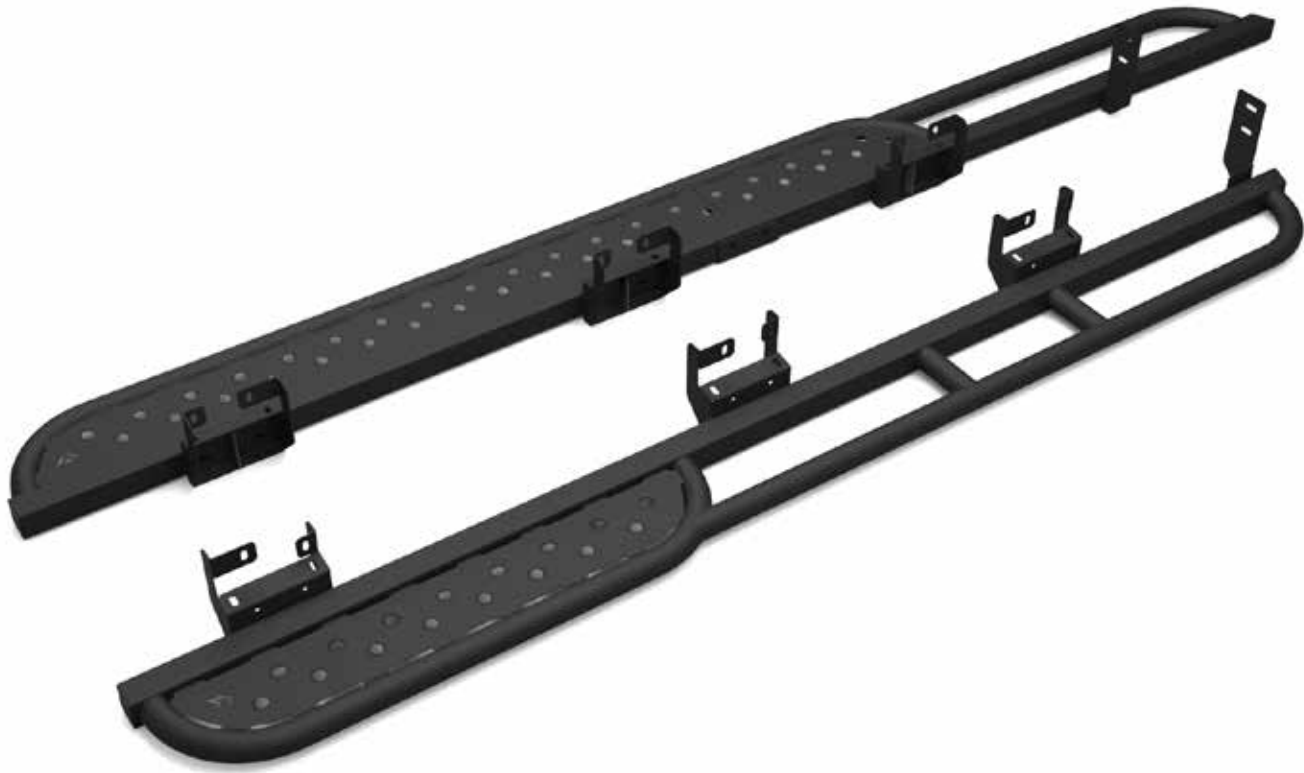




Installation Guide



Transit Side Steps 148 TR1101B

All Flatline Van Co products must be properly assembled and secured before attaching to your vehicle. Improper attachment could result in an automobile accident, and could cause serious bodily injury or death to you or to others involved. You are responsible for assembling and securing Flatline Van Co products to your vehicle, checking the mounting points and attachments prior to use, and regularly inspecting the products for wear and or damage. We always recommend you use a professional to install any aftermarket accessories to your vehicle. If you have no mechanical experience and are not thoroughly familiar with the installation procedures, you must have the product installed by a professional installer or other qualified persons. The responsibility is yours and must be taken seriously for everyone's safety.



thanks.

