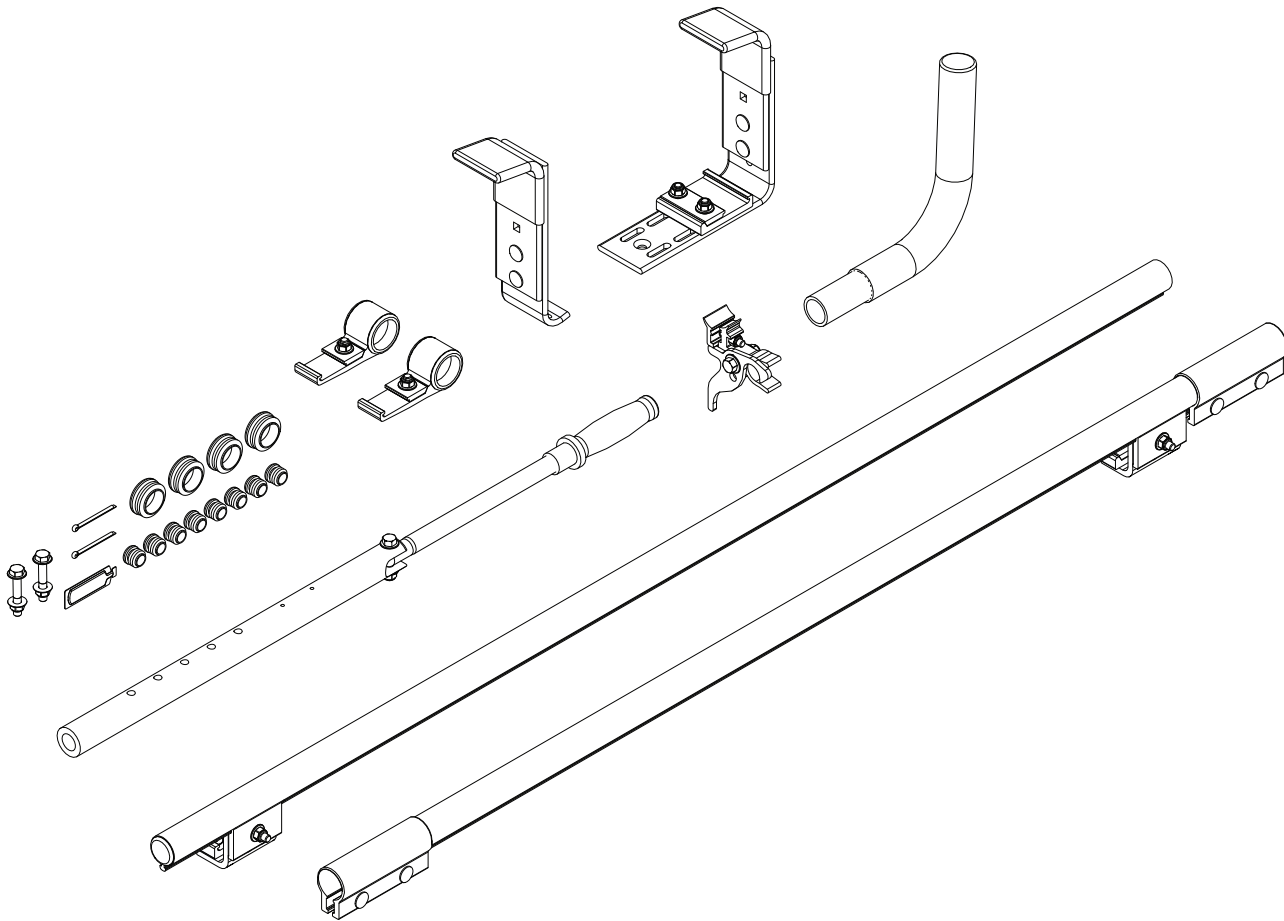


PRIME DESIGN™

A Safe Fleet Brand



4'-8' CLAMP DOWN KIT

PRIME DESIGN, A SAFE FLEET BRAND

Address: 580 Opperman Drive, Eagan, MN 55123 • Toll Free: 1.8.PRIME.RACK

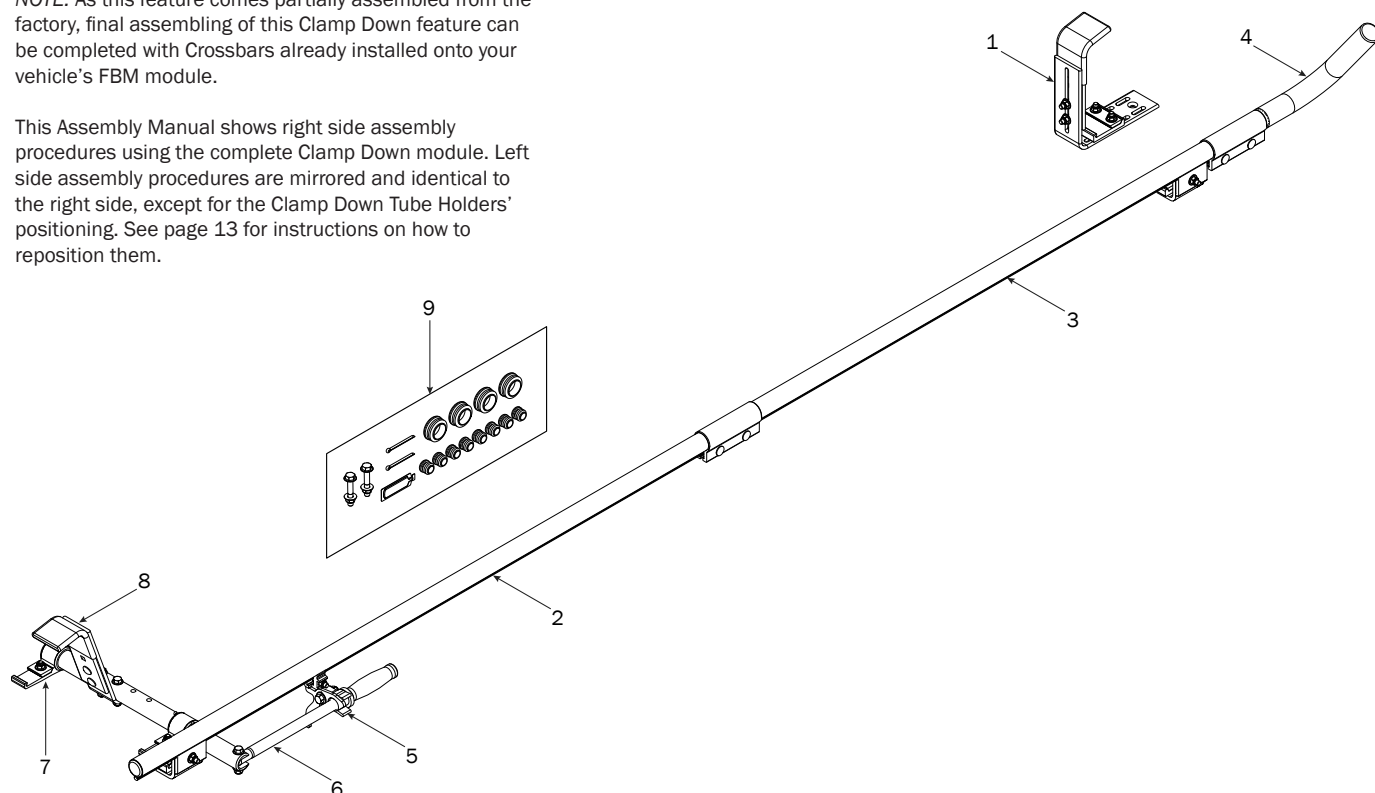
Fax: 651-552-1799 • Email: info@primedesign.net • Website: www.primedesign.net

FEA0008

CONTENTS OVERVIEW

NOTE: As this feature comes partially assembled from the factory, final assembling of this Clamp Down feature can be completed with Crossbars already installed onto your vehicle's FBM module.

This Assembly Manual shows right side assembly procedures using the complete Clamp Down module. Left side assembly procedures are mirrored and identical to the right side, except for the Clamp Down Tube Holders' positioning. See page 13 for instructions on how to reposition them.



