

# 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.**
2. Locate the driver side front and rear mounting points under the vehicle on the pinch weld.
3. Install the 10mm Clip Nuts (*Figure 1*). **NOTE:** The rear mount will required (2) Clip Nuts and the front only (1).
4. 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.*
5. 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*)..
6. 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.*
7. Level and align Side Bar with the side of the vehicle then tighten all hardware at this time.
8. Repeat steps 2 to 7 for passenger side.
9. Periodically check and retighten the hardware as necessary.

Front Driver Shown

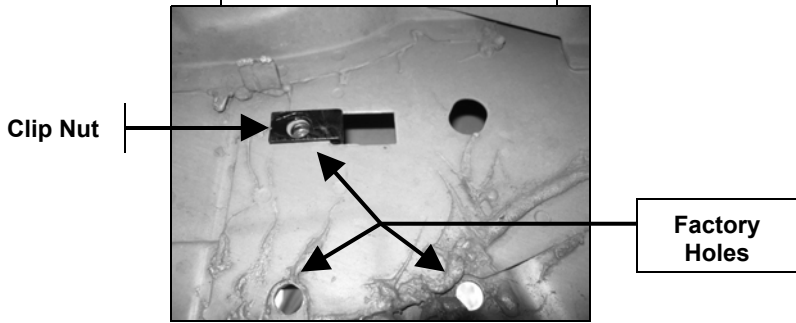


Figure 1

Front Driver Side Bracket Shown

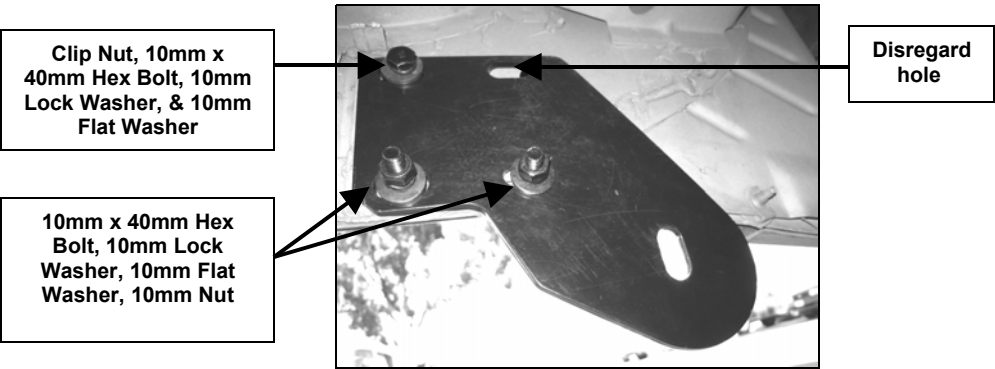


Figure 2

Rear Driver Side Bracket Shown

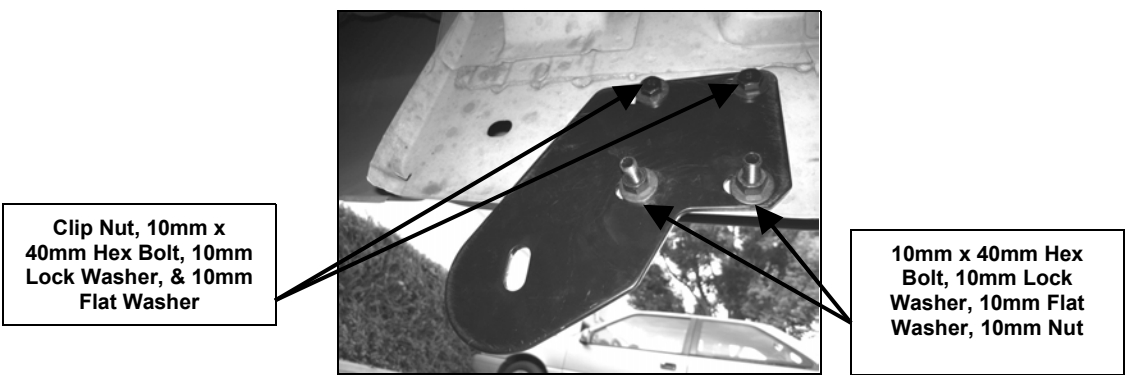


Figure 3

Rear Driver Side Bracket Shown

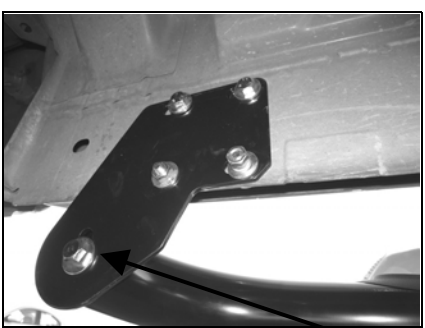


Figure 4

Front Driver Side Bracket Shown

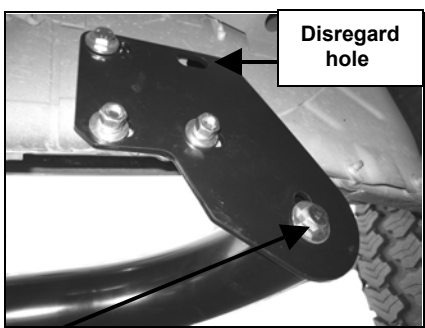


Figure 5

12mm x 50mm Hex Bolt, 12mm Lock Washer, & 12mm Flat Washer