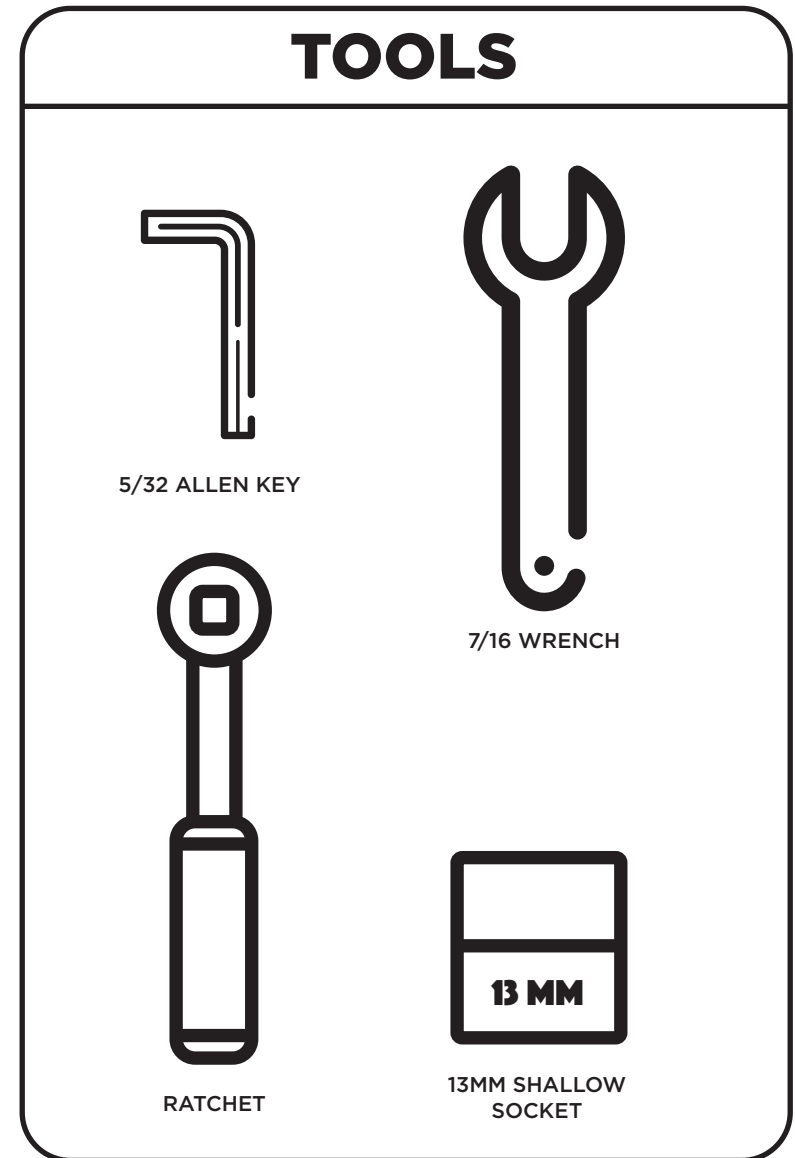
THANK YOU!

ARE YOU EXCITED ABOUT YOUR NEW SIDE STEPS? HERE ARE A FEW THINGS TO DO BEFORE BEGINNING THE INSTALLATION PROCESS--

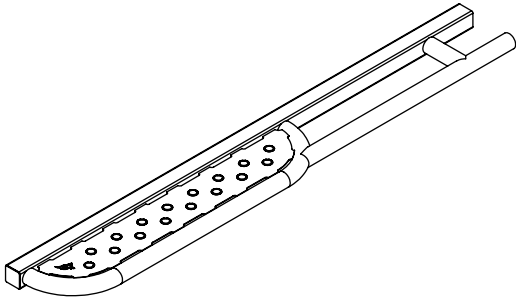
- PLEASE INSPECT THE PRODUCT TO ENSURE THERE WAS NO DAMAGE INCURRED DURING SHIPPING.
- IF THERE IS DAMAGE TO REPORT, PLEASE CONTACT OUR CUSTOMER SERVICE DEPARTMENT AS SOON AS POSSIBLE.
- NEXT, USING THE "PACKAGE CONTENTS" PAGE, CHECK INVENTORY AND FAMILIARIZE YOURSELF WITH THE PARTS AND HARDWARE.
- GATHER ALL TOOLS REQUIRED FOR INSTALL.
 - POWER DRILL
 - 3/16 DRILL BIT
 - 17/32 DRILL BIT
 - 7/32 ALLEN KEY
 - 5/32 ALLEN KEY
 - RIVET NUT TOOL WITH M8X1.25 MANDREL
 - 13MM SOCKET
 - 7/16 WRENCH
 - RATCHET
 - BLUE LOCTITE

ESTIMATED INSTALL TIME- 2 HRS

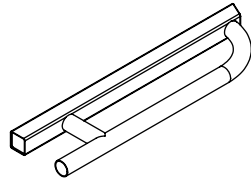
ADDITIONAL HELP IS SUGGESTED FOR A FEW OF THE INSTALL STEPS.



