



# FITTING INSTRUCTIONS

Part Number	Product Description	Suited to vehicle/s	Fitting Kit Number
4450200	SIDE RAIL	2 DOOR (SWB)	6172268
4450210	SIDE RAIL	4 DOOR (LWB)	6172253

## WARNING

### ALSO, NOTE THE FOLLOWING:

- ◆ This product must be installed exactly as per these instructions using only the hardware supplied.
- ◆ Do not use this product for any vehicle make or model, other than those specified by ARB.
- ◆ This product or its fixing must not be modified in any way.
- ◆ The installation of this product may require the use of specialized tools and/or techniques
- ◆ It is recommended that this product is only installed by trained personnel
- ◆ These instructions are correct as at the publication date. ARB Corporation Ltd. cannot be held responsible for the impact of any changes subsequently made by the vehicle manufacturer
- ◆ During installation, it is the duty of the installer to check correct operation/clearances of all components
- ◆ Work safely at all times
- ◆ Unless otherwise instructed, tighten fasteners to specified torque

## **ARB 4x4 ACCESSORIES**

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## FITTING REQUIREMENTS

### REQUIRED TOOLS FOR FITMENT OF PRODUCT:

Basic Tool Kit	Drill
Round Hand File	11 mm Drill Bit
	6.5mm Drill Bit

### HAVE AVAILABLE THESE SAFETY ITEMS WHEN FITTING PRODUCT:

<b>Protective eyewear</b>	
<b>Hearing protection</b>	

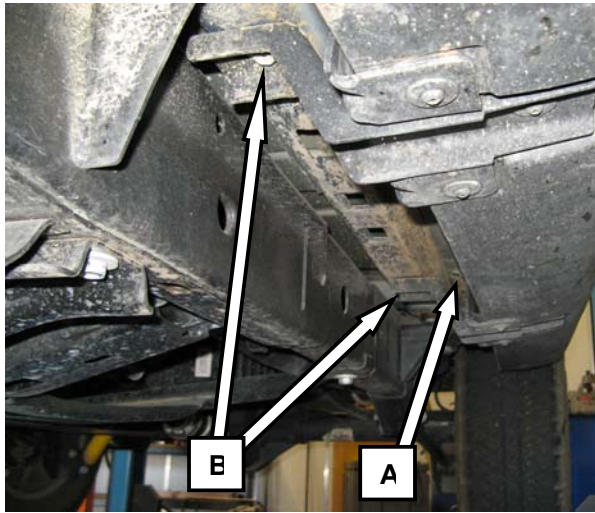
**NOTE:** 'WARNING' notes in the fitting procedure relate to OHS situations, where to avoid a potentially hazardous situation it is suggested that protective safety gear be worn or a safe work procedure be employed. If these notes and warnings are not heeded, injury may result.

### FASTENER TORQUE SETTINGS:

SIZE	Torque Nm	Torque lbft
M6	9Nm	4lbft
M10	44Nm	32lbft
M12	77Nm	57lbft

<b>PARTS LISTING</b>			
<b>APPLICATION.</b>	<b>PART NO.</b>	<b>QTY</b>	<b>DESCRIPTION</b>
ANGLE TRIM TO VEHICLE (LWB)	3199987L	1	PLATE ANGLE LH (LWB)
	3199987R	1	PLATE ANGLE RH (LWB)
	6151412	12	M6 X 16 BUTTON HEAD CAP SCREW
	4584295	12	M6 WASHER BLACK
	6151128	8	M6 FLANGE NUT
ANGLE TRIM TO VEHICLE (SWB)	3199988L	1	PLATE ANGLE LH (SWB)
	3199988R	1	PLATE ANGLE RH (SWB)
	6151412	8	M6 X 16 BUTTON HEAD CAP SCREW
	4584295	8	M6 WASHER BLACK
	6151128	4	M6 FLANGE NUT
FRONT MOUNT BRACKET TO CHASSIS (LHS & RHS)	3199943	2	CAGE PLATE M10 (225mm)
	6151304	2	CAGE NUT M10
	6151204	2	BOLT M10 X 35mm
	4581040	2	WASHERS M10
	4581048	2	SPRING WASHERS M10
REAR MOUNT BRACKET TO CHASSIS (LHS & RHS)	3199943	2	CAGE PLATE M10 (225mm)
	3199848	2	CAGE PLATE M12
	6151304	2	CAGE NUT M10
	6151305	2	CAGE NUT M12
	4581040	2	WASHERS M10
	4581007	2	WASHERS GOLD M12
	4581048	2	SPRING WASHERS M10
	4581050	2	SPRING WASHERS M12
	6151255	2	BOLT M12 X 1.75 X 40mm
	6151232	2	BOLT M10 X 30mm
MIDDLE MOUNT BRACKET TO CHASSIS (LHS & RHS)	3199944	4	CAGE PLATE M10 (335mm)
	6151304	4	CAGE NUT M10
	4581040	4	WASHERS M10
	4581048	4	SPRING WASHERS M10
	6151204	4	BOLT M10 X 35mm
FRONT MOUNT BRACKET (LHS & RHS) MANUAL TRANSMISSION VARIANT	6151098	2	BOLT M12 X 1.5 X 40
	4581007	4	WASHER / PACKER M12 GOLD
	4581050	2	SPRING WASHER
MISCELLANEOUS	215637	2	STICKER "ARB"
	6500002	2	RUBBER PLUG 60.3mm TUBE

