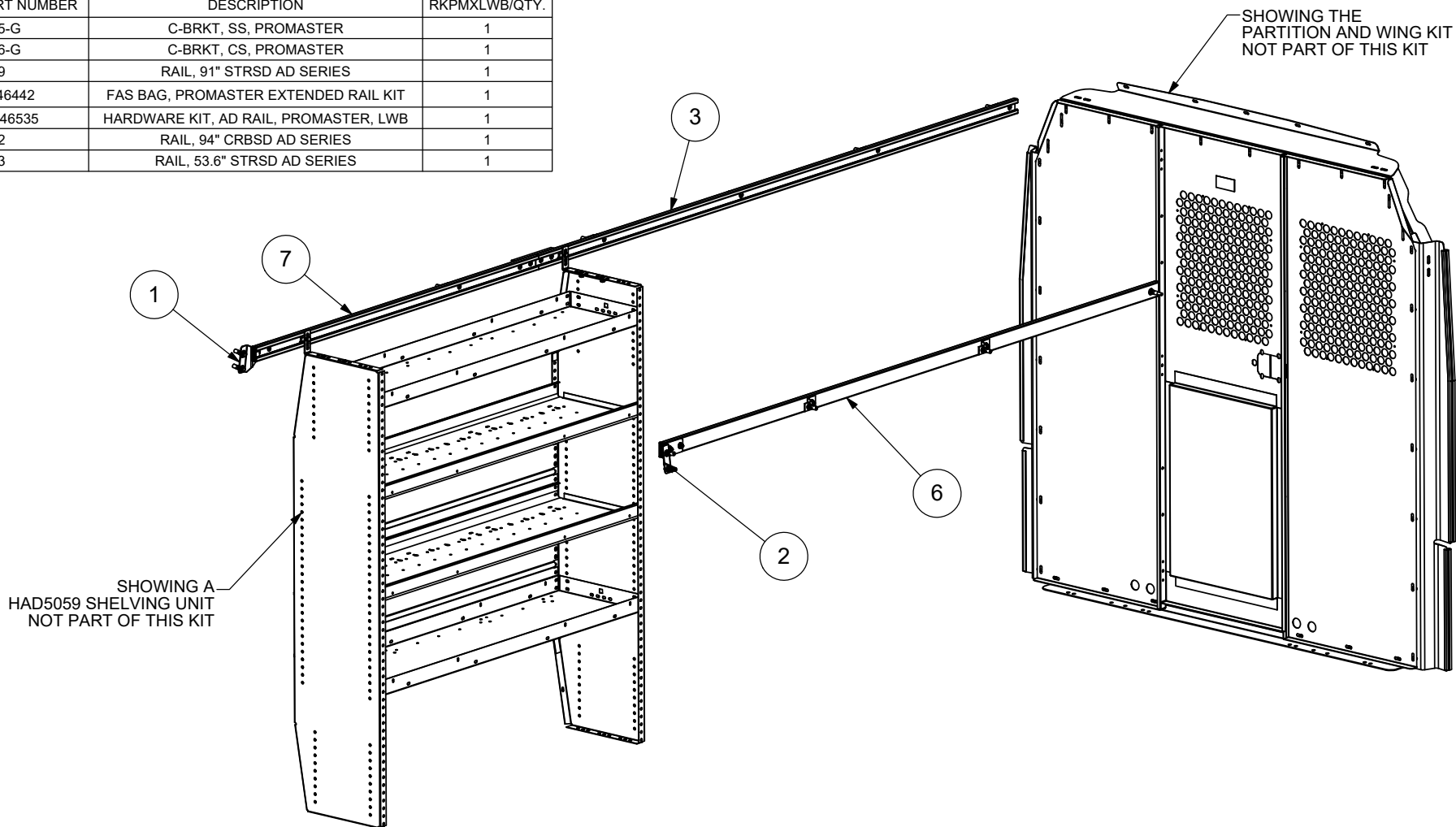


ITEM NO.	PART NUMBER	DESCRIPTION	RKPMXLWB/QTY.
1	45715-G	C-BRKT, SS, PROMASTER	1
2	45716-G	C-BRKT, CS, PROMASTER	1
3	45719	RAIL, 91" STRSD AD SERIES	1
4	BAG46442	FAS BAG, PROMASTER EXTENDED RAIL KIT	1
5	HDW46535	HARDWARE KIT, AD RAIL, PROMASTER, LWB	1
6	45722	RAIL, 94" CRBSD AD SERIES	1
7	45723	RAIL, 53.6" STRSD AD SERIES	1



THIS DRAWING IS THE PROPERTY OF ADRIAN STEEL COMPANY AND IS NOT TO BE USED IN ANY MANNER  
DETRIMENTAL TO THE INTERESTS OF ADRIAN STEEL COMPANY

#### MATERIAL & FINISH

PRINTED DOCUMENT IS UNCONTROLLED

Sheet 1 of 1

#### TOLERANCES & INSPECTION

UNLESS OTHERWISE SPECIFIED		
ALL BEND ANGLES ARE 90 DEGREES		
ALL DIMENSIONS ARE IN INCHES.		
REFERENCE DIMENSIONS (X.XXX) DO NOT REQUIRE INSPECTION		
FEATURES	HOLES/SLOTS	ANGLES
0.0 = ± .125	0.0 = ± .062	0° = ± 2°
0.00 = ± .062	0.00 = ± .031	0.0° = ± 1°
0.000 = ± .031	0.000 = ± .015	

Material Thickness: per ASTM Std.  
Weld Callouts per AWS

#### RELEASE & REVISIONS

INITIAL ECN:	22106
CURRENT ECN:	00000
ECN DESCRIPTION:	
FOR PRODUCTION RELEASE	
REVISED BY:	N/A

MECHANICAL FINISHING:

N/A

PRIMER: N/A

FINAL FINISH: NONE  
NONE

MATERIAL TYPE: ASM

#### PART / PRODUCT IDENTIFICATION



**ADRIAN STEEL**

ADRIAN STEEL COMPANY  
906 JAMES STREET, ADRIAN, MI 49221

REVISION LEVEL

**A**

MAT'L USED:

DESIGNED BY: N. Weeden

DESCRIPTION: RAIL KIT, PM 159 EXT TOP

WEIGHT  
(Lbs.):