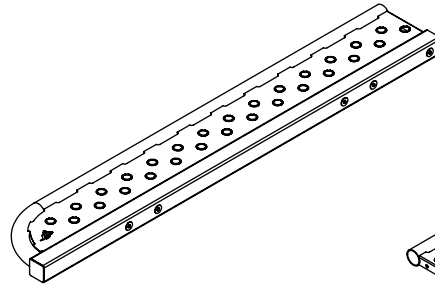
PACKAGE CONTENTS



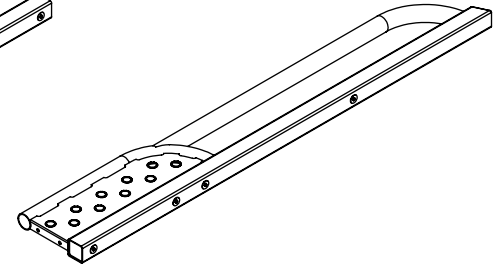
DRIVER STEP - FRONT
QTY - 1



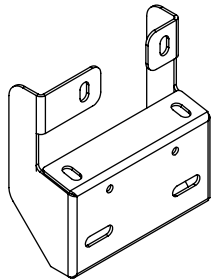
DRIVER STEP - REAR
QTY - 1



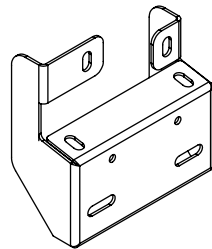
PASSENGER STEP - FRONT
QTY - 1



PASSENGER STEP - REAR
QTY - 1



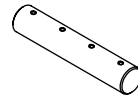
STEP BRACKET
QTY - 5



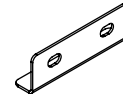
DRIVER FRONT STEP BRACKET
QTY - 1



REAR STEP BRACKET
QTY - 2



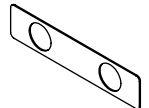
BAYONET
QTY - 2



JOINING BRACKET
QTY - 2

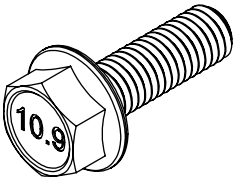


BRACKET SPACER SINGLE
QTY - 2



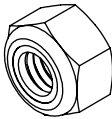
BRACKET SPACER DOUBLE
QTY - 6

HARDWARE



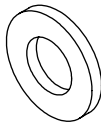
**M8-1.25 X 25
FLANGED HEX HEAD
SCREW**

QTY - 46



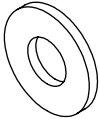
**M8-1.25 NYLON
INSERT LOCKNUT**

QTY - 12



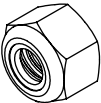
**M8 SCREW FLAT
WASHER**

QTY - 12



**1/4 SCREW FLAT
WASHER**

QTY - 2



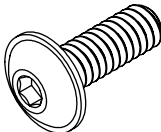
**1/4-20 NYLON INSERT
LOCKNUT**

QTY - 2



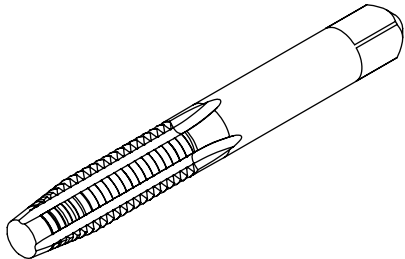
**M8-1.25 X 0.7-3.8 THK
HEAVY DUTY RIVET
NUT**

