![ARIES logo]

INSTALLATION INSTRUCTIONS
4"ROUND SIDE BAR
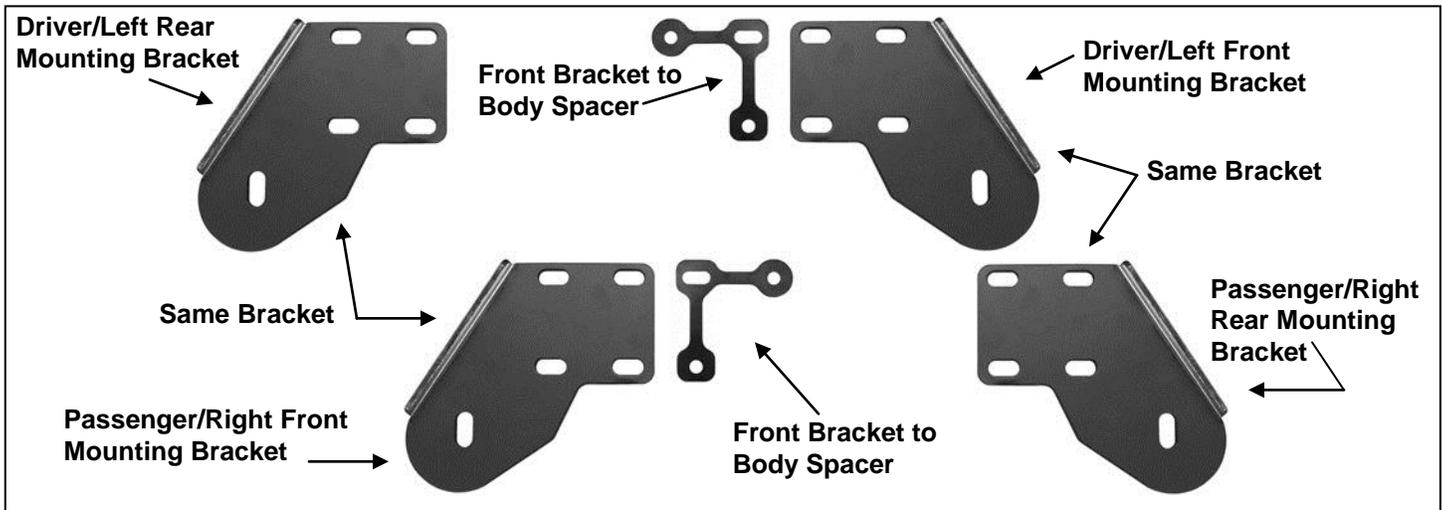**FORD F250/350/450/550HD CREW CAB 99-15**
PART #AL 233006

PARTS LIST:

1	Passenger Sidebar	8	10mm Flat Washers
1	Driver Sidebar	6	10mm Clip Nuts
2	Driver Side Front/Passenger Side Rear Mounting Brackets	14	10-1.50mm x 40mm Hex Head Bolts
2	Driver Side Rear/Passenger Side Front Mounting Brackets	22	10mm x 27mm OD x 3mm Flat Washers
2	Front Bracket Spacers	22	10mm Lock Washers
		8	10mm Hex Nuts
		8	10mm x 45mm Hex Bolts

Brackets pictures for reference only, actual brackets may be different .

Driver/Left Rear Mounting Bracket

Front Bracket to Body Spacer

Driver/Left Front Mounting Bracket

Same Bracket

Same Bracket

Passenger/Right Front Mounting Bracket

Front Bracket to Body Spacer

**Passenger/Right Rear Mounting Bracket**

PROCEDURE:

1. **REMOVE CONTENTS FROM BOX. VERIFY ALL PARTS ARE PRESENT. READ INSTRUCTIONS CAREFULLY BEFORE STARTING INSTALLATION. ASSISTANCE IS RECOMMENDED.**
2. Starting on the driver side-front of the vehicle, locate the front set of factory holes in the body panel and the (2) holes in the pinch weld under the front of the front door, **(Figures 1 & 2)**. Insert (1) 10mm Clip Nut into the rectangular opening and line up the threaded hole in the Clip with the round hole next to the opening. **NOTE**: Threaded nut must go towards the inside of the body panel, **(Figures 1 & 2)**.
3. Next, select (1) Front Bracket Spacer and (1) Driver Side Front Bracket. Line up the (2) holes in the Spacer with the Clip Nut and (1) hole in the pinch weld, **(Figures 3 & 4)**. Insert (1) 10mm x 40mm Hex Bolt, (1) 10mm Lock Washer and (1) 10mm Flat Washer through the top hole in the Bracket, the Spacer and into the Clip Nut, **(Figure 5)**. Leave hardware loose. Bolt the bottom of the Bracket to the pinch weld and Spacer with the included (2) 10mm x 40mm Hex Bolts, (2) 10mm Lock Washers, (4) 10mm Flat Washers and (2) 10mm Hex Nuts, **(Figure 5)**. **NOTE**: Insert Hex Bolts in from the outside, through the pinch weld and then the Bracket.
4. Move to the last mounting location at the rear of the cab. Repeat **Steps 2 – 3** for Rear Mounting Bracket installation, **(Figures 6 & 7)**. **NOTE**: Each rear mounting location is made up of a rectangular hole with a round hole on each side and two holes through pinch weld, **(Figure 7)**.
5. With assistance, carefully place the Sidebar into position and attach it to the Mounting Brackets using the included (4) 10mm x 45mm Hex Bolts, (4) 10mm Lock Washers and (4) 10mm Flat Washers, **(Figures 5 & 8)**.
6. Level and align the Sidebar with the side of the vehicle then tighten all hardware.
7. Repeat **Steps 2 – 6** for passenger side Mounting Bracket and Sidebar installation.
8. Periodically check and retighten the hardware as necessary.

To protect your investment, wax this product after installing. Regular waxing is recommended to add a protective layer over the finish. Do not use any type of polish or wax that may contain abrasives that could damage the finish.

For stainless steel: Aluminum polish may be used to polish small scratches and scuffs on the finish. Mild soap may be used also to clean the Sidebar.

For gloss black finishes: Mild soap may be used to clean the Sidebar.

Driver Side Installation Pictured
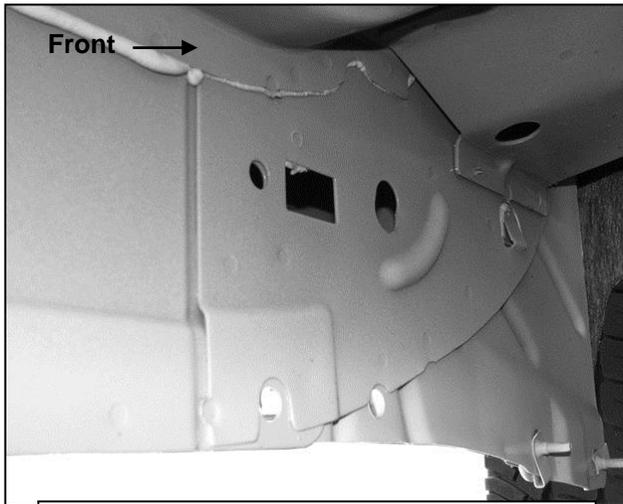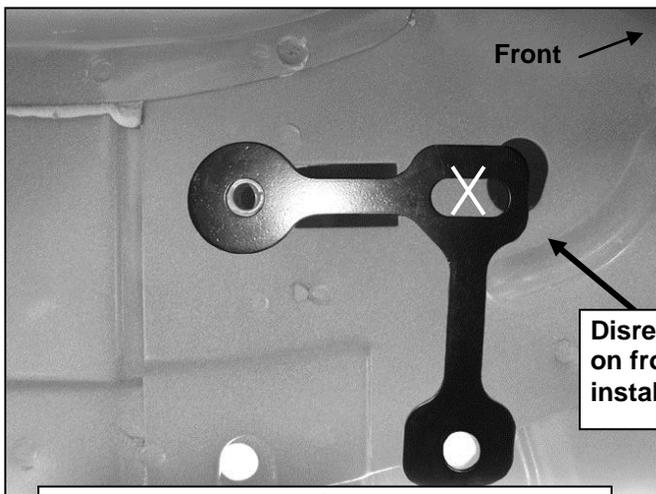
Front →