SEGMENT  
CODE: HDW

PART NUMBER: 58577

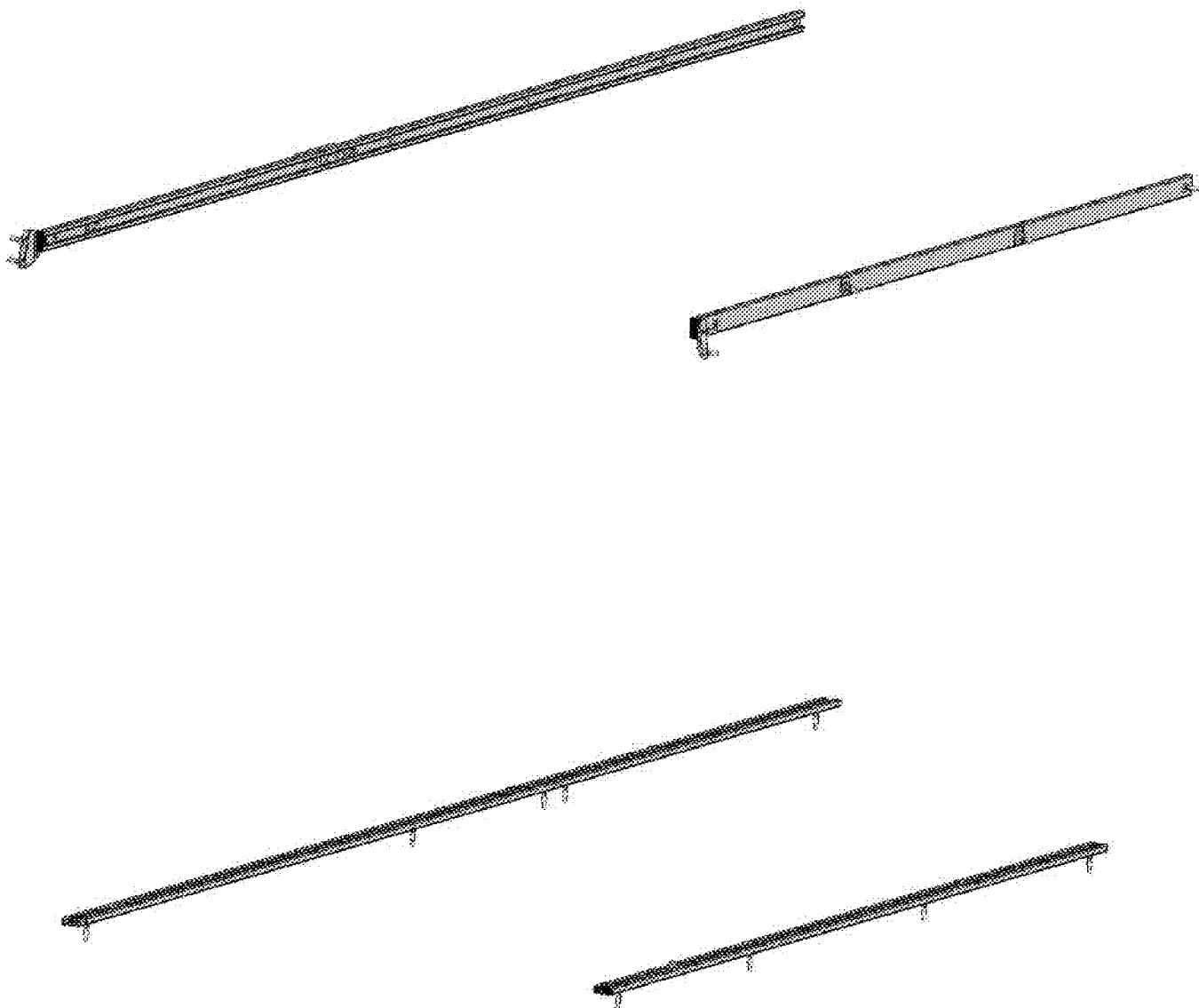


### Introduction / Comments:

This rail kit is designed to fit in your 159 Extended wheel base Promaster vehicle.

**Note:**

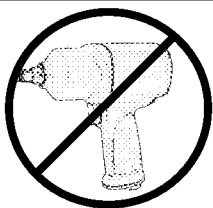
It is advised that all fasteners used in this assembly and installation should be checked for tightness at the following intervals: @ 2-weeks and again @ 6-weeks of operation. This preventive maintenance step must be completed to ensure your Rail kit gives you long service life.



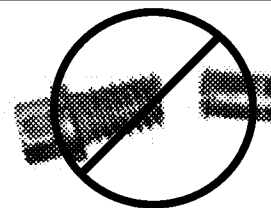
### **RKPMXLWB RAIL KIT, 159 WB EXTENDED PROMASTER**



## - PRECAUTIONS -

**CAUTION**

**THE USE OF AIR IMPACT TOOLS CAN  
OVER-TORQUE FASTENERS AND  
CAUSE FASTENER FAILURE!**

**CAUTION**

**ALL INSTALLATION HOLES SHOULD BE SEALED  
WITH SILICON OR BUTYL SEALANT TO PREVENT  
EXHAUST FUMES FROM ENTERING THE VEHICLE!**

**DANGER**

**INSPECT FOR FUEL TANK, FUEL LINES, BRAKE LINES, HIGH  
VOLTAGE BATTERIES AND ELECTRICAL LINES PRIOR TO  
DRILLING TO AVOID DAMAGING CRITICAL VEHICLE SYSTEMS  
OR INJURY TO INSTALLER DURING INSTALLATION PROCESS!**

**CAUTION**

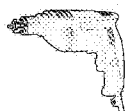
**TO AVOID DAMAGING THE VEHICLE ALWAYS USE DRILL  
STOPS WHEN DRILLING ANY INSTALLATION HOLES!  
ADRIAN AVAILABLE PART #'S 31121-0 (1/2" DEEP),  
31122-0 (3/4" DEEP)**



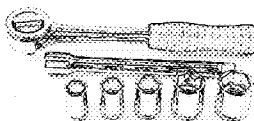
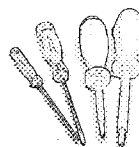
## - IMPORTANT WARRANTY REQUIREMENTS -

1. SUBSTITUTING ADRIAN STEEL SPECIFIED FASTENERS FOR ASSEMBLY AND/OR INSTALLATION WILL VOID YOUR PRODUCT WARRANTY.
2. ALL HOLES DRILLED INTO VEHICLE SHOULD HAVE THE RAW METAL EDGES SEALED WITH A SELF-ETCHING PRIMER TO RESIST CORROSION AND POTENTIAL FASTENER POINT FAILURE.
3. ALL FASTENERS USED IN THE INSTALLATION OF THIS PRODUCT SHOULD BE TIGHTENED TO THE TORQUE(S) SPECIFIED IN THESE INSTRUCTIONS.
4. THESE INSTRUCTIONS SHOULD BE KEPT WITH THE VEHICLE.

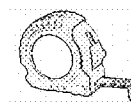
### THE BASIC TOOLS NEEDED FOR MOST INSTALLATIONS



DRILL

DRILL BIT WITH  
STOPRATCHET, SOCKETS  
AND/OR WRENCHES

SCREWDRIVERS



MEASURING TAPE

ADDITIONAL TOOLS MAY BE NEEDED FOR THIS INSTALLATION AND THEY WILL BE IDENTIFIED IN THE STEPS THAT FOLLOW.

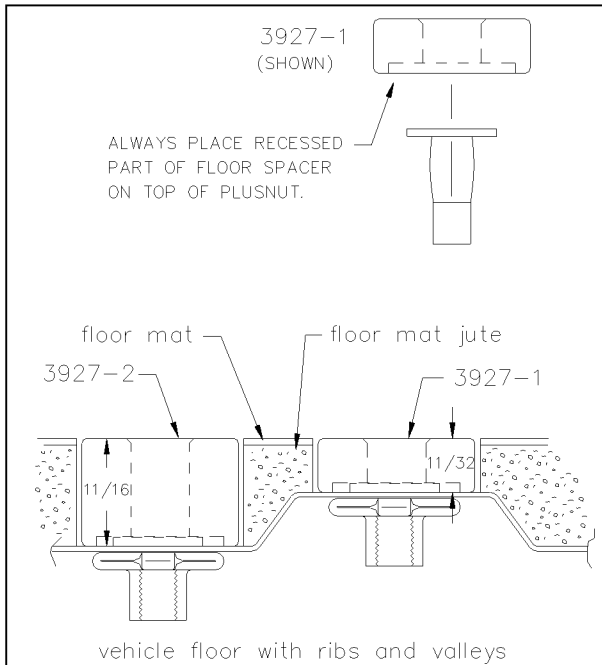


If your vehicle contains carpet or a rubber floor mat you will need to prepare the mounting location. Position the product to be installed into the vehicle and once you are satisfied with the mounting locations, mark the mounting locations. Using a 1-3/16" diameter carpet cutter (P/N: 31183-0). Select the appropriate floor spacers as shown in the illustration. Set those aside for use later into the installation process.