1—HD Front Hook Assy..... (Qty 1)

2—Clamp Down Tube Assy..... (Qty 1)
Rear, RH, 56.00"

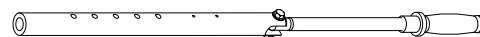
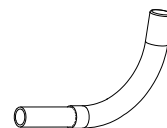
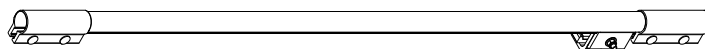
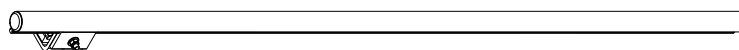
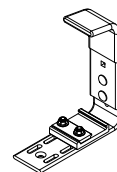
3—Clamp Down Tube Assy..... (Qty 1)
Front, RH, 48.00"

4—Removable Horn..... (Qty 1)
With Cap, 15.00"

5—Clamp Down Handle Latch (Qty 1)
Right Hand

6—Clamp Down Handle Tube Assy..... (Qty 1)

7—Clamp Down Handle Tube Bracket (Qty 2)



8—Quick Clamp Rear Clamp Assy (Qty 1)
Adjustable



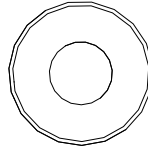
9—HKT-8403..... (Qty 1)
Modular Clamp Down Hardware Kit



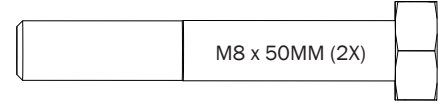
Cotter Pin (2X)



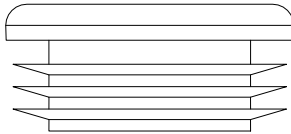
1/4 Lock Nut (2X)



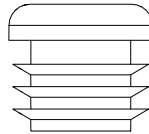
Flat Washer (4X)



M8 x 50MM (2X)



Cap, Large (4X)

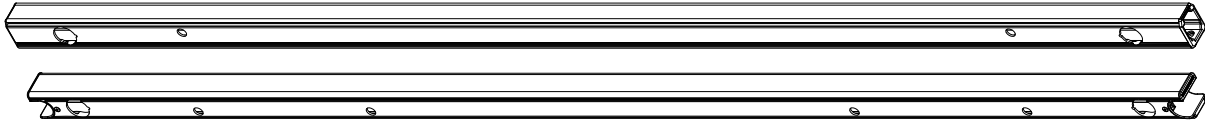


Cap, Small (8X)



Anti-Seize (1X)

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



11—Crossbar (not shown on pg 2) (Qty 1)
Ordered separately, Mid Crossbar Kit, Gen 4



Small Caps (2X)



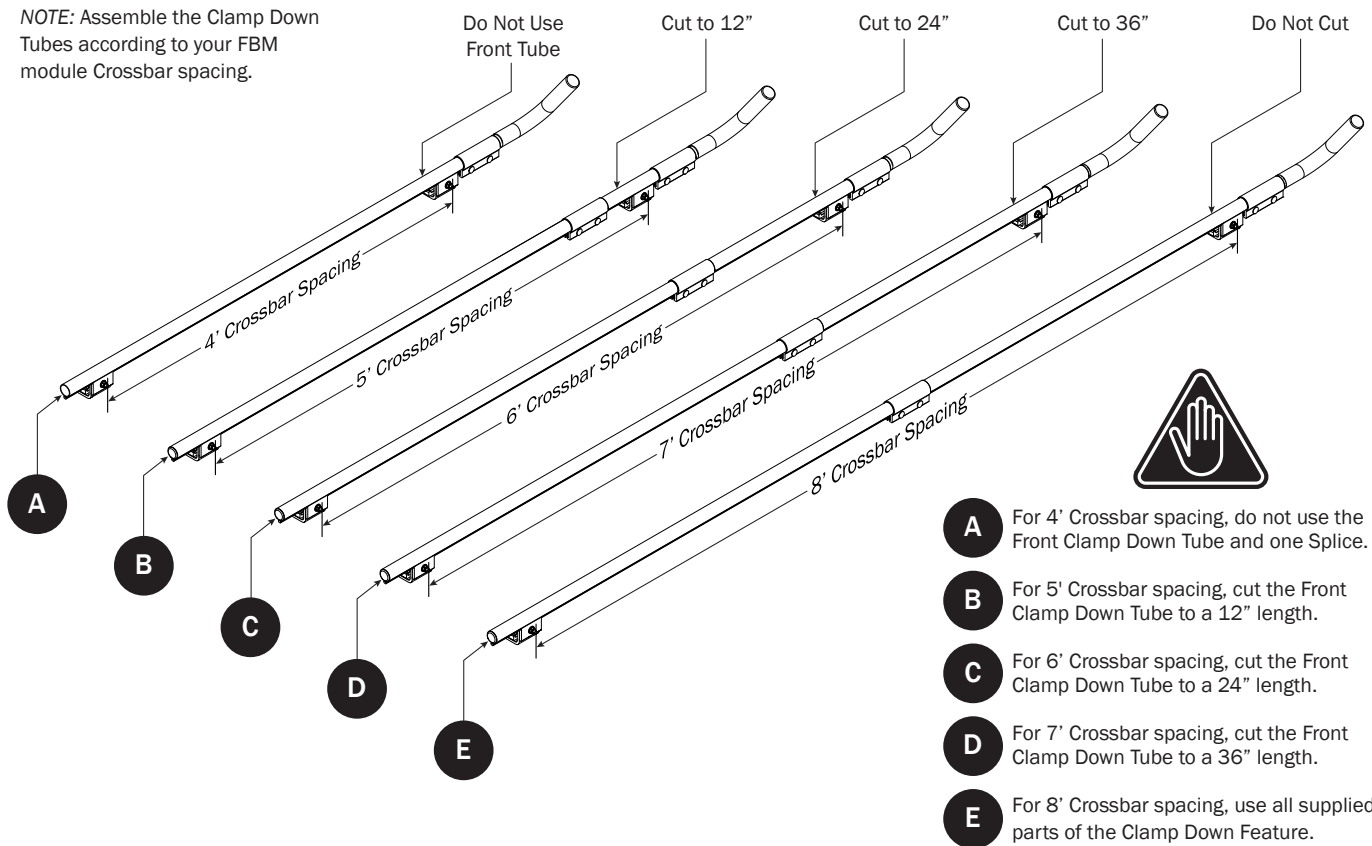
Large Caps (2X)



*NOTE: This module is an optional purchase according to your vehicle configuration.

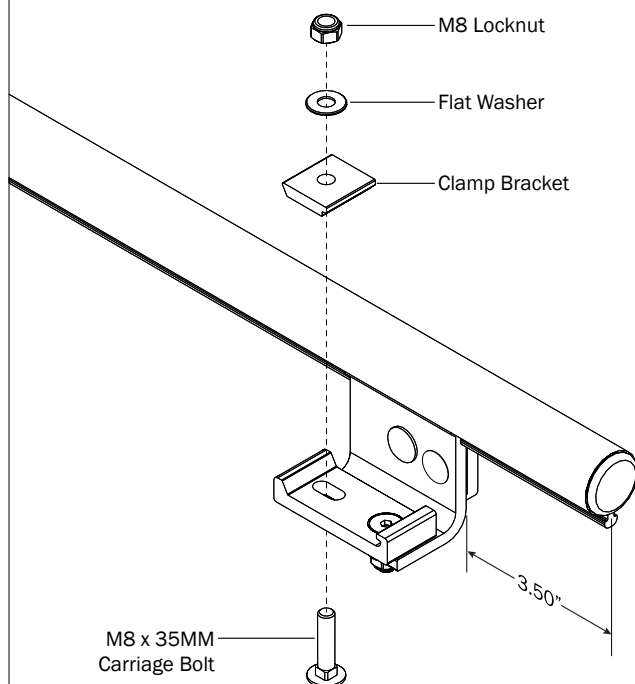
CLAMP DOWN VARIATIONS**4' – 8' CROSSBAR SPACING**

NOTE: Assemble the Clamp Down Tubes according to your FBM module Crossbar spacing.

**REAR CLAMP DOWN TUBE HOLDER**

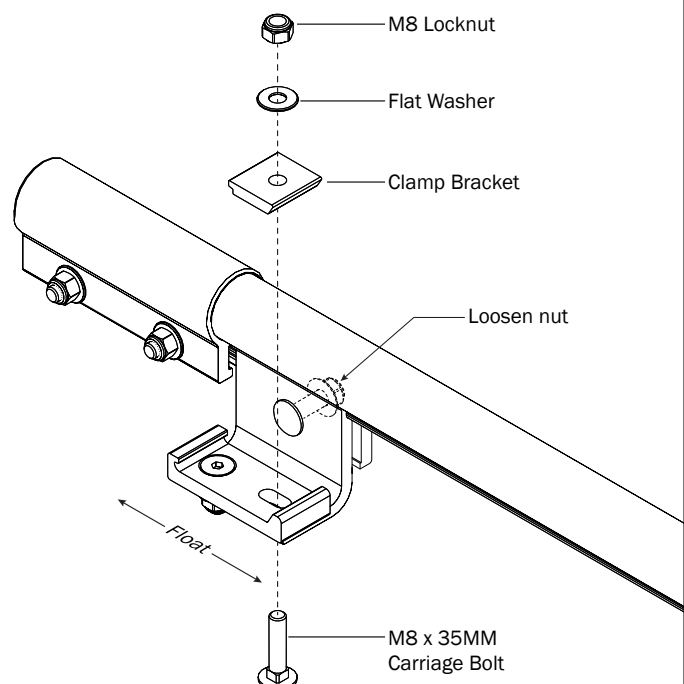
- 0.1** To assemble the left and right hand Clamp Down: Remove only the indicated hardware and retain for RH and LH Steps 3.4–3.7. Verify Rear Holder to distance shown, and adjust if necessary.

If assembling LH Clamp Down, proceed to Step 0.3 on page 13.

**FRONT CLAMP DOWN TUBE HOLDER**

- 0.2** To assemble the left and right hand Clamp Down: Remove only the indicated hardware and retain for RH and LH Steps 3.10–3.13. Loosen nut as indicated below, and leave the Front Tube Holder loose to float until Step 3.8.

