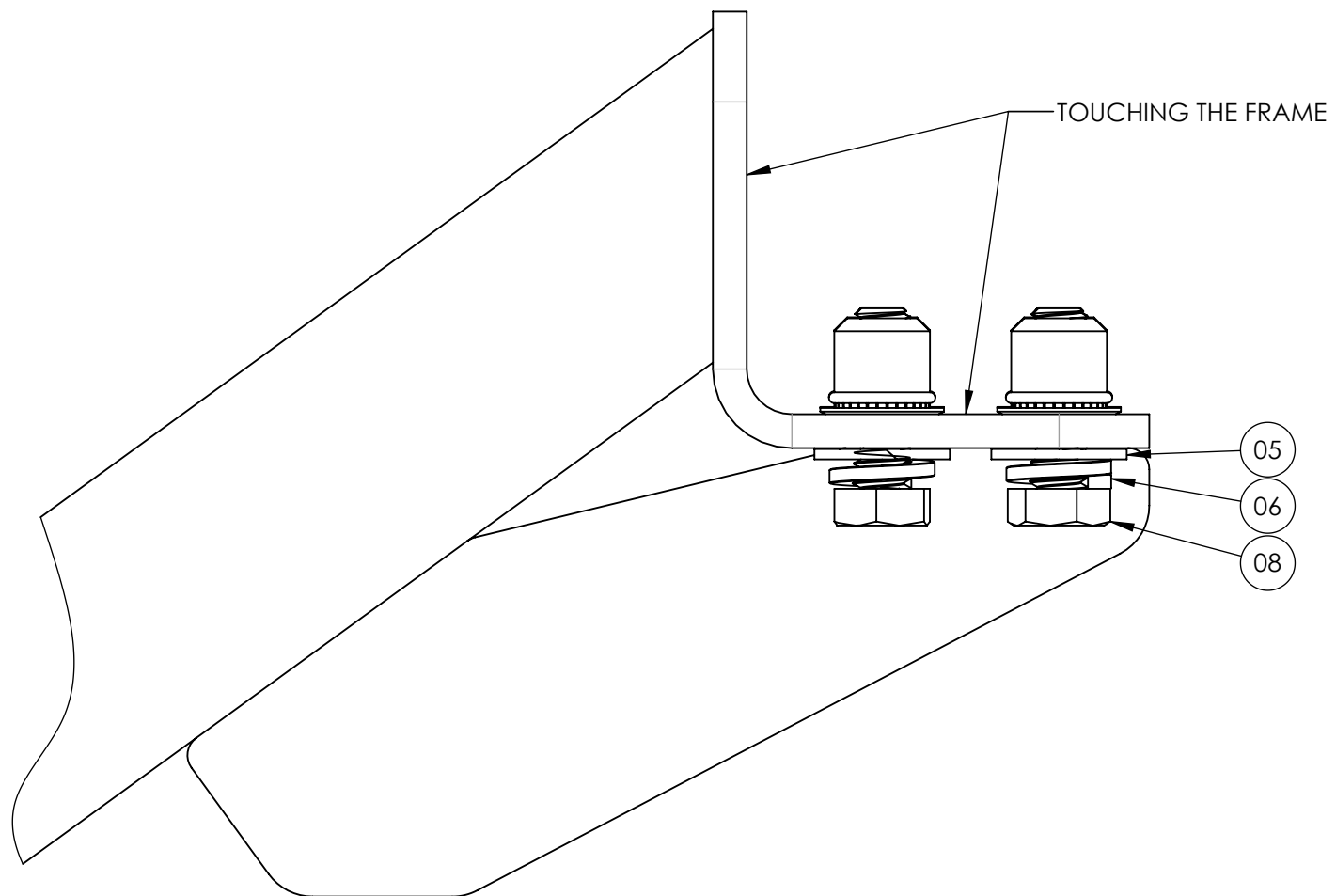
- USING THE RIVET NUT INSTALL TOOL, CAREFULLY INSTALL THE RIVET NUTS INTO THE FRAME



