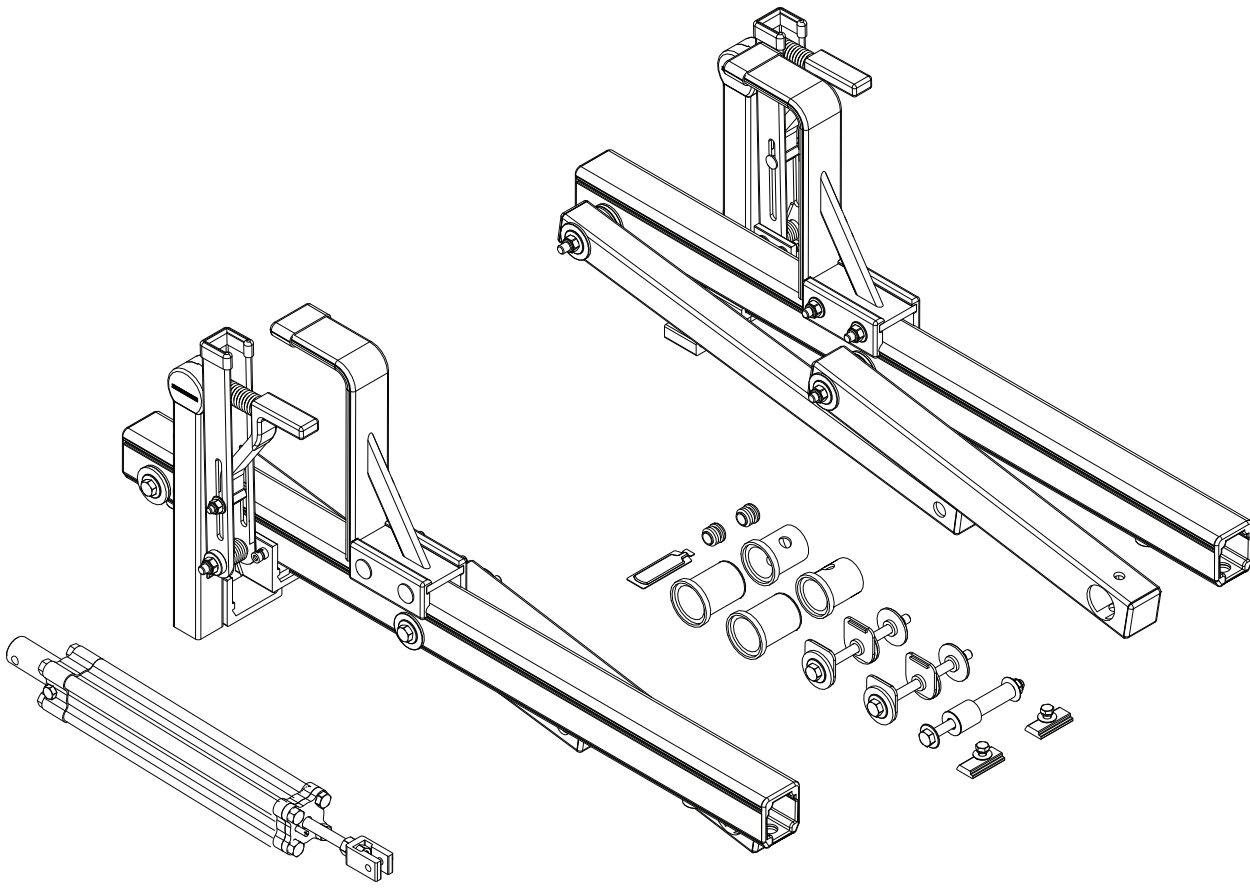


PRIME DESIGN™

A Safe Fleet Brand



FEA0002

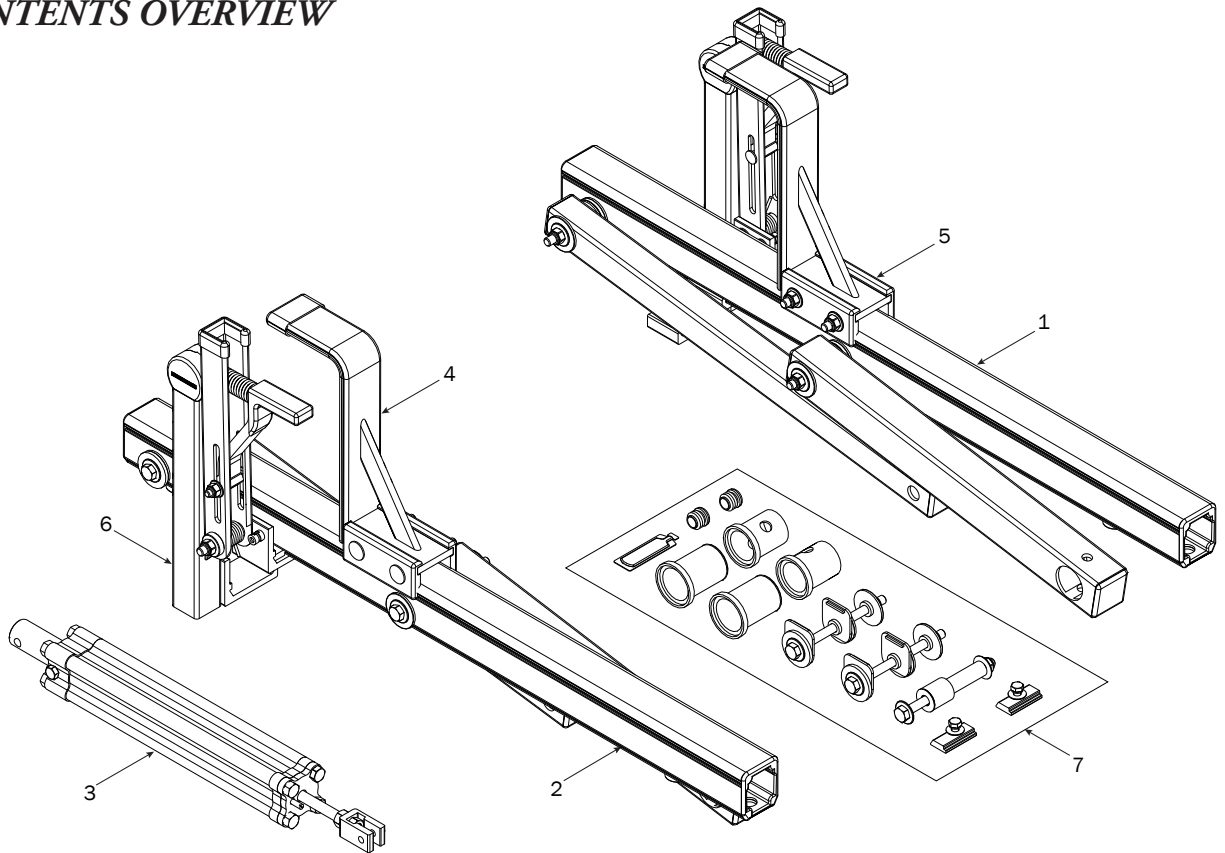
STANDARD ROTATION KIT

PRIME DESIGN, A SAFE FLEET BRAND

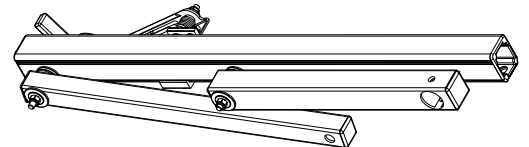
Address: 580 Opperman Drive, Eagan, MN 55123 • Toll Free: 1.8.PRIME.RACK

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

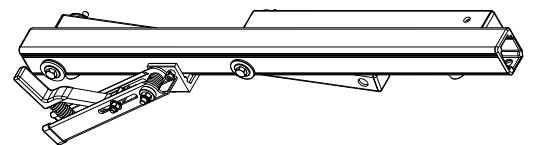
CONTENTS OVERVIEW



1—Right Front/Left Rear Rotation Assembly..... (Qty 1)



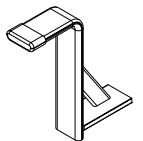