## FITTING PROCEDURE

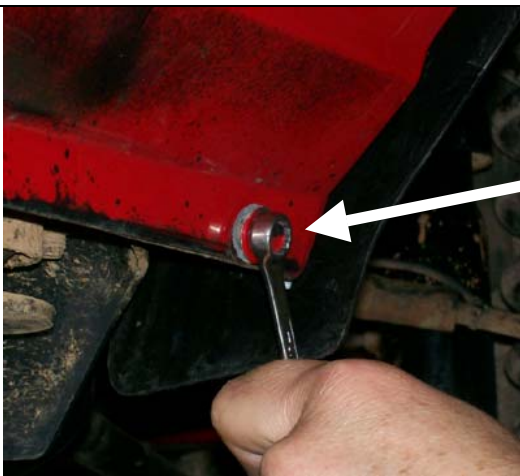


1. Remove the original side steps from the vehicle by removing existing four nuts (A) from side step studs along sill.
2. Remove two existing bolts (B) and carefully remove side rail with help of another person.

**WARNING – Only remove one side at a time.**



3. Place rubber plugs supplied into the end of the side rails.



4. Remove all the bolts which go through to the sill of the vehicle. Like the one shown in the photograph on the left.



5. Using the black M6 dome head bolts plus M6 black flat washer, loosely fit the sill cover. Some of the holes pick up on existing holes with weld nuts behind them, some pass through existing holes but require a flange nut to be fitted on the inside of the sill, and some holes will have to be drilled.



6. For the holes which have to be drilled, use a centre punch to mark the position of the hole in the centre of the slot in the sill cover.
7. Remove the sill cover and drill through the sill using a 6.5mm drill. Tough up the bare metal in the hole with black paint.
8. Remove the sill cover to prevent damage to it during drilling operations later.

**NOTE: The sill covers get refitted at the end of the installation process.**

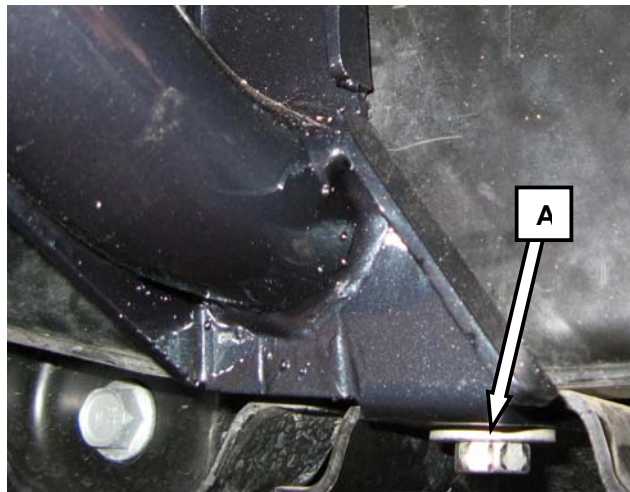


9. For automatic vehicles, support the weight of the gearbox cross member with stand or similar. Remove and retain existing bolt for front bracket.



10. For the rear mounting bracket, fit a M12 cage nut into one of the M12 cage nut plates and make appropriate bend in cage plate to reach through the hole shown and position the cage nut behind the hole the M12 bolt will pass through. As shown in photo on left.
11. With the assistance of another person, hold side rail against chassis.
12. Using a M12 x 1.75 x 40 bolt(course thread), M12 spring washer and M12 Gold washer loosely fasten into place.

**NOTE: Leave this bolts finger tight at this stage.**



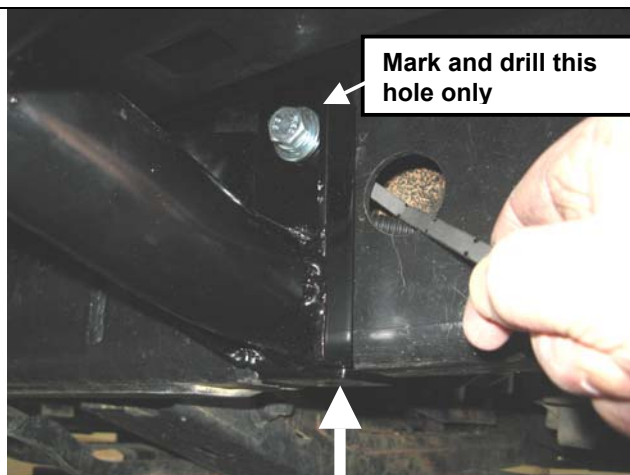
13. Fasten Front Bracket to vehicle as shown.

(For Auto vehicles, use the bolt removed in step 8)

**Note:** For manual vehicles use Bolt M12 X 1.5 X 40 (fine pitch), M12 Gold washer and M12 spring washer which are supplied in fitting kit. Use extra M12 Gold washer as packer between chassis and Front Bracket. (Some manual vehicles are fitted with a steel fuel pump cover which secures to the chassis with this bolt. If this is the case, do not use the extra M12 gold washer as a packer between the chassis and the rail bracket.)