QTY - 28



**1/4-20 X 0.75
FLANGED BUTTON
HEAD HEX DRIVE
SCREW**

QTY - 10



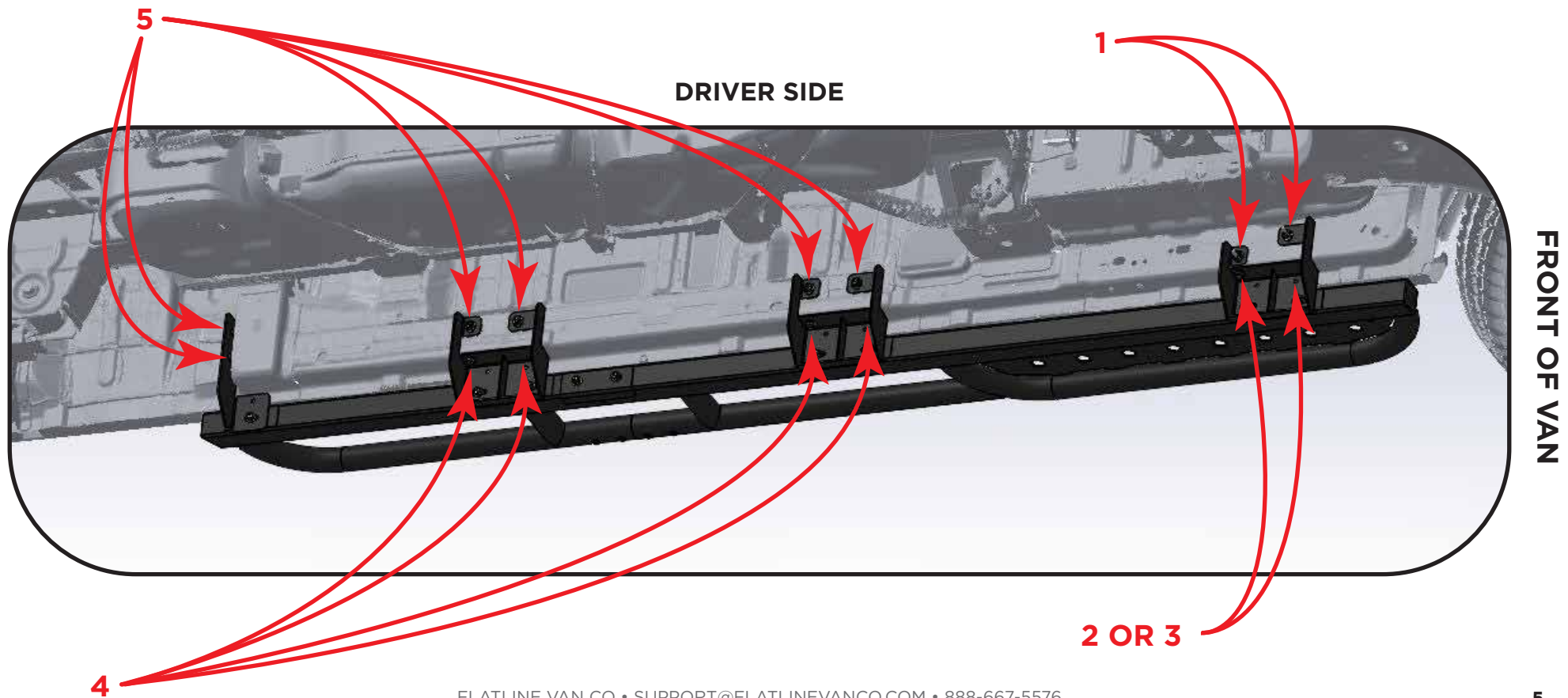
M8-1.25 TAP

QTY - 1

NOTES ON FACTORY MOUNT POINTS-

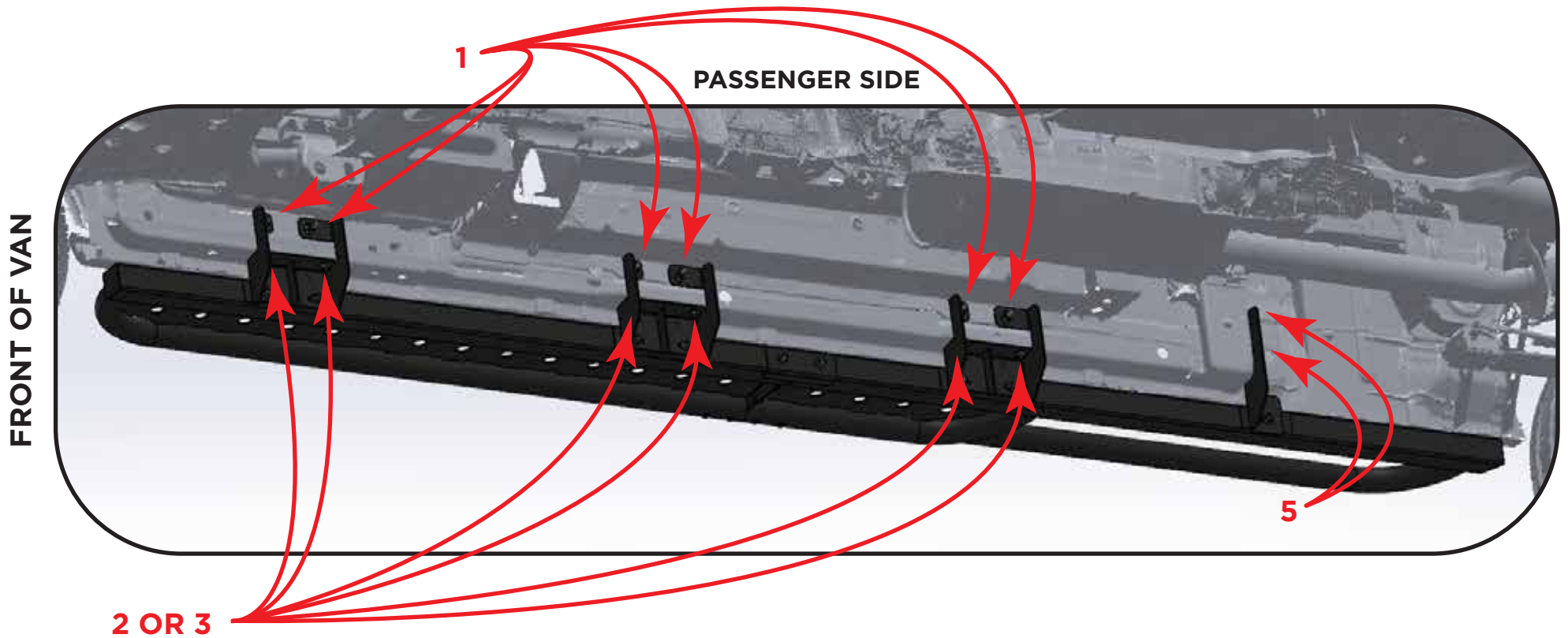
FVC Side Step Brackets are designed to work with the Ford Factory Side Step mounting locations. Your van may not have come equipped with Side Steps from the factory, so there may be some differences in mounting hardware required for your installation. We have accounted for this and supplied you with enough hardware for any possible configuration. You may need to drill additional holes for rivet nuts if your van differs. Here are the potential installation hardware situations-