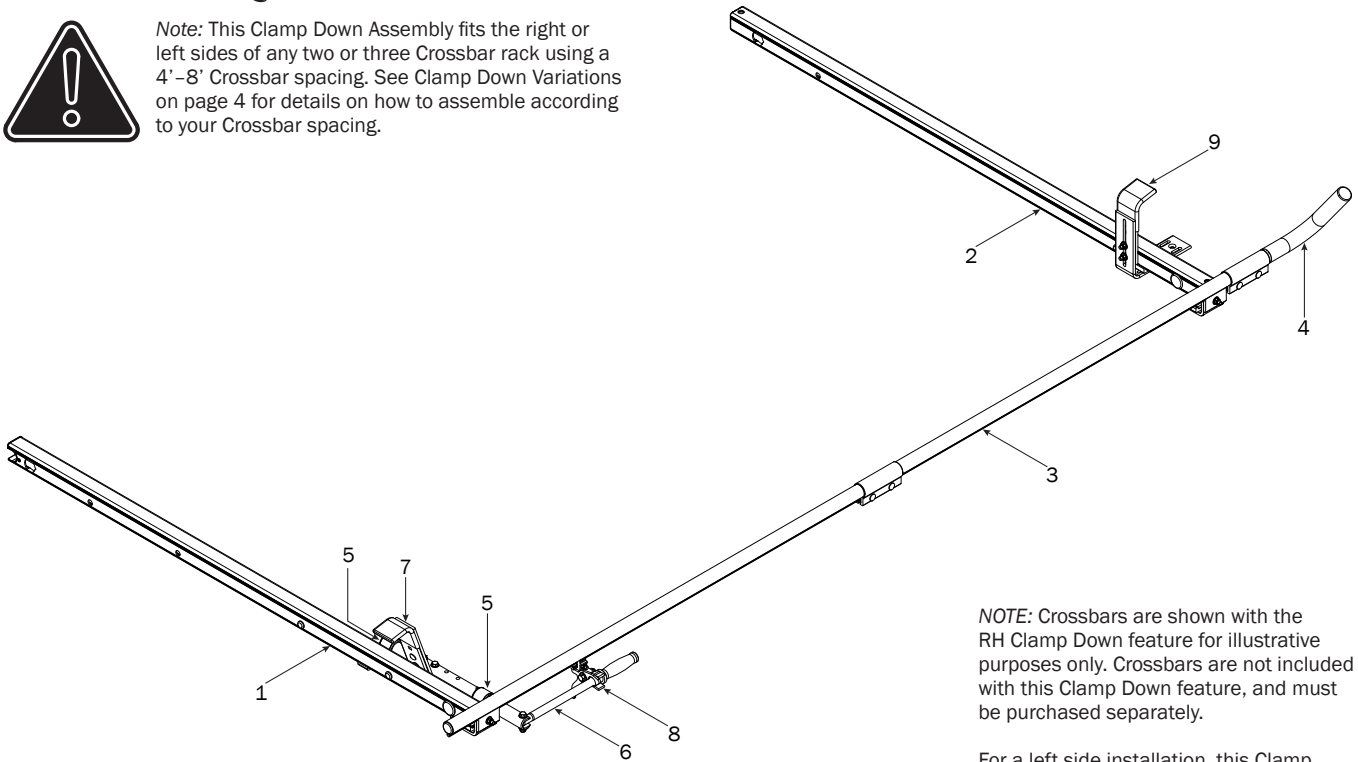
If assembling LH Clamp Down, proceed to Step 0.4 on page 13.



RIGHT CLAMP DOWN ASSEMBLY SEQUENCE



Note: This Clamp Down Assembly fits the right or left sides of any two or three Crossbar rack using a 4'-8' Crossbar spacing. See Clamp Down Variations on page 4 for details on how to assemble according to your Crossbar spacing.

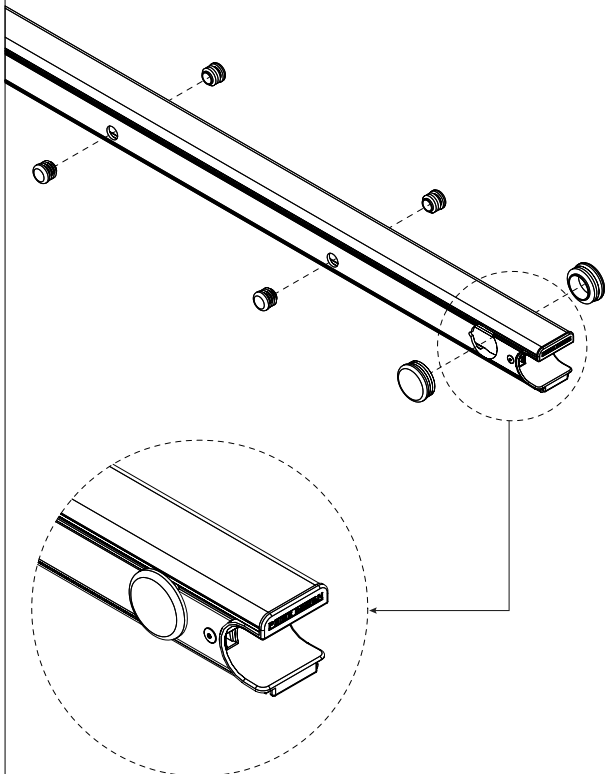


NOTE: Crossbars are shown with the RH Clamp Down feature for illustrative purposes only. Crossbars are not included with this Clamp Down feature, and must be purchased separately.

For a left side installation, this Clamp Down Assembly can also be fitted onto the optional Mid Crossbar for the carrying of step ladders.

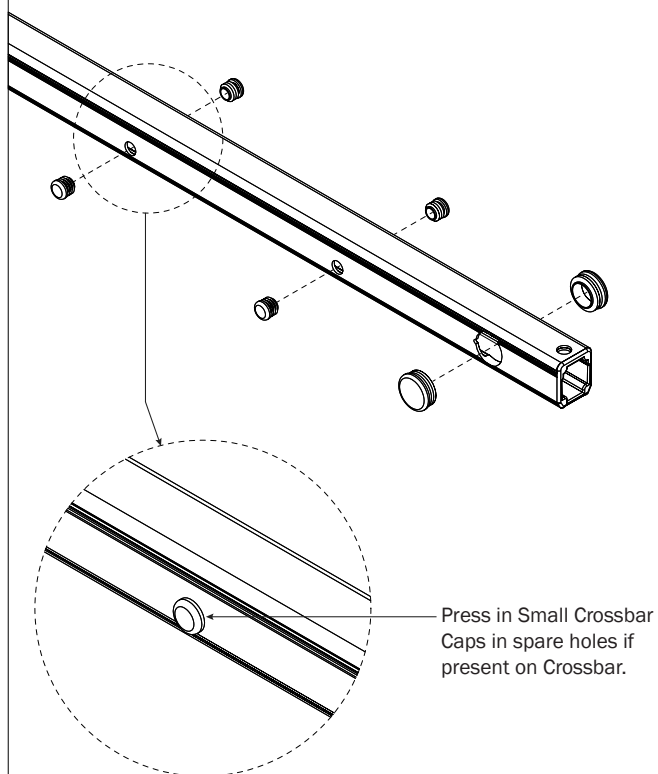
REAR CROSSBAR CAPS

- 1** Press Large and Small Crossbar Caps into open Crossbar holes on side where Clamp Down will be installed.



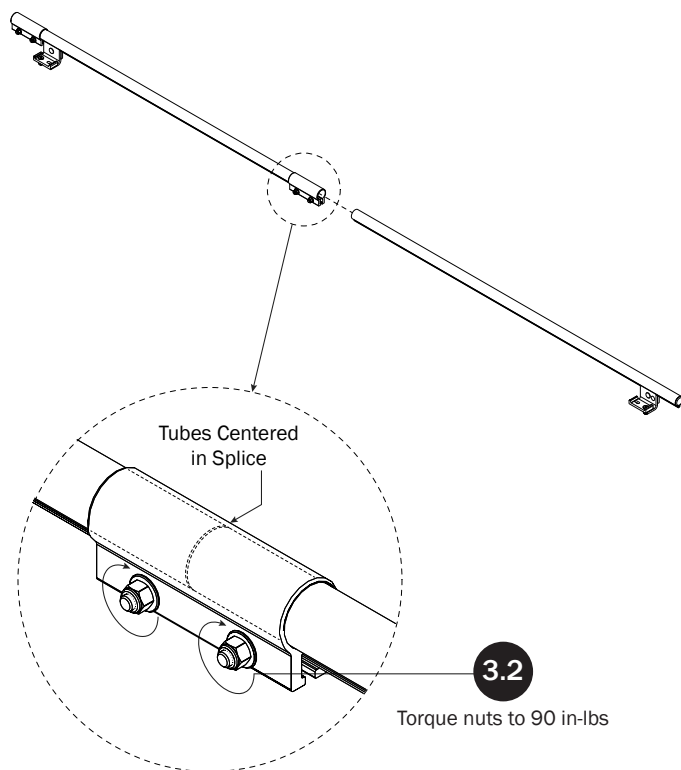
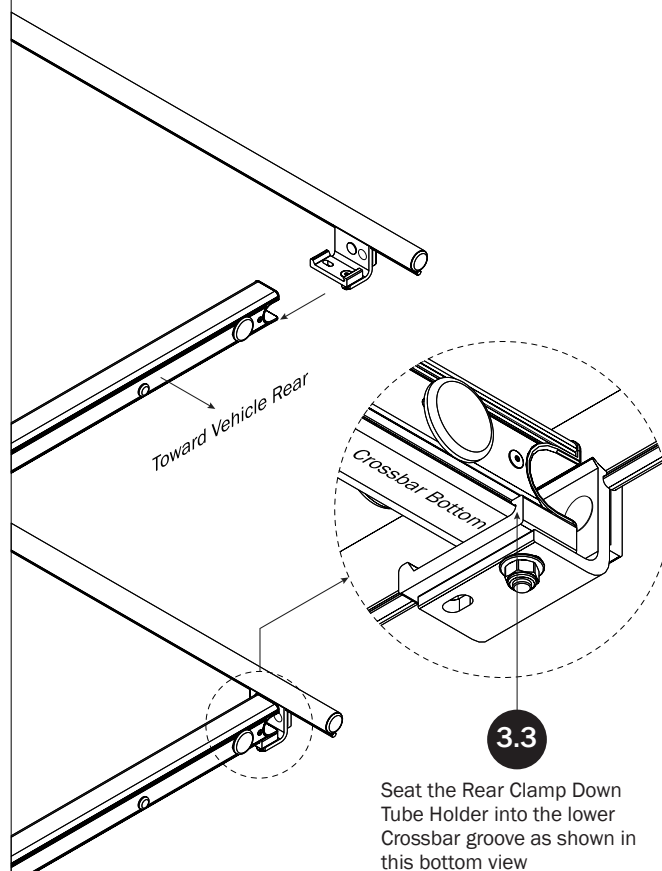
FRONT CROSSBAR CAPS

- 2** Press Large and Small Crossbar Caps into open Crossbar holes on side where Clamp Down will be installed. Some Front Crossbars may have additional drilled holes. Press Crossbar Caps into additional Crossbar holes if present.