Using the correct drill bit size for the selected plusnut, drill the mounting holes in the vehicle sheet metal to prepare for installing the plusnuts.

If you are thru-bolting at any of the locations simply drill a hole that is 1/16" larger than the bolt size(s) for those locations.

Once you have drilled the holes into the vehicle, the raw metal edges should be sealed using a self-etching primer to resist corrosion and potential fastener point failure.



A PLUSNUT (RIVNUT) SETTING TOOL IS REQUIRED FOR PLUSNUT (RIVNUT) INSTALLATION AND IS SUPPLIED WITH THIS KIT. OR USE AN AIR POWERED PLUSNUT SETTING GUN.

1/4-20UNC Plusnut (FAS0052) Use 3/8" dia. drill w/stop

FAS0080 SCREW, HXHD, 1/4-20UNCx2.00", G8

FAS0067 WASHER, FLAT, 1/4"ID

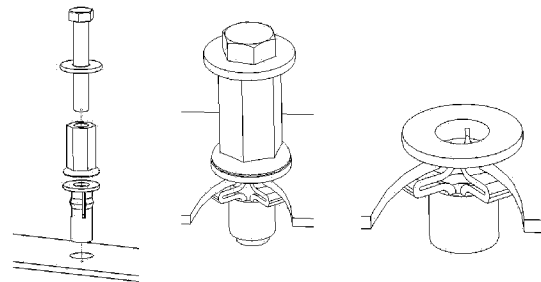
22200-0 PLUSNUT TOOL

5/16-18UNC Plusnut (FAS0091) Use 1/2" dia. drill w/stop

FAS0095 SCREW, HXHD, 5/16-18UNCx2.00", G8

FAS0086 WASHER, FLAT, 5/16"ID

22200-0 PLUSNUT TOOL



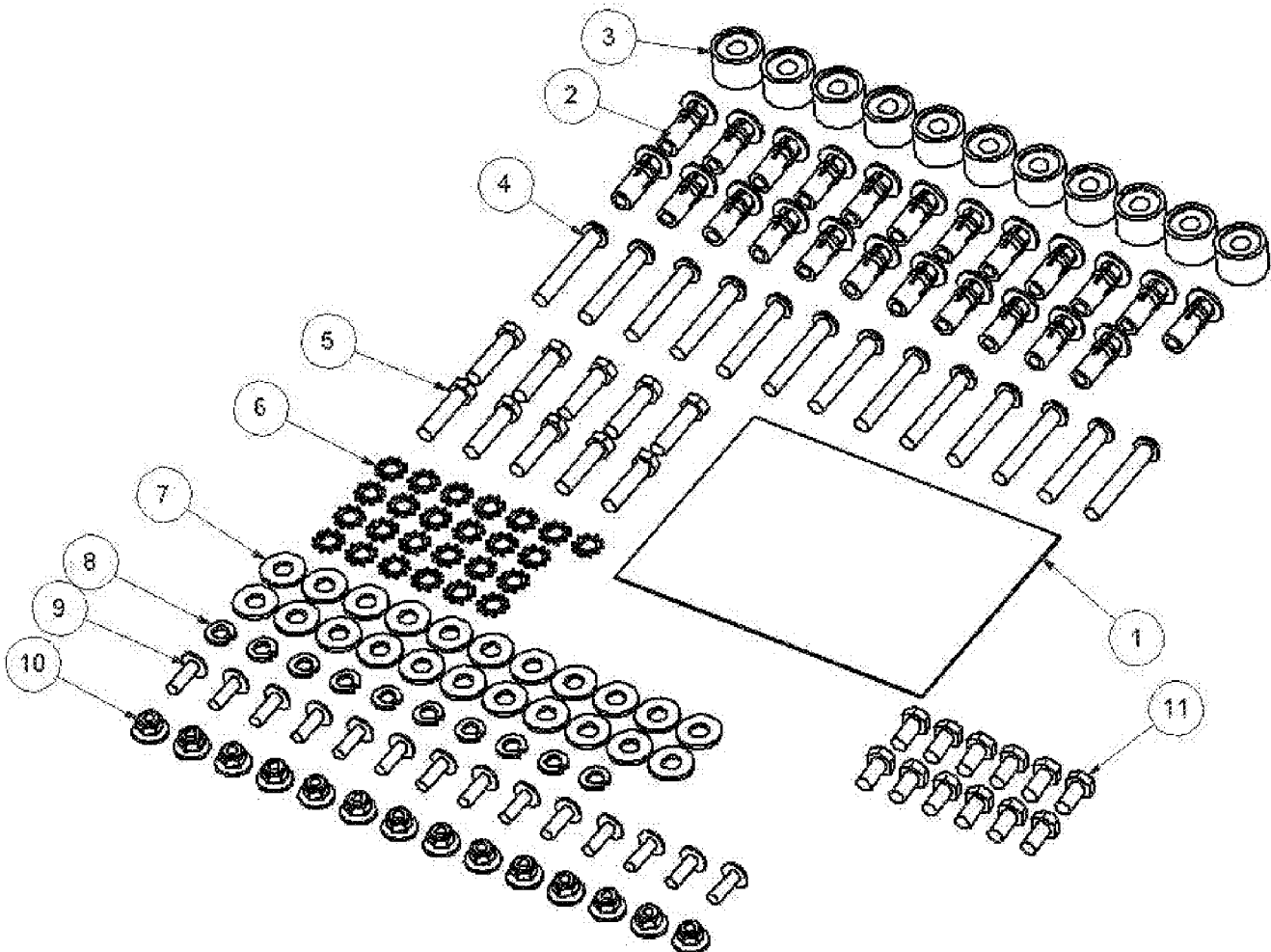
Place barrel of the plusnut body in sheet metal thru hole until flange is flush with sheet metal.

Using a 9/16" combination wrench of plusnut tool body and a second hand wrench, ratchet, or air tool, rotate the hex bolt head CW to draw plus nut flanges up (set the plusnut).



