



# INSTALLATION MANUAL

## 203025-2

### Parts List

1	Driver / left side bar
1	Passenger / right side bar
2	Driver / left side mounting bracket
2	Passenger / right side mounting bracket
14	Hex bolt, M10 - 1.50 x 35mm
22	Flat washer, M10
14	Lock washer, M10
6	Clip-nut, M10
4	Hex bolt, M12 - 1.75 x 50mm
4	Flat washer, M12
4	Lock washer, M12

### Level of Difficulty

Easy

### Product Image



### Tools Required

Torque wrench	Socket, 16mm
Ratchet	Socket, 18mm
Level	Wrench, 16mm

### Brackets



### Torque Specifications

	METRIC	SAE
M6 bolt	3 ft.-lbs.	
M8 bolt	7 ft.-lbs.	
M10 bolt	16 ft.-lbs.	
M12 bolt	28 ft.-lbs.	
1/4" bolt	3 ft.-lbs.	
5/16" bolt	7 ft.-lbs.	
3/8" bolt	16 ft.-lbs.	
7/16" bolt	20 ft.-lbs.	
1/2" bolt	28 ft.-lbs.	

### Notes and Maintenance

Before you begin installation, read all instructions thoroughly.

Proper tools will improve the quality of installation and reduce the time required.

To protect the product, wax 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 and aluminum, polish may be used to clear small scratches and scuffs on the finish. Mild soap may be used also to clean the product.

Refer to the table to the left when securing hardware during the installation process to help prevent damage to the product or vehicle.

### Step 1

Starting on the driver side, locate the two mounting points.



### Step 2

Locate the driver side front mounting point. Insert an M10 clip nut into the rectangular access hole at the top left location and align the clip nut with the adjacent mounting hole.

Secure the top left hole of the mounting bracket using an M10 hex bolt, lock washer and flat washer.

Snug the hardware, but do not fully tighten.



### Step 3

Insert an M10 hex bolt and flat washer from the outside through the lower left mounting bracket hole. Secure using an M10 flat washer, lock washer and hex nut.

Repeat this process for the lower right mounting hole. **Note:** the front mounting bracket will use only three of the mounting holes in the bracket.

Snug the hardware, but do not fully tighten.



### Step 4

Locate the rear mounting point and bracket. Repeat step 2 to secure both top mounting points and step 3 to secure both bottom mounting points.

**Note:** the rear mounting bracket will use all four mounting holes in the bracket.



### Step 5

Once all the driver side brackets are installed, align the mounting points on the driver side bar with the holes on the mounting brackets.

Secure the side bar to the brackets using two M12 x 50mm hex bolts, two lock washers and two flat washers.

Snug the hardware, but do not fully tighten.



### Step 6

At this time, adjust the side bar to the desired location.

With the side bar in position, it is recommended to tighten all brackets to the vehicle first, followed by the side bar connections.

For recommended torque specifications, refer to the table on the title page.



### Step 7

Repeat steps 1 through 6 on the passenger side of the vehicle.

Congratulations on the installation of your new ARIES 3" round side bars.

With the side bars installed, periodic inspections should be performed to ensure all mounting hardware remains tight.

To protect your investment, see the 'Notes and Maintenance' section on the first page of this instruction manual.