STEP 6

INSTALL SUPPORT BARS

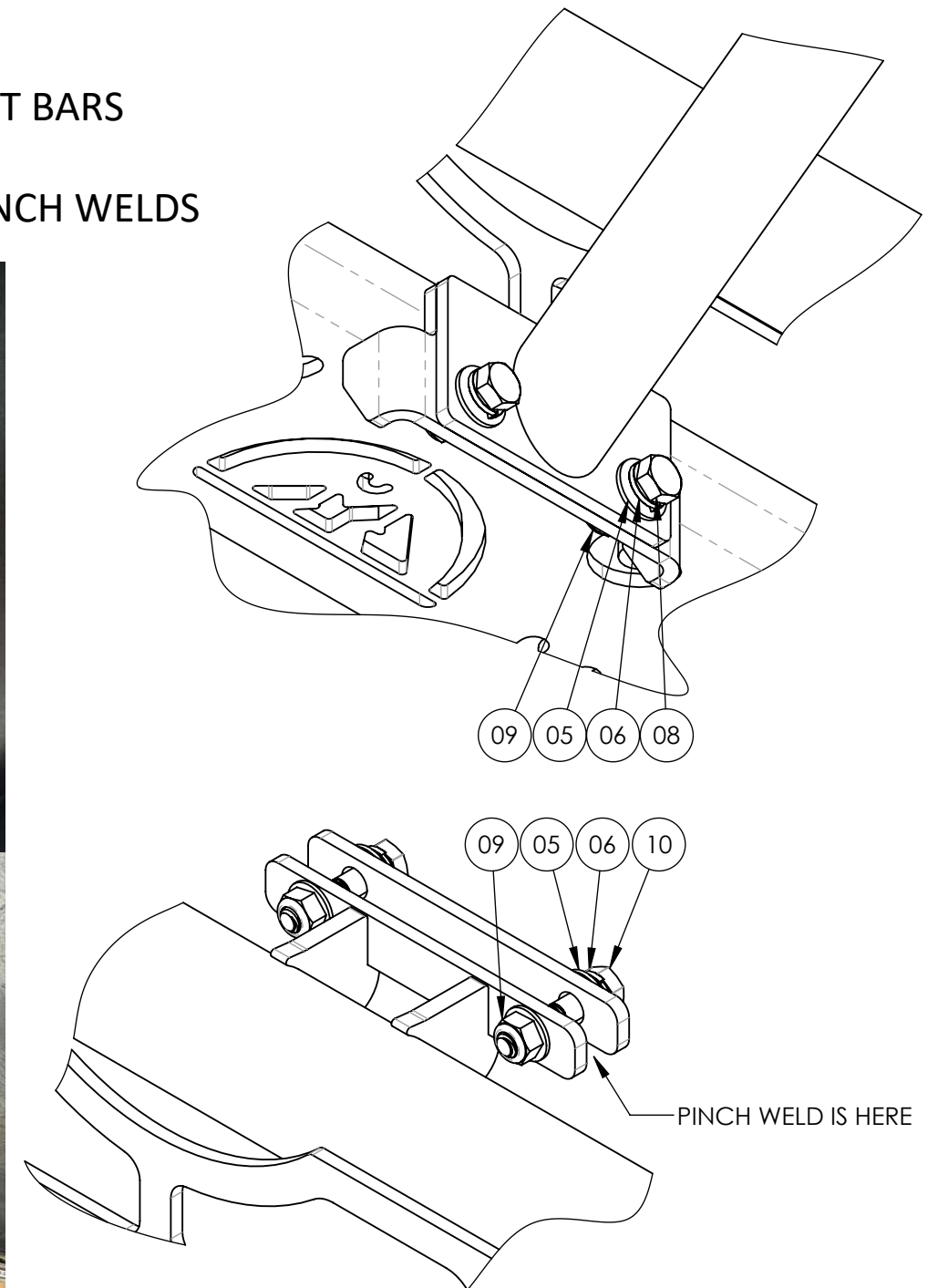
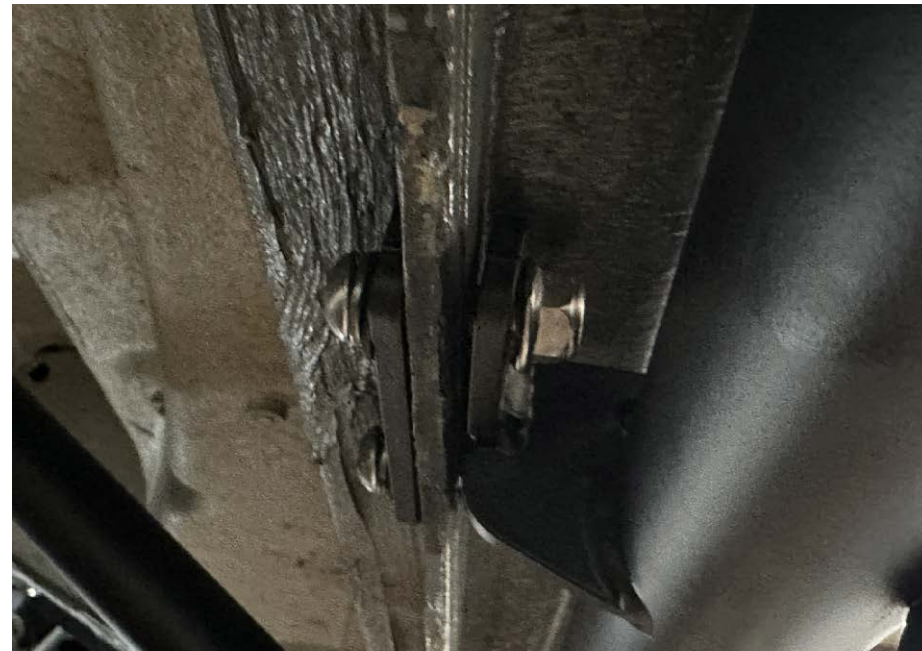
- INSTALL THE SUPPORT BARS USING THE SUPPLIED HARDWARE ON TO THE FRAME. BE SURE THE BRACKET IS FULLY SEATED WITH THE FRAME
- LEAVE THE HARDWARE SLIGHTLY LOOSE FOR THE NEXT STEPS



