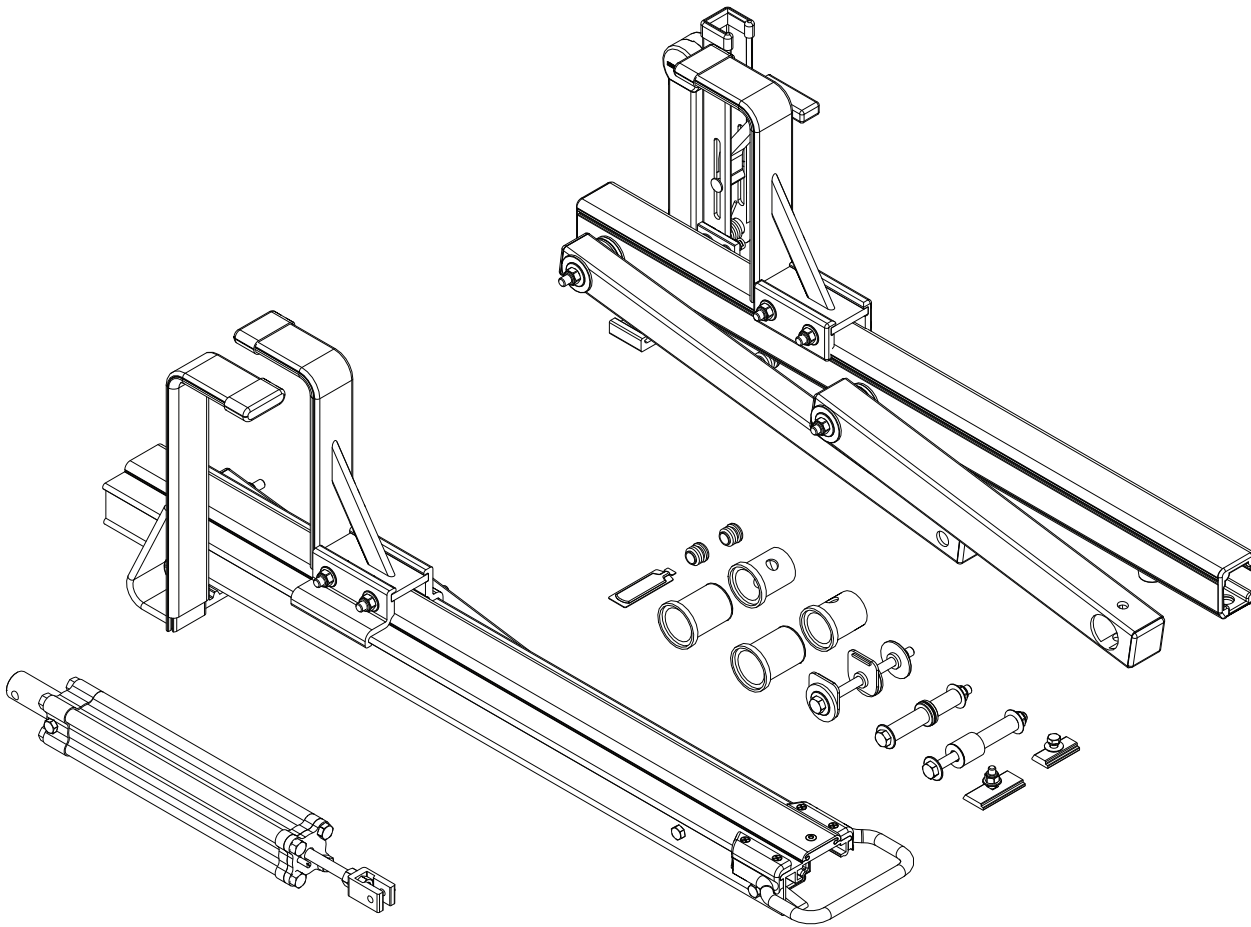


# PRIME DESIGN™

A Safe Fleet Brand



## *RIGHT SIDE SLIDE ROTATION KIT*

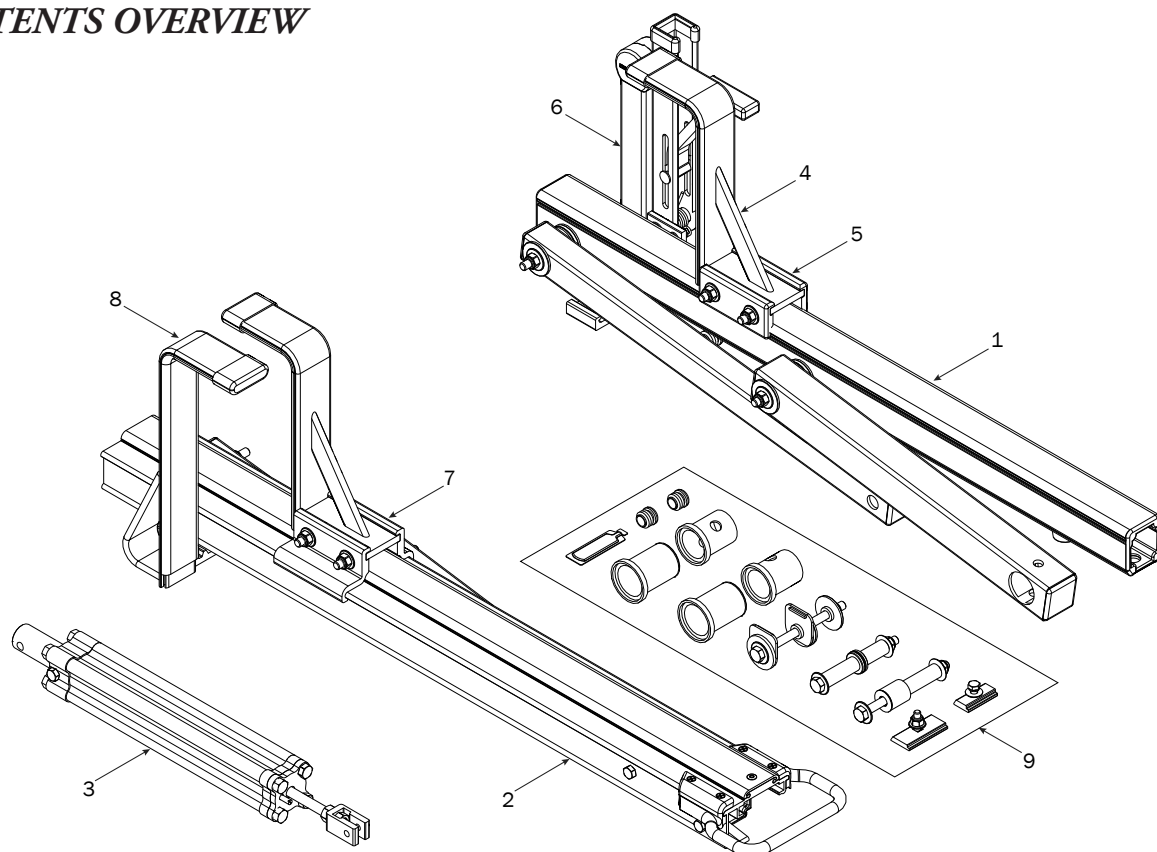
PRIME DESIGN, A SAFE FLEET BRAND

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

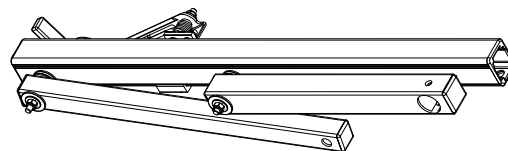
Fax: 651-552-1799 • Email: [info@primedesign.net](mailto:info@primedesign.net) • Website: [www.primedesign.net](http://www.primedesign.net)

