



INSTRUCTIONS—INSTRUCCIONES—CONSIGNES

AUTOMOTIVE PRODUCTS, INC.

APPLICATION: 2011 FORD EXPLORER
 APP PART # 23-3600, 23-3605, 21-3600, 21-3605
 E SERIES STEP BARS/4 " OVAL [STEP BARS](#)

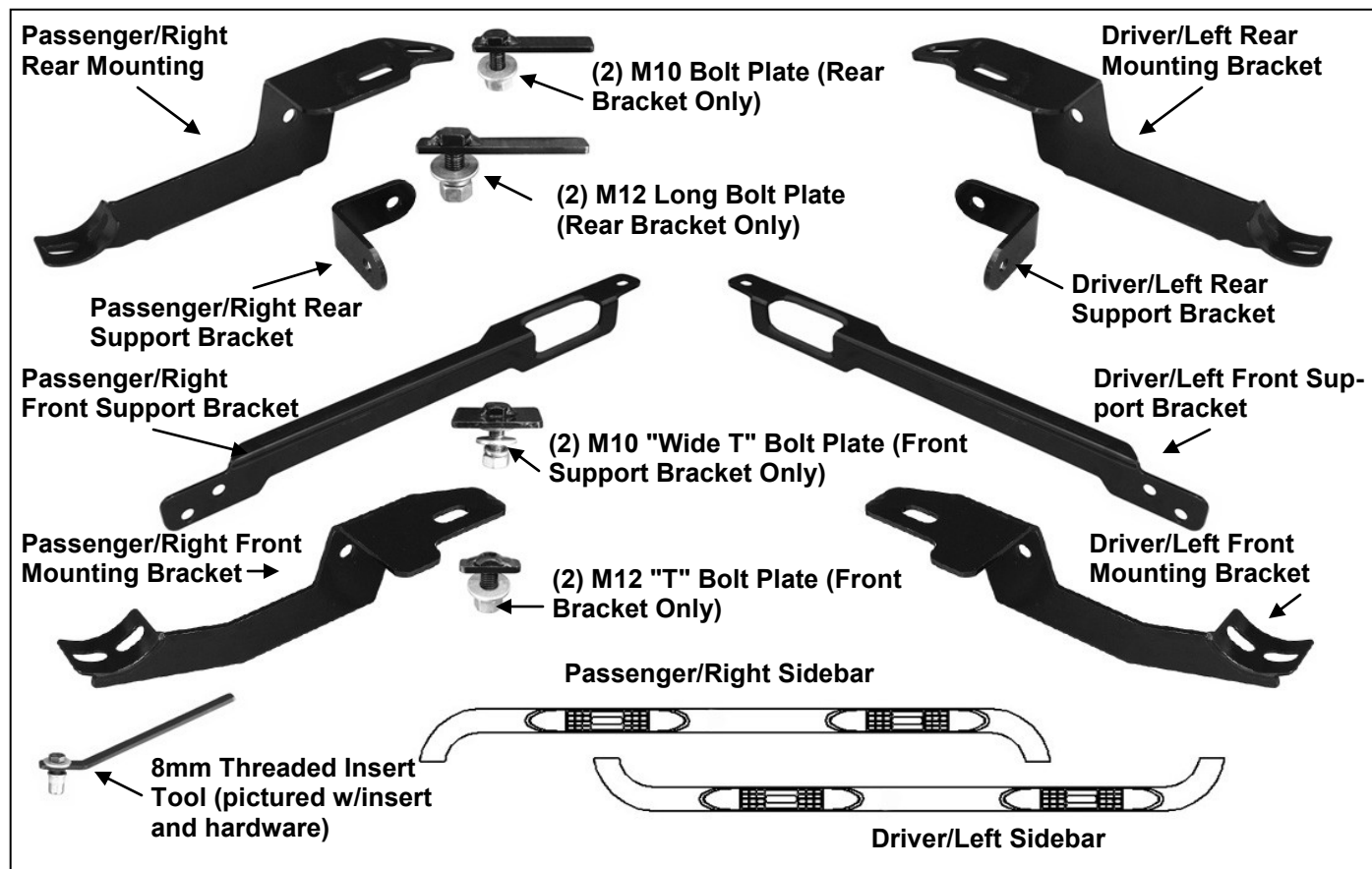
ITEM	QUANTITY	DESCRIPTION	TOOLS NEEDED
1	2	STEP BARS	18MM SOCKET
2,3	2	FRONT MOUNTING BRACKET (2) DRIVERS SIDE, (3) PASSENGER SIDE	16MM SOCKET
4,5	2	REAR MOUNTING BRACKET (4) DRIVERS SIDE , (5) PASSENGER SIDE	13MM SOCKET
6,7	2	FRONT SUPPORT BRACKET (6) DRIVERS SIDE, (7) PASSENGER SIDE	RATCHET
8,9	2	REAR SUPPORT BRACKET (8) DRIVERS SIDE, (9) PASSENGER SIDE	TORQUE WRENCH
10	1	INSERT TOOL	
11	2	M8 THREADED INSERTS	
12	2	M12 T BOLT PLATES	
13	2	M12 LONG BOLT PLATES	
14	2	M10 WIDE T BOLT PLATES	
15	2	M10 BOLT PLATE	
16	4	M12 FLAT WASHERS	
17	4	M12 LOCK WASHERS	
18	4	M12 HEX NUTS	
19	6	M10 HEX HEAD BOLTS	
20	4	M10 LARGE FLAT WASHERS	
21	12	M10 SMALL FLAT WASHERS	
22	4	M10 LOCK WASHERS	
23	6	M10 NYLOCK NUTS	
24	4	M10 HEX NUTS	
25	10	M8 HEX HEAD BOLTS	
26	10	M8 FLAT WASHERS	
27	10	M8 LOCK WASHERS	
28	8	PLASTIC RETAINERS	