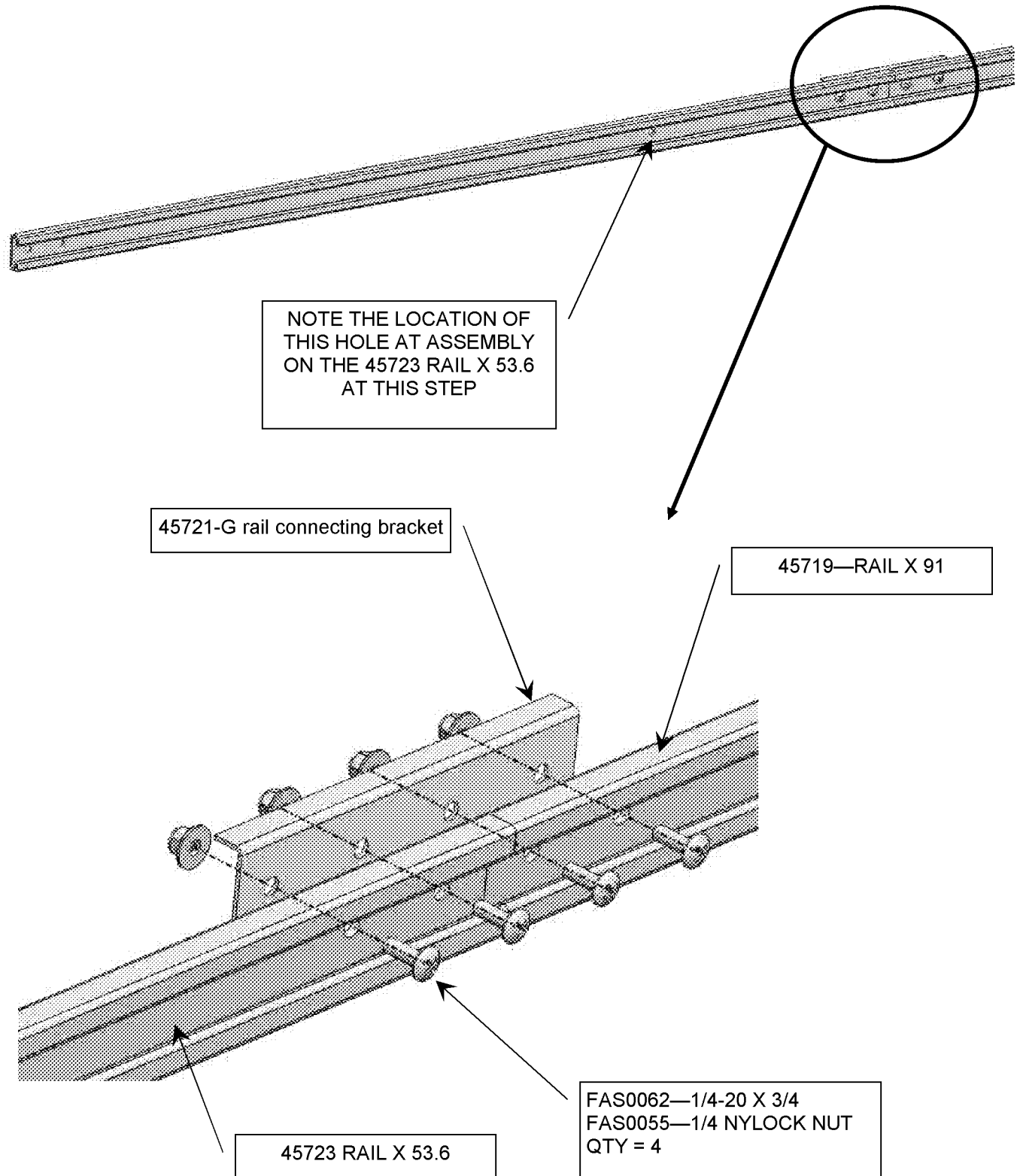
## Assembly and Installation Fastener Identification Sheet ( BAG46442)

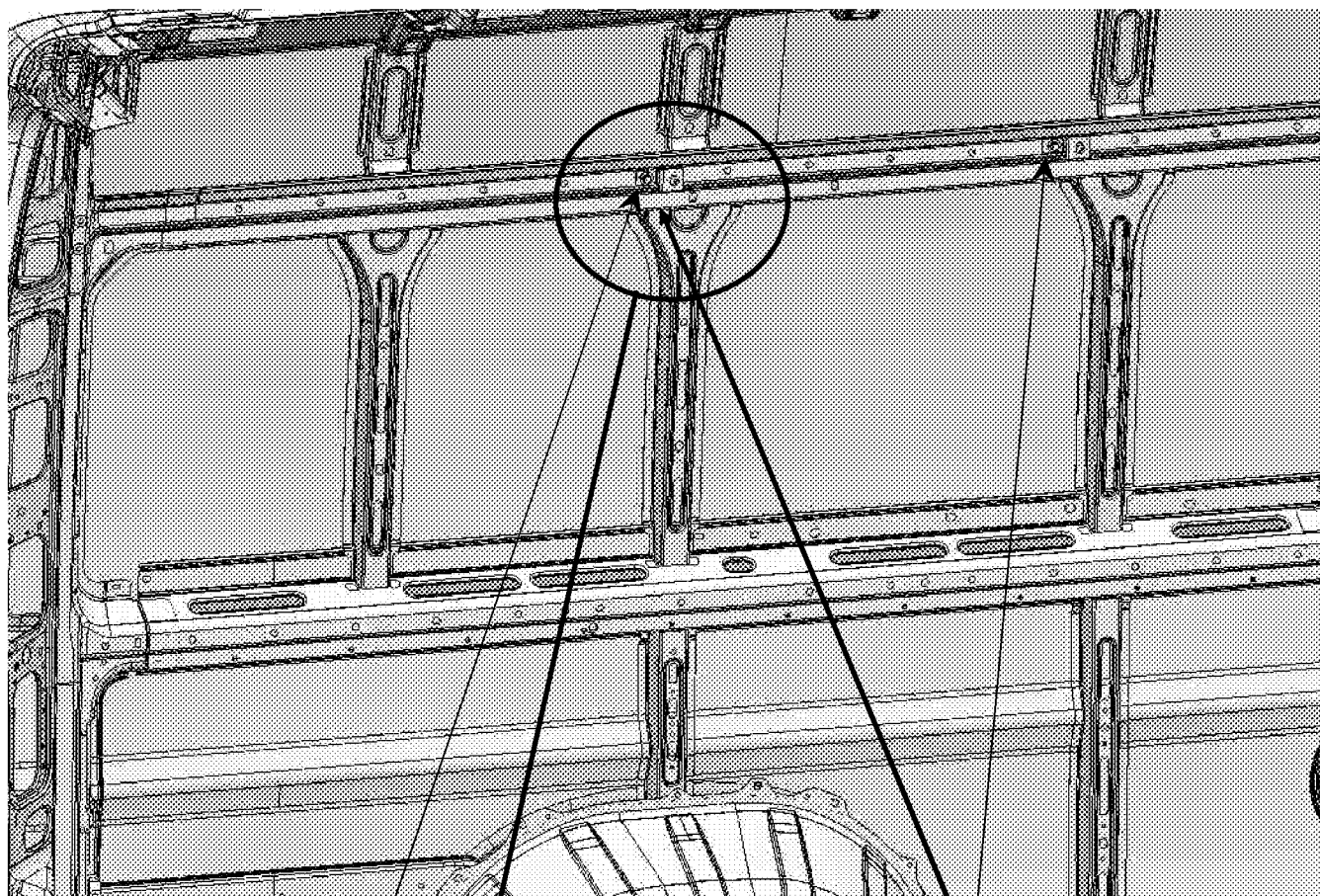
ITEM NO.	PART NUMBER	DESCRIPTION	QTY
1	BAG0507-A	5" x 7" 3MIL AUTOBAG	1
2	FAS0091	Plusnut, 5/16	23
3	03927-2	Tall Floor Spacer	11
4	FAS0048	Screw, Button Hd Hex Soc, 5/16-18X 2, BLK OXIDE	13
5	FAS0093	Screw, Hex Hd, 5/16-18x1.25	10
6	FAS0085	Washer, Lock, Ext. Tooth, 5/16	25
7	FAS0086	Washer, Flat, 5/16, ZN	22
8	FAS0098	Washer, Lock, Split, 5/16, Zinc Plate	10
9	FAS0062	Screw, Truss Hd, Ph, 1/4-20x0.75	14
10	FAS0055	Nut, Hex Flange, Nylock, 1/4-20	14
11	FAS0165	Screw, Hex Hd, 5/16-18x 6.25	12