# FEA0003

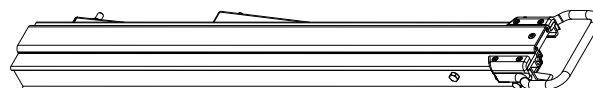
## CONTENTS OVERVIEW



1—Right Front Rotation Assembly ..... (Qty 1)



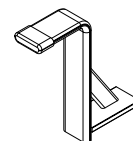
2—Right Rear Slide Rotation Assembly ..... (Qty 1)



3—Cylinder ..... (Qty 1)



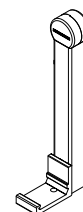
4—Z Post ..... (Qty 2)  
Adjustable, 7.25"



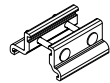
5—Z Post Mounting Clamp Assembly..... (Qty 1)



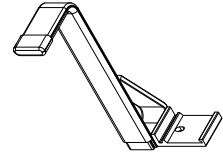
6—L Post..... (Qty 1)  
With Roller Cap, 9.25"



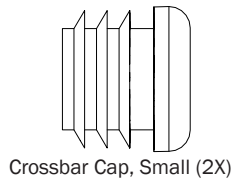
7—Z Post Bracket Assembly ..... (Qty 1)  
Adjustable, Slide



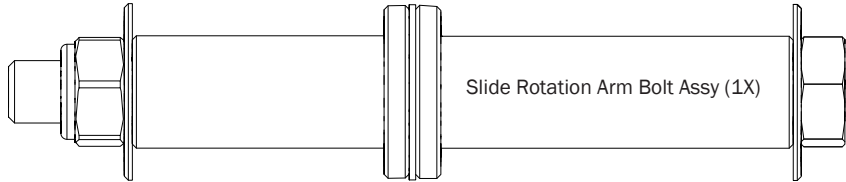
8—Z Post..... (Qty 1)  
Adjustable Slide, 7.25"



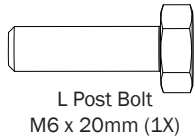
9—HKT-8400..... (Qty 1)  
Modular Rotation Hardware Kit, Slide



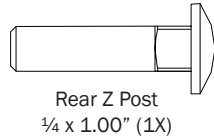
Crossbar Cap, Small (2X)



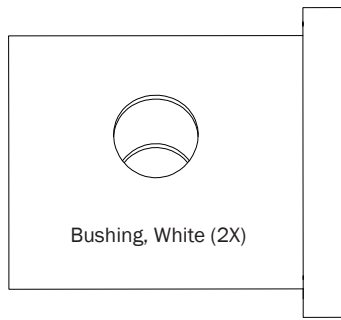
Slide Rotation Arm Bolt Assy (1X)



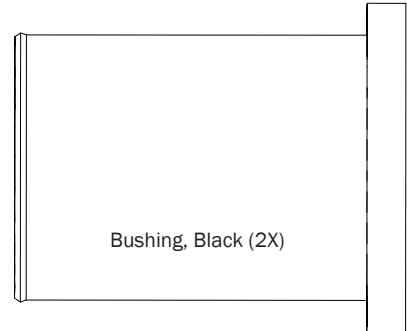
L Post Bolt  
M6 x 20mm (1X)



Rear Z Post  
1/4 x 1.00" (1X)



Bushing, White (2X)



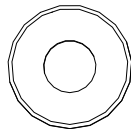
Bushing, Black (2X)



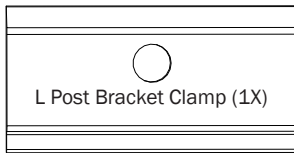
Rear Z Post  
1/4 Lock Nut (1X)



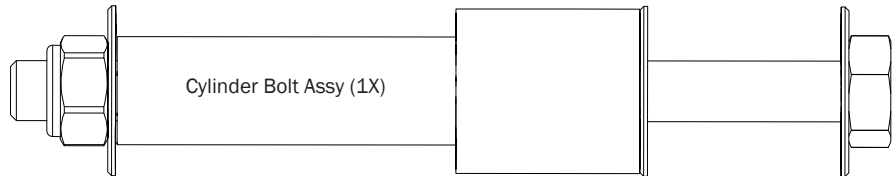
L Post  
Lock Washer (1X)



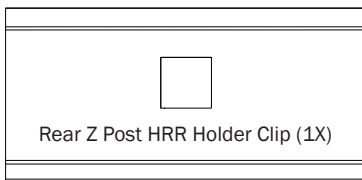
L Post Flat Washer (2X)



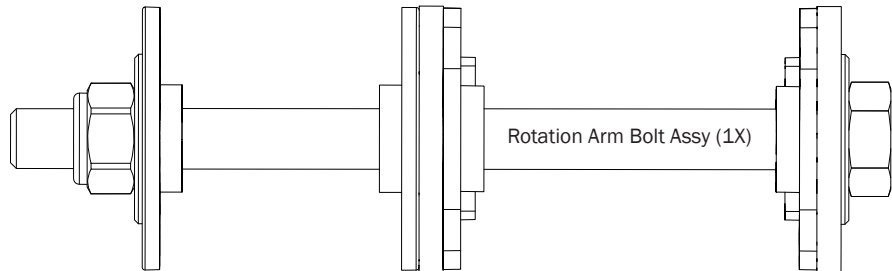
L Post Bracket Clamp (1X)



Cylinder Bolt Assy (1X)

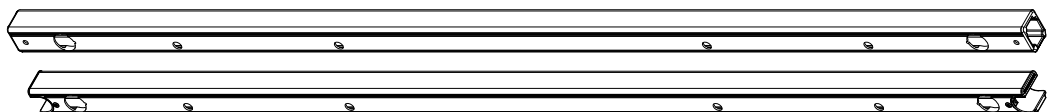


Rear Z Post HRR Holder Clip (1X)

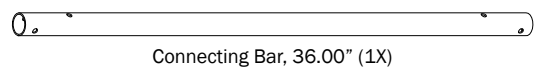


Rotation Arm Bolt Assy (1X)

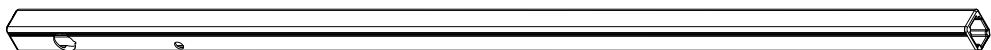
10—Crossbars (not shown on pg 2) ..... (Qty 1)  
Ordered separately, Front & Rear, Gen 4



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



Connecting Bar, 36.00" (1X)

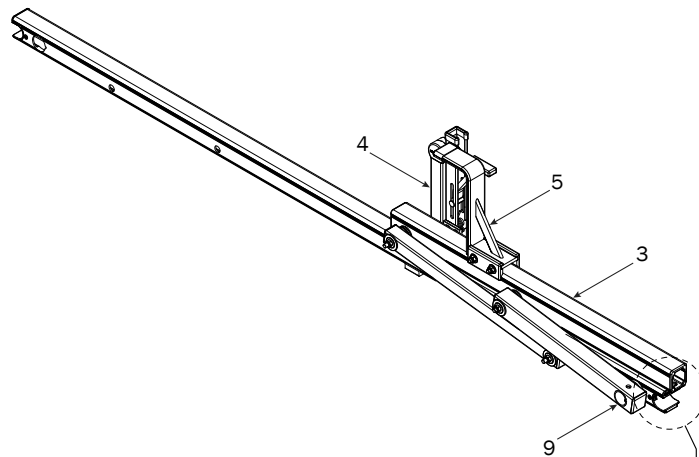
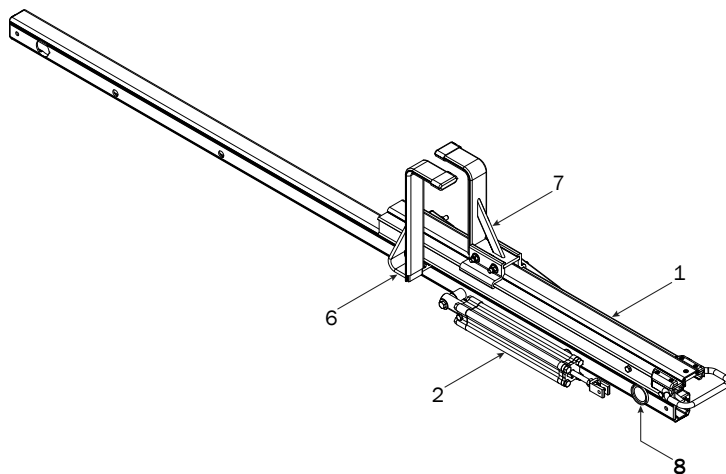


\*NOTE: This module is an optional purchase according to your vehicle configuration.