2—Right Rear/Left Front Rotation Assembly..... (Qty 1)



3—Cylinder..... (Qty 1)



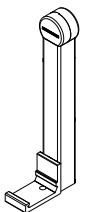
4—Z Post (Qty 2)
Adjustable, 7.25"



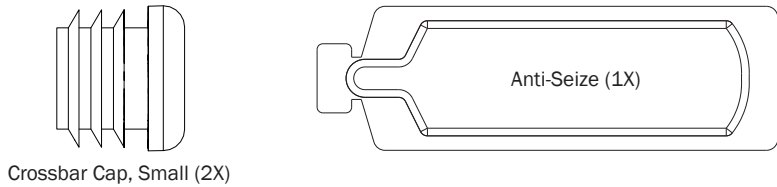
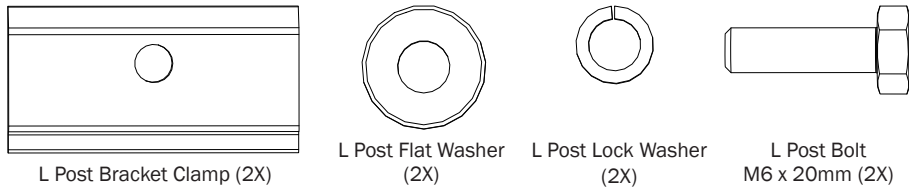
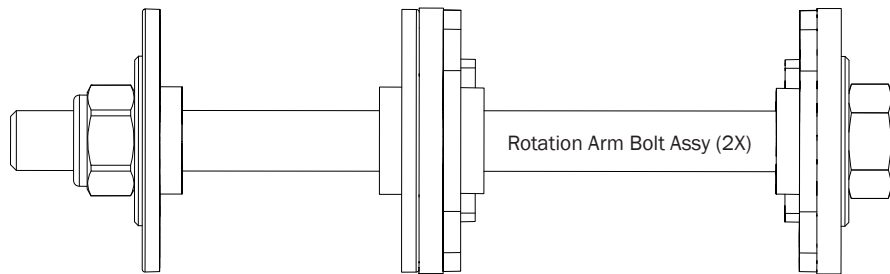
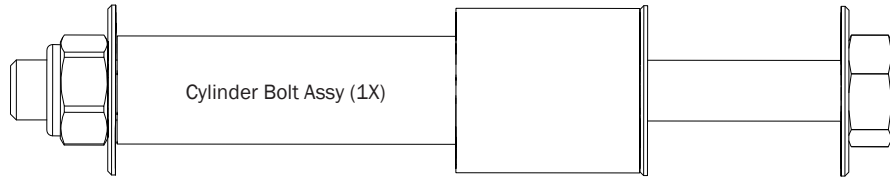
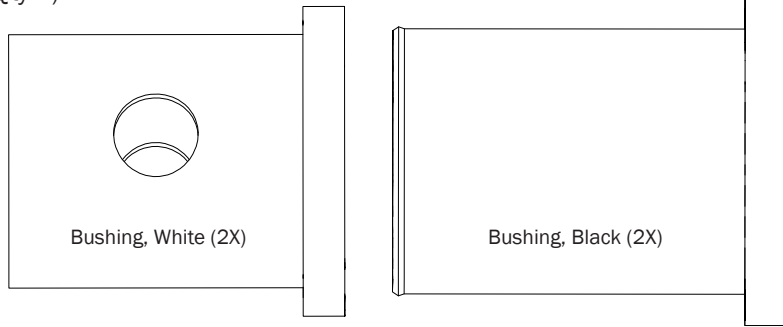
5—Z Post Mounting Clamp Assembly..... (Qty 2)



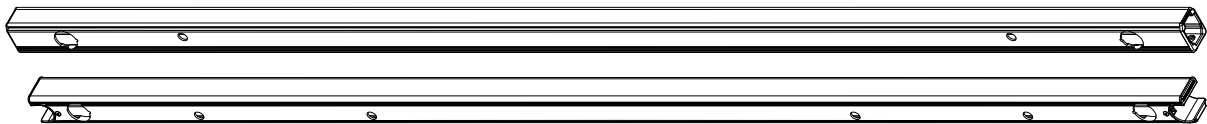
6—L Post..... (Qty 2)
With Roller Cap, 9.25"