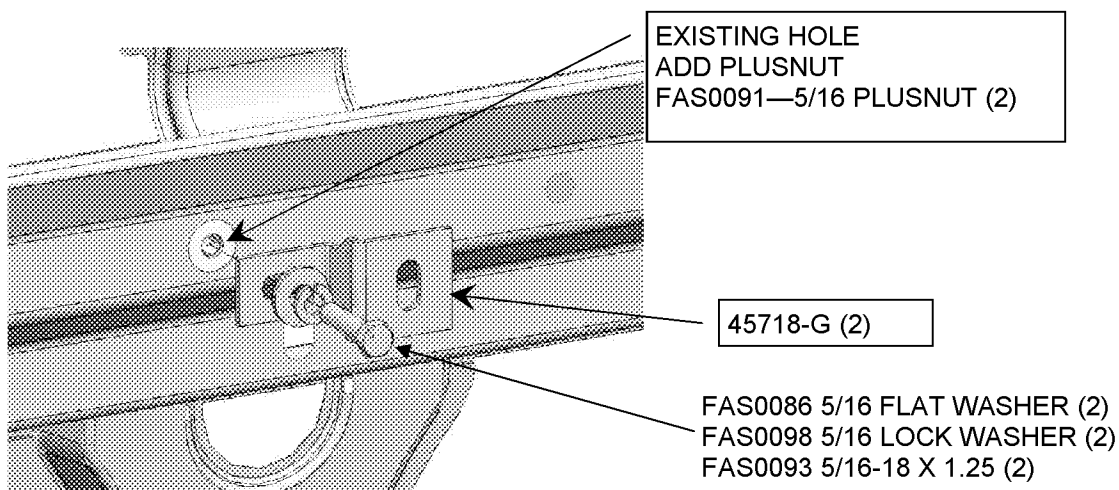
## STEP 1A ASSEMBLE STREET SIDE UPPER RAILS.



**STEP 1A LOCATE STREET SIDE UPPER HOLES—WORK WITH NEXT PAGE !**

EXISTING HOLE  
6TH HOLE FROM REAR

EXISTING HOLE  
5 HOLES FROM FIRST  
HOLE



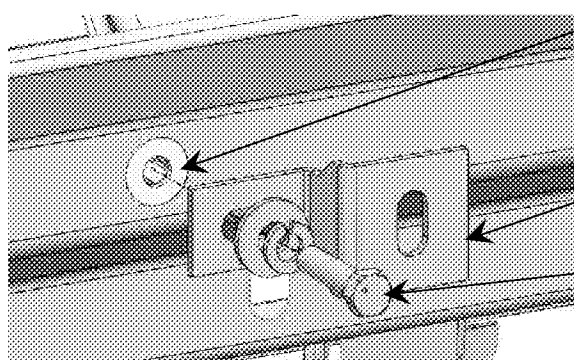
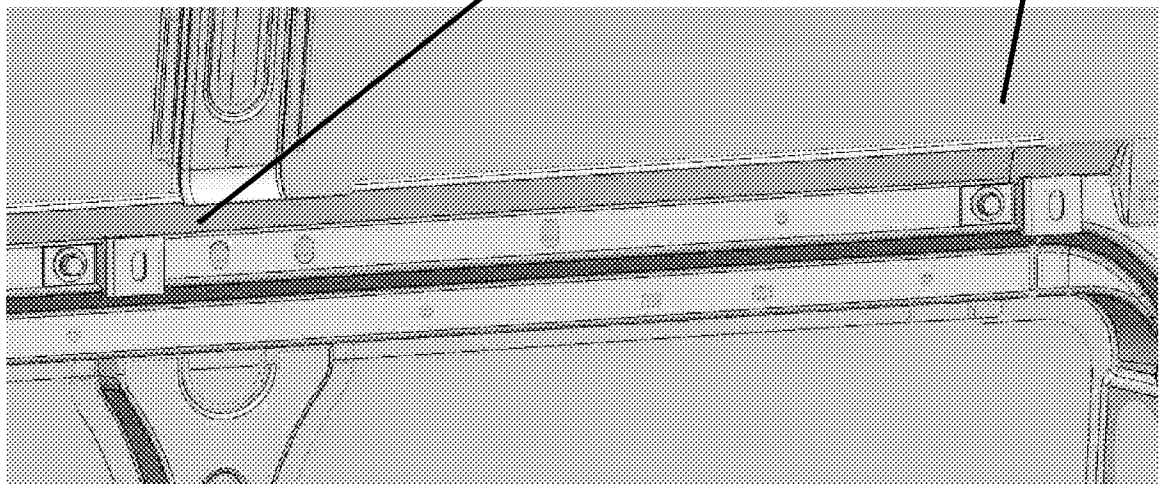
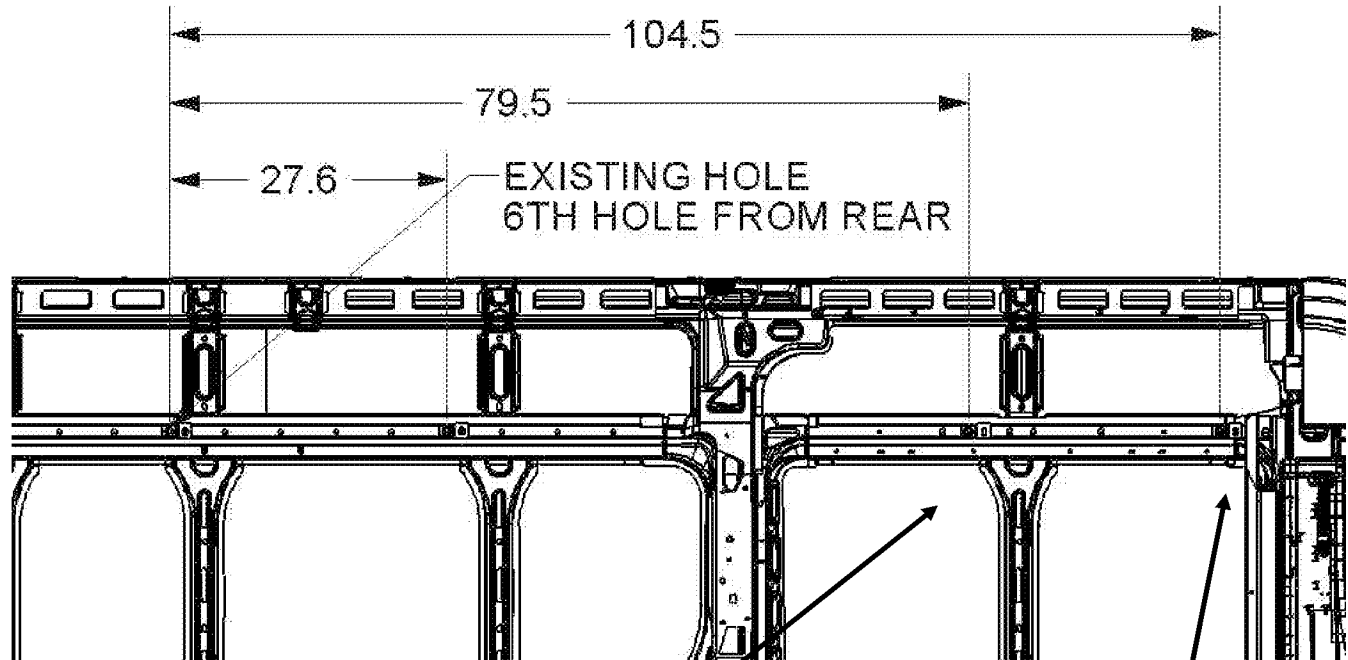
EXISTING HOLE  
ADD PLUSNUT  
FAS0091—5/16 PLUSNUT (2)

45718-G (2)

