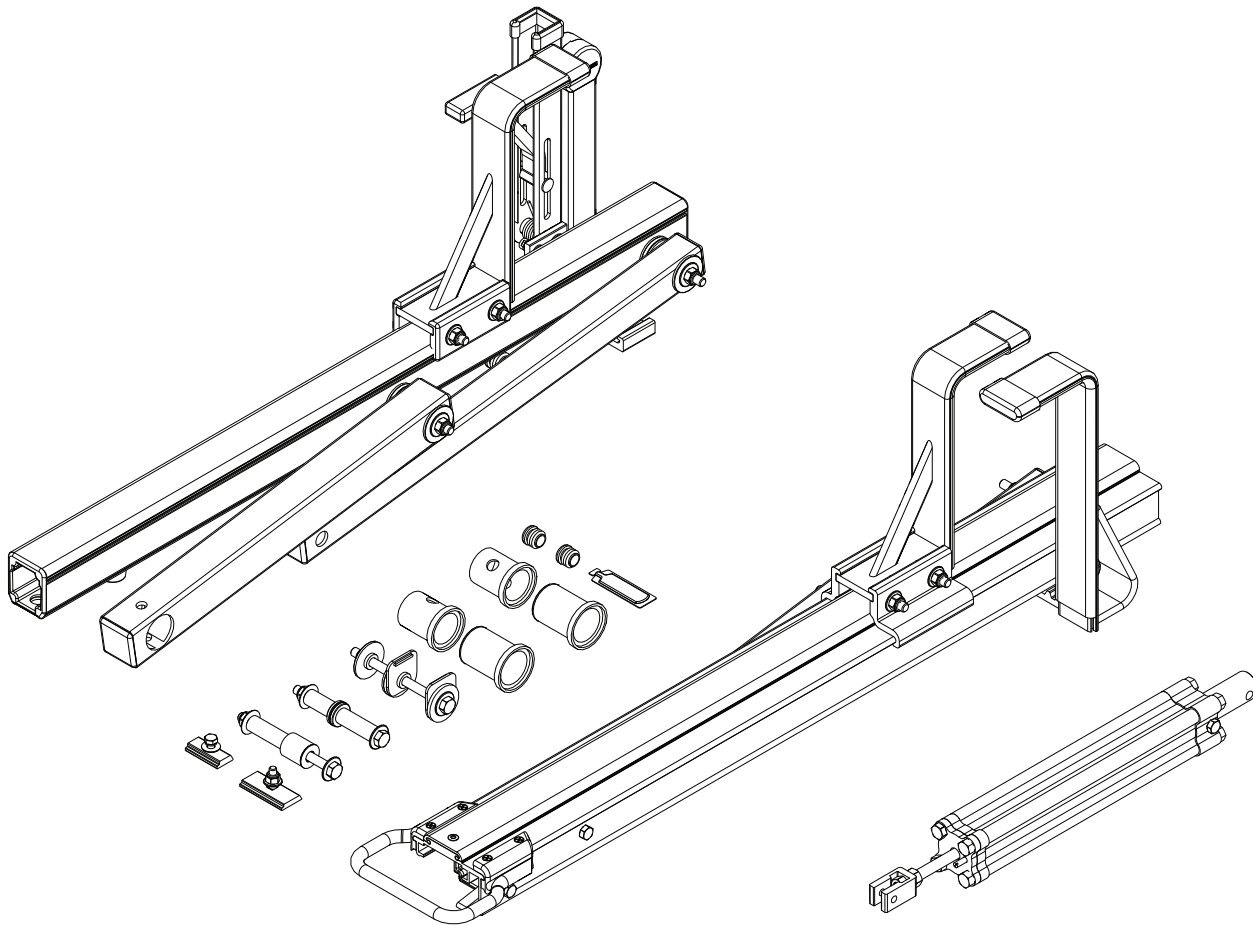


PRIME DESIGN™

A Safe Fleet Brand

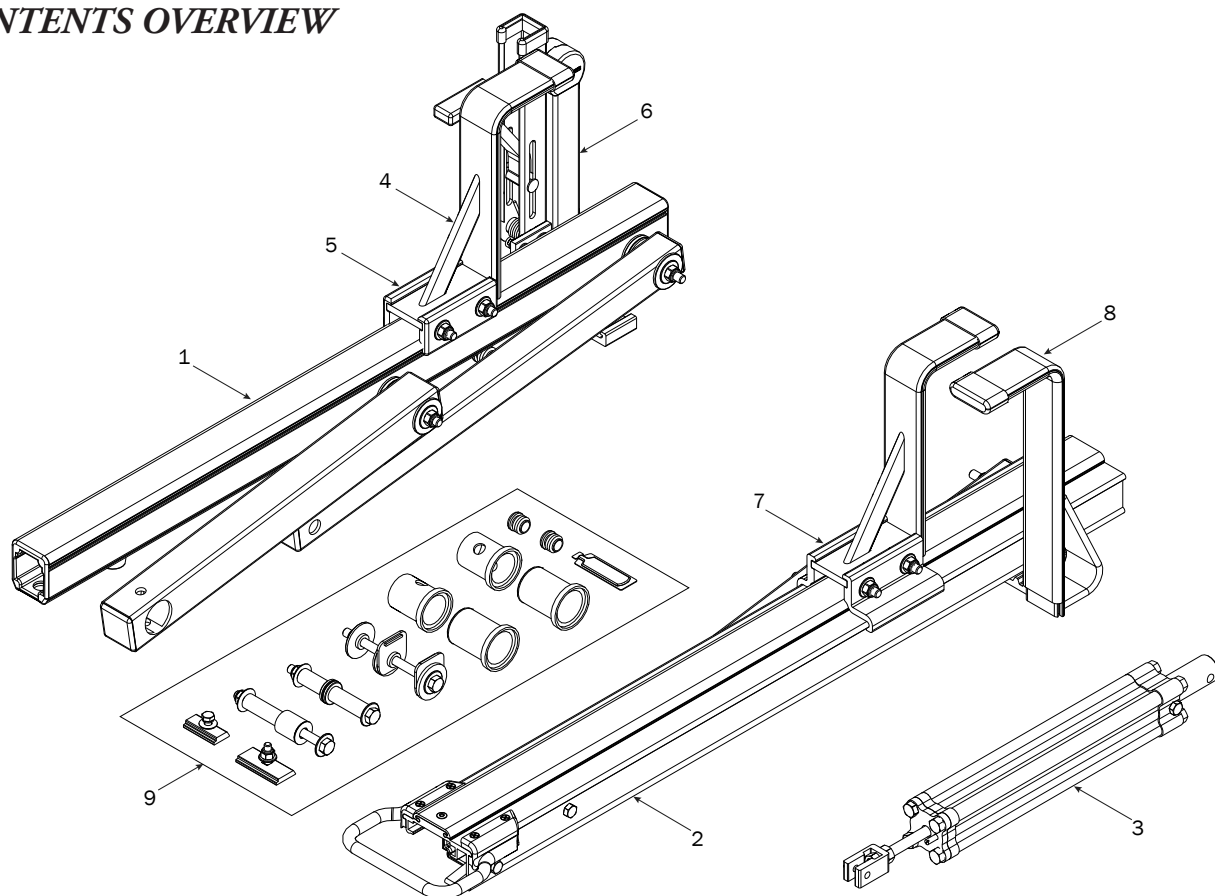


LEFT SIDE SLIDE ROTATION KIT

PRIME DESIGN, A SAFE FLEET BRAND • Address: 1689 Oakdale Avenue #102, West St Paul, Minnesota 55118
Toll Free: 1.8.PRIME.RACK • Fax: 651-552-1799 • Email: info@primedesign.net • Website: www.primedesign.net

FEA 0004

CONTENTS OVERVIEW



1—Left Front Rotation Assembly (Qty 1)

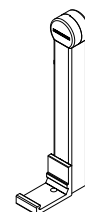
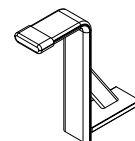