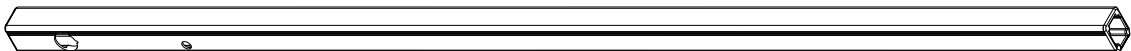
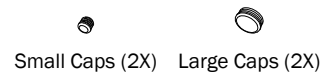
7—HKT-8401..... (Qty 1)
Modular Rotation Hardware Kit



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



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



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

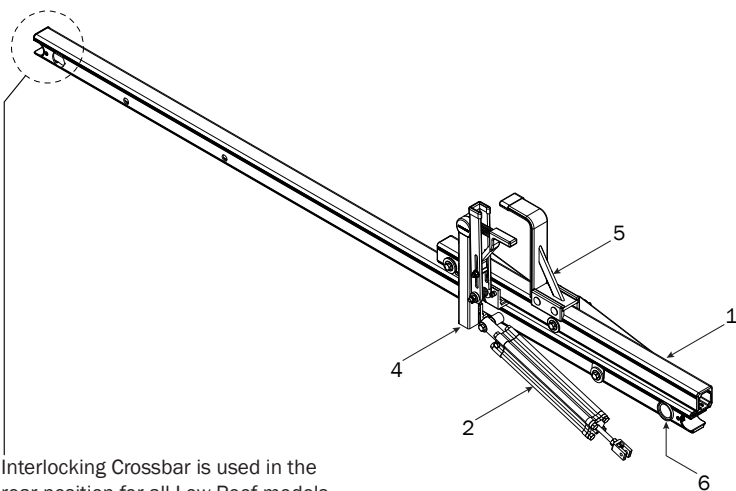
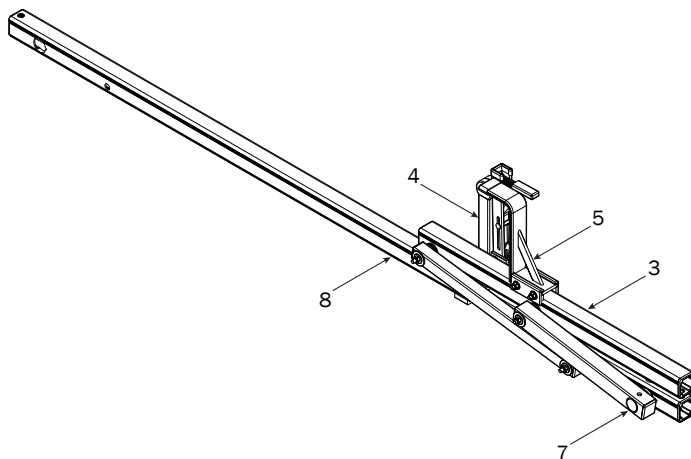
ROTATION ASSEMBLY SEQUENCE



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 both Right and Left sides.

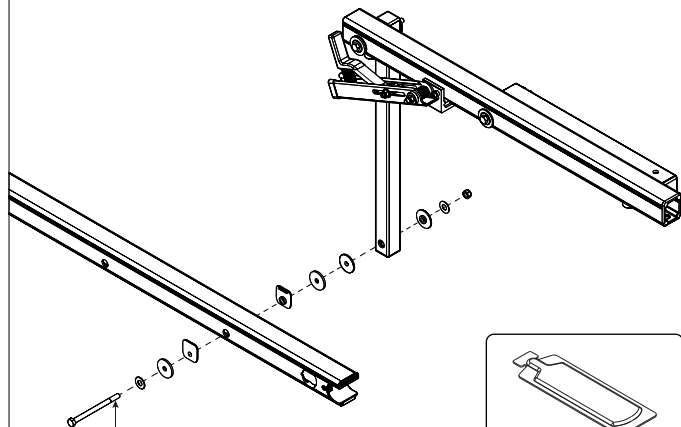
This Assembly Manual shows right side assembly procedures on Front & Rear Crossbars. Left side assembly procedures are mirrored and identical to the right side.



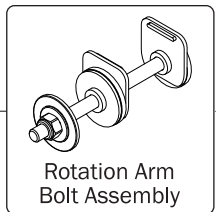
Interlocking Crossbar is used in the rear position for all Low Roof models.

REAR CROSSBAR ROTATION ASSEMBLY

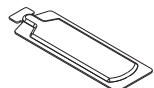
NOTE: For installation on the left side, the Rear Rotation Assembly can also be assembled to the optional Mid Crossbar for the carrying of step ladders.



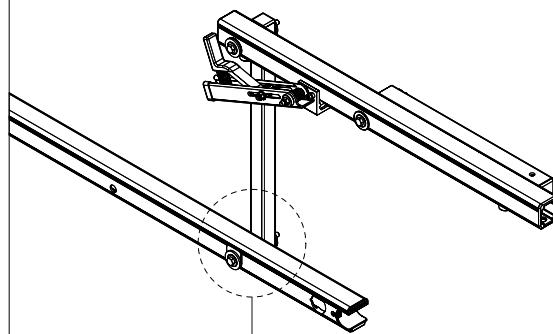
1.1



Rotation Arm Bolt Assembly

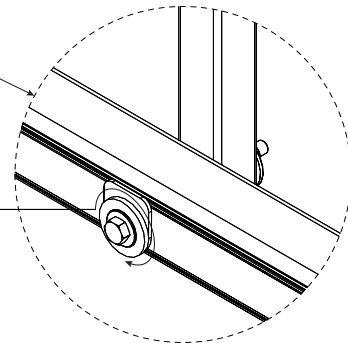


Anti-Seize
Must apply Anti-Seize Compound and torque to specified value.