FAS0086 5/16 FLAT WASHER (2)  
FAS0098 5/16 LOCK WASHER (2)  
FAS0093 5/16-18 X 1.25 (2)



## STEP 1B LOCATE ALL RAIL ADAPTER HOLES IN THE UPPER STREET RAIL



1/2" DIA WITH DRILL STOP  
ADD PLUSNUT  
FAS0091—5/16 PLUSNUT (2)

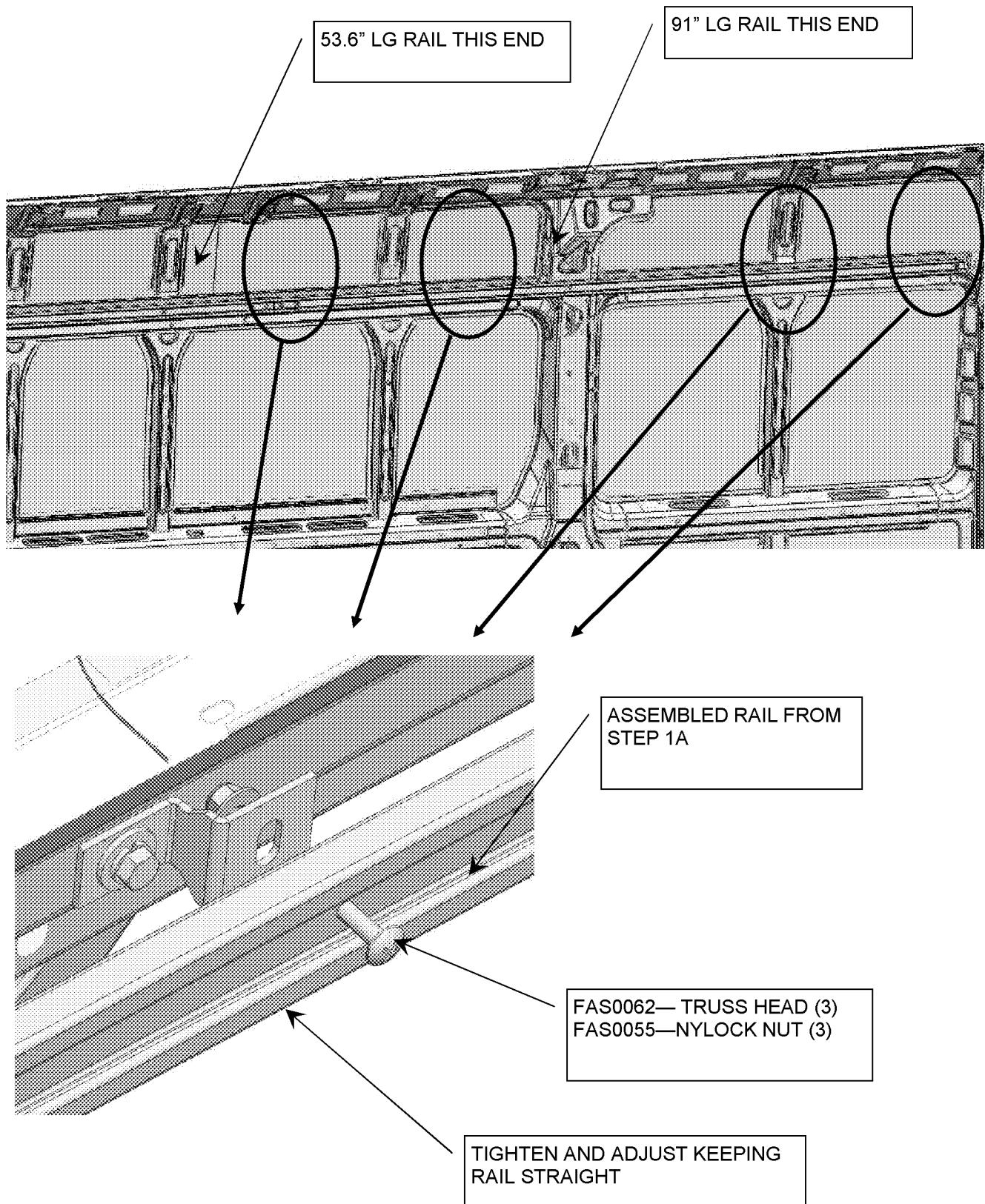
45718-G (2)

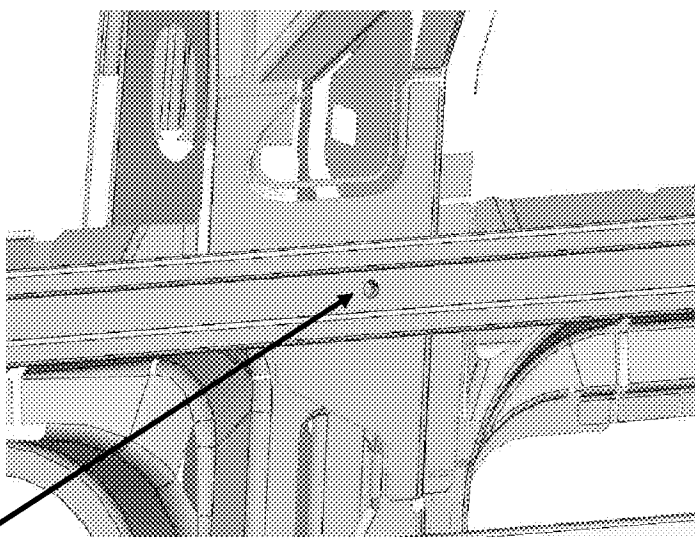
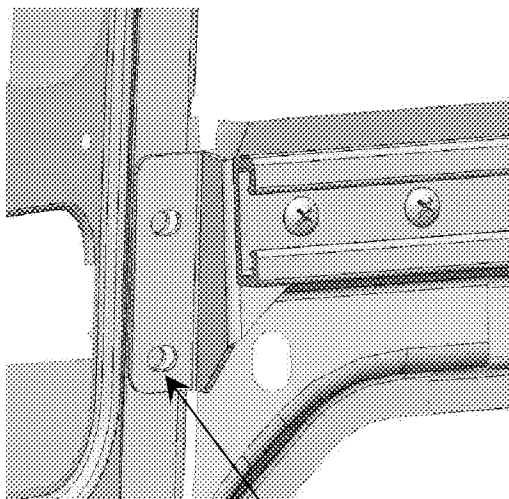
FAS0086 5/16 FLAT WASHER (2)  
FAS0098 5/16 LOCK WASHER (2)  
FAS0093 5/16-18 X 1.25 (2)