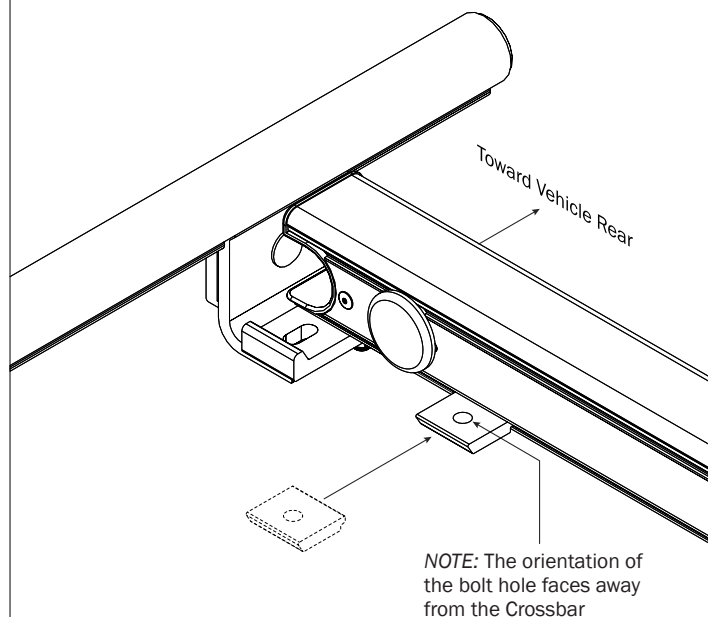


CLAMP DOWN TUBE ASSEMBLY

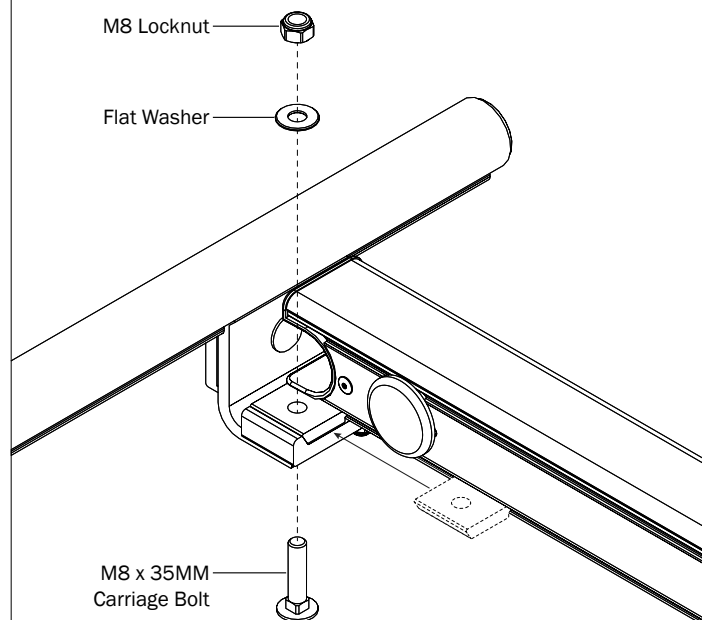
- 3.1** Insert the Rear Clamp Down Tube into the Tube Splice. Ensure both Clamp Down Tubes are centered and fully seated into the Splice before proceeding to Step 3.2

**REAR CLAMP DOWN TUBE**

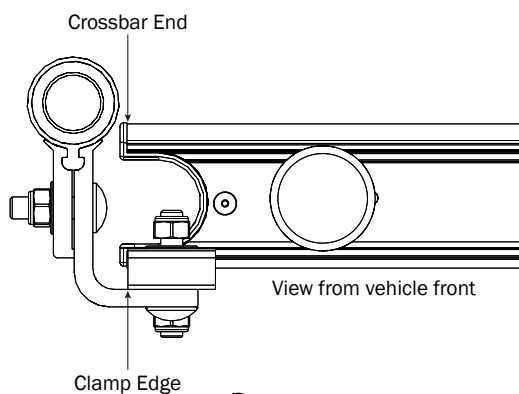
- 3.4** Place the Clamp Bracket removed in Step 0.1 into the lower groove of the Crossbar, and slide it on top of the Rear Clamp Down Tube Holder



- 3.5** Reassemble the Rear Clamp Down Tube Holder using the fastening hardware removed in Step 0.1. Do not tighten until Step 3.7



- 3.6** Align the Rear Crossbar End to the Rear Clamp Down Tube Holder edge as shown



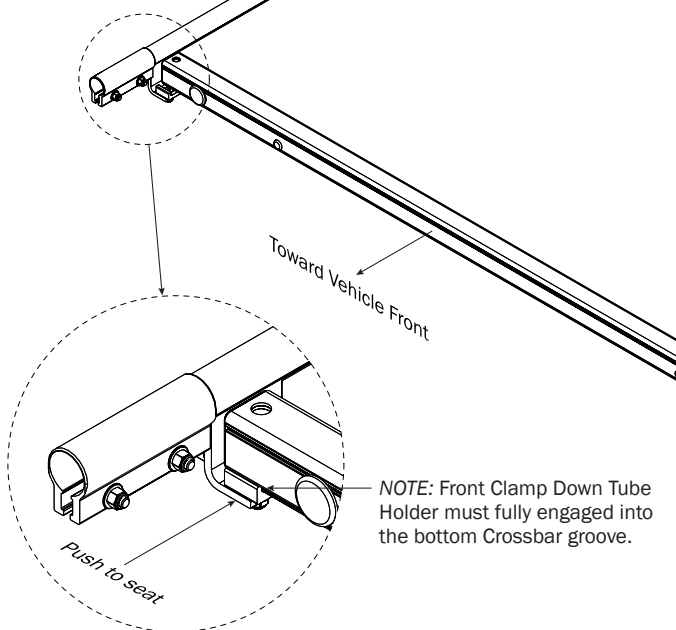
3.7

Torque to 90 in-lbs

FRONT CLAMP DOWN TUBE

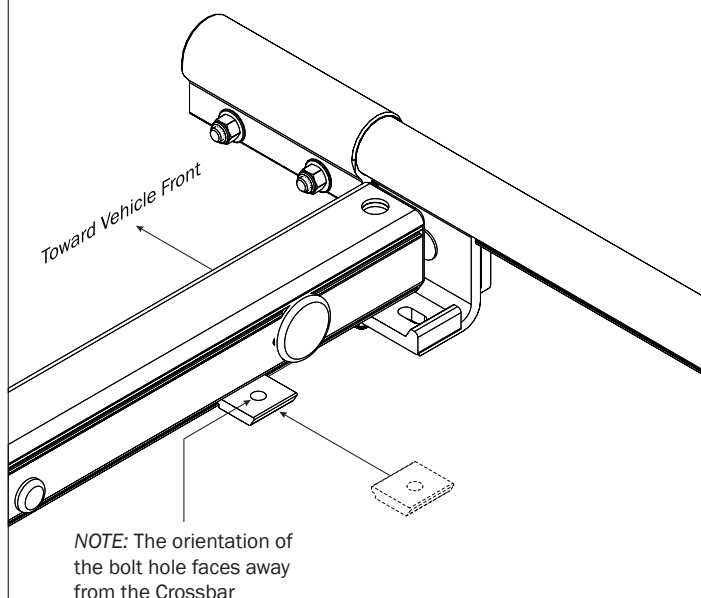
3.8

Place the Front Clamp Down Tube Holder into the lower groove of the Crossbar, and slide it rearward until it fully seats into the bottom groove of the Front Crossbar