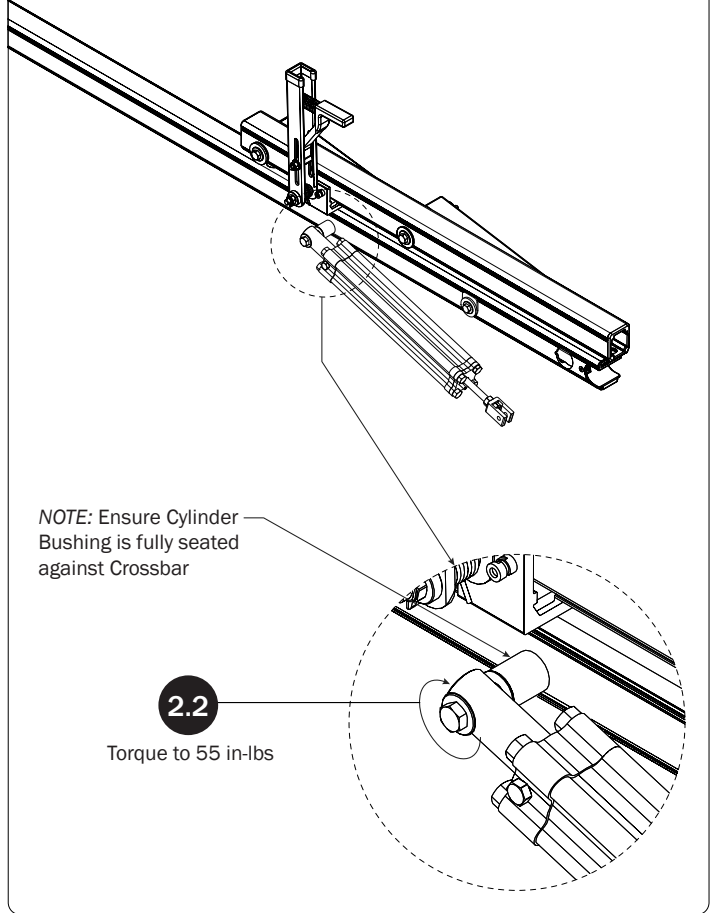
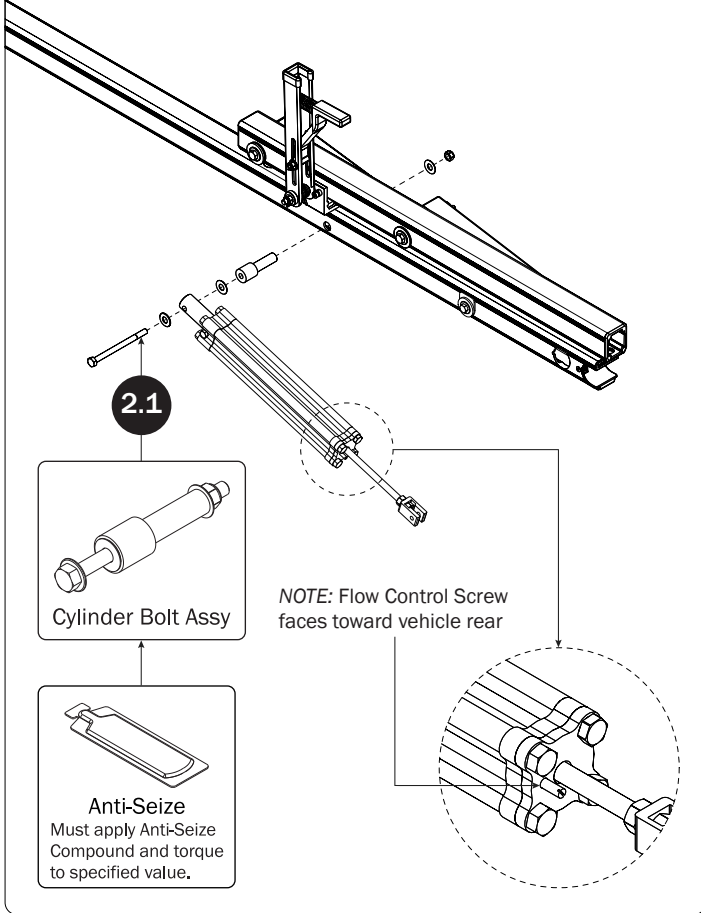


1.2

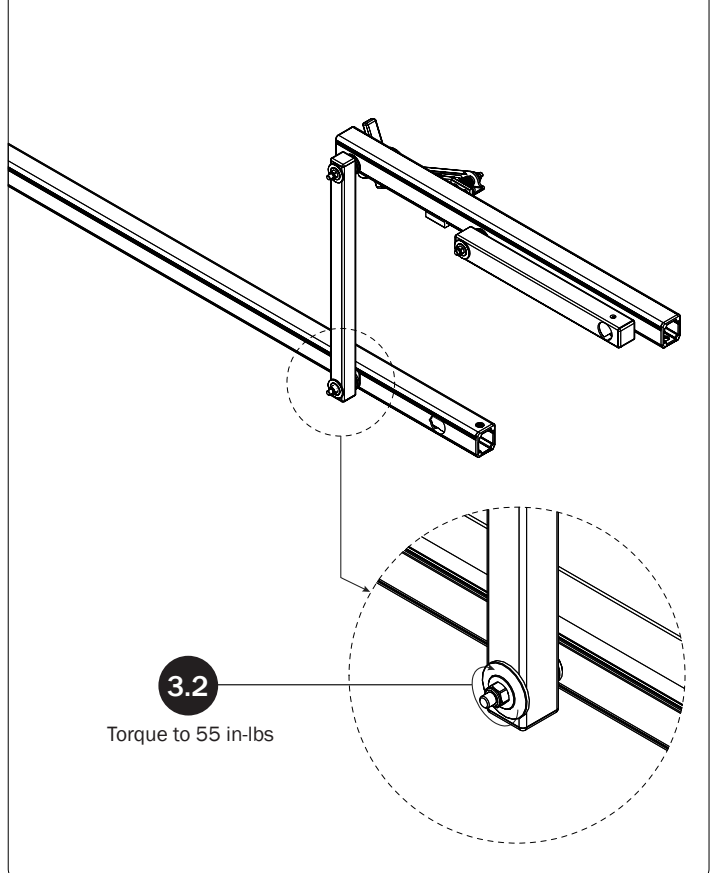
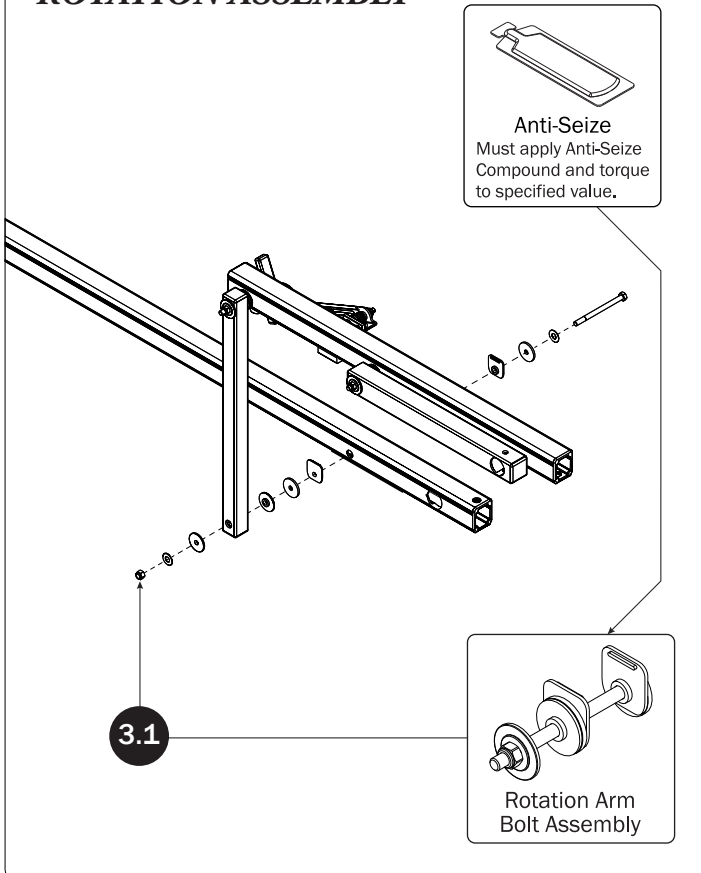
Torque to 55 in-lbs