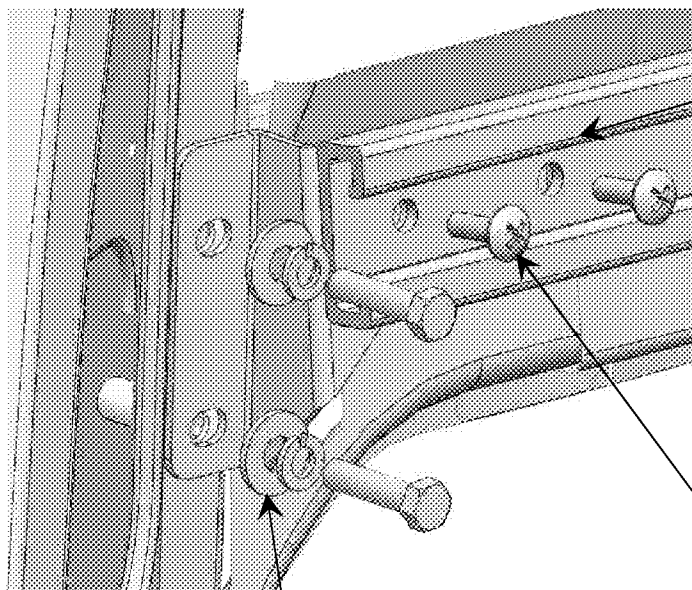


**STEP 1C - ADD STREET SIDE UPPER RAILS TO THE RAIL ADAPTERS.**

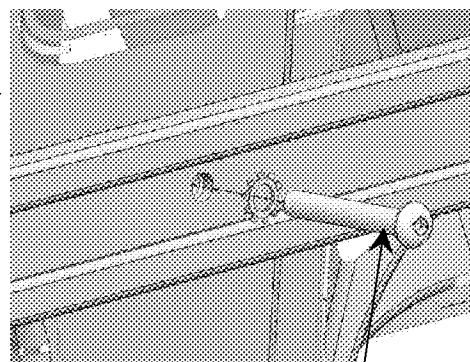


**STEP 1D - ADD STREET SIDE D-PILLAR MTG PLATE**

TRANSFER HOLE LOCATIONS  
REMOVE RAIL  
DRILL AND SET PLUSNUTS  
FAS0091—5/16 PLUSNUT



FAS0091—PLUSNUT  
FAS0093— HEX HEAD (2)  
FAS0098—LOCK WASHER (2)  
FAS0086—FLAT WASHER (2)

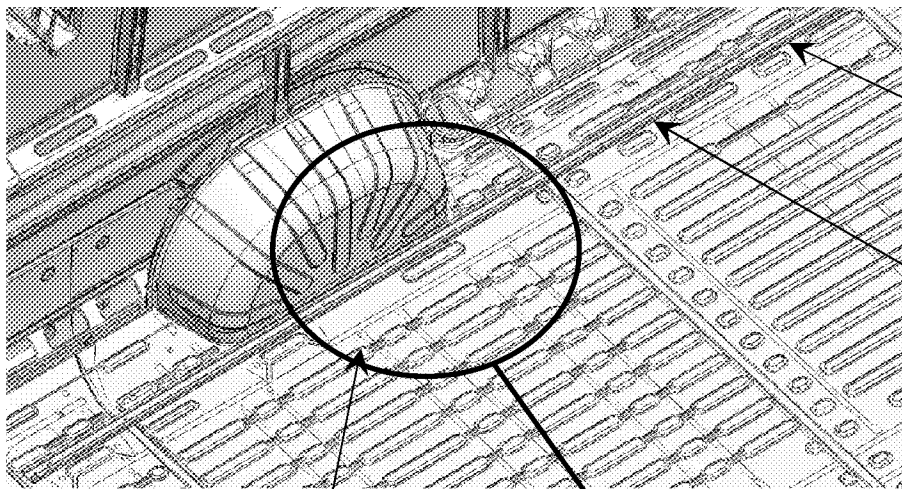


FAS0091—PLUSNUT  
FAS0048— BUTTON HD  
FAS0085—STAR WASHER

FAS0062— TRUSS HEAD (2)  
FAS0055—NYLOCK NUT (2)



## STEP 2A - ADD STREET SIDE FLOOR RAILS WITH OEM PARTITION GO TO STEP 2B FOR INSTRUCTIONS WITH ADRIAN PARTITION

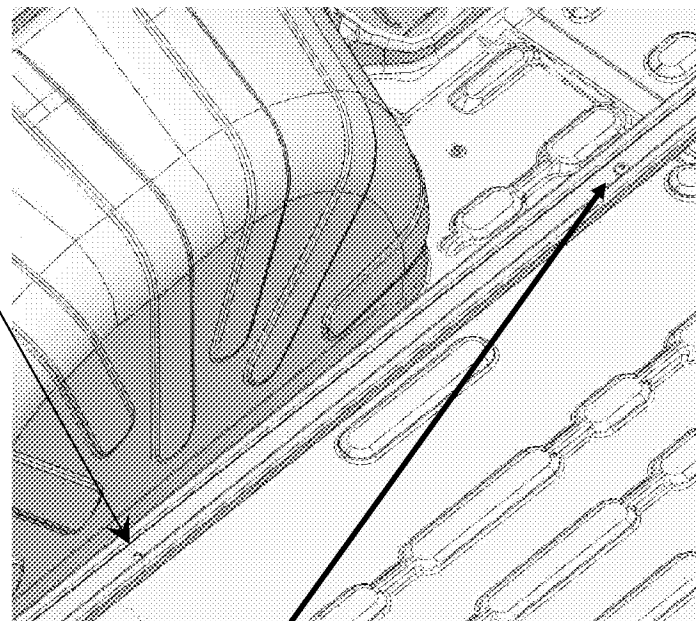


53.6" LG RAIL  
45723

91" LG RAIL  
45719

UP AGAINST  
WHEEL WELL

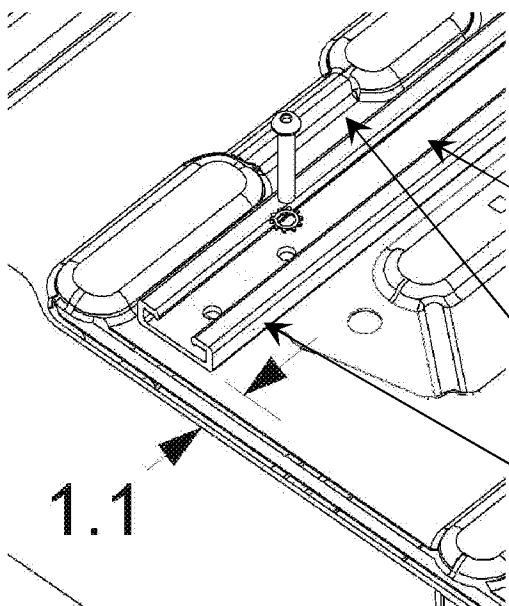
**CAUTION !!! DO NOT  
USE THIS HOLE**



91" LG RAIL  
45719

FAS0091—PLUSNUT (2)  
FAS0048— BUTTON HD (2)  
FAS0085—STAR WASHER (2)