1. Ford factory stud (may need clean up)
2. Ford factory threaded insert (may need clean up)
3. Ford factory unthreaded insert (tapping required)
4. Ford factory pre-existing hole with no insert (requires rivet nut)
5. No hole or stud (drilling required & rivet nut)



NOTES ON FACTORY MOUNT POINTS (CONT'D)-

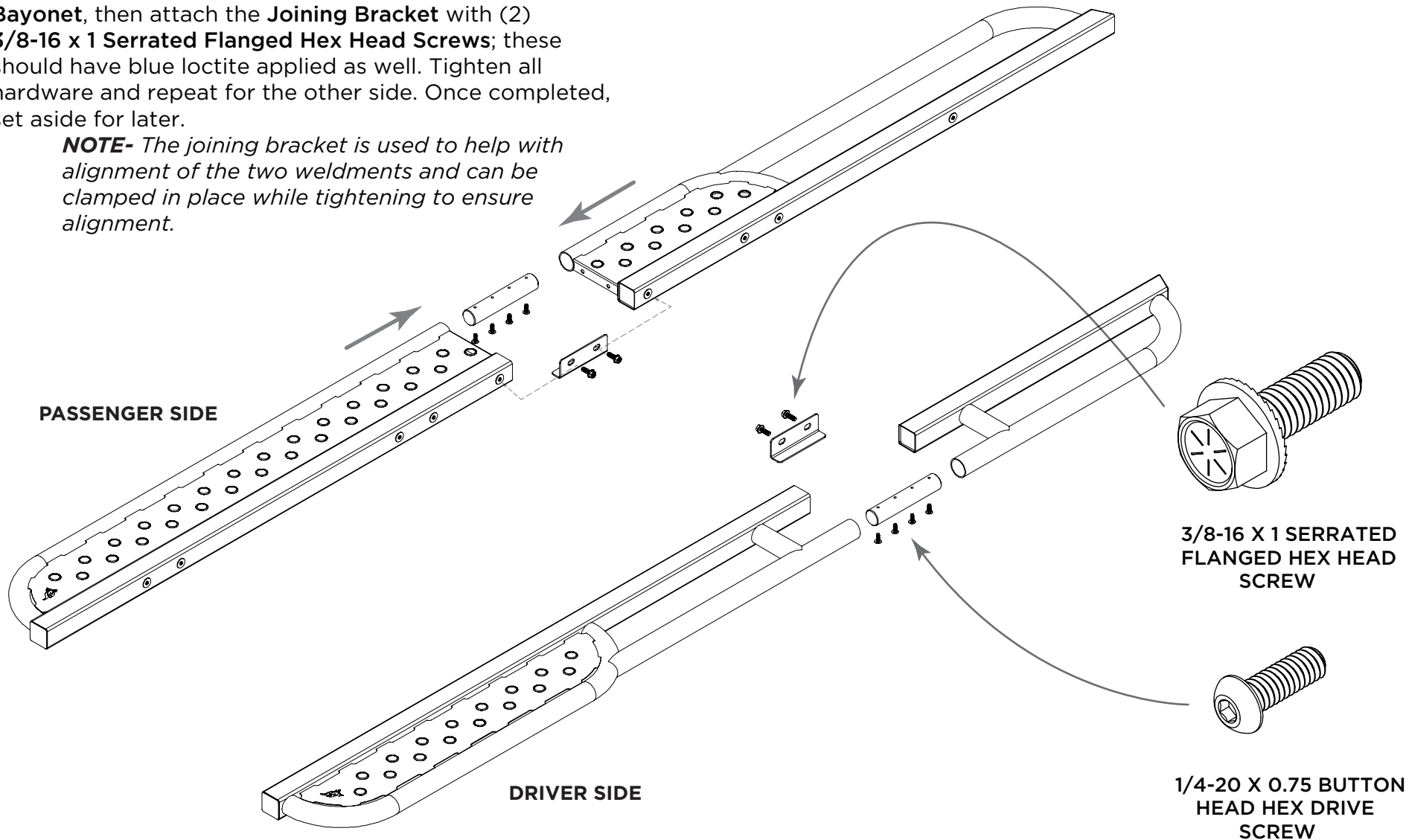
1. Ford factory stud (may need clean up)
2. Ford factory threaded insert (may need clean up)
3. Ford factory unthreaded insert (tapping required)
4. Ford factory pre-existing hole with no insert (requires rivet nut)
5. No hole or stud (drilling required & rivet nut)