CYLINDER ASSEMBLY



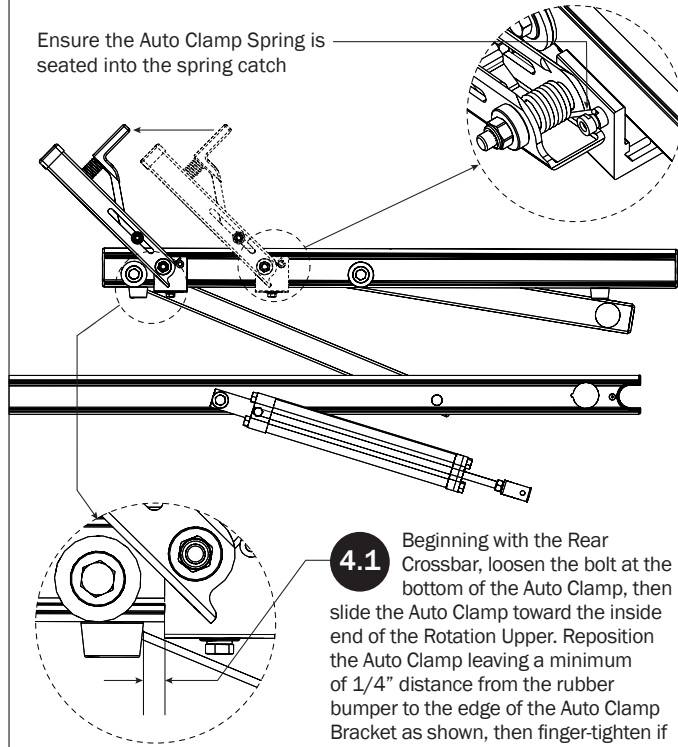
FRONT CROSSBAR ROTATION ASSEMBLY



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

NOTE: The Auto Clamps come preset from the factory for packaging purposes only. To assemble the L Posts to the Crossbars, the Auto Clamps must be repositioned.

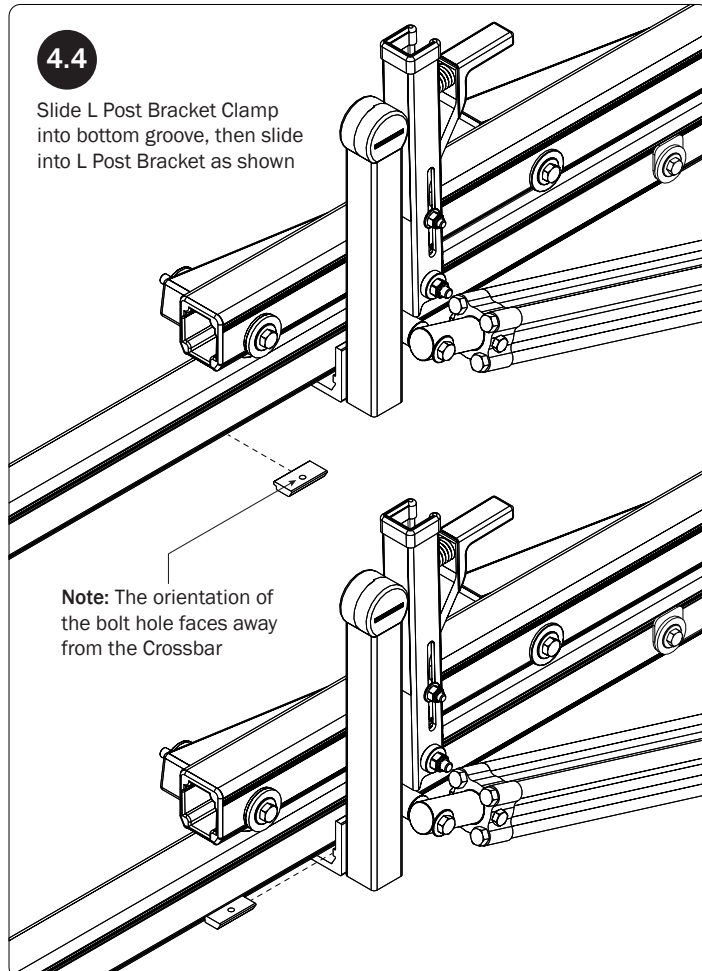
Ensure the Auto Clamp Spring is seated into the spring catch