14. While pushing the side rail to get the vertical face of the front mounting bracket as close to the side of the chassis as possible, tighten up the bolt "A".

15. Using a marker, mark the position of the hole in the vertical side of the chassis for the front bracket.



16. While using a jack or a lever, push the centre mounting bracket up against the bottom of the chassis. (In the direction of the arrow)

17. Using a marker, mark the position of the hole in the side of the chassis rail for the centre bracket. (Do not mark or drill the hole in the bottom of the chassis rail at this stage.)

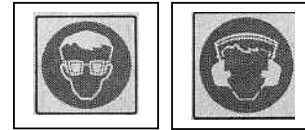




18. Use a centre punch to mark the centre of the marked hole for the front bracket. Then using an 11mm drill bit, drill the hole. Be careful, as depending on the size of your drill, the bit will tend to wander upwards from the marked position.

Remove any sharp burrs, and touch up the bare metal with black paint to prevent corrosion.

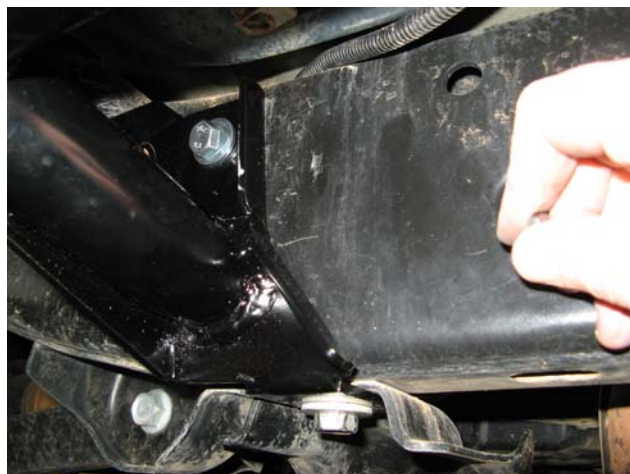
**Warning: Drilling operations can result in flying metal debris, safety glasses should be**



19. Use a centre punch to mark the centre of the marked hole for the centre bracket. Then using an 11mm drill bit, drill the hole. Be careful, as depending on the size of your drill, the bit will tend to wander upwards from the marked position.

Remove any sharp burrs, and touch up the bare metal with black paint to prevent corrosion.

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Refit the side rail as follows.

20. Fit the M12 bolt through the hole into the bottom of the chassis rail.
21. Fit an M10 cage nut into M10 cage nut plate and make appropriate bends in cage nut plate to reach the hole in the top of the front bracket.
22. Insert cage nut plate through chassis hole as shown and line up cage nut with hole and bracket.
23. Using an M10 x 35 bolt, M10 spring washer and M10 x 25 flat steel washer loosely fasten into place.



24. For the centre bracket, fit M10 cage nut into M10 cage nut plate and make appropriate bends in cage nut plate to reach the hole.
25. Insert cage plate through the hole in the chassis as shown and line up cage nut with hole and bracket.
26. Using a M10 x 35 bolt, M10 spring washer and M10 x 25 flat steel washer loosely fasten into place.
27. While pushing up on the centre bracket to make sure that it is up against the bottom of the chassis rail, tighten the bolt shown.



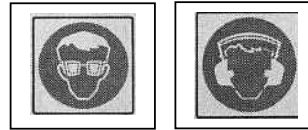
28. For the rear bracket, fit an M12 cage nut into one of the M12 cage nut plates and make appropriate bends in the cage nut plate to reach through the hole shown and position the cage nut behind the hole the M12 bolt will pass through. As shown in photo on left.
29. Using a M12 x 40 bolt, M12 spring washer and M12 Gold washer loosely fasten into place.





30. Using an 11mm drill bit, drill through the bottom of the chassis, using the hole in the bottom of the centre bracket as a guide.

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31. Clean off any sharp burs, and treat the bare metal surfaces with paint to prevent corrosion.
32. Fit an M10 cage nut into M10 cage nut plate and make appropriate bends in cage nut plate to reach the hole in the bottom of the chassis member.
33. Use an M10 x 35mm bolt, flat and spring washer to fasten the bottom of the centre bracket to the chassis.



34. Using an 11mm drill bit, drill through the bottom of the chassis, using the hole in the bottom of the rear bracket as a guide.

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35. Clean off any sharp burs, and treat the bare metal surfaces with paint to prevent corrosion.
36. Fit an M10 cage nut into M10 cage nut plate and make appropriate bends in cage nut plate to reach the hole in the bottom of the chassis member.
37. Use an M10 x 30mm bolt, flat and spring washer to fasten the bottom of the rear bracket to the chassis.

38. Finally, refit the sill cover, using the black M6 dome headed bolts, flat washers and flange nuts as required.



39. Fit ARB Sticker to rails at the location shown.



40. Tighten all bolts to recommended torque.

41. Break off all protruding cage nut plates from chassis.

Repeat for the other side of vehicle.