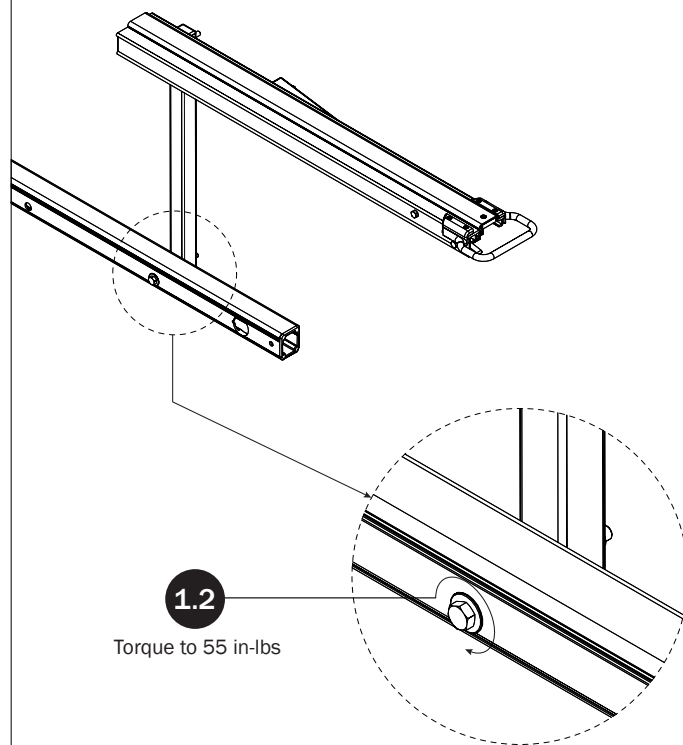
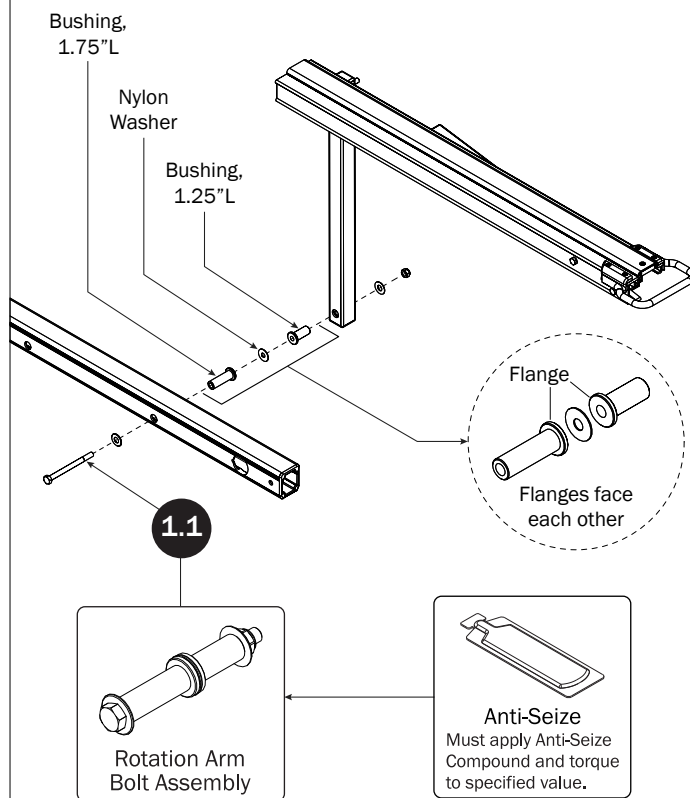
**ROTATION ASSEMBLY SEQUENCE**

*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.

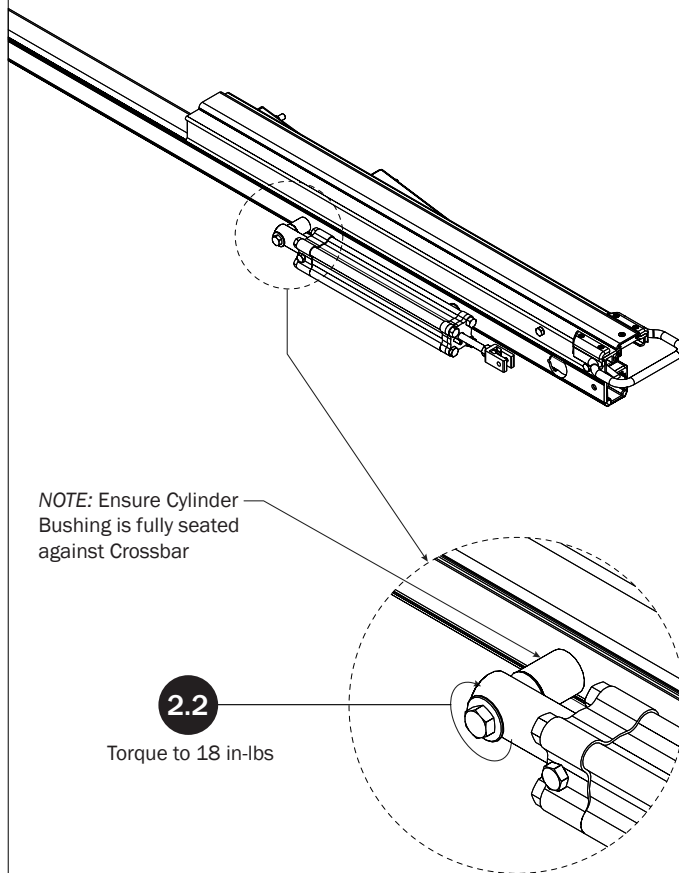
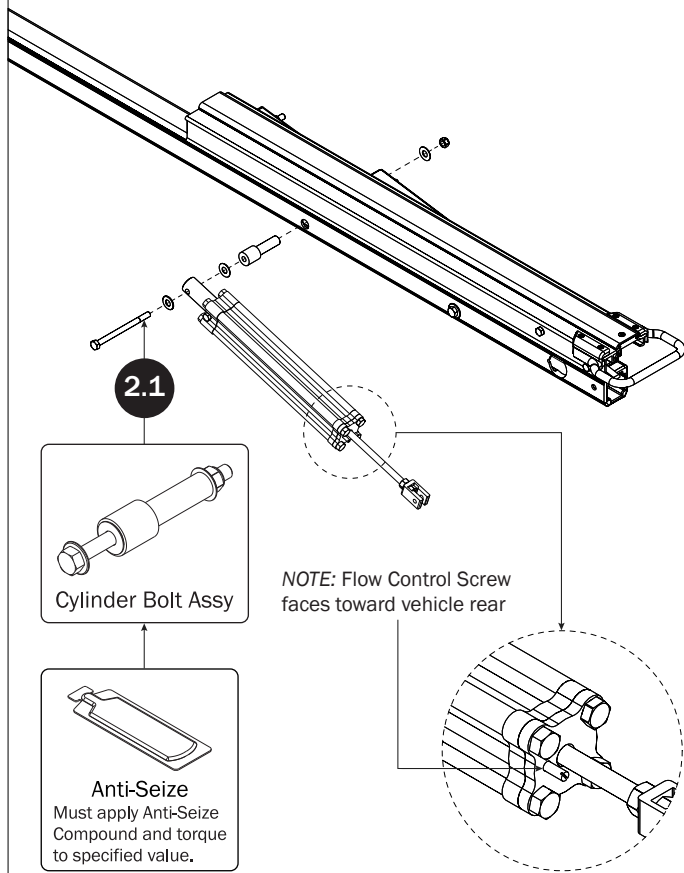
*Note:* This Rotation Kit fits only on the right side. Refer to FEA-0004 for left side Slide Rotation assembly instructions.