4.1 Beginning with the Rear 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.

4.4

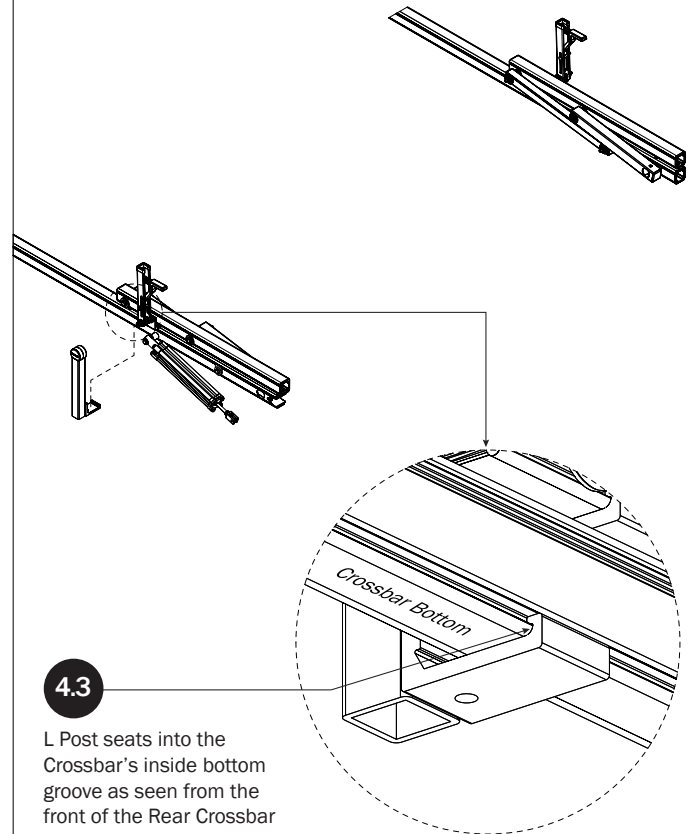
Slide L Post Bracket Clamp into bottom groove, then slide into L Post Bracket as shown



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

4.2

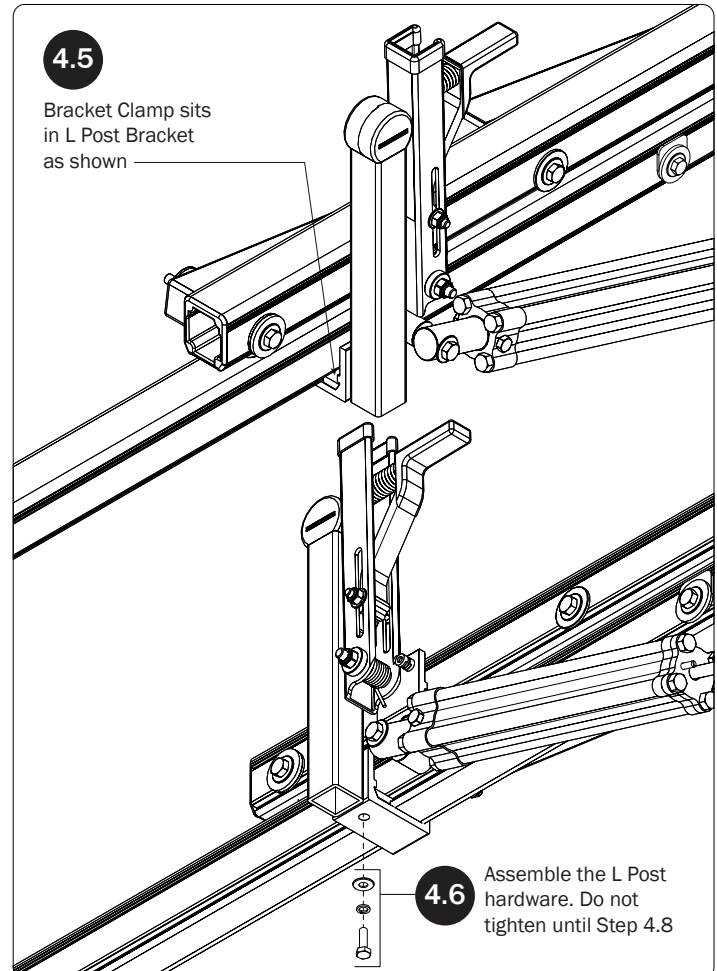
Place an L Post into the bottom groove of the Rear Crossbar

**4.3**

L Post seats into the Crossbar's inside bottom groove as seen from the front of the Rear Crossbar

4.5

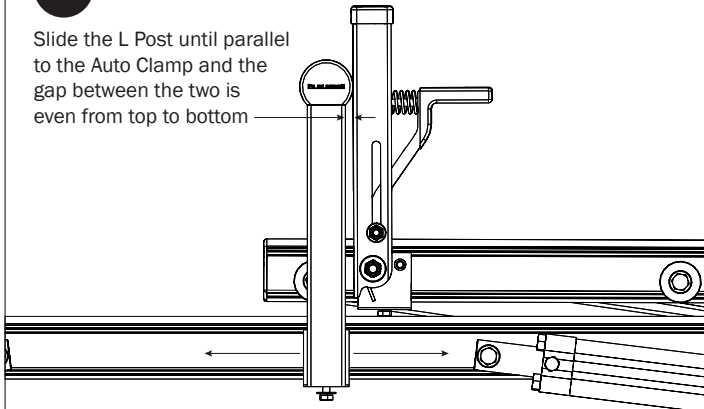
Bracket Clamp sits in L Post Bracket as shown