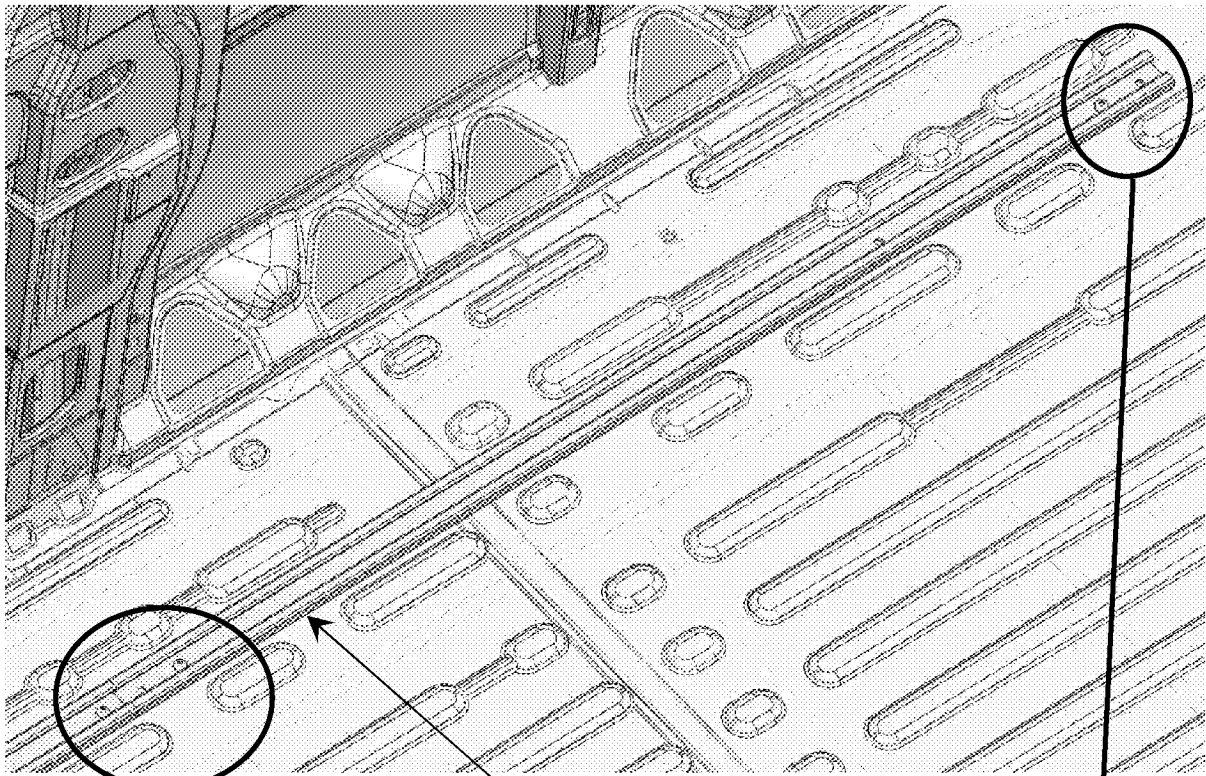
**WITH OEM PARTITION  
APPROX 1.1" FROM SEAM  
LINE UP WITH TOP RAIL**



1.1

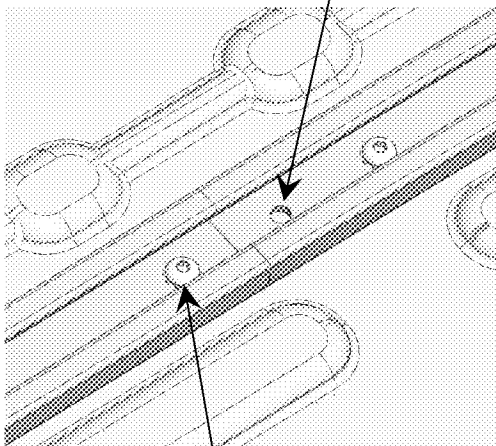


**STEP 2A - ADD STREET SIDE FRONT FLOOR RAIL WITH OEM PARTITION.**

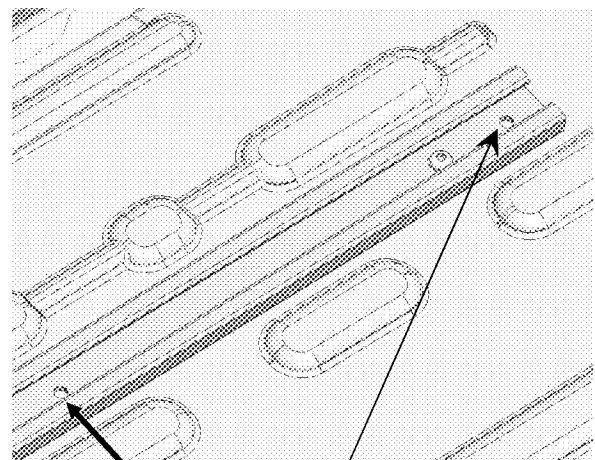


HOLE NOT USED

53.6" LG RAIL  
45723



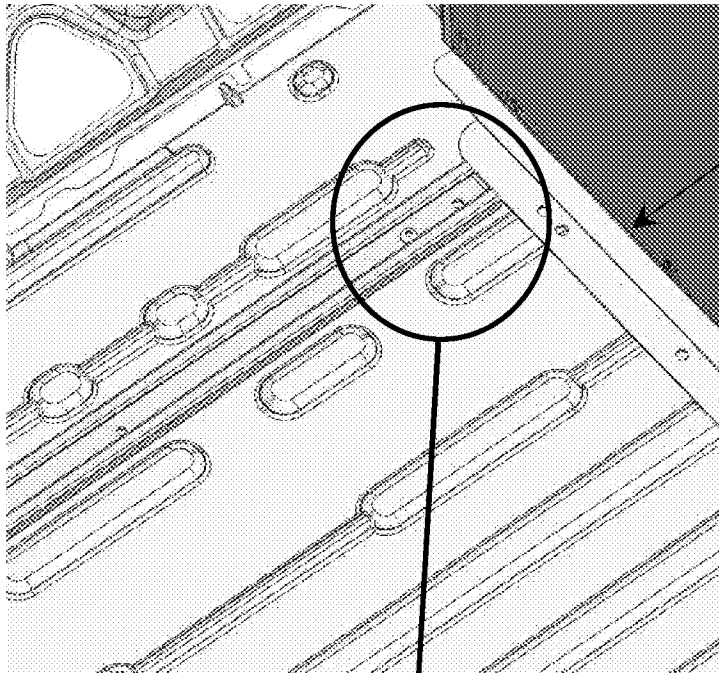
TRANSFER HOLE LOCATIONS  
REMOVE RAIL  
DRILL AND SET PLUSNUTS  
FAS0091—5/16 PLUSNUT (3)  
FAS0048— BUTTON HD (3)  
FAS0085—STAR WASHER (3)



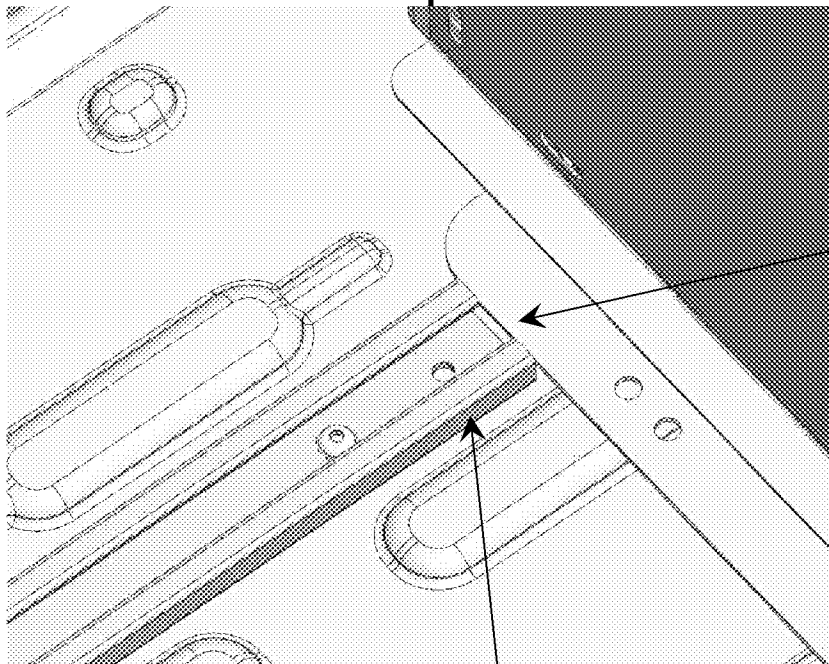
HOLES NOT USED



## STEP 2B - ADD STREET SIDE FLOOR RAILS WITH ADRIAN PARTITION



**INSTALLED  
ADRIAN PARTITION  
FOOTER RAIL.**

