

# Aries Automotive

## INSTALLATION INSTRUCTIONS

### SIDE BAR

1999-11 FORD F250 / F350 CREW CAB 2000-06 ECURSION

Part Number 203006/ 203006-2/ 233006-2

#### PARTS LIST:

|   |                                 |    |                                 |
|---|---------------------------------|----|---------------------------------|
| 1 | Passenger Side Bar              | 6  | 10mm Clip Nuts                  |
| 1 | Driver Side Bar                 | 14 | 10-1.50mm x 40mm Hex Head Bolts |
| 4 | Mounting Brackets               | 22 | 10mm Flat Washers               |
| 4 | 12-1.75mm x 50mm Hex Head Bolts | 14 | 10mm Lock Washers               |
| 4 | 12mm Lock Washers               | 8  | 10mm Hex Nuts                   |
| 4 | 12mm Flat Washers               |    |                                 |

#### PROCEDURE:

- 1. REMOVE CONTENTS FROM BOX. VERIFY ALL PARTS ARE PRESENT. READ INSTRUCTIONS CAREFULLY.**
- Locate the driver side front and rear mounting points under the vehicle on the pinch weld.
- Install the 10mm Clip Nuts (*Figure 1*). **NOTE:** The rear mount will required (2) Clip Nuts and the front only (1).
- Loosely attach the Driver Side Brackets to pinch weld using the included (2) 10-1.50mm x 40mm Hex Head Bolts, (4) 10mm Flat Washers, and (2) 10mm Lock Washers (2 & 3)).  
**NOTE:** *Pinch weld and side panel holes on the bracket must be Horizontal when installing.*
- Loosely attach the upper side of the Mounting Brackets to already installed Clip Nuts by using (2) 10-1.50mm x 40mm Hex Head Bolts, (2) 10mm Flat Washers, and 10mm Lock Washers on each Mounting Bracket (*Figure 2 & 3*)..
- Place Side Bar into position and loosely attach it to Mounting Brackets using the included (2) 12-1.75mm x 50mm Hex Head Bolts, (2) 12mm Flat Washers, and (2) 12mm Lock Washers (*Figure 4 & 5*). **NOTE:** *Side Bar mounting hole on the brackets must be vertical.*
- Level and align Side Bar with the side of the vehicle then tighten all hardware at this time.
- Repeat steps 2 to 7 for passenger side.
- Periodically check and retighten the hardware as necessary.