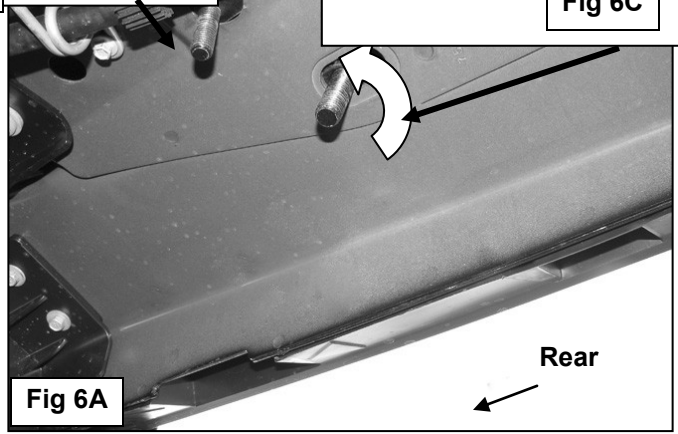
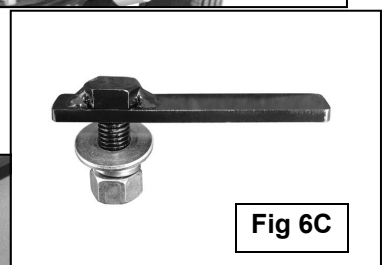
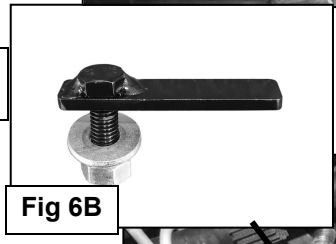
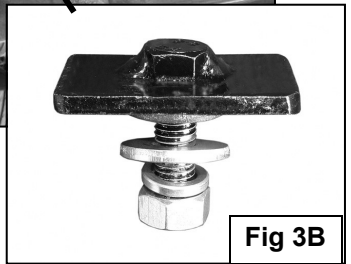
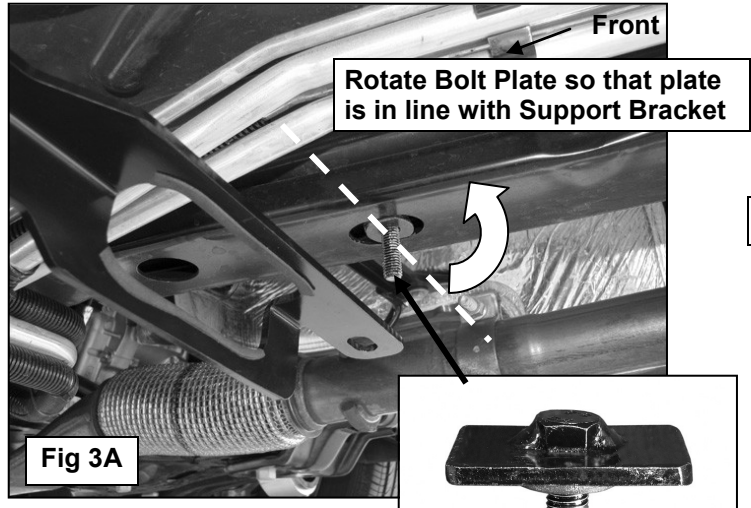
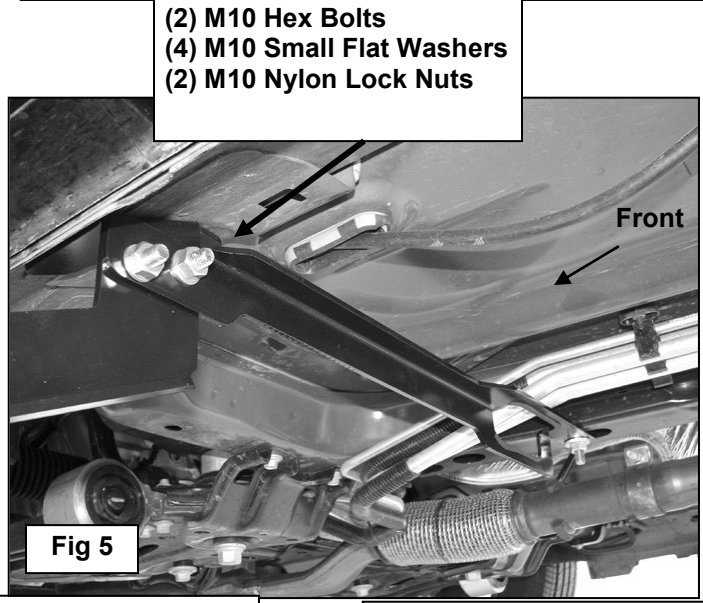
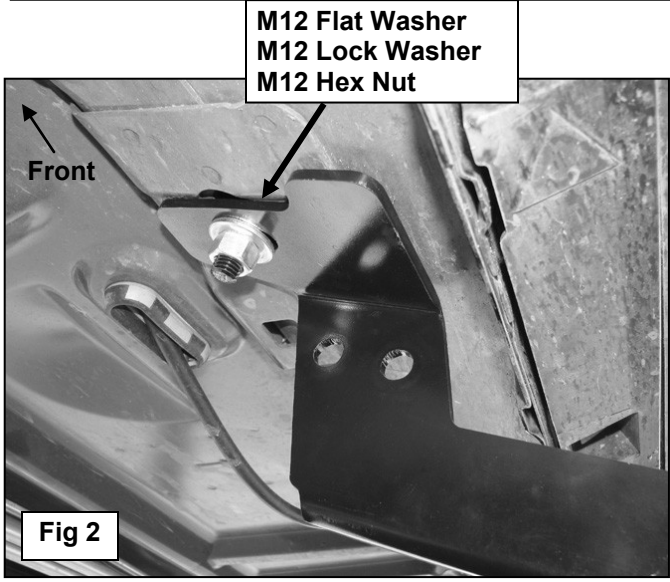
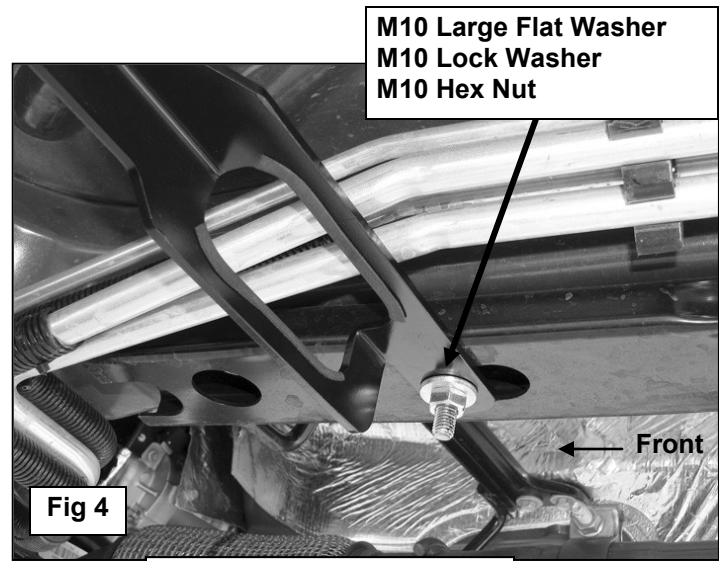
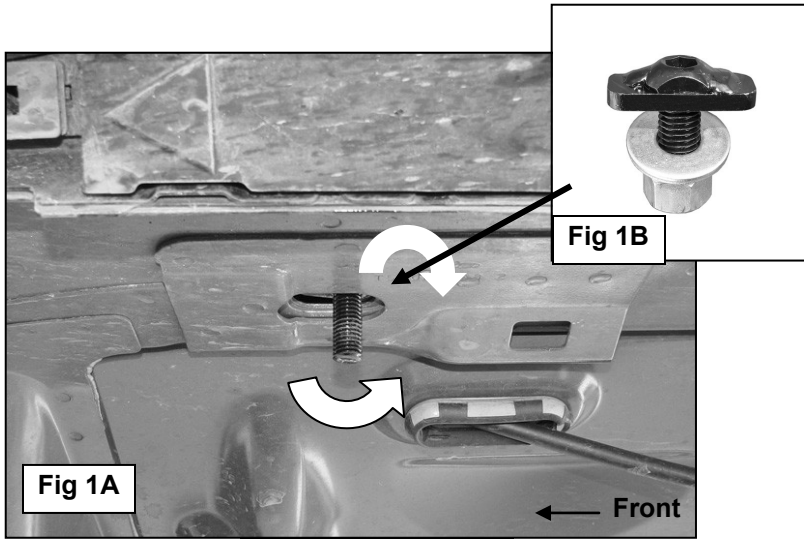
1. Remove contents from box, verify all parts listed are present and free from damage. Carefully read and understand all instructions before attempting installation.
2. Start installation under the driver side of the vehicle. Select (1) M12 T-Bolt Plate and insert it into the factory oval hole in the floor panel. Thread (1) plastic retainer on the bolt plate to hold it in place, (Figures 1A & 1B). Rotate the Bolt Plate 90-degrees so that the plate is across the oval hole. Select the driver side front Mounting Bracket. Hang the Bracket from the Bolt Plate with (1) M12 Flat Washer, (1) M12 Lock Washer and (1) M12 Hex Nut, (Figure 2). NOTE: Make sure that the mounting flange on the Front Bracket is lined up properly with the indent in the floor panel. The Front Mounting Bracket must sit flat against the floor panel. Do not tighten hardware at this time.
3. Insert (1) M10 Wide T-Bolt Plate, (Figure 3B), into the large round hole in the bottom of the inner frame channel. Thread (1) plastic retainer on the bolt plate to hold it in place, (Figure 3A). Rotate the Bolt Plate so that the plate is inline with the Support Bracket and 90-degrees to the direction of the frame channel. Select the driver side Front Support Bracket. Hang the Support Bracket from the Bolt Plate and secure it with the included (1) M10 Large Flat Washer, (1) M10 Lock Washer and (1) M10 Hex Nut, (Figure 4). Do not tighten hardware at this time.