**4.6**

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

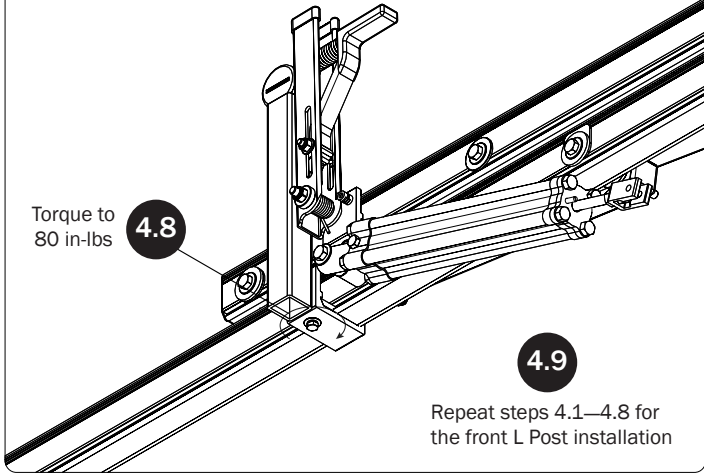
4.7

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



Torque to 80 in-lbs

4.8



4.9

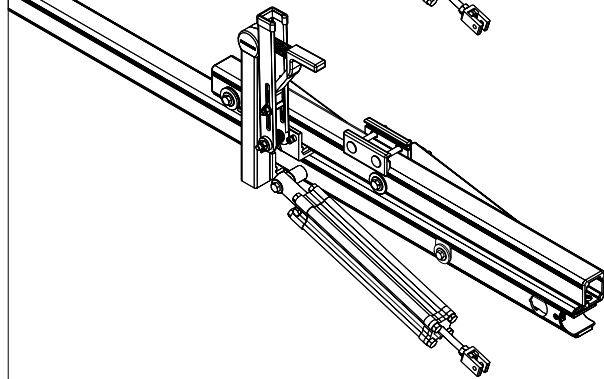
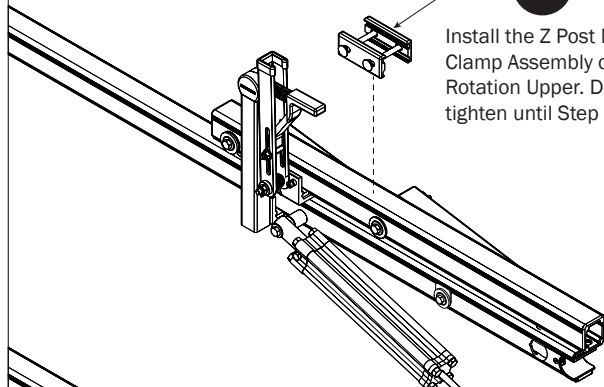
Repeat steps 4.1—4.8 for the front L Post installation

Z POSTS

SEE QUICK START GUIDE FOR ADJUSTMENTS

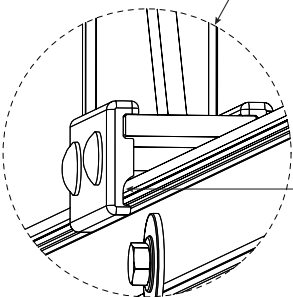
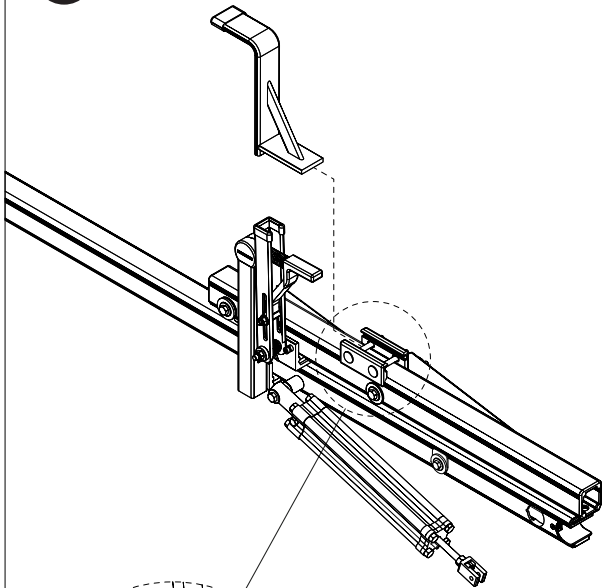
5.1

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



5.2

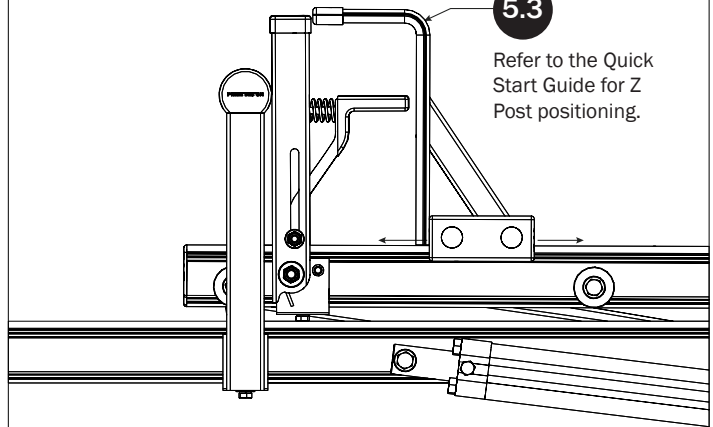
Slide the Z Post into the Mounting Clamp Assembly



Ensure both Z Post Mounting Clamps are fully seated into the top groove of the Upper

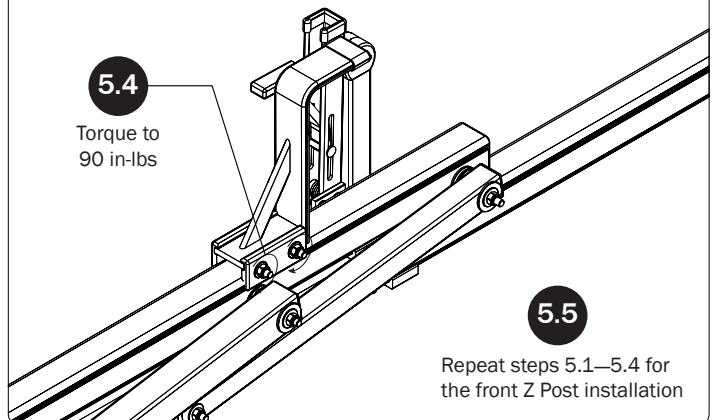
5.3

Refer to the Quick Start Guide for Z Post positioning.