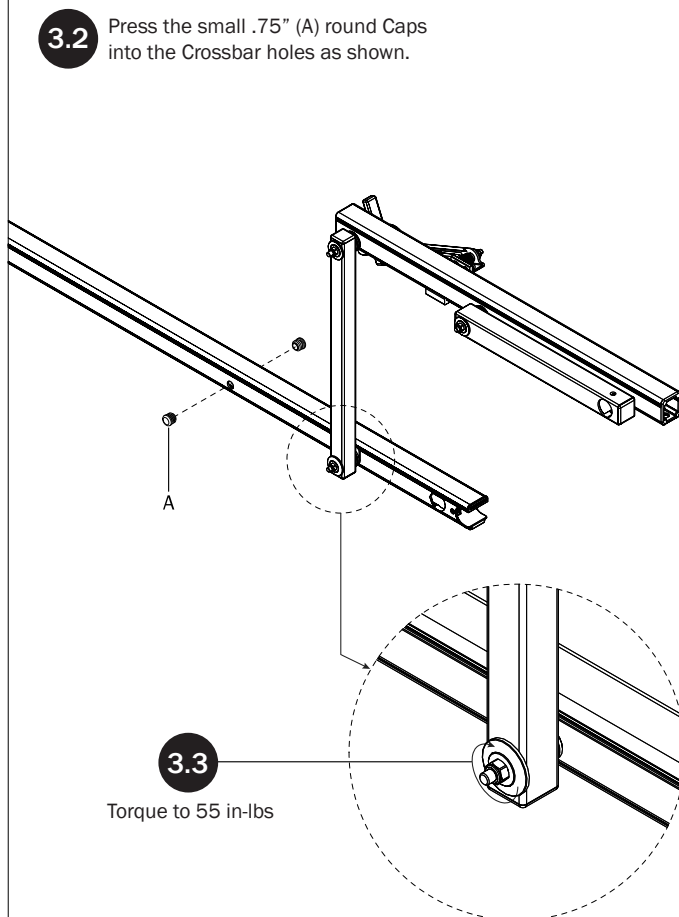
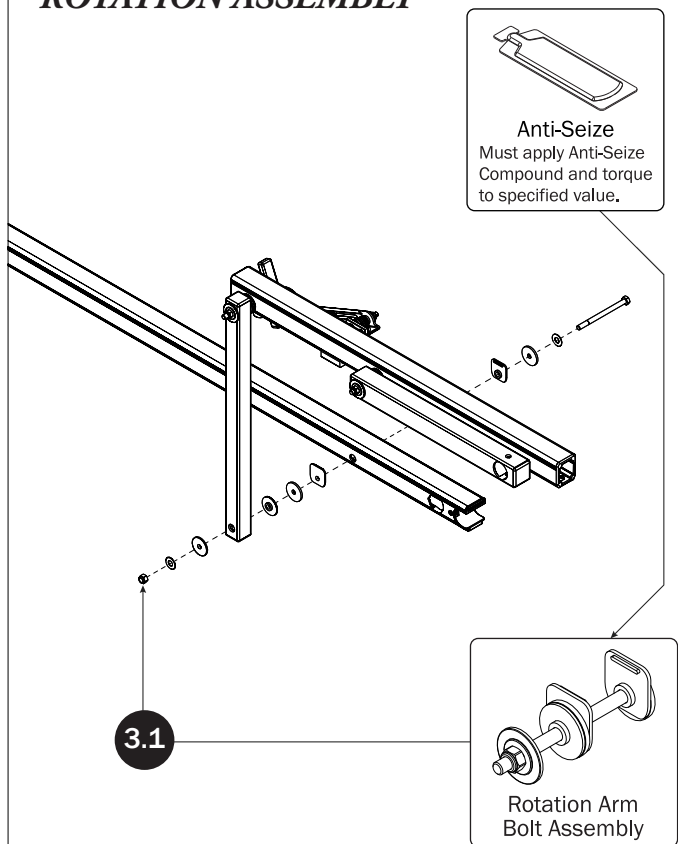
Interlocking Crossbar is used in the front position for all High Roof models.

**REAR CROSSBAR  
ROTATION ASSEMBLY**

## CYLINDER HARDWARE

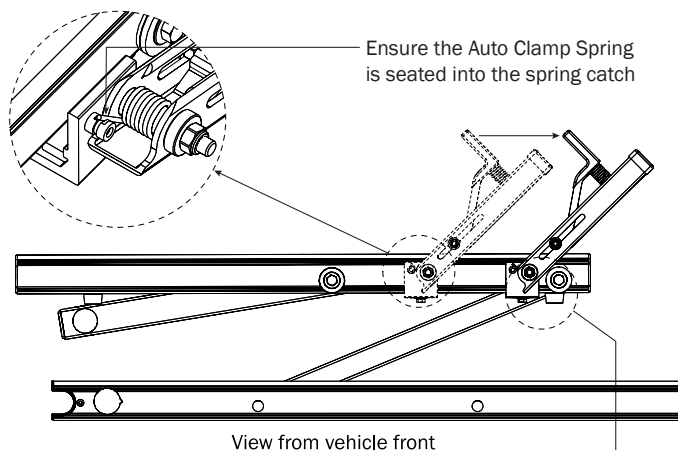


## FRONT CROSSBAR ROTATION ASSEMBLY

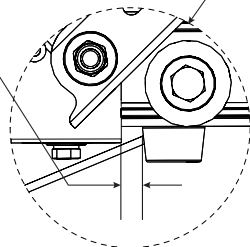


**L POSTS****SEE QUICK START GUIDE FOR ADJUSTMENTS**

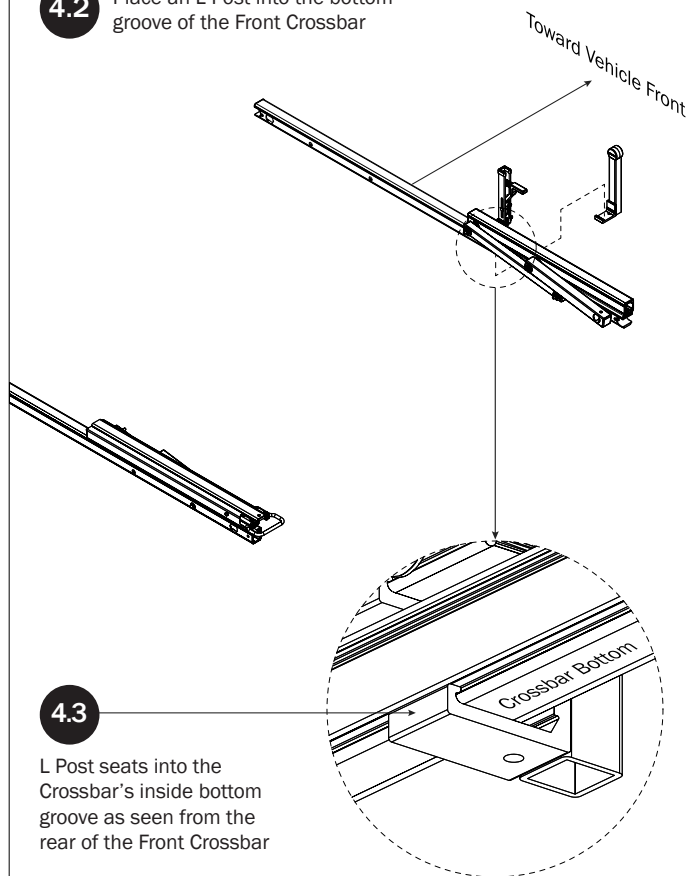
**NOTE:** The front Auto Clamp come preset from the factory for packaging purposes only. To assemble the L Post to the Crossbar, the Auto Clamps must be repositioned.