STEP 1

1. The first step is to assemble the side steps. Start with one side, grab both ends of the step and slide a **Bayonet** into the **Step-Rear**. Apply blue loctite and loosely thread in (2) **1/4-20 x 0.75 Button Head Hex Drive Screws** to hold the **Bayonet** in place, then slide the **Step-Front** on as shown in the diagram. Thread the other two screws into the **Bayonet**, then attach the **Joining Bracket** with (2) **3/8-16 x 1 Serrated Flanged Hex Head Screws**; these should have blue loctite applied as well. Tighten all hardware and repeat for the other side. Once completed, set aside for later.

NOTE- The joining bracket is used to help with alignment of the two weldments and can be clamped in place while tightening to ensure alignment.



STEP 2

STUDS-

Studs present on the underbody in **Location 1** on the diagrams from page 5 & 6 will likely need the undercoating to be cleaned off before a fastener can be threaded onto them. We recommend either using a wire brush with heat gun (**Figure 1**) or an **M8x1.25 Die** (**Figure 2**) to clean the threads and prepare them for hardware.

THREADED AND UNTHREADED HOLES-

Holes in **Locations 2 & 3** on the underbody will also need clean up. If the hole is pre-threaded; we recommend carefully running the provided **M8x1.25 Tap** through to clean the threads. Similarly, if the hole is not threaded from the factory you will need to tap the hole.

NOTE- *We highly recommend using a lubricant when tapping holes. WD40 or motor oil works in a pinch, but a cutting oil is recommended.*

FIGURE 1



FIGURE 2



FIGURE 3



STEP 3

RIVET NUTS-

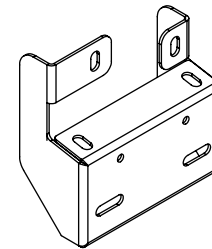
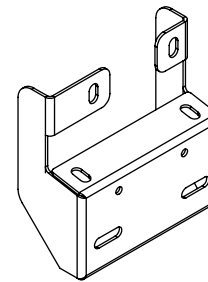
The next step is to install the rivet nuts in **Location 4** on page 5. There should be holes in the underbody of your van sized to accept the provided **M8X1.25 Rivet Nuts**. We recommend using a pneumatic or electric drill adapter rivet nut tool for this, although a manual rivet nut tool can work if you have enough ground clearance.

We like the **Astro Tools ADN38 XL** model for a drill adapter. Pictured below for reference.