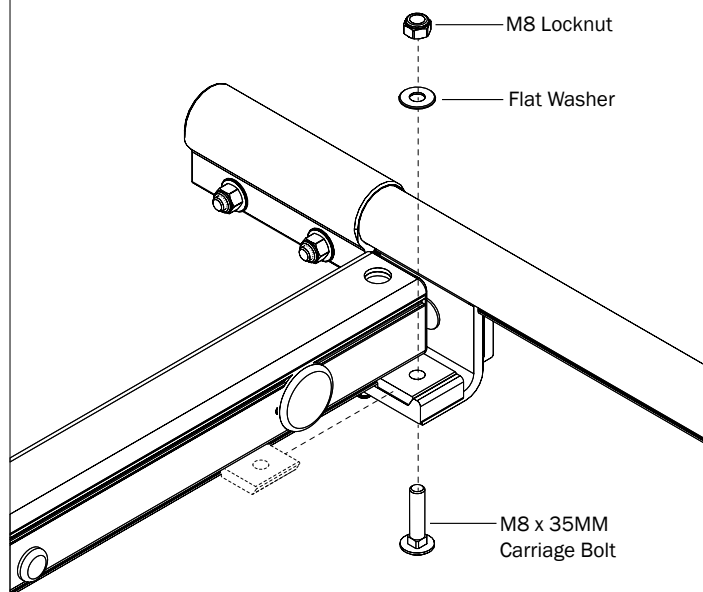
3.10

Place the Clamp Bracket removed in Step 0.2 into the lower groove of the Crossbar, and slide it on top of the Front Clamp Down Tube Holder

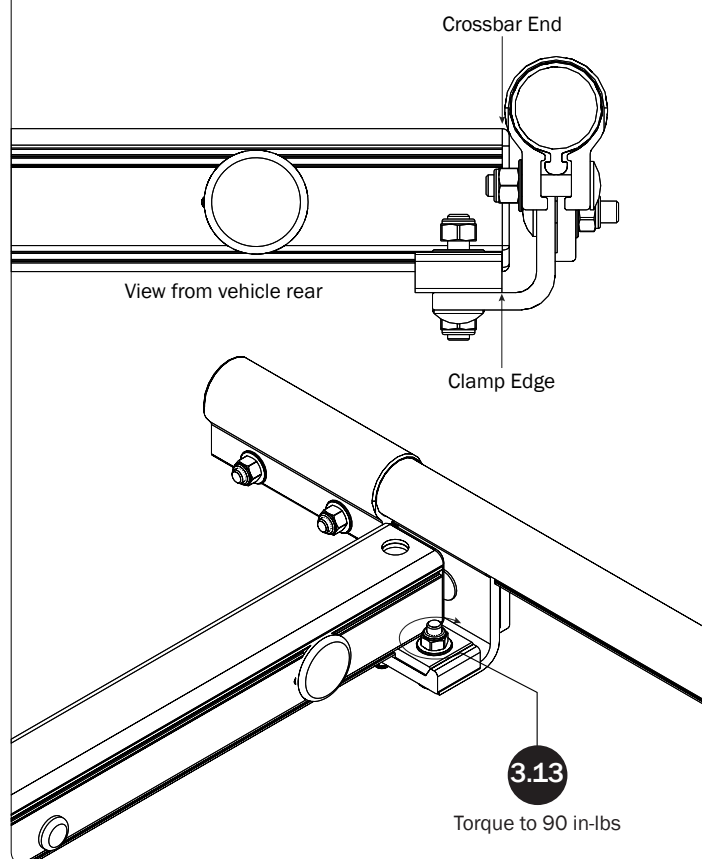


3.11

Reassemble the Front Clamp Down Tube Holder using the fastening hardware removed in Step 0.2. Do not tighten until Step 3.13

**3.12**

Align the Front Crossbar End to the Front Clamp Down Tube Holder edge as shown

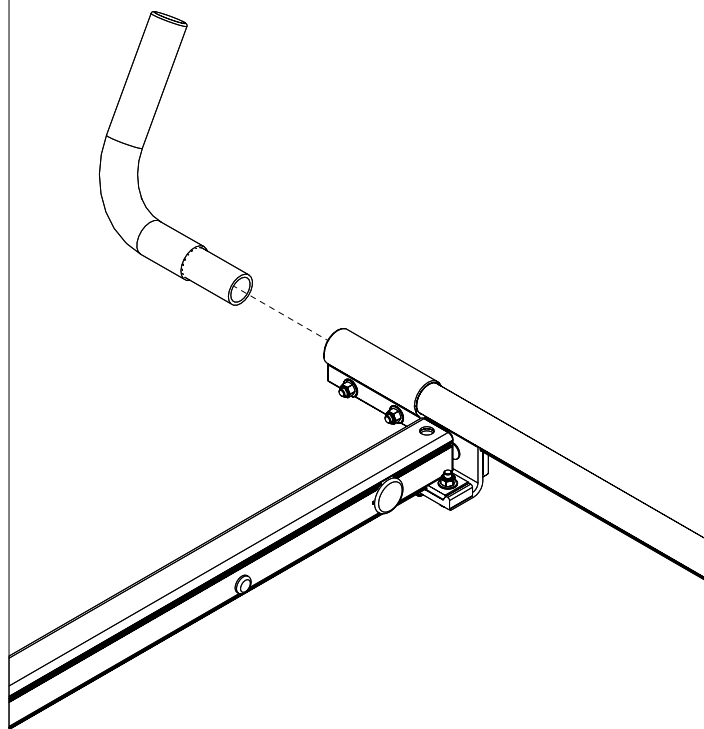
**3.13**

Torque to 90 in-lbs

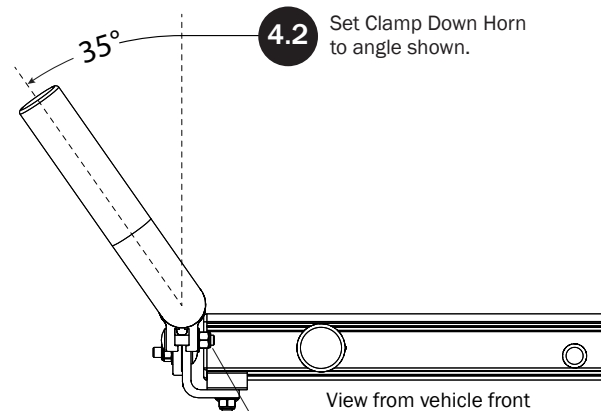
CLAMP DOWN HORN

4.1

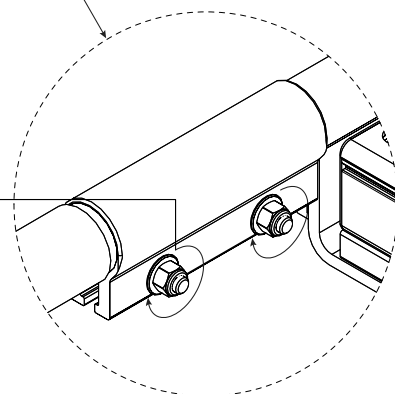
Insert the Front Clamp Down Horn into the Front Tube Splice. Do not tighten until Step 4.3

**4.2**

Set Clamp Down Horn to angle shown.

**4.3**

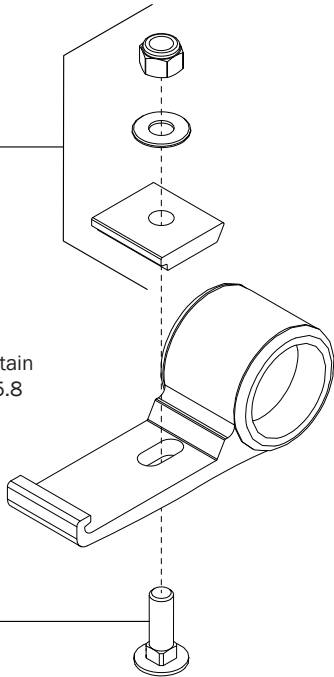
Torque to 90 in-lbs



REAR CROSSBAR CLAMP DOWN HANDLE TUBE BRACKETS

5.1

Remove and retain
for Steps 5.3–5.8



NOTE: To provide visual clarity, the Clamp
Down Tube Assembly is not shown attached
to the Rear Crossbar from Steps 5.2- 7.2

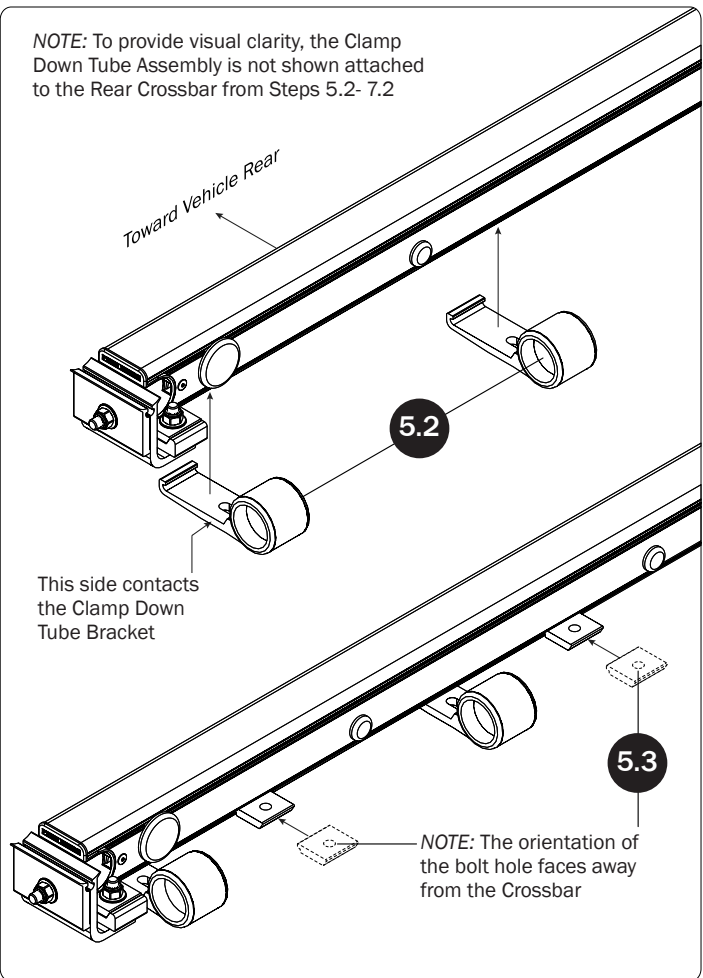
Toward Vehicle Rear

5.2

This side contacts
the Clamp Down
Tube Bracket

5.3

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



5.4

Reassemble the Handle Tube Brackets using the
fastening hardware removed in Step 5.1. Do not
tighten until Step 5.10