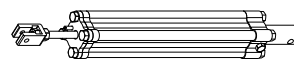
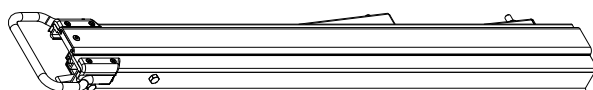
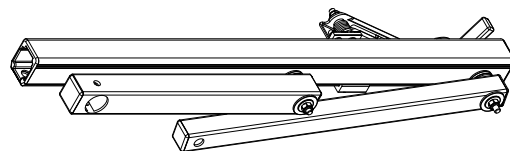
2—Left Rear Slide Rotation Assembly..... (Qty 1)

3—Cylinder..... (Qty 1)

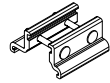
4—Z Post (Qty 2)
Adjustable, 7.25"

5—Z Post Mounting Clamp Assembly..... (Qty 1)

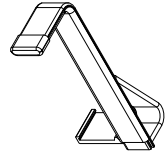
6—L Post..... (Qty 1)
With Roller Cap, 9.25"



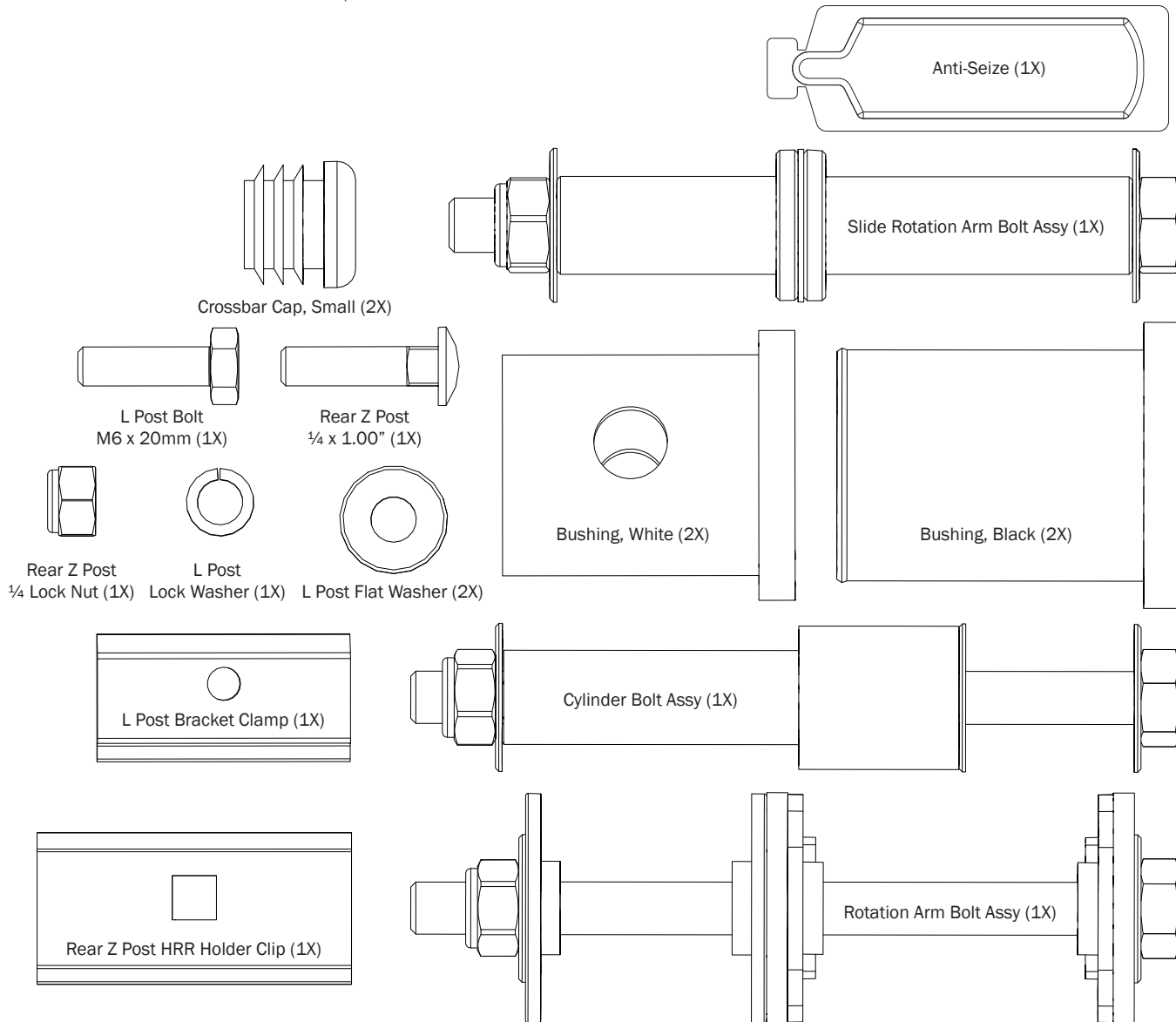
7—Z Post Bracket Assembly (Qty 1)
Adjustable, Slide