(Fig 1) Driver side front mounting location

Line up Clip Nut with factory hole
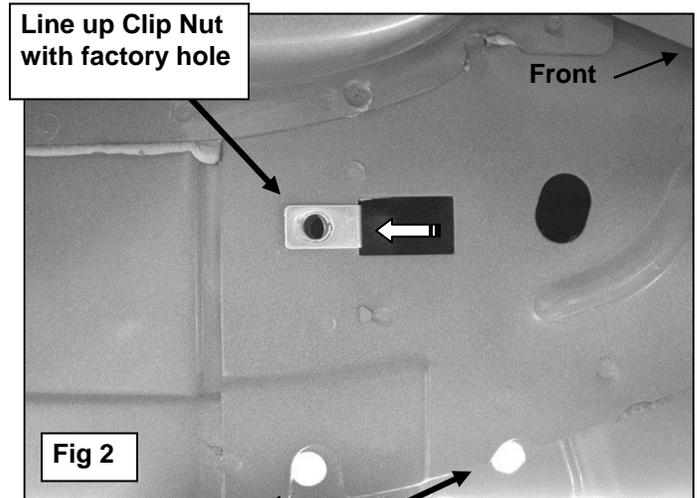
Front →

Fig 2

Back of pinch weld

Front →

Disregard extra slot on front bracket installation

(Fig 3) Front Bracket Spacer on driver side

Front →

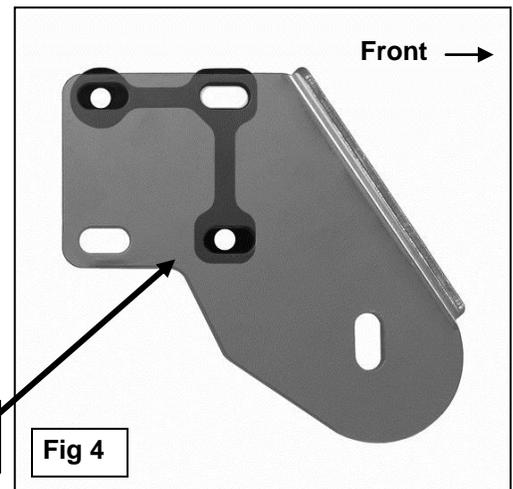**Spacer installs between the body panel and front Bracket only**

Fig 4

Driver Side Installation Pictured

**10mm Clip Nut
10mm x 40mm Hex Bolt
10mm Lock Washer
10mm Flat Washer**
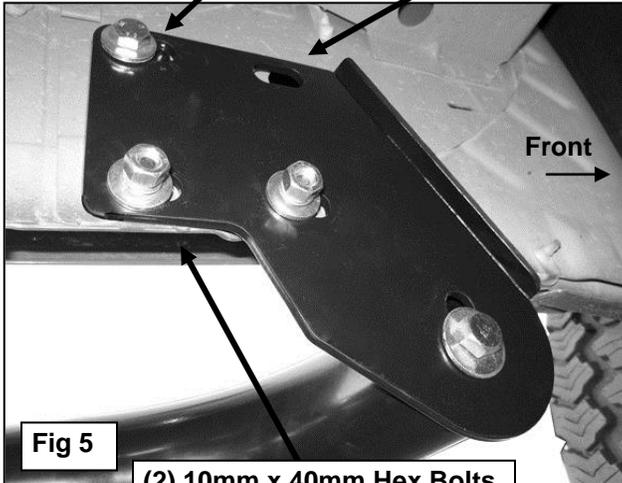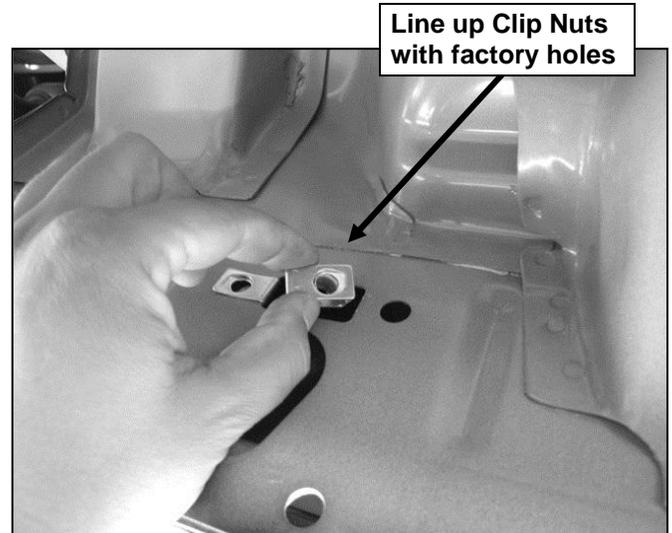
Disregard extra slot on front bracket installation