4. Hold the Support Bracket up to the back of the Front Bracket and line up the (2) mounting holes. Bolt the two Brackets together with the included (2) M10 Hex Bolts, (4) M10 Small Flat Washers and (2) M10 Nylon Lock Nuts, (Figure 5). Snug but do not tighten hardware at this time.
5. Select the driver side rear Mounting Bracket and (1) Rear Support Bracket. Bolt the Support Bracket to the front facing side of the Mounting Bracket with (1) M10 Hex Bolt, (2) M10 Small Flat Washers and (1) M10 Nylon Lock Nut, (Figures 7A & 7B).
6. Locate the oval and round holes in the floor panel toward the rear of the vehicle, (Figure 6A). Insert (1) M10 Bolt Plate into the round hole. Thread (1) plastic retainer on the bolt plate to hold it in place, (Figure 6B). Insert (1) M12 Long Bolt Plate into the oval hole next to the pinch weld. Thread (1) plastic retainer on the bolt plate to hold it in place, (Figure 6C). Rotate the Bolt Plate 90-degrees so that the plate is across the oval hole. Position the Rear Mounting Bracket over the (2) Bolt Plates. Secure the Bracket to the M12 Bolt Plate with (1) M12 Flat Washer, (1) M12 Lock Washer and (1) M12 Hex Nut, (Figure 7). Bolt the Bracket to the M10 Bolt Plate with the included (1) M10 Large Flat Washer, (1) M10 Lock Washer and (1) M10 Hex Nut. Hold the Support Bracket firmly against the back of the pinch weld and tighten the hardware at this time.
7. Select the driver Sidebar and carefully place it onto the Mounting Brackets to avoid damaging the finish on the Sidebar. Line up the holes in the Sidebar with the Mounting Brackets and bolt together with the included (4) M8 Hex Bolts, (4) M8 Flat Washers and (4) M8 Lock Washers, (Figure 8).
8. Level and adjust the Sidebar and tighten all hardware except the M10 hex bolt securing the Rear Support Bracket to the Rear Mounting Bracket, (Figure 9).
9. Move back to the driver side Rear Mounting Bracket. Hold the Support Bracket firmly against the back of the pinch weld. Mark the mounting hole location on the Support Bracket onto the pinch weld, (Figure 9). Check the Sidebar for level before proceeding. CAUTION: Do not drill the hole too close to the bottom edge of the pinch weld.
10. Remove the Support Bracket. Carefully drill this location with a 7/16" drill bit, (Figure 10A). IMPORTANT! Be very careful and drill slowly through the pinch weld to avoid damaging the outer rocker panel cover. Any cutting or drilling tool may break or shatter. Government regulations require safety glasses & equipment at all times when cutting or drilling.
11. Assemble the Threaded Insert installation tool as pictured in Figure 10B. Hold the handle and push the insert into the drilled hole in the pinch weld. NOTE: Insert must fit snug in hole. If necessary, use a small hammer to carefully tap the insert into the hole until the rim on the insert is flush against the pinch weld. Firmly hold the tool handle and tighten the hex bolt in the tool to expand the insert in the hole. Continue until threads are flush with the top of the insert, (Figure 10C). Remove the tool and hardware. Bolt the Support Bracket to the threaded insert with (1) M8 Hex Bolt, (1) M8 Flat Washer and (1) M8 Lock Washer, (Figure 11). Tighten hardware at this time. Torque all M12 fasteners to 50-55 ft lbs. M10 to 35-40 ft lbs, and M8 to 25-30 ft lbs
12. Repeat Steps 2-11 for passenger/right Sidebar installation.