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.

**4.1****4.2**

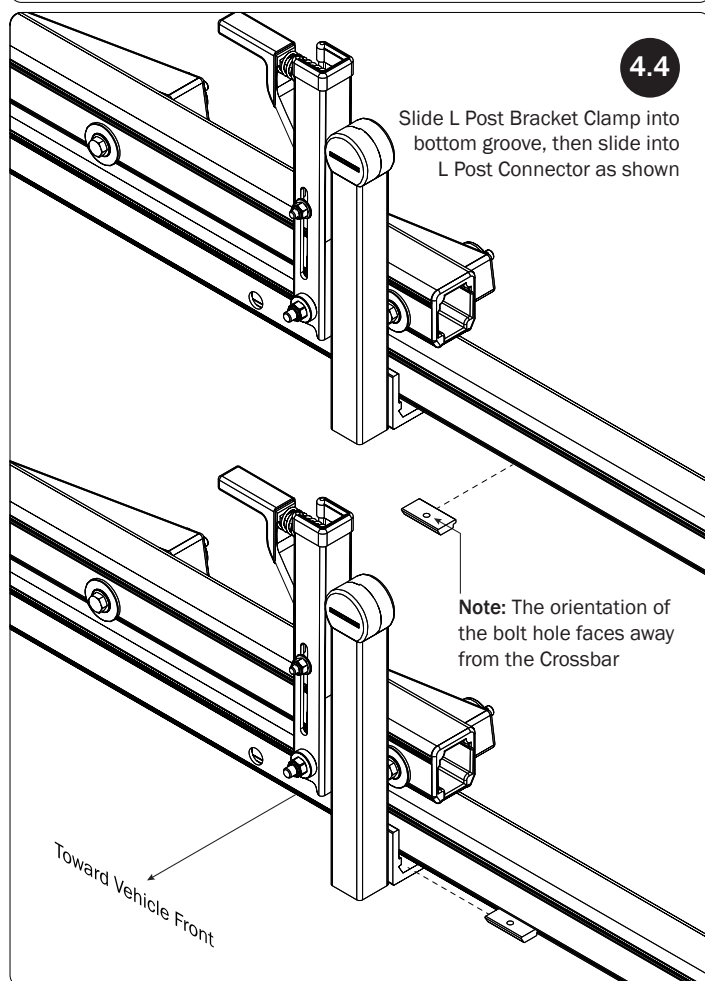
Place an L Post into the bottom groove of the Front Crossbar

**4.3**

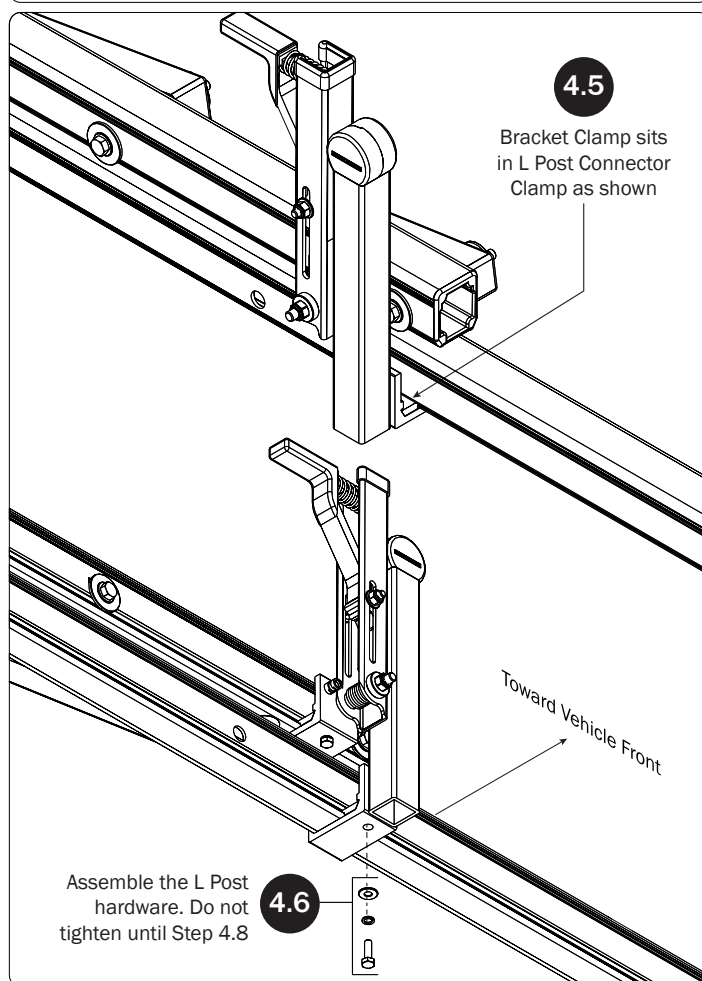
L Post seats into the Crossbar's inside bottom groove as seen from the rear of the Front Crossbar

**4.4**

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

**4.5**

Bracket Clamp sits in L Post Connector Clamp as shown



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

**4.6**



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

Torque to 80 in-lbs

4.8

Toward Vehicle Front

**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

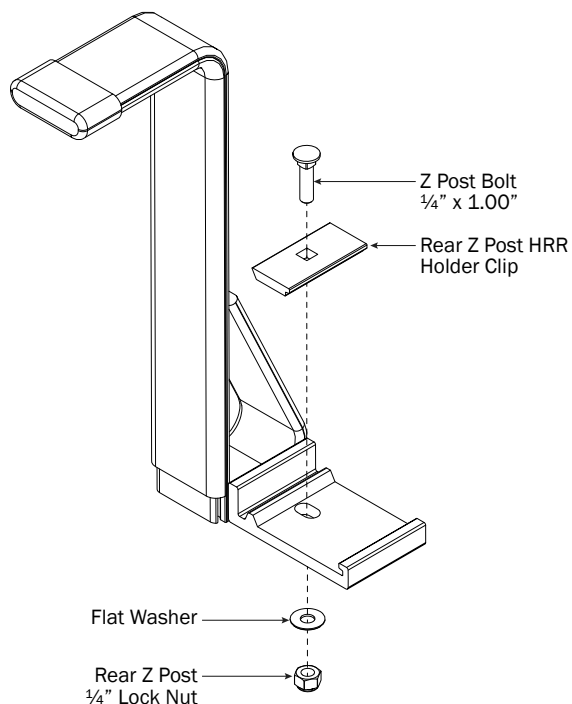
5.2

Slide the Z Post into the Mounting Clamp Assembly

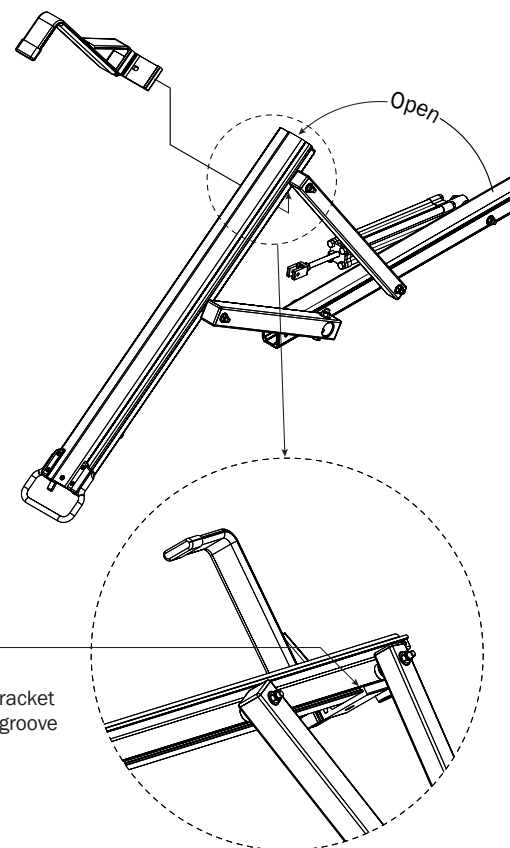
The Z Post fully seats into the top slot of the Mounting Clamps