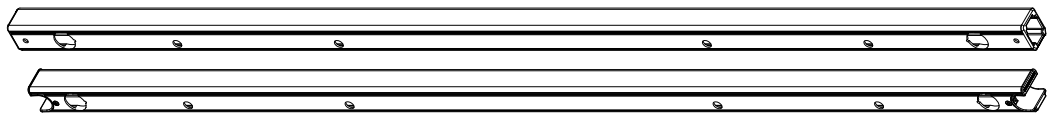
8—Z Post..... (Qty 1)
Adjustable Slide, 7.25"



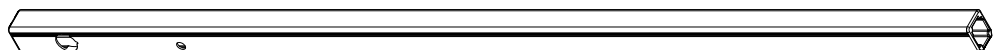
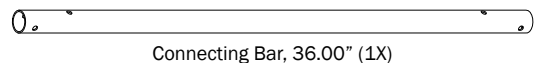
9—HKT-8400..... (Qty 1)
Modular Rotation Hardware Kit, Slide

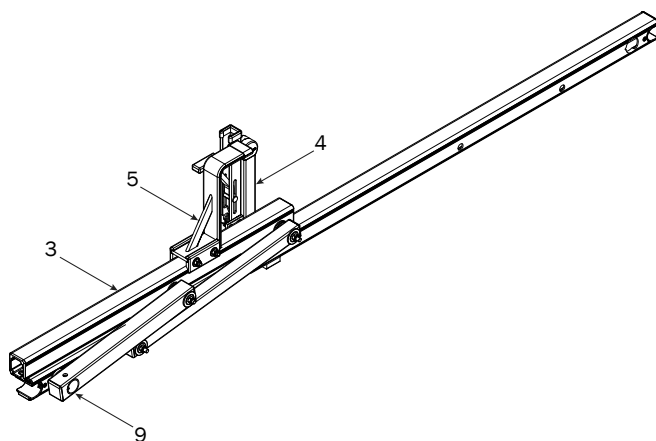


10—Crossbars (not shown on pg 2) (Qty 1)
Ordered separately, Front & Rear, Gen 4



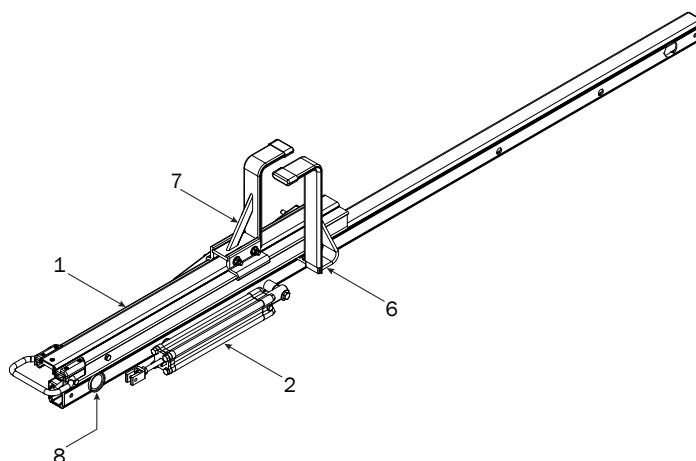
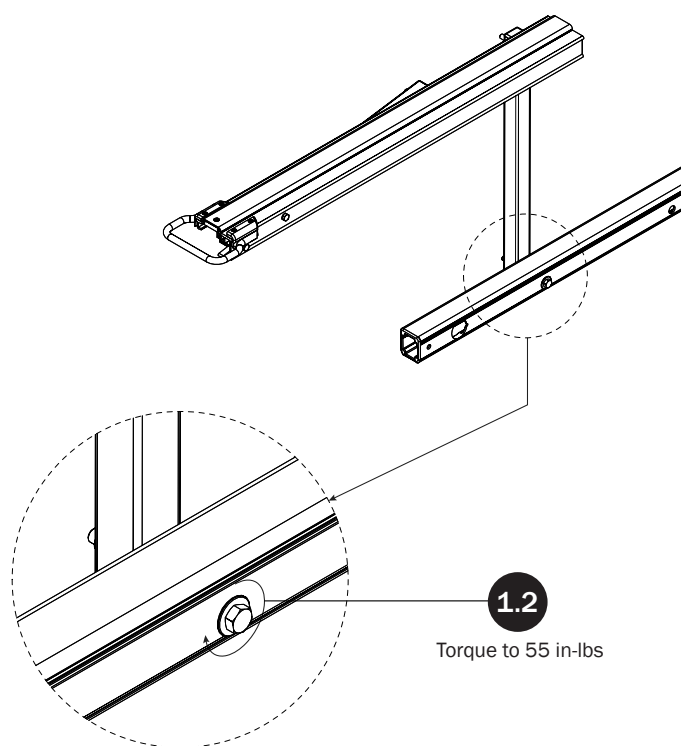
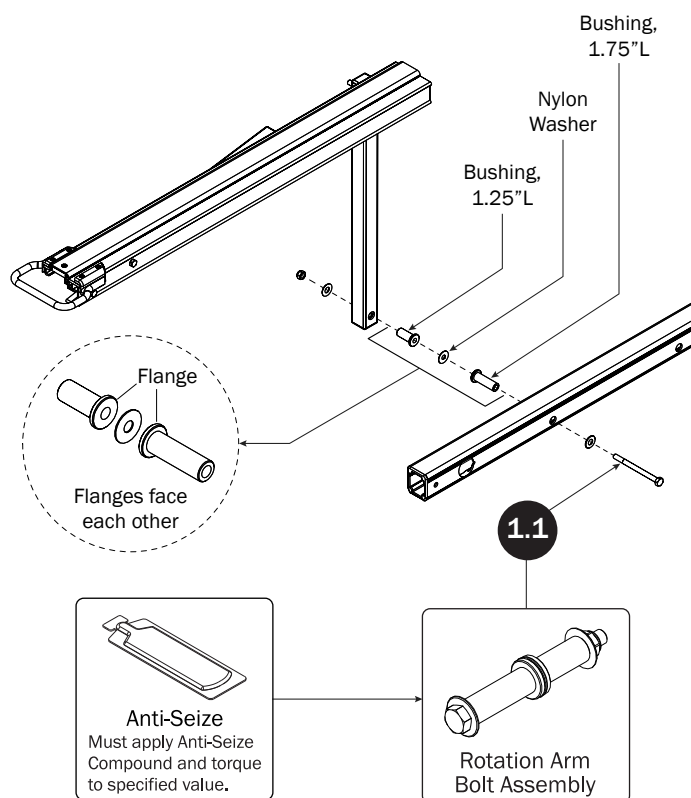
11—Crossbar (not shown on pg 2) (Qty 1)
Optional Center Crossbar Kit, Gen 4
(Hardware Kit not shown)