5.6

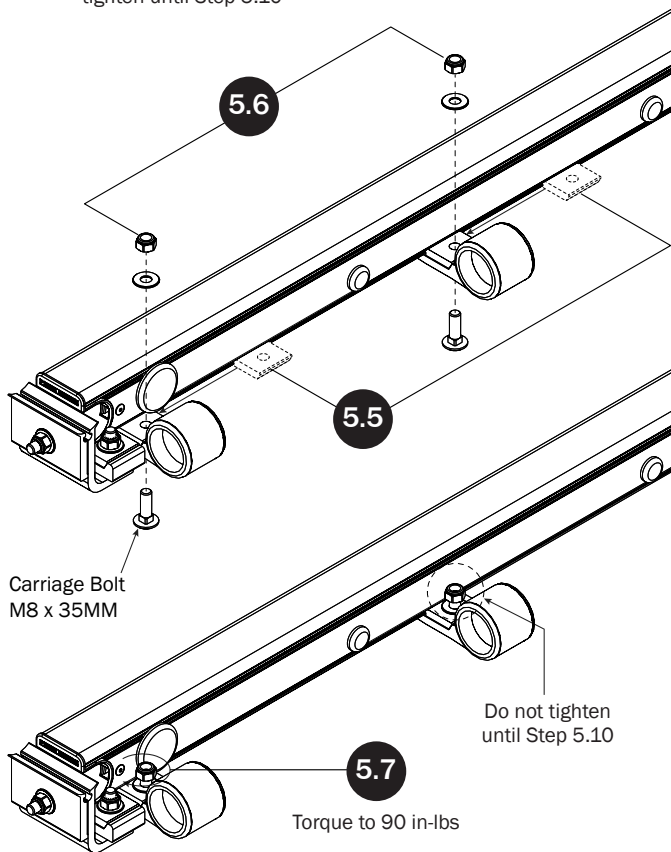
5.5

Carriage Bolt
M8 x 35MM

5.7

Torque to 90 in-lbs

Do not tighten
until Step 5.10



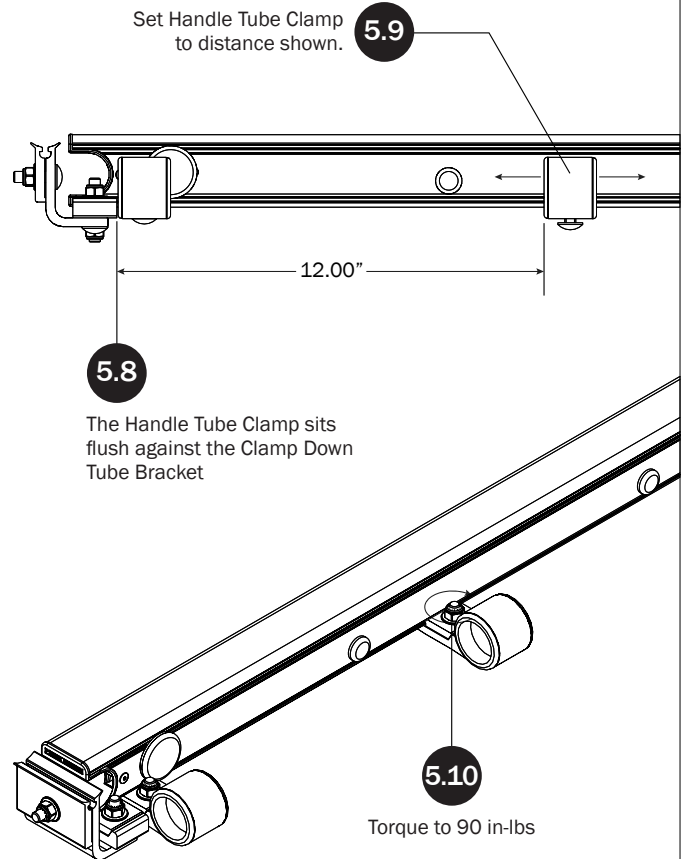
Set Handle Tube Clamp
to distance shown.

5.9

12.00"

5.8

The Handle Tube Clamp
sits
flush against the Clamp Down
Tube Bracket



5.10

Torque to 90 in-lbs

9

FEA-0008 ASSEMBLY INSTRUCTIONS—RIGHT SIDE CLAMP DOWN

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CLAMP DOWN HANDLE TUBE**6.1**

With the Clamp Down Handle oriented toward the front of the vehicle, slide the Handle Assembly into the Handle Tube Brackets.

Toward Vehicle Rear

6.2

Insert Cotter Pins as shown. Bend ends flush to Handle Tube to lock pins in place

NOTE: The orientation of the notch in the Handle Tube faces toward the front of the vehicle

CLAMP DOWN REAR HOOK
SEE QUICK START GUIDE FOR ADJUSTMENTS**7.1****7.2**

Torque to 90 in-lbs

Anti-Seize
Must apply Anti-Seize Compound and torque to specified value.

HANDLE LATCH

Toward Vehicle Rear

8.1

Do not tighten until Step 8.3

8.2

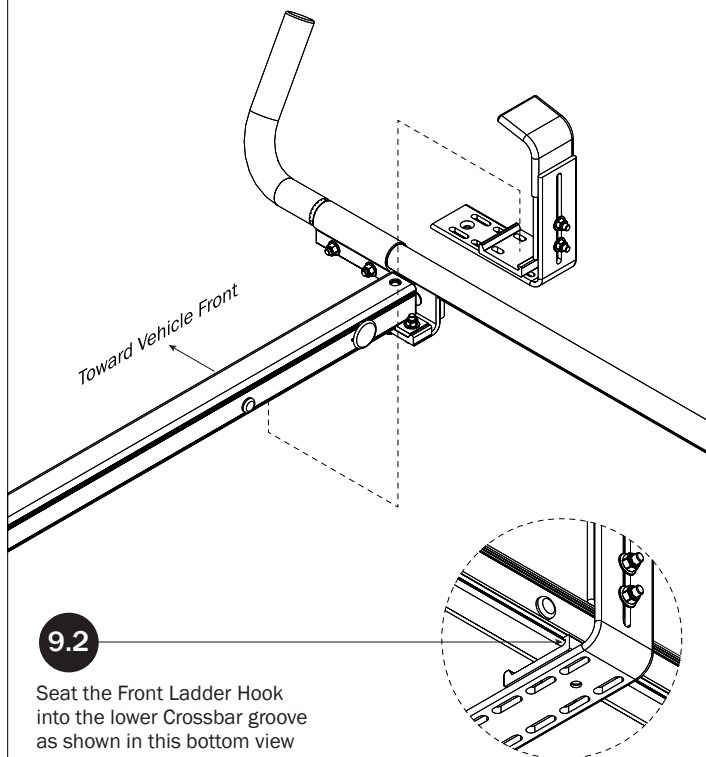
Position the Handle Latch until the Handle Grip is firmly seated.

8.3

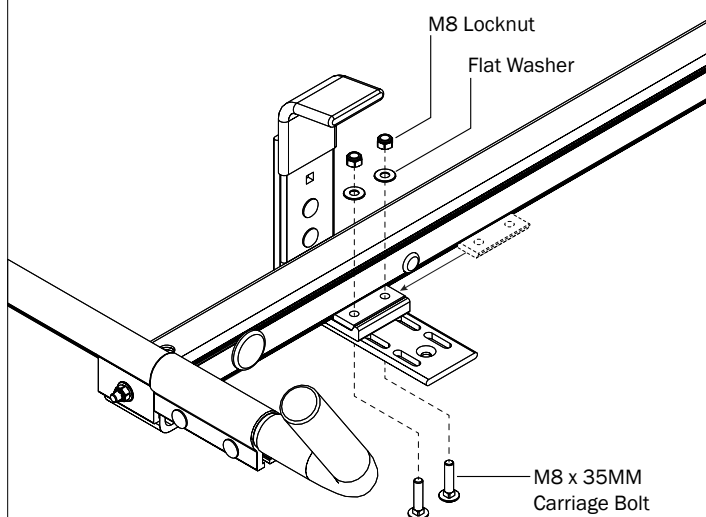
Torque to 90 in-lbs

FRONT LADDER HOOK SEE QUICK START GUIDE FOR ADJUSTMENTS

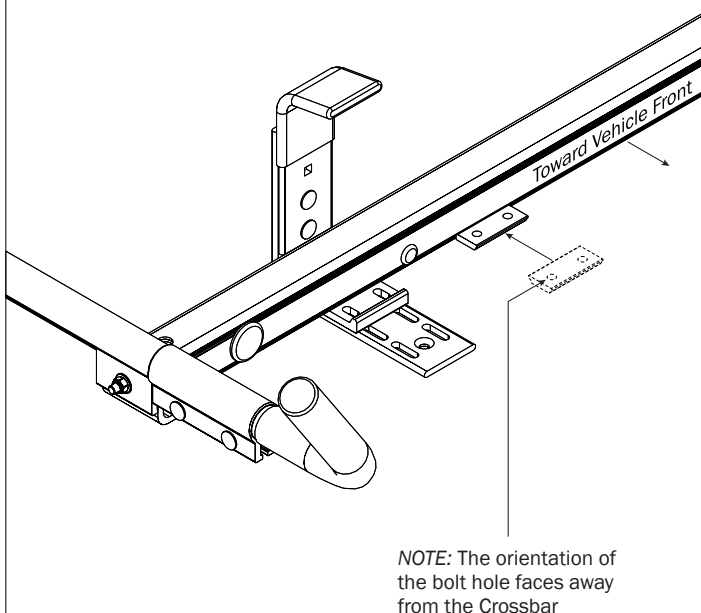
- 9.1** Remove and retain the Front Ladder Hook fastening hardware (not shown in this view) for Steps 9.3 and 9.4