## 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

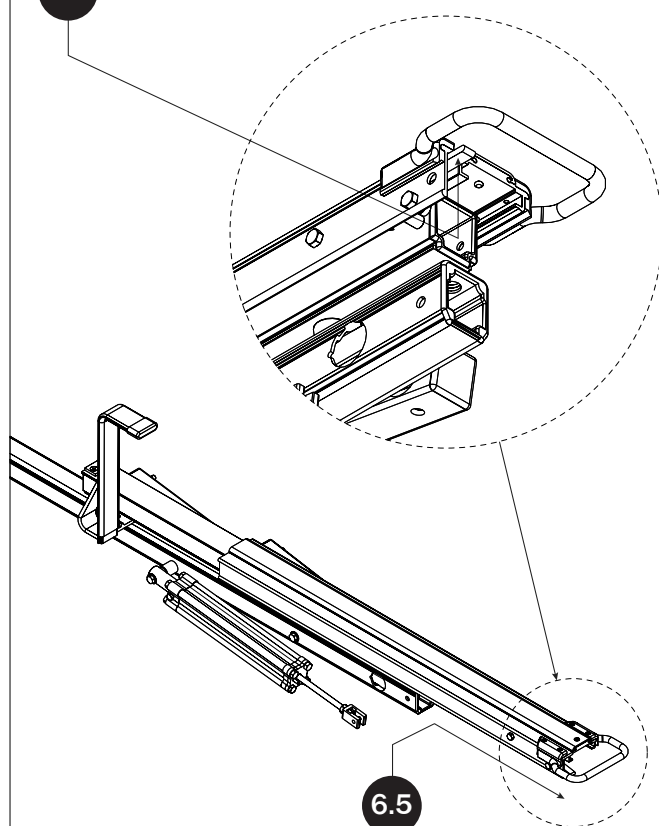


- 6.2** Place Slide Z Post into bottom of Rear Slide Upper



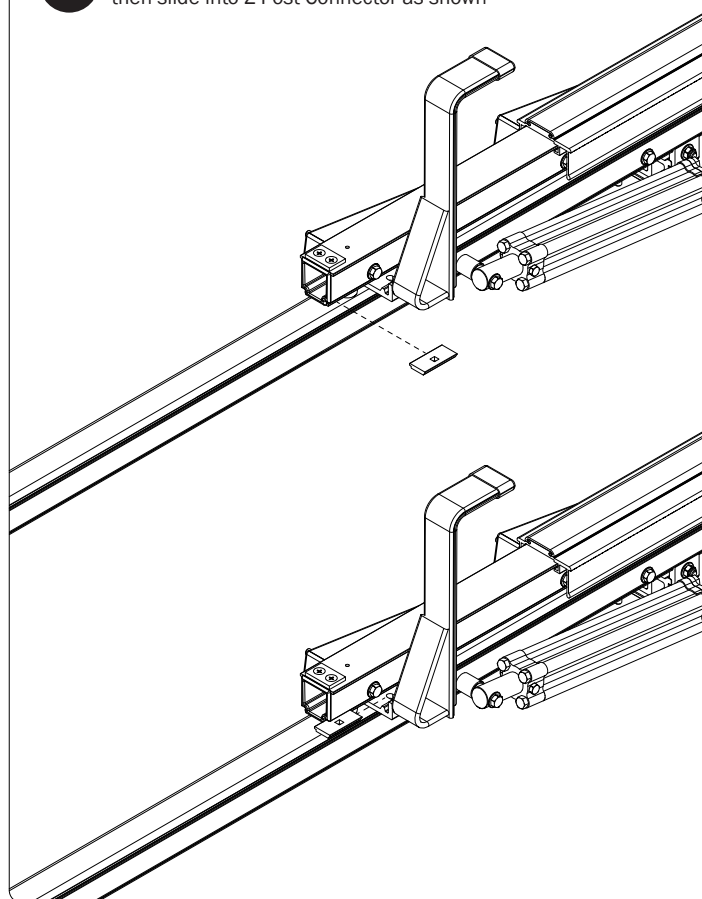
- 6.3** Fit Slide Z Post Bracket Clamp into Slide groove