CARE INSTRUCTIONS

- REGULAR WAXING IS RECOMMENDED. DO NOT USE ANY TYPE OF POLISH OR WAX THAT MAY CONTAIN ABRASIVES
- STAINLESS STEEL PRODUCTS CAN BE CLEANED WITH MILD SOAP AND WATER. STAINLESS STEEL POLISH SHOULD BE USED TO POLISH SMALL SCRATCHES.
- GLOSS BLACK FINISHES SHOULD BE CLEANED WITH MILD SOAP AND WATER





Hold the Support Bracket firmly against the back of the pinch weld and tighten the hardware on the Mounting Bracket

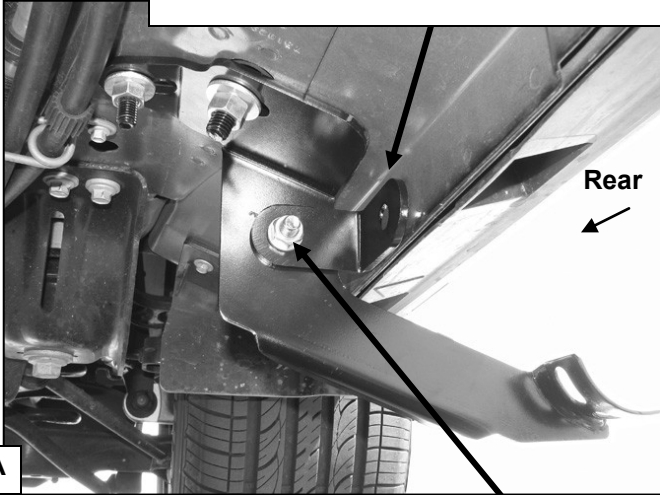
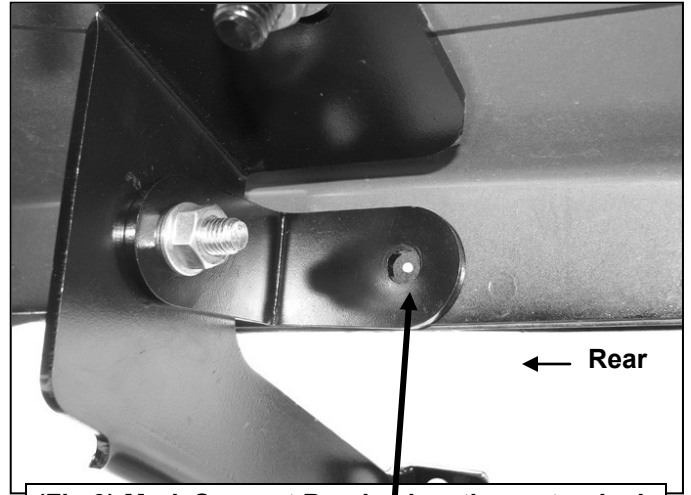