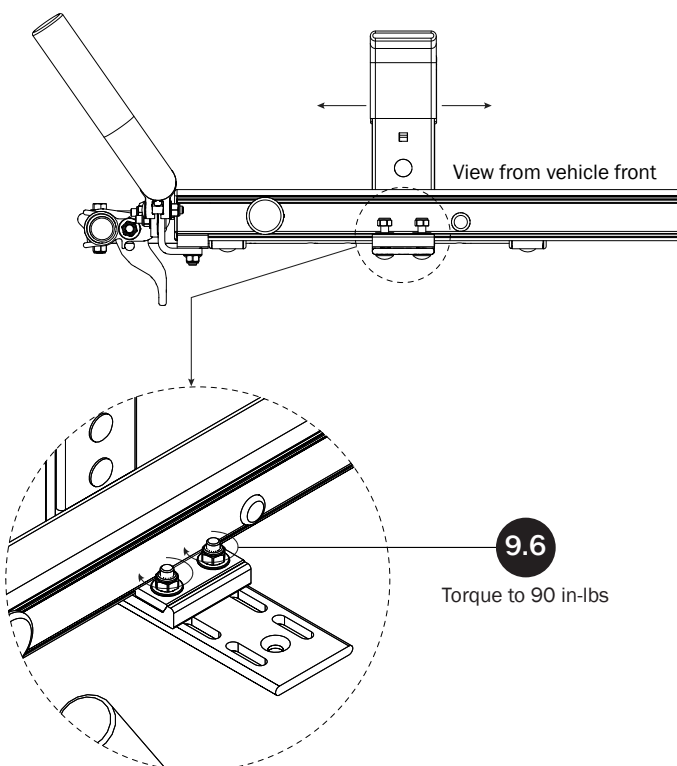
- 9.4** Reassemble the Front Clamp Down Tube Holder using the fastening hardware removed at Step 9.1. Do not tighten until Step 9.6

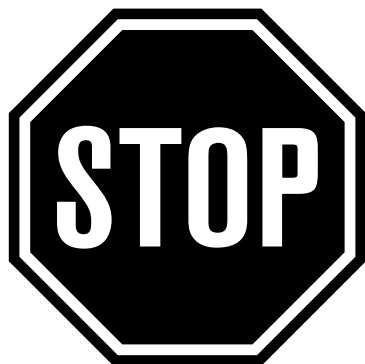


- 9.3** Place the Front Hook Clamp Bracket removed in Step 9.1 into the lower groove of the Crossbar, and slide it on top of the Front Ladder Hook Clamp



- 9.5** Adjust the Front Hook until it aligns with the Rear Hook. Perfect alignment may not be possible in all instances, and depends upon the location of the Crossbar Mounting Brackets. If such interference should occur, align the Hook as close as possible.





NOTE: This completes the right hand assembling of FEA-0008. To assemble the left side Clamp Down, proceed to Steps 0.3–0.11 on pages 13 & 14 of this 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.

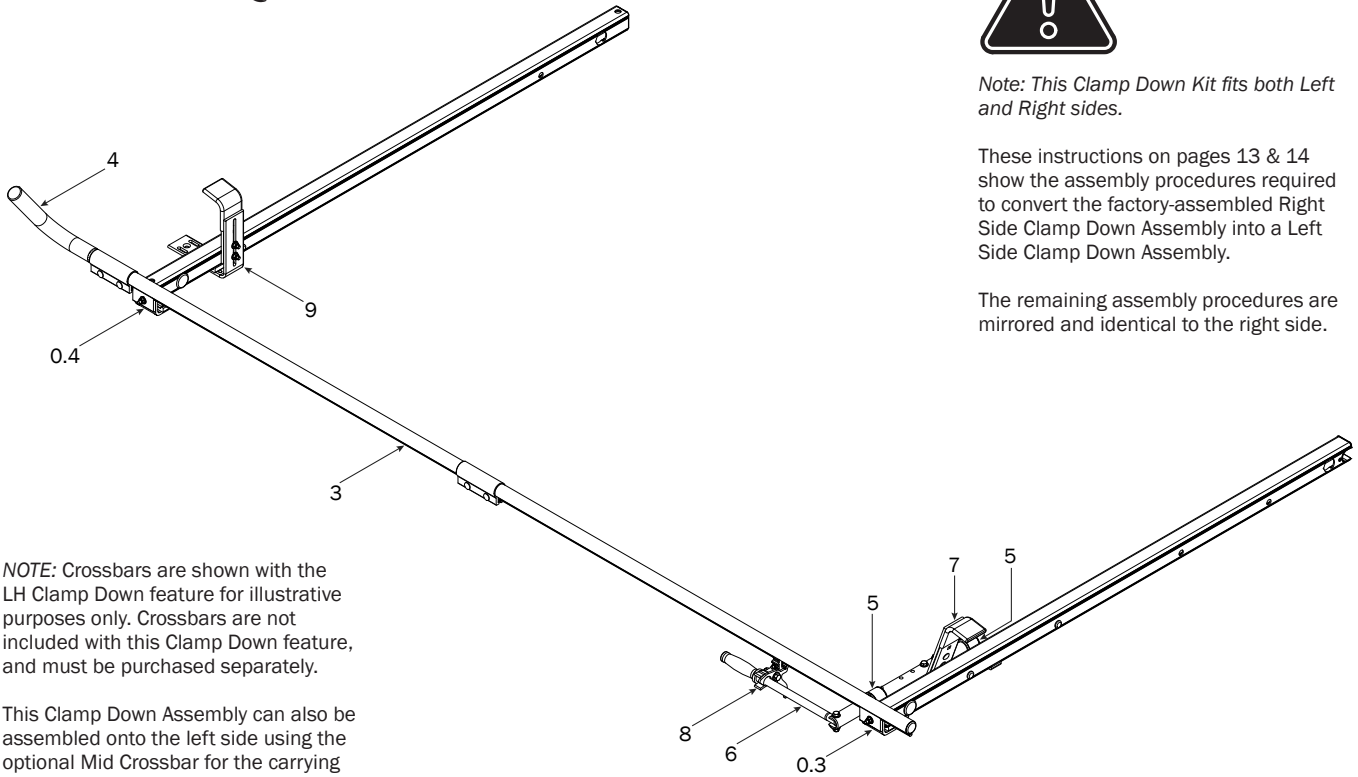
LEFT CLAMP DOWN ASSEMBLY SEQUENCE



Note: This Clamp Down Kit fits both Left and Right sides.

These instructions on pages 13 & 14 show the assembly procedures required to convert the factory-assembled Right Side Clamp Down Assembly into a Left Side Clamp Down Assembly.

The remaining assembly procedures are mirrored and identical to the right side.

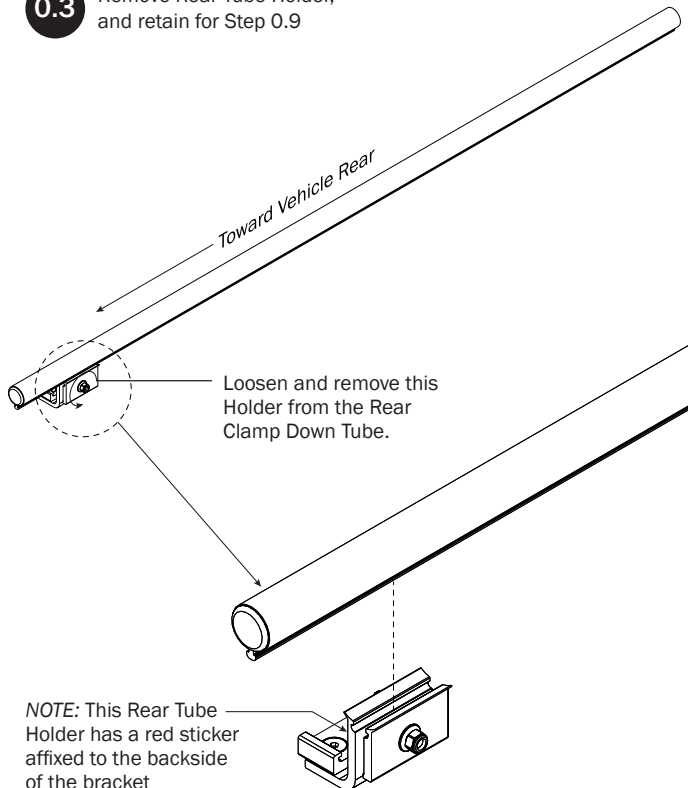


NOTE: Crossbars are shown with the LH Clamp Down feature for illustrative purposes only. Crossbars are not included with this Clamp Down feature, and must be purchased separately.