STEP 7

INSTALL SIDE STEPS

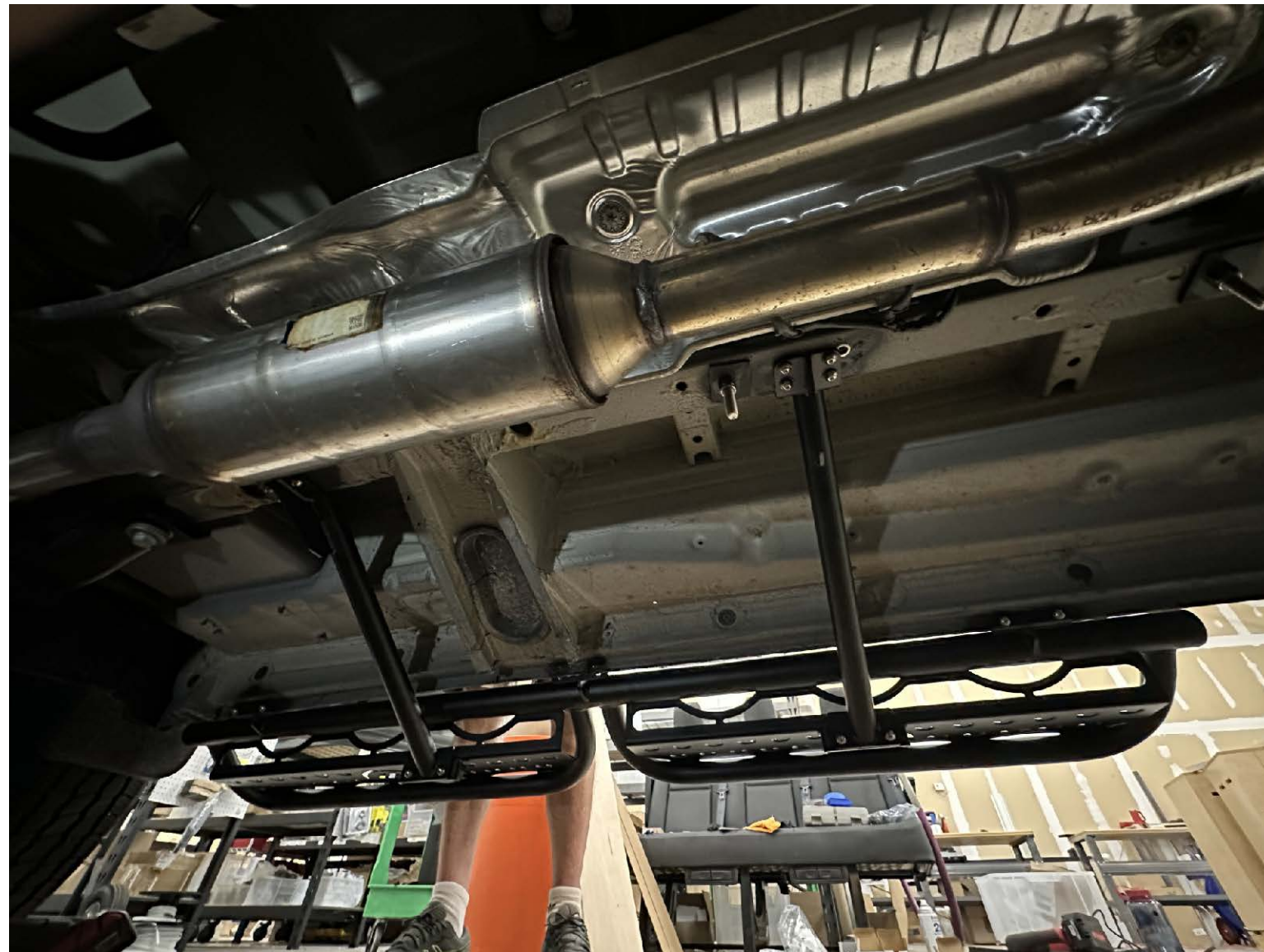
- RAISE THE SIDE STEPS INTO POSITION TO LINE UP ALL HOLES ON PINCH WELDS AND SUPPORT BARS
- MOVING THE STEPS AROUND TO GET ALL HARDWARE INSERTED MAY BE NECESSARY
- USING THE SUPPLIED HARDWARE, CONNECT THE SIDE STEPS TO THE SUPPORT BARS AND PINCH WELDS