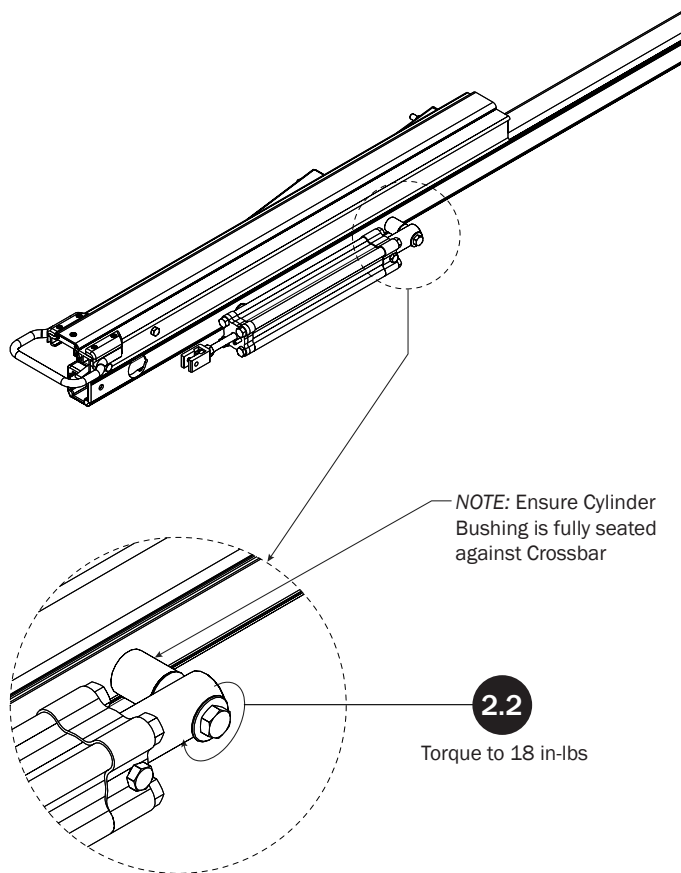
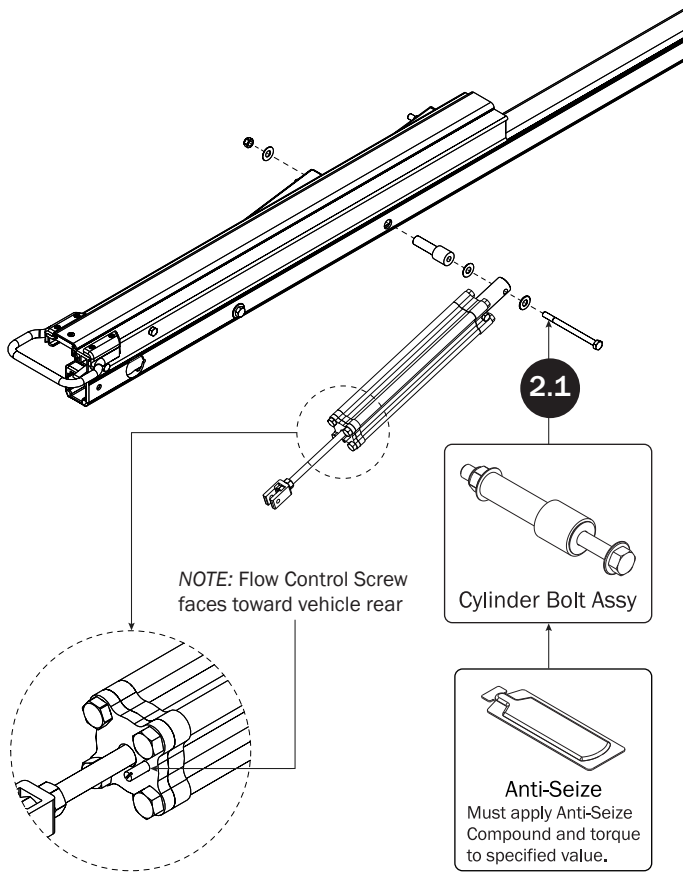
ROTATION ASSEMBLY SEQUENCE

Note: For ease of installation, it's recommended to assemble any Rotations onto the Crossbars before placing them onto the FBM's mounting brackets. The use of a helper is recommended when placing built Crossbars onto the vehicle.

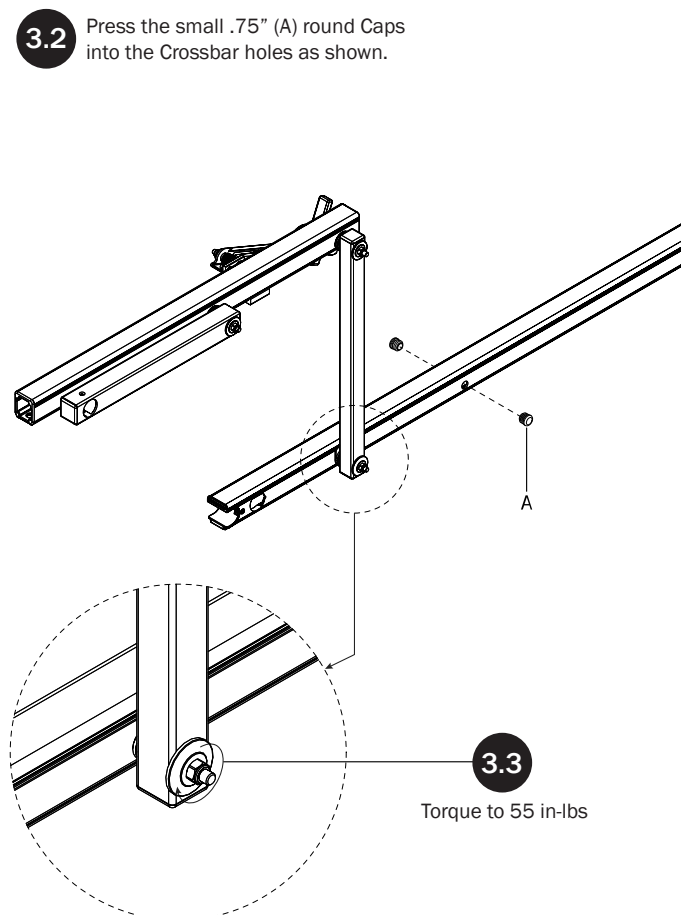
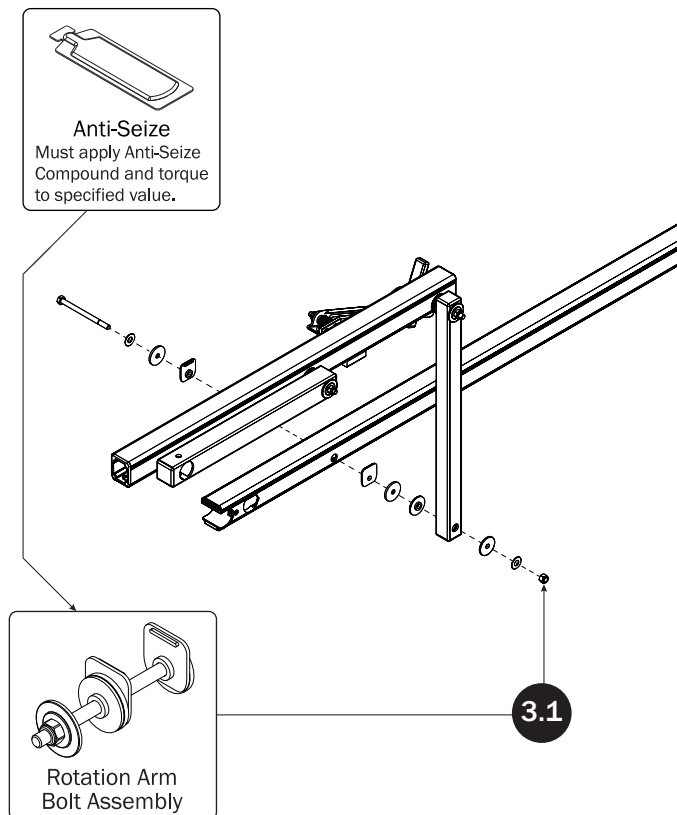
Note: This Rotation Kit fits only on the left side. Refer to FEA-0003 for right side Slide Rotation assembly instructions.