This Clamp Down Assembly can also be assembled onto the left side using the optional Mid Crossbar for the carrying of step ladders. See page 4 for details on how to configure according to your Crossbar spacing.

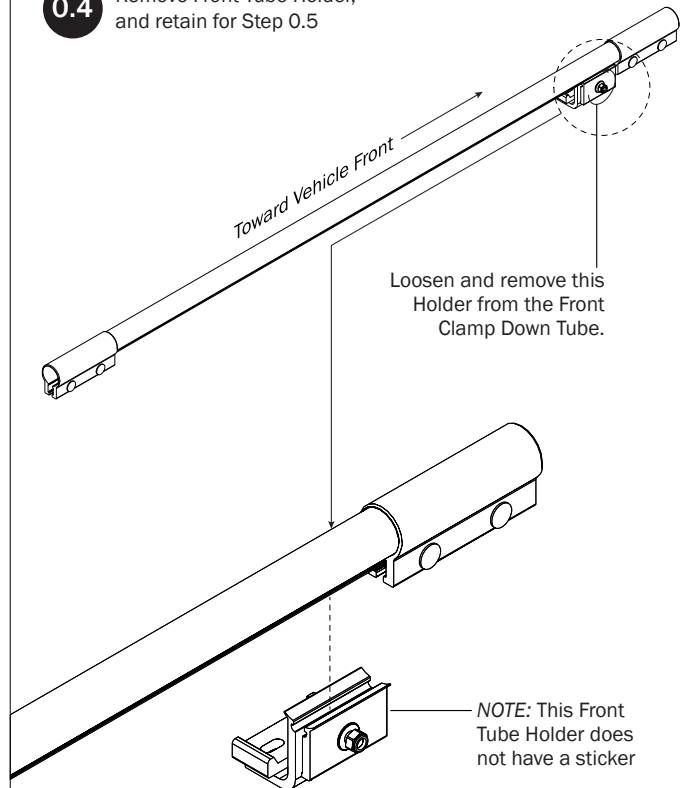
REAR CLAMP DOWN TUBE HOLDER

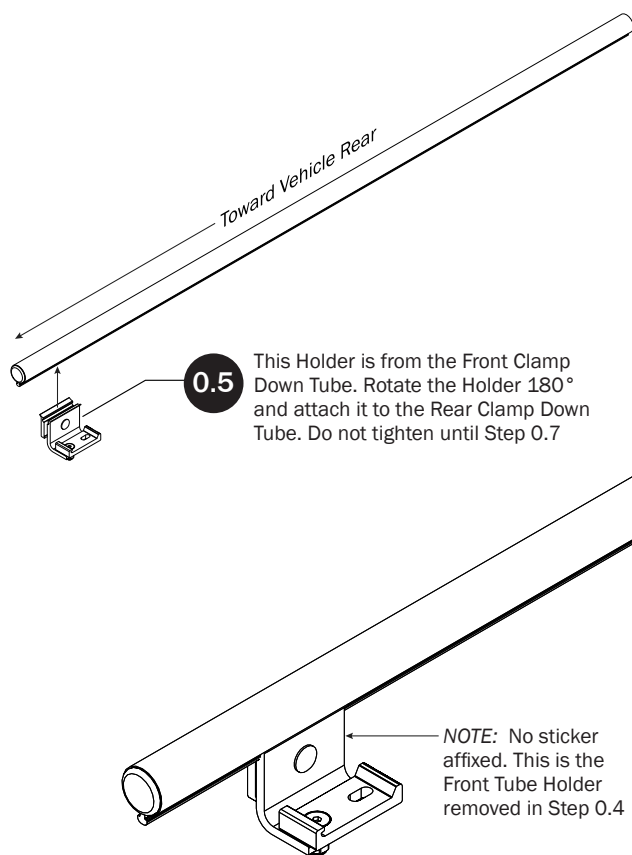
- 0.3** Remove Rear Tube Holder, and retain for Step 0.9



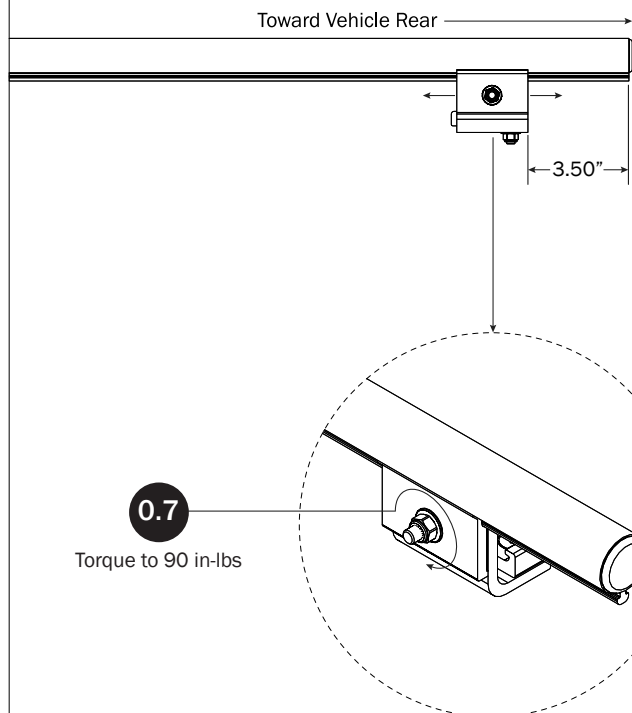
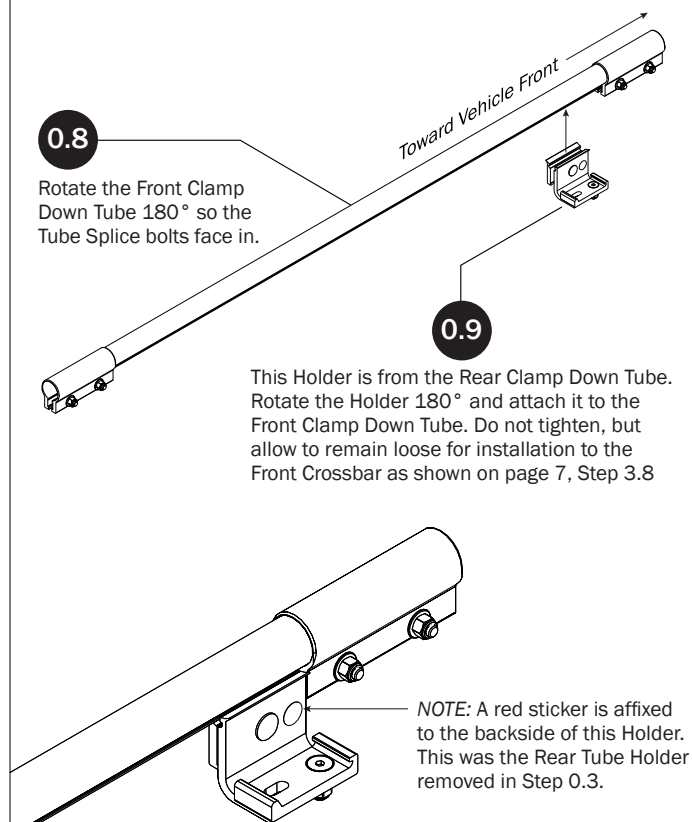
FRONT CLAMP DOWN TUBE HOLDER

- 0.4** Remove Front Tube Holder, and retain for Step 0.5

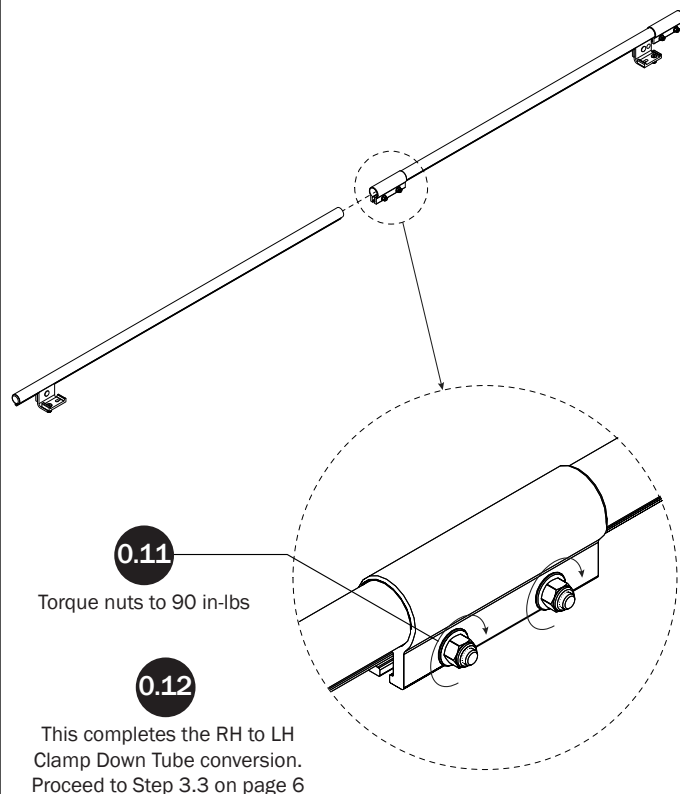


REAR CLAMP DOWN TUBE HOLDER**0.6**

Position the Rear Tube Holder to the dimension shown below

**FRONT CLAMP DOWN TUBE HOLDER****CLAMP DOWN TUBE ASSEMBLY****0.10**

Insert the Rear Clamp Down Tube into the Tube Splice. Ensure the front of the Rear Clamp Down Tube is fully seated into the Splice before proceeding to Step 0.11



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