- 6.4** Press Slide Release Lever upward



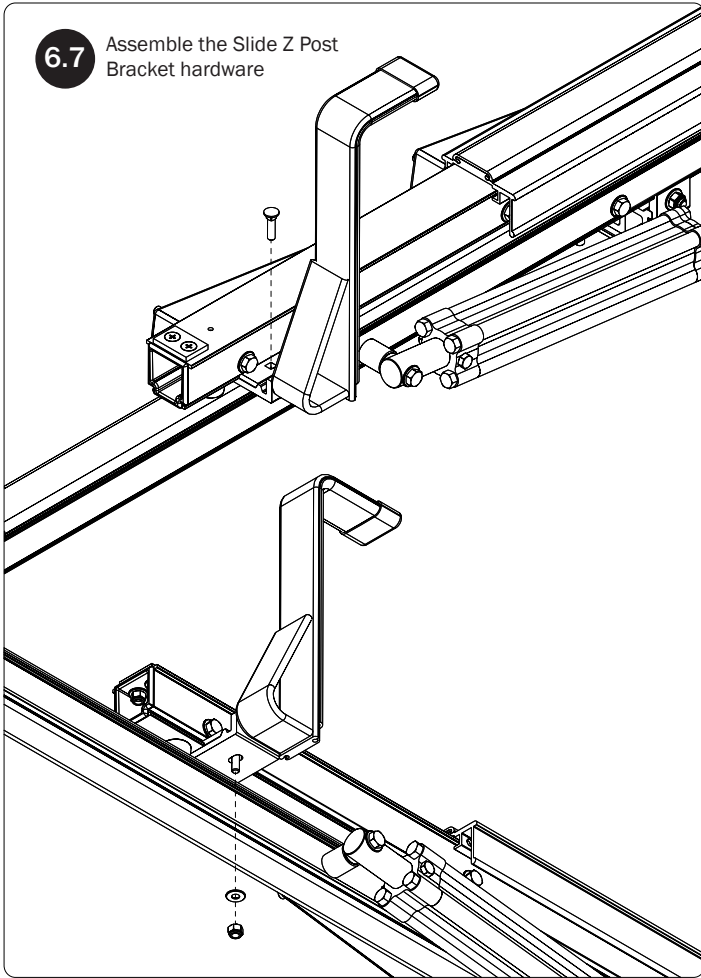
- 6.5** Extend Slide Upper

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

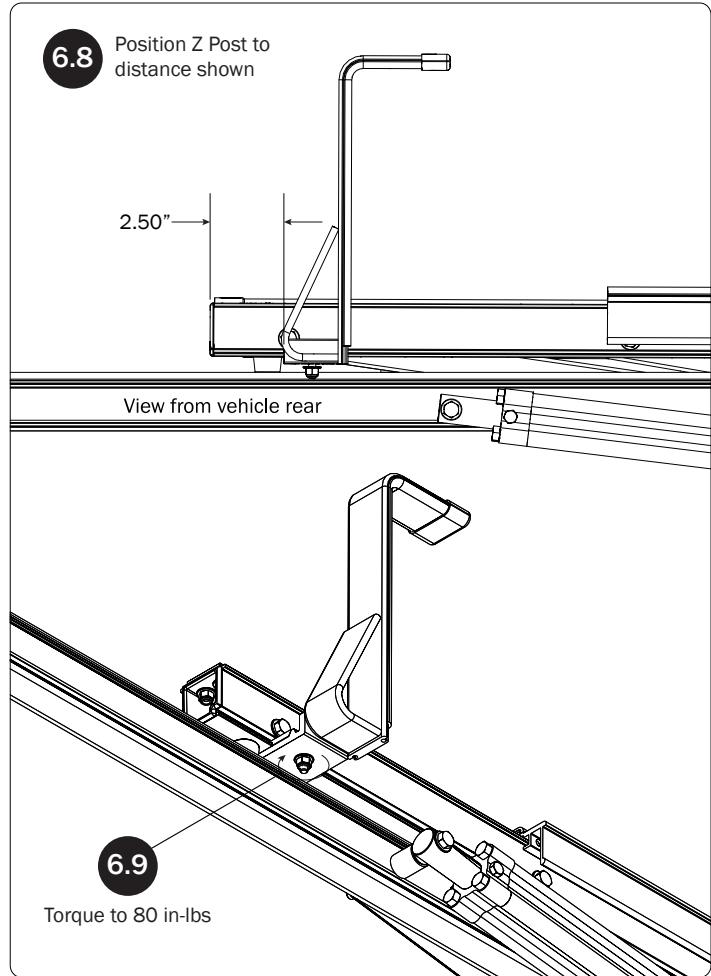




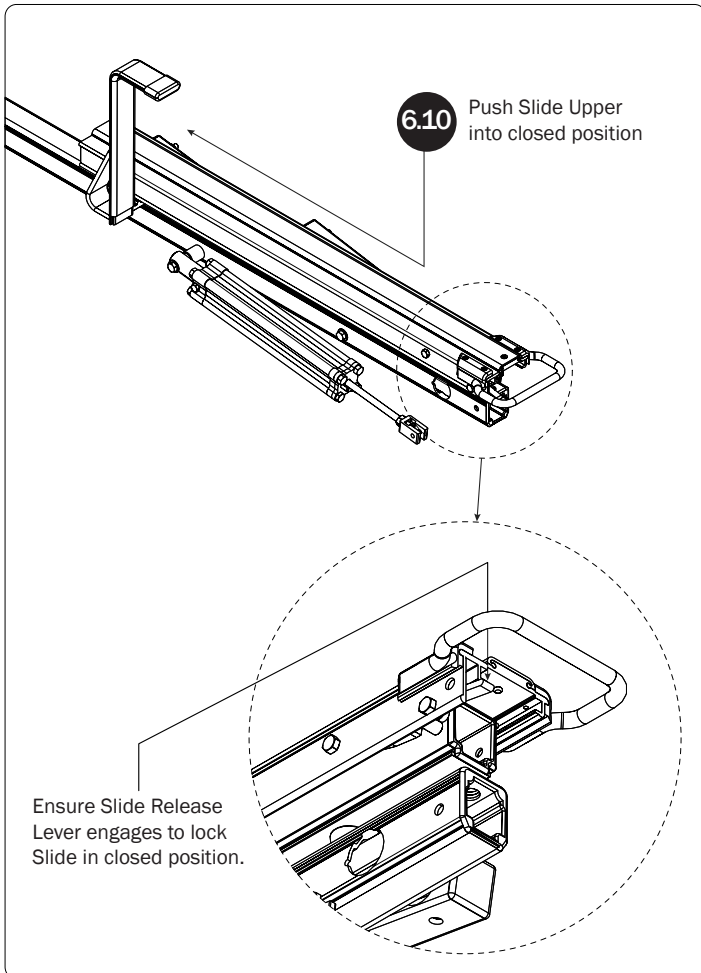
### 6.7 Assemble the Slide Z Post Bracket hardware