**REAR CROSSBAR
ROTATION ASSEMBLY**

CYLINDER HARDWARE



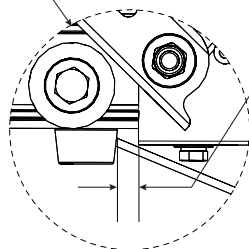
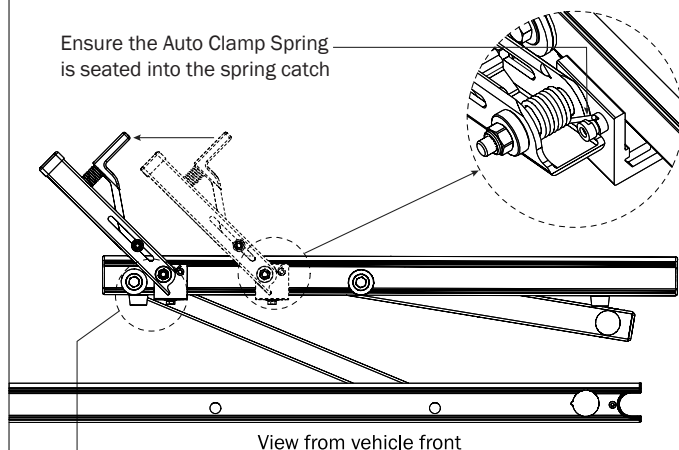
FRONT CROSSBAR ROTATION ASSEMBLY



L POSTS**SEE QUICK START GUIDE FOR ADJUSTMENTS**

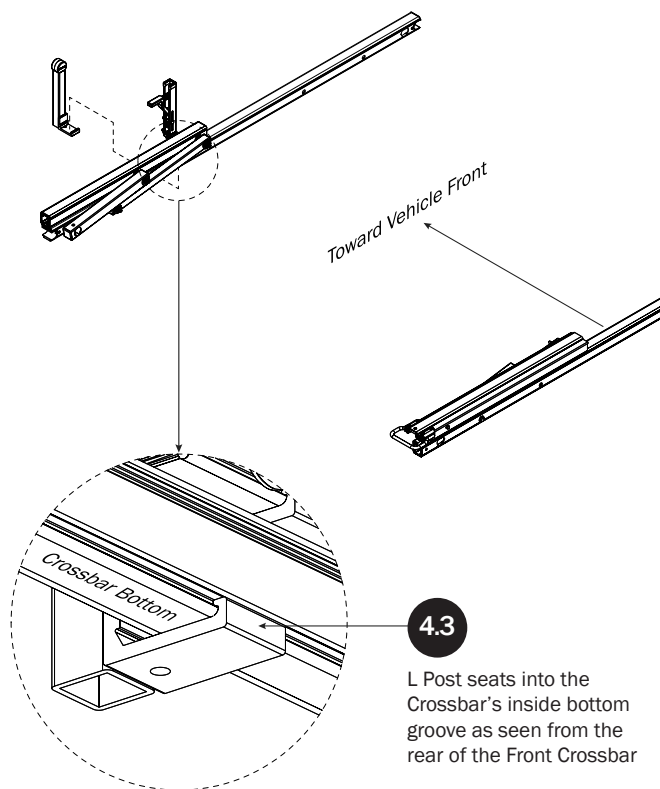
NOTE: The front Auto Clamp come preset from the factory for packaging purposes only. To assemble the L Post to the Crossbar, the Auto Clamps must be repositioned.

Ensure the Auto Clamp Spring is seated into the spring catch



4.1 Beginning with the Front Crossbar, loosen the bolt at the bottom of the Auto Clamp, then slide the Auto Clamp toward the inside end of the Rotation Upper. Reposition the Auto Clamp leaving a minimum of 1/4" distance from the rubber bumper to the edge of the Auto Clamp Bracket as shown, then finger-tighten if adjusting later, or torque to 80 in-lbs.