5.4

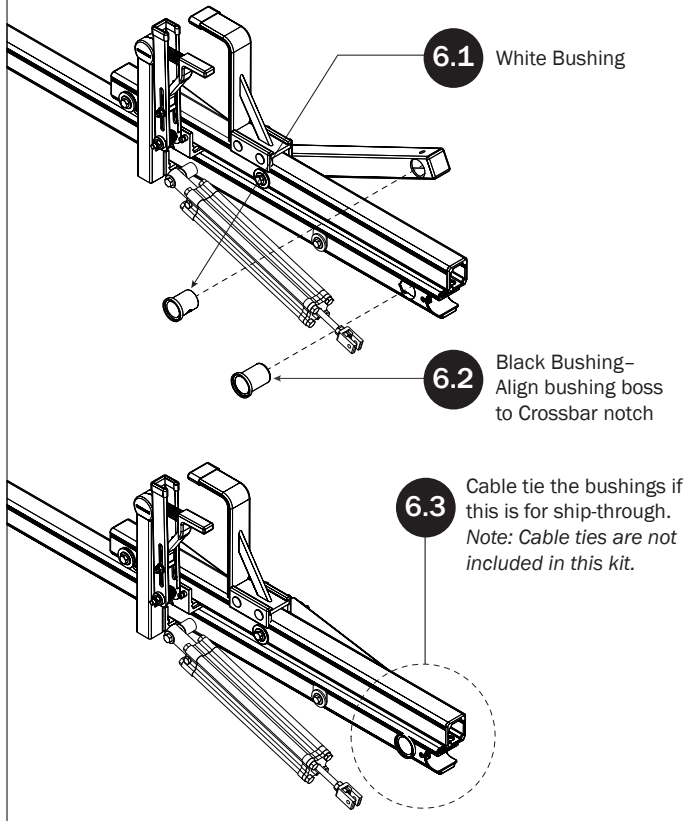
Torque to 90 in-lbs



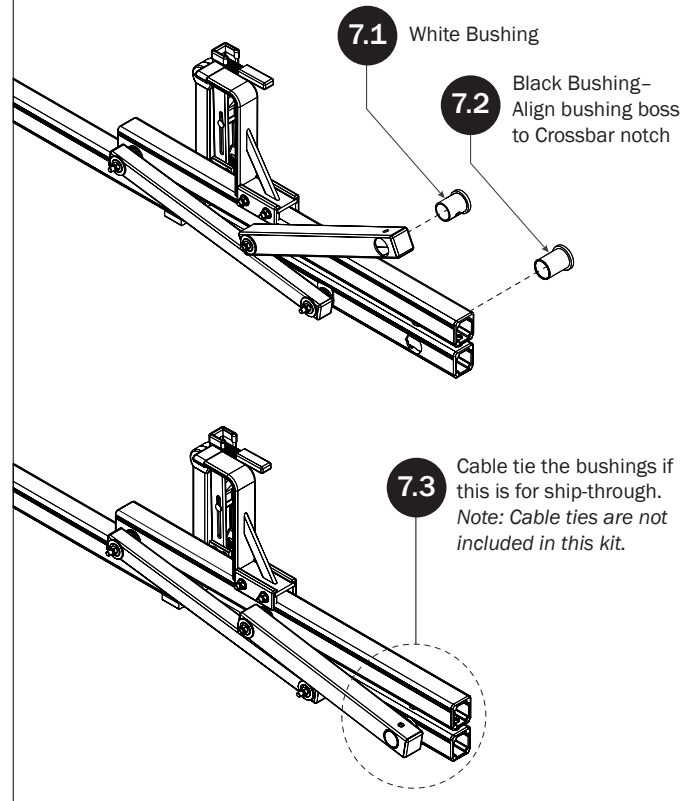
5.5

Repeat steps 5.1—5.4 for the front Z Post installation

REAR ROTATION BUSHINGS

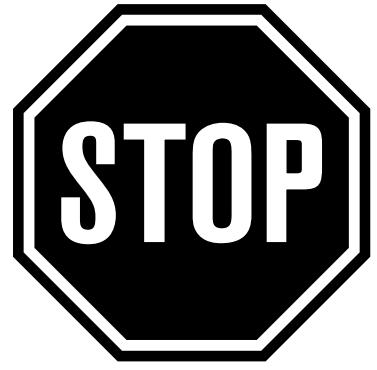
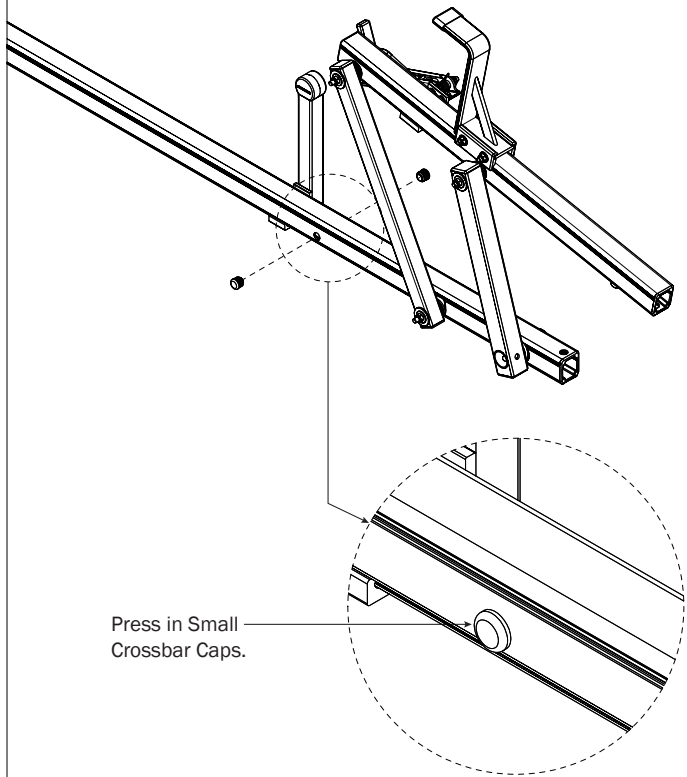


FRONT ROTATION BUSHINGS



FRONT CROSSBAR CAPS

8 Some Front Crossbars may have additional drilled holes. Press Crossbar Caps into Crossbar holes if present and unused.



NOTE: This completes the installation of FEA-0002. For left side Rotation installation, repeat Steps 1.1–8 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.