### 6.8 Position Z Post to distance shown

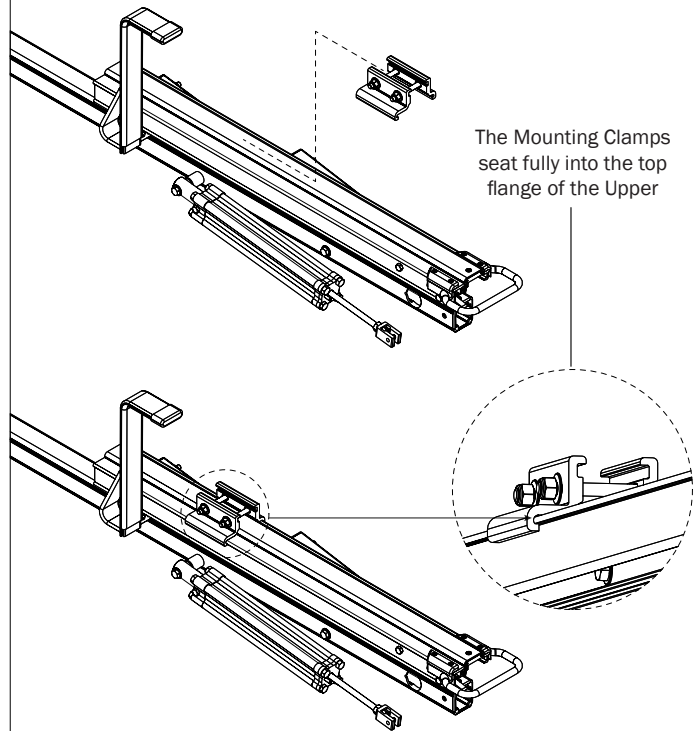


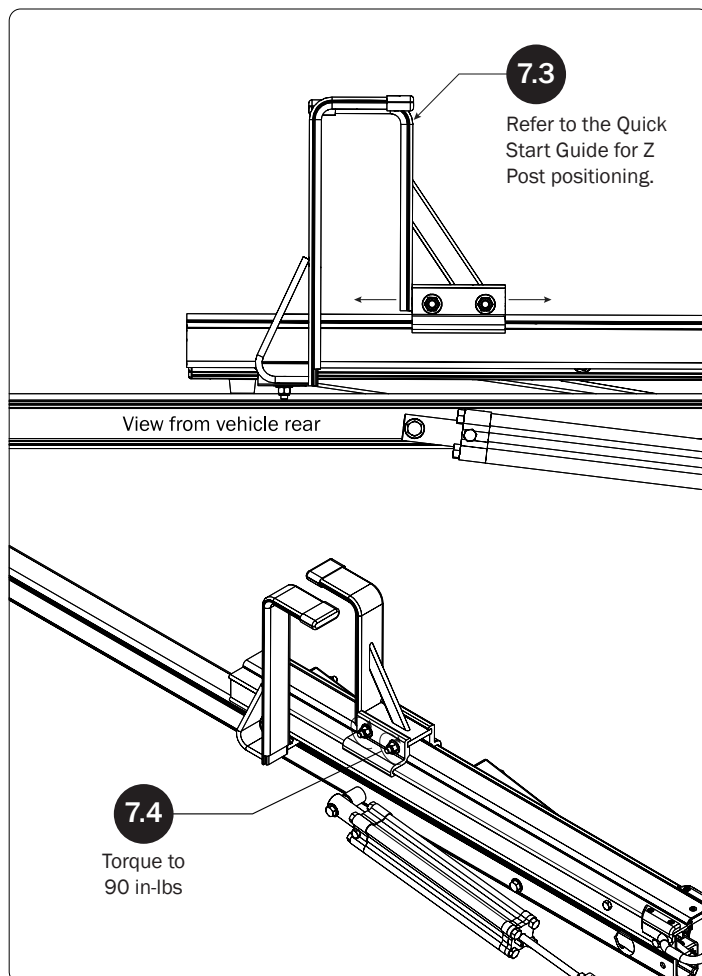
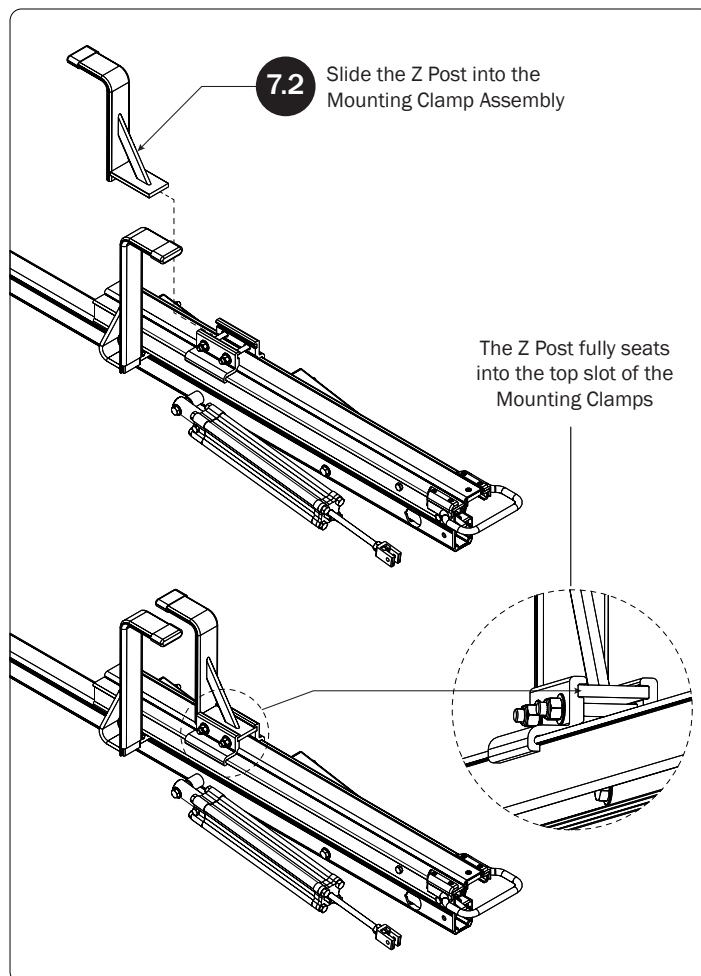
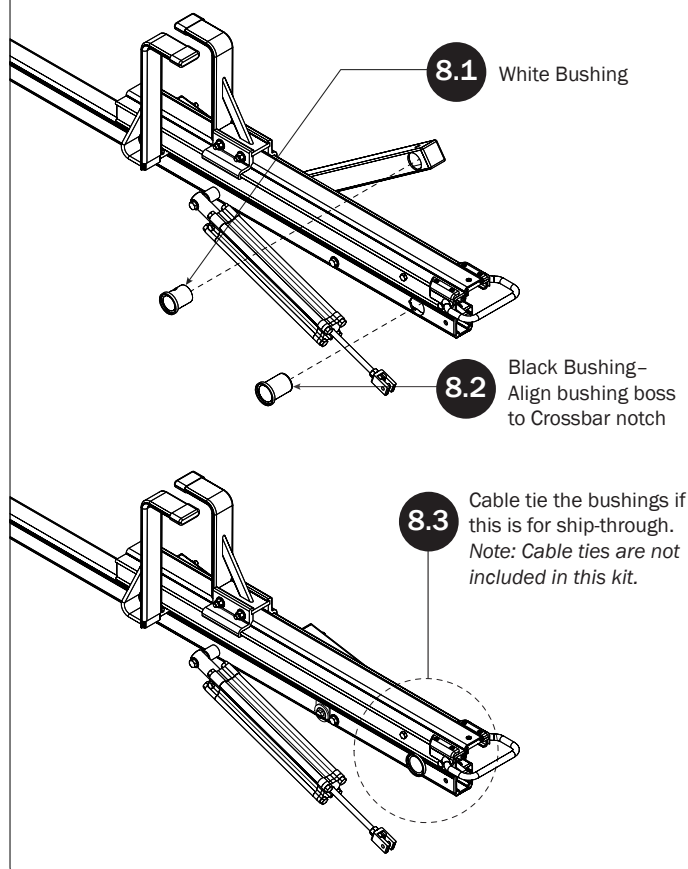
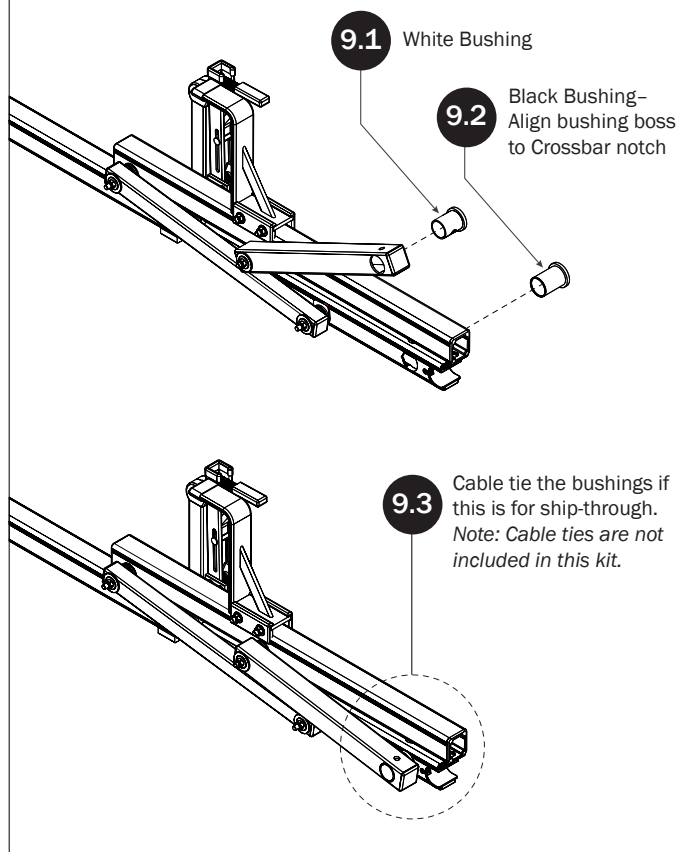
### 6.10 Push Slide Upper into closed position

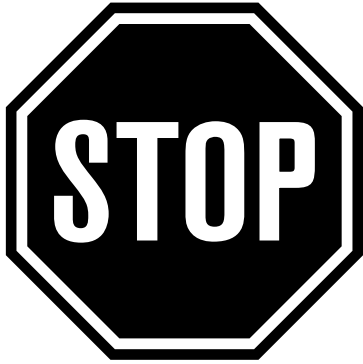


## SLIDE TOP Z POST SEE QUICK START GUIDE FOR ADJUSTMENTS

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



**REAR ROTATION BUSHINGS****FRONT ROTATION BUSHINGS**



**NOTE:** This completes the installation of FEA-0003. For left side Slide Rotation installation, refer to the FEA-0004 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.