Fig 7A



(Fig 9) Mark Support Bracket location onto pinch weld. Carefully drill the location with 7/16" drill bit. Do not drill and install the Insert until after the Sidebar has been completely installed, checked for level and aligned on the vehicle

M10 Hex Bolt
(2) M10 Flat Washers
M10 Nylon Lock Nut

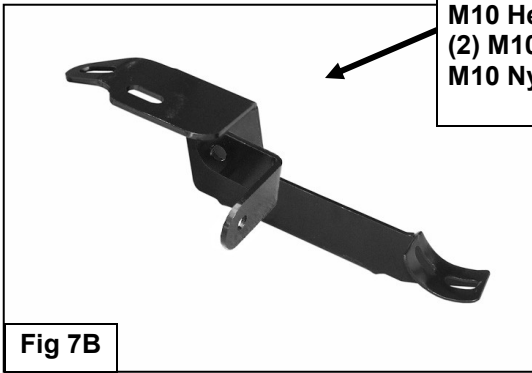


Fig 7B

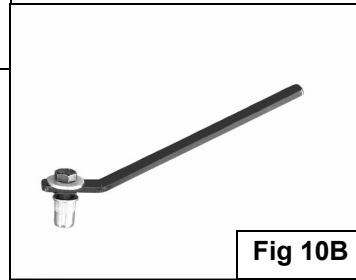


Fig 10B

M8 Hex Bolt
M8 Flat Washer
Insert Tool
M8 Expanding Threaded Insert

Fig 10C

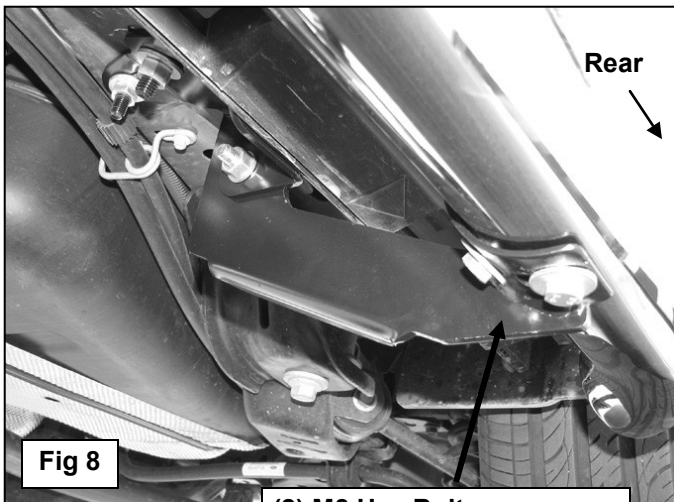


Fig 8

(2) M8 Hex Bolts
(2) M8 Flat Washers
(2) M8 Lock Washers

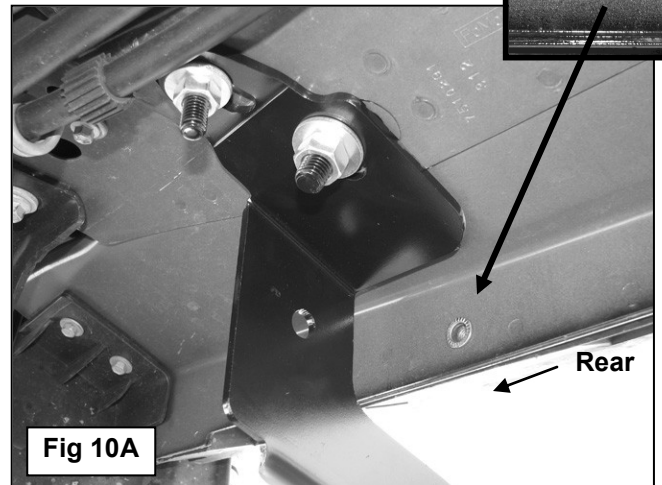


Fig 10A

**M10 Hex Bolt
(2) M10 Flat Washers
M10 Nylon Lock Nut**

**M8 Hex Bolt
M8 Flat Washer
M8 Lock Washer**