Front

Fig 5

**(2) 10mm x 40mm Hex Bolts
(2) 10mm Lock Washers
(4) 10mm Flat Washers
(2) 10mm Nuts**

Line up Clip Nuts with factory holes

(Fig 6) Example of typical rear mounting location
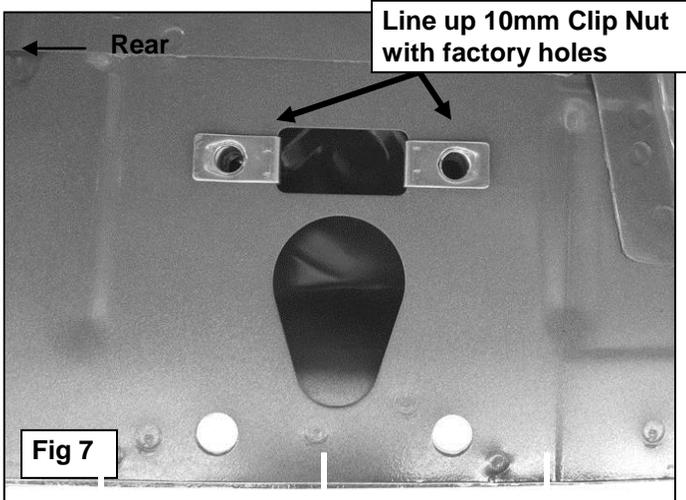
Line up 10mm Clip Nut with factory holes

Rear

Fig 7

**(2) Clip Nuts
(2) 10mm x 40mm Hex Bolts
(2) 10mm Lock Washers
(2) 10mm Flat Washers**

Rear

**(2) 10mm x 40mm Hex Bolts
(2) 10mm Lock Washers
(4) 10mm Flat Washers
(2) 10mm Nuts**

**(2)10mm x 45mm Hex Bolts
(2)10mm Lock Washer
(2)10mm Flat Washer
Actual brackets has 2 holes here**

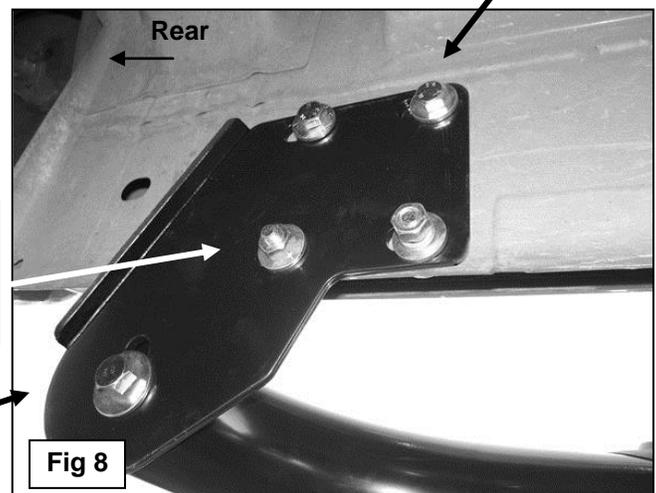**Fig 8**