STEP 4.1 (DRIVER SIDE)

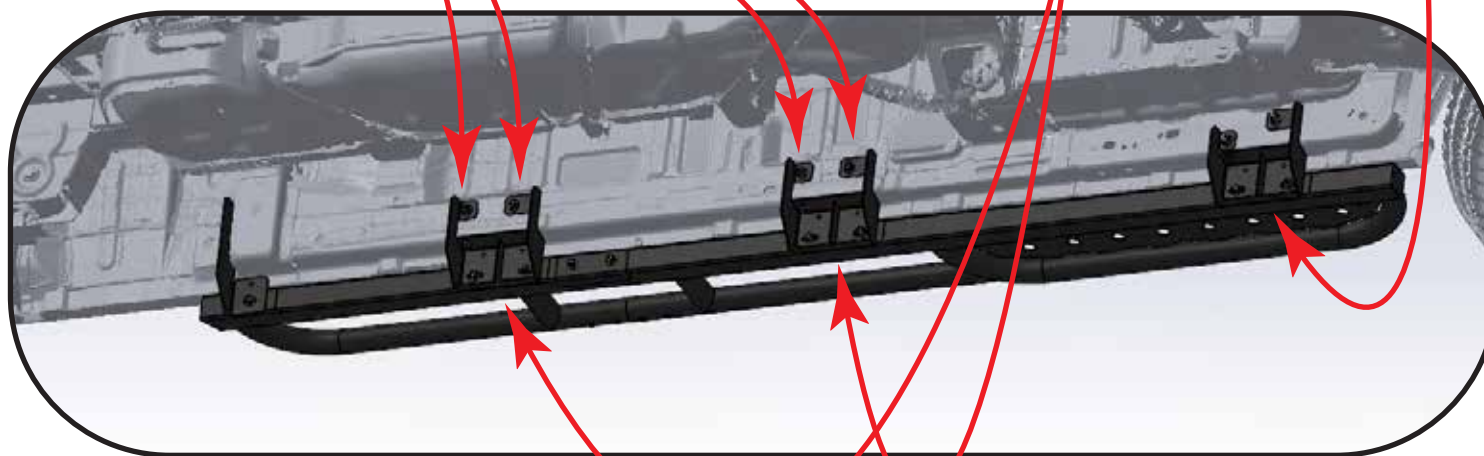
- 4.1.1- Install the **Step Brackets** as shown in the diagram below, noting that the Driver Side has 1 unique bracket that mounts up front. Mount all brackets loosely using the **M8-1.25 x 25 Flanged Hex Head Screws** on the bottom into the underbody.
- 4.1.2- Using the bracket as a guide; mark locations to drill for rivet nuts as shown below in the diagram, then remove the (2) **Step Brackets**, drill holes to 17/32", and insert rivet nuts.
- 4.1.3- Re-install the (2) **Step Brackets**, this time using (4) **M8-1.25 x 25 Flanged Hex Head Screws** (with blue thread lock applied) per bracket, and insert an **M8 Screw Flat Washer** and **M8-1.25 Nylon Insert Locknut** onto each stud on the **Driver Front Step Bracket**. *Leave all hardware slightly loose at this time to aid in attachment of Side Step!*