STEP 8

COMPLETE PASSENGER SIDE INSTALL

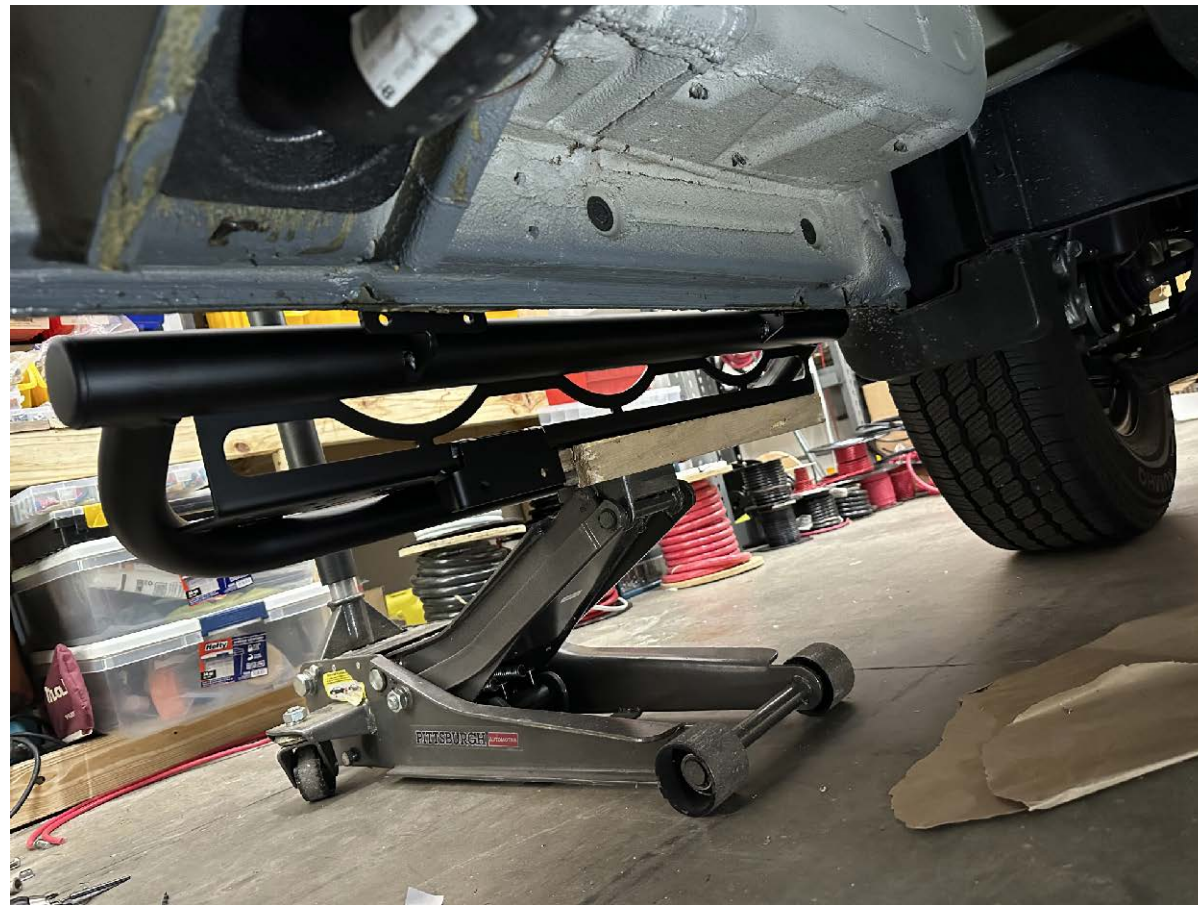
- ONCE ALL FASTENERS ARE INSTALLED, TIGHTEN ALL HARDWARE TO APPROX 20 LB-FT
- WHEN LOAD TESTING THE STEPS FOR THE FIRST TIME, MAKE SURE TO HOLD ON TO THE VAN
- THE SIDE STEPS WILL NOT BE 100% RIGID WHEN WEIGHT IS APPLIED, THERE WILL BE SLIGHT MOVEMENT AROUND THE AREA OF LOAD (1-2MM)