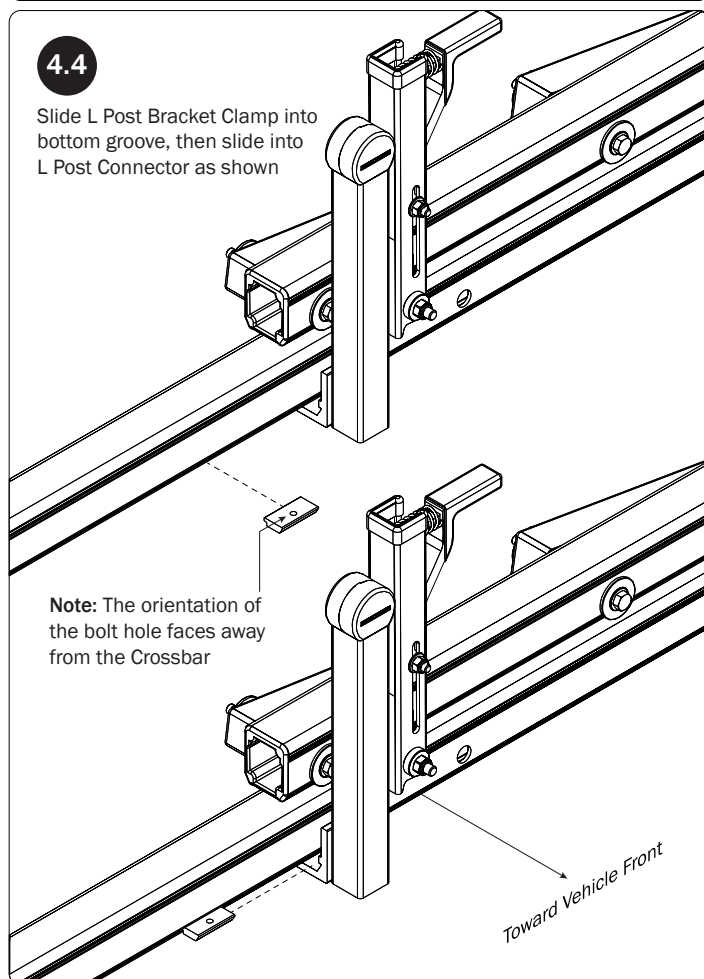
4.2 Place an L Post into the bottom groove of the Front Crossbar



4.3 L Post seats into the Crossbar's inside bottom groove as seen from the rear of the Front Crossbar

4.4

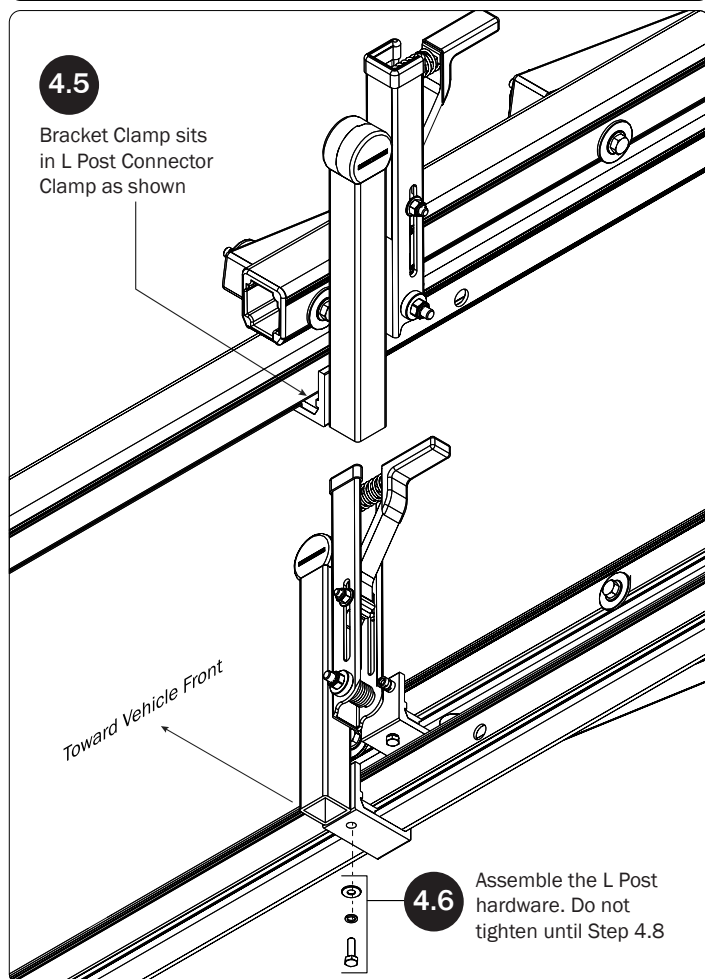
Slide L Post Bracket Clamp into bottom groove, then slide into L Post Connector as shown



Note: The orientation of the bolt hole faces away from the Crossbar

4.5

Bracket Clamp sits in L Post Connector as shown



4.6

Assemble the L Post hardware. Do not tighten until Step 4.8

4.7

Slide the L Post until parallel to the Auto Clamp and the gap between the two is even from top to bottom

View from vehicle front

Toward Vehicle Front

4.8

Torque to 80 in-lbs

Z POSTS

SEE QUICK START GUIDE FOR ADJUSTMENTS

5.1

Assemble the Z Post Mounting Clamp Assembly onto the Rotation Upper. Do not tighten until Step 5.4.

The Mounting Clamps seat fully into the top groove of the Upper

5.3

Refer to the Quick Start Guide for Z Post positioning.