STEP BRACKET

DRIVER FRONT STEP BRACKET

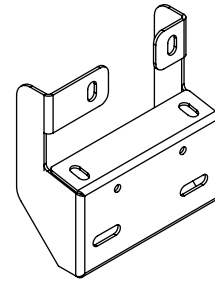
HOLES TO BE DRILLED FOR RIVET NUT



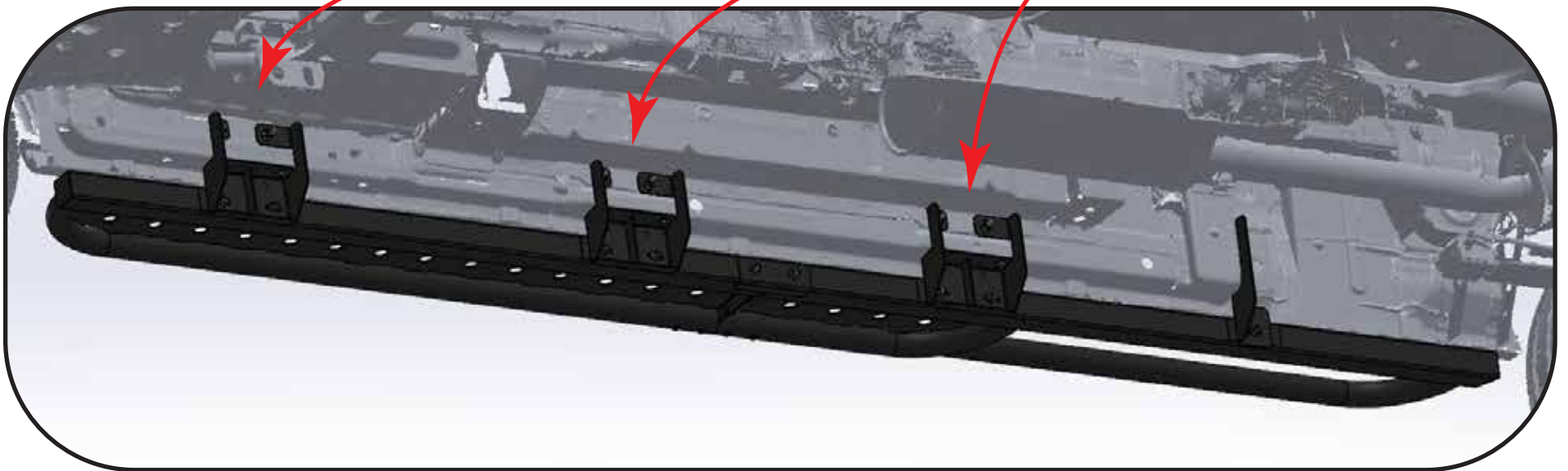
FRONT OF VAN →

STEP 4.2 (PASSENGER SIDE)

- 4.2.1- Install the (3) **Step Brackets** using 2 **M8-1.25 x 25 Flanged Hex Head Screws** (with blue thread lock applied) per bracket, and insert an **M8 Screw Flat Washer** and **M8-1.25 Nylon Insert Locknut** onto each stud on the top each bracket as shown below in the diagram. *Leave all hardware slightly loose at this time to aid in attachment of Side Step!*



STEP BRACKET



← FRONT OF VAN

STEP 5

ATTACH STEPS TO BRACKETS-

It's now time to attach the **Side Steps** you assembled earlier to the brackets you've just mounted to the van. You will need 6 **M8-1.25 x 25 Flanged Hex Head Screws**, and (3) **Bracket Spacer-Double** per side. Having someone to help (or a floor jack) makes this step much easier.

Lift the step up into place and slide the **Bracket Spacer Double** in between the bracket and step as shown in **Figure 4**, and then, after applying blue thread lock to each screw, thread in the **M8-1.25 x 25 Flanged Hex Head Screws**. Leave the bolts loose until you get all of them in, and then tighten them down to **20 ft-lbs**.



FIGURE 4



STEP 6

MOUNTING REAR BRACKETS

- 6.1-** On the Driver Side, mount the **Rear Step Bracket** to the **Side Step** with a **Spacer Plate-Single** and **M8-1.25 x 25 Flanged Hex Head Screw**. Position the bracket to be tight to vertical sheet metal of the van and mark both slots for where to install rivet nuts. Repeat for Passenger Side, and then remove the brackets.
- 6.2-** Drill holes to $17/32$ ", and insert rivet nuts.
- 6.3-** Re-install rear bracket with **Spacer Plate-Single** and 1 **M8-1.25 x 25 Flanged Hex Head Screw** (with blue thread lock applied) to the Side Step, and insert (2) of the M8 Screws (also with blue thread lock applied) into the rivet nuts. Tighten all screws to **20 ft-lbs**.

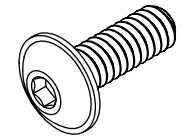


STEP 7

STEP CONNECTING PLATE-

Grab the remaining (2) **1/4-20 Flanged Button Head Hex Drive Screws**, (2) **1/4 Screw Flat Washers**, and **1/4-20 Nylon Insert Locknuts** and insert them underneath the **Passenger Side Side Step** to secure the two halves of the step plate together. Tighten these down.

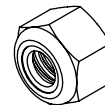
Go back through and ensure all of your bolts and screws are tightened to 20ft-lbs. Once you've ensured everything is tight the install is complete!



**1/4-20 X 0.75
FLANGED BUTTON
HEAD HEX DRIVE
SCREW**



**1/4 SCREW FLAT
WASHER**



**1/4-20 NYLON INSERT
LOCKNUT**

GET OUT AND EXPLORE!

LEAVE US A REVIEW

Happy with your new FVC product? We would love to hear (and see) from you! Head to the product page and click "Leave Review." Add a short review and upload a few photos to be showcased on the product page.

SHARE YOUR PHOTOS WITH US

We love seeing how our customers use their FVC products and following along with your adventures. Tag us in your photos with @flatlinevanco or send them to us via email. We love posting customer pictures in our feed!

CUSTOMER SUPPORT

If you are having any issues with your product, please reach out, and we will make it right. FVC is a company of van and outdoor enthusiasts that design and use our own products, so we want you to be as stoked on your new parts as we are!



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thanks!