STEP 9

LINE UP DRIVER STEP FOR BODY HOLE DRILLING

- USING EXTRA HELPING HANDS OR A LARGE JACK AND SOME FLAT WOOD, RAISE THE SIDE STEPS UP AND UNDER THE VAN
- THE FRONT END OF THE STEPS WILL BE JUST BEHIND THE WHEEL WELL FENDER LINER
- THERE IS A TOLERANCE OF POSITION BY ABOUT AN INCH IN FORWARD OR BACKWARD DIRECTION
- WHEN PROPERLY PLACED, THE SUPPORT BRACKET HOLES WILL NOT OVERLAP WITH ANY HOLES ON THE SPRINTER FRAME
- MOVE THE STEPS TO YOUR PREFERRED POSITION AND MAKE HARDWARE HAND TIGHT



STEP 10

POSITION PARTS FOR DRILLING

- USING THE SUPPLIED HARDWARE, ATTACH THE SUPPORT BARS TO THE SIDE STEP
- HARDWARE WILL BE HAND TIGHT FOR THIS STEP
- POSITION THE SUPPORT BAR AGAINST THE FRAME TO MARK THE HOLES FOR DRILLING
- MAKE SURE THE FRAME IS FULLY NESTED IN THE BRACKET



STEP 11

MARK HOLES FOR DRILLING IN PINCH WELD AND FRAME

- MAKING SURE THE ASSEMBLY HAS NOT MOVED, THE PINCH WELD DRILLING LOCATIONS MUST BE MARKED AND FRAME HOLES MARKED WITH BRACKETS IN PLACE.
- MARK THE HOLES ON THE PINCH WELDS BY USING THE PINCH WELD PLATES AND LINING THEM UP VISUALLY WITH THE WELDED PLATES ON THE STEPS
- LOOKING AT THE PICTURE ON THE RIGHT, SOME AREAS OF THE PINCH WELD HAVE THICKER MATERIAL BUILD UP. GRINDING FLAT MAY BE NECESSARY.



STEP 12

DRILL HOLES / RUST PROTECTION

- WITH THE STEPS AND SUPPORT BARS REMOVED, DRILL HOLES
- USE 13/32 TO 7/16 DRILL BIT FOR PINCH WELD HOLES
- USE 17/32 DRILL BIT FOR FRAME HOLES FOR RIVET NUT
- AFTER ALL HOLES ARE DRILLED, GRIND FLAT AS SHOWN BELOW
- COAT WITH RUSTOLEUM PAINT OR EQUIVALENT PAINT PROTECTION