View from vehicle front

Toward Vehicle Front

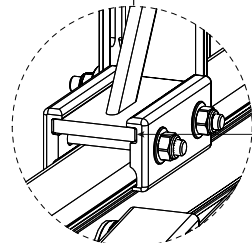
5.4

Torque to 90 in-lbs

Slide the Z Post into the Mounting Clamp Assembly

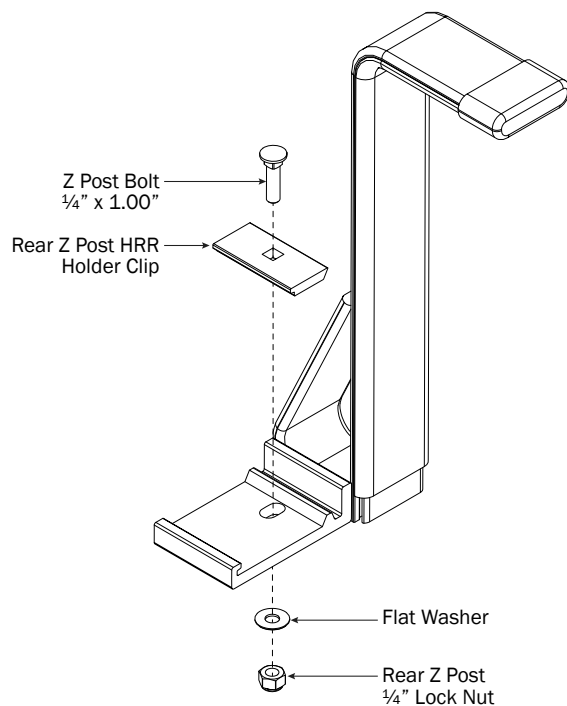
5.2

The Z Post fully seats into the top slot of the Mounting Clamps

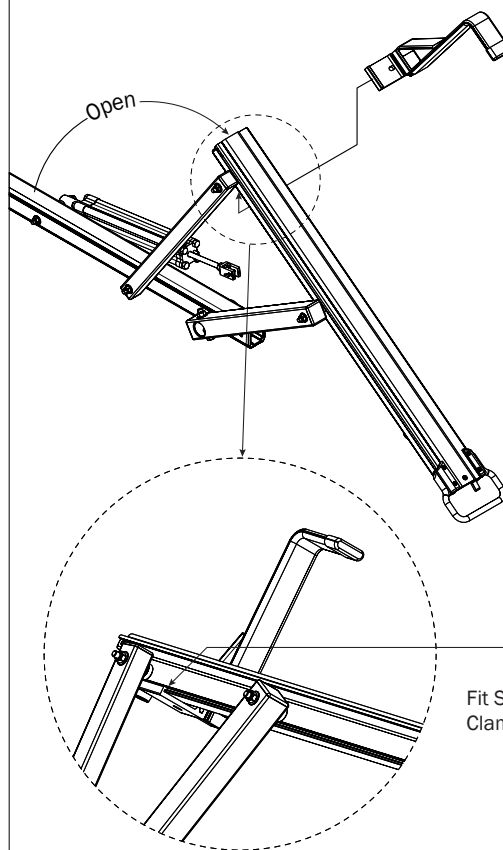


SLIDE UPPER Z POST**SEE QUICK START GUIDE FOR ADJUSTMENTS**

- 6.1** Prepare the parts shown below for assembling the Slide Z Post onto the bottom of the Rear Slide Rotation, but do not assemble. Assembly begins at Step 6.6

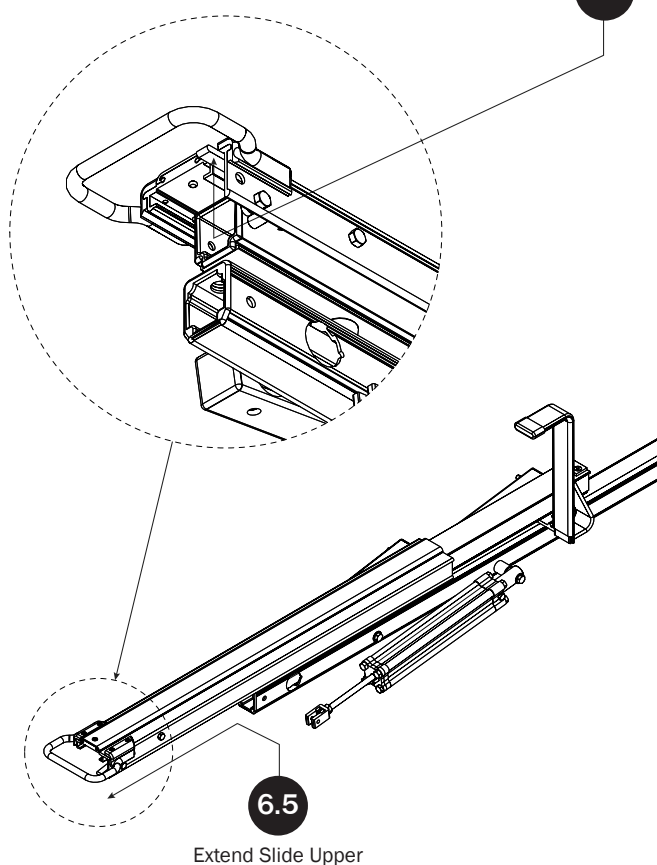


- 6.2** Place Slide Z Post into bottom of Rear Slide Upper

**6.3**

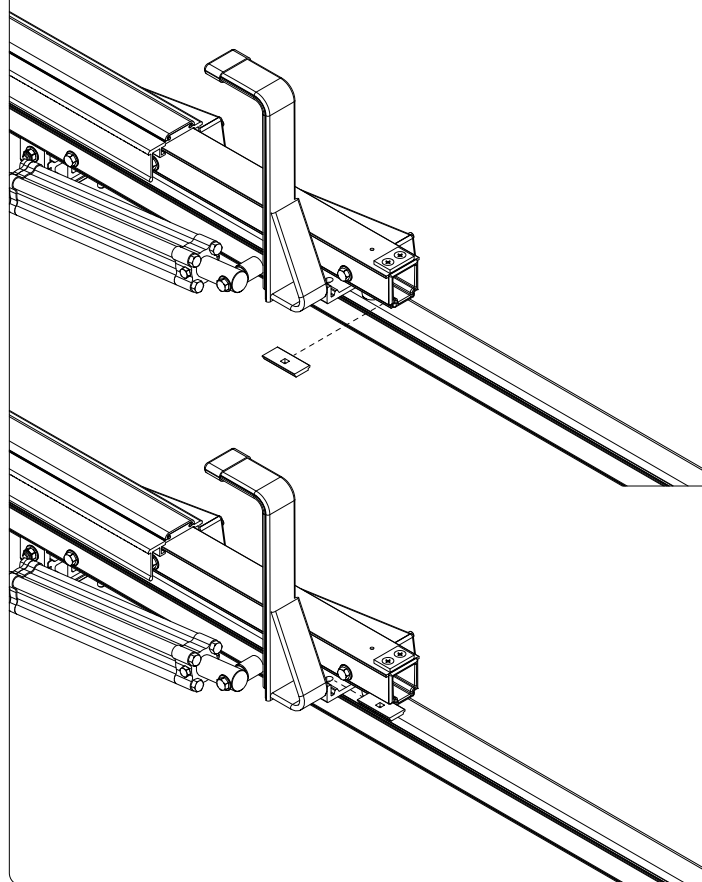
Fit Slide Z Post Bracket Clamp into Slide groove

- Press Slide Release Lever upward **6.4**

**6.5**

Extend Slide Upper

- 6.6** Place Slide Z Post Bracket Clamp into bottom groove, then slide into Z Post Connector as shown



Assemble the Slide Z Post
Bracket hardware

6.7

Position Z Post to
distance shown

6.8

2.50"

View from vehicle rear

6.9

Torque to 80 in-lbs

6.10 Push Slide Upper
into closed position

Ensure Slide Release
Lever engages to lock
Slide in closed position.

SLIDE TOP Z POST SEE QUICK START GUIDE FOR ADJUSTMENTS

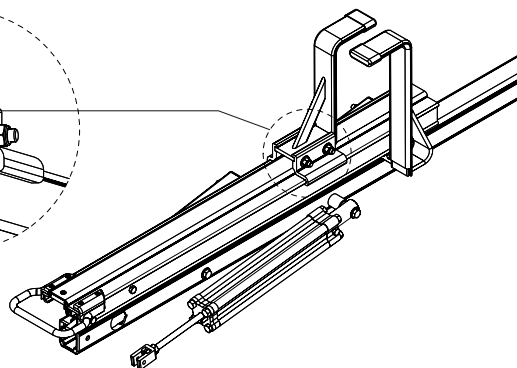
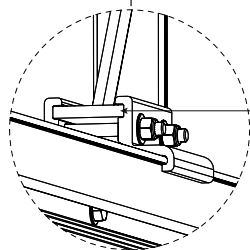
7.1 Install the Z Post Mounting Clamp Assembly onto the
Rotation Upper. Do not tighten until Step 7.4

The Mounting Clamps
seat fully into the top
flange of the Upper

Slide the Z Post into the
Mounting Clamp Assembly

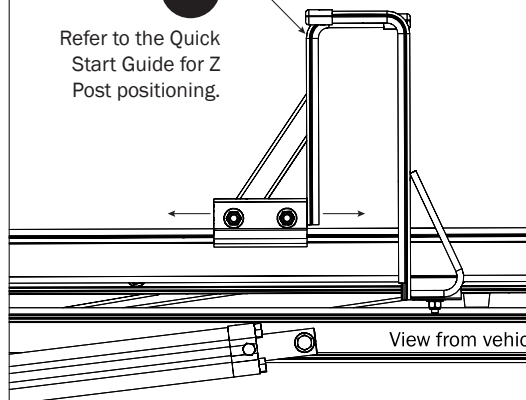
7.2

The Z Post fully seats
into the top slot of the
Mounting Clamps



7.3

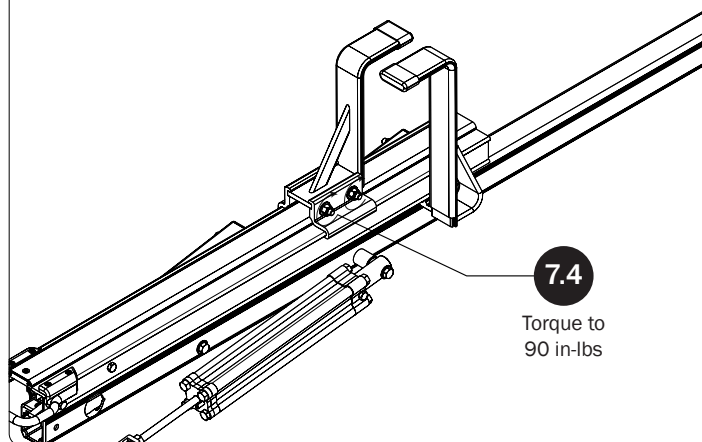
Refer to the Quick
Start Guide for Z
Post positioning.



View from vehicle rear

7.4

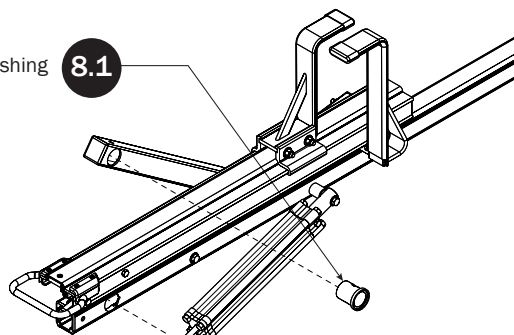
Torque to
90 in-lbs



REAR ROTATION BUSHINGS

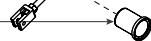
White Bushing

8.1



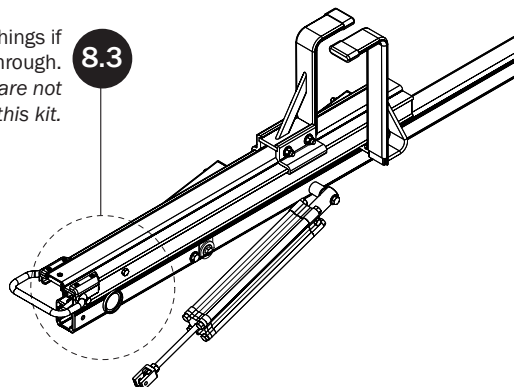
Black Bushing—
Align bushing boss
to Crossbar notch

8.2



Cable tie the bushings if
this is for ship-through.
Note: Cable ties are not
included in this kit.

8.3



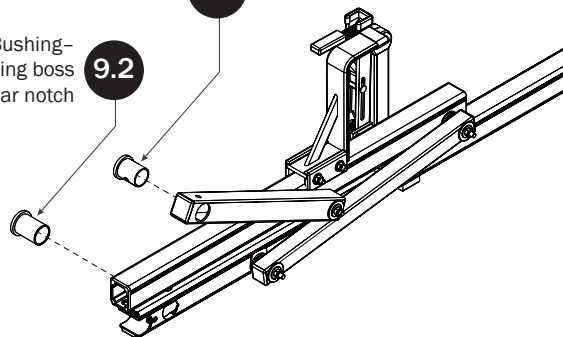
FRONT ROTATION BUSHINGS

White Bushing

9.1

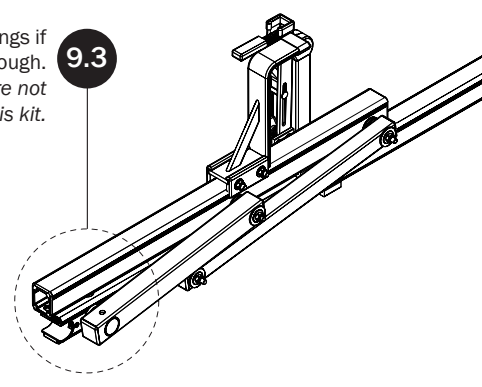
Black Bushing—
Align bushing boss
to Crossbar notch

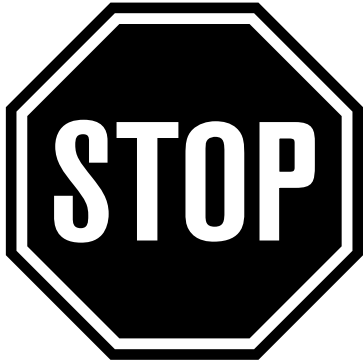
9.2



Cable tie the bushings if
this is for ship-through.
Note: Cable ties are not
included in this kit.

9.3





NOTE: This completes the installation of FEA-0004. For right side Slide Rotation installation, refer to the FEA-0003 Assembly Manual.

If applicable, refer to your next FEA Assembly Manual.

If completed, refer back to your FBM Assembly Manual, and resume assembling at Step 3.1.

WARNING: Failure to position the Crossbars as shown in your FBM Assembly Manual may result in damage to the sliding door and/or ladder rack.