STEP 13

INSTALL RIVET NUTS

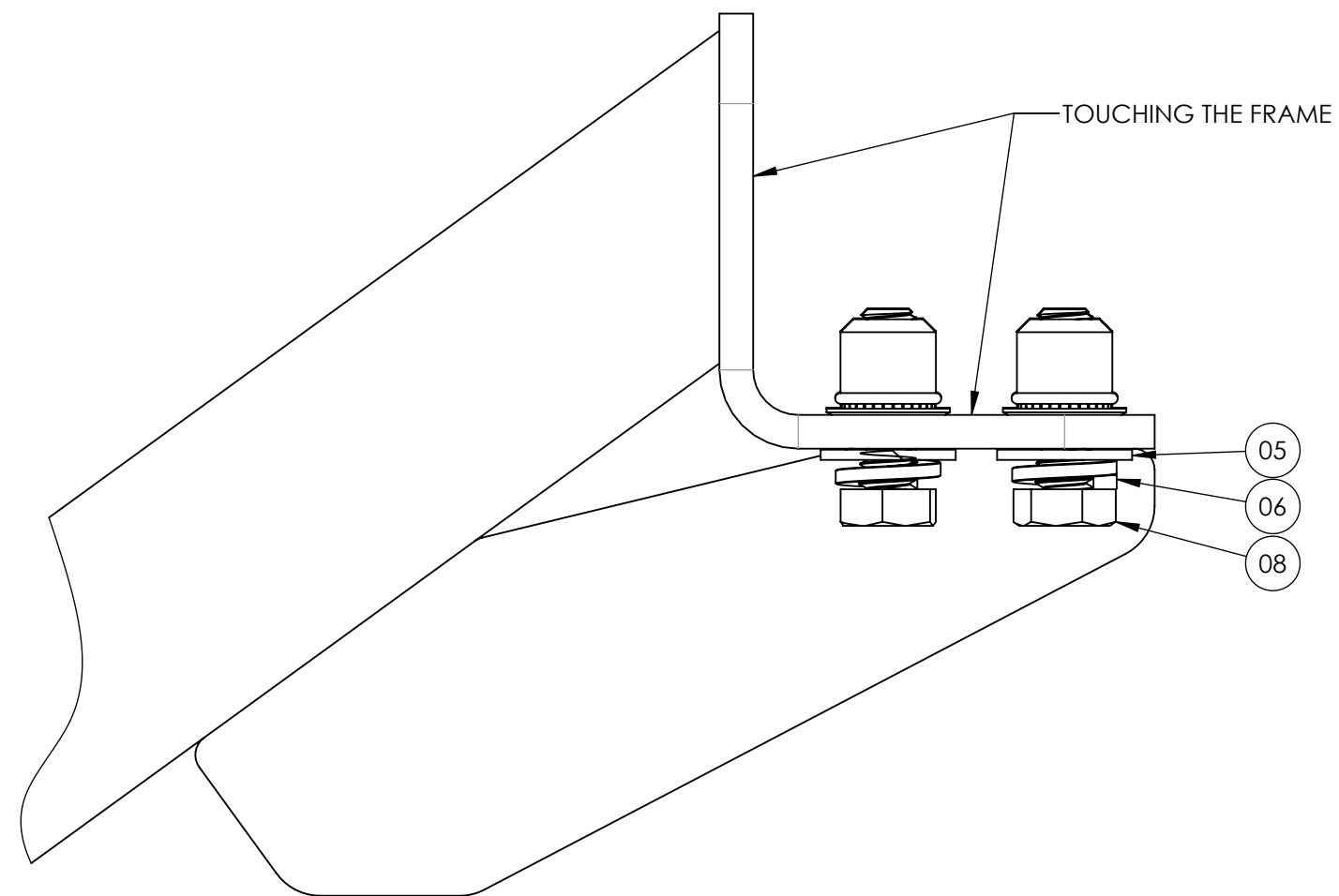
- USING THE RIVET NUT INSTALL TOOL, CAREFULLY INSTALL THE RIVET NUTS INTO THE FRAME



STEP 14

INSTALL RIVET NUTS

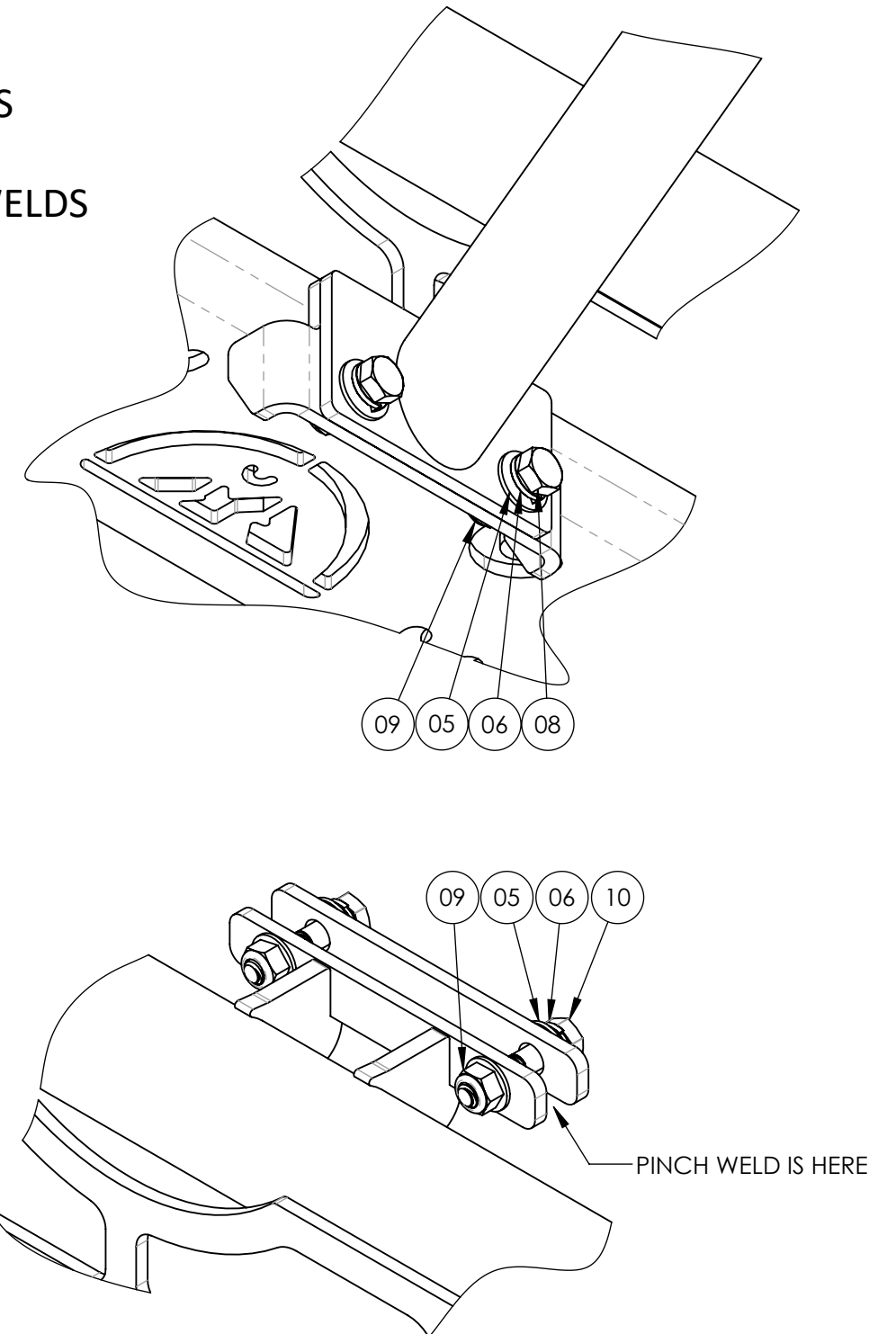
- USING THE RIVET NUT INSTALL TOOL, CAREFULLY INSTALL THE RIVET NUTS INTO THE FRAME



STEP 15

INSTALL DRIVER SIDE STEP

- RAISE THE SIDE STEPS INTO POSITION TO LINE UP ALL HOLES ON PINCH WELDS AND SUPPORT BARS
- MOVING THE STEPS AROUND TO GET ALL HARDWARE INSERTED MAY BE NECESSARY
- USING THE SUPPLIED HARDWARE, CONNECT THE SIDE STEPS TO THE SUPPORT BARS AND PINCH WELDS



STEP 16

COMPLETE DRIVER SIDE INSTALL

- ONCE ALL FASTENERS ARE INSTALLED, TIGHTEN ALL HARDWARE TO APPROX 20 LB-FT
- WHEN LOAD TESTING THE STEPS FOR THE FIRST TIME, MAKE SURE TO HOLD ON TO THE VAN
- THE SIDE STEPS WILL NOT BE 100% RIGID WHEN WEIGHT IS APPLIED, THERE WILL BE SLIGHT MOVEMENT AROUND THE AREA OF LOAD (1-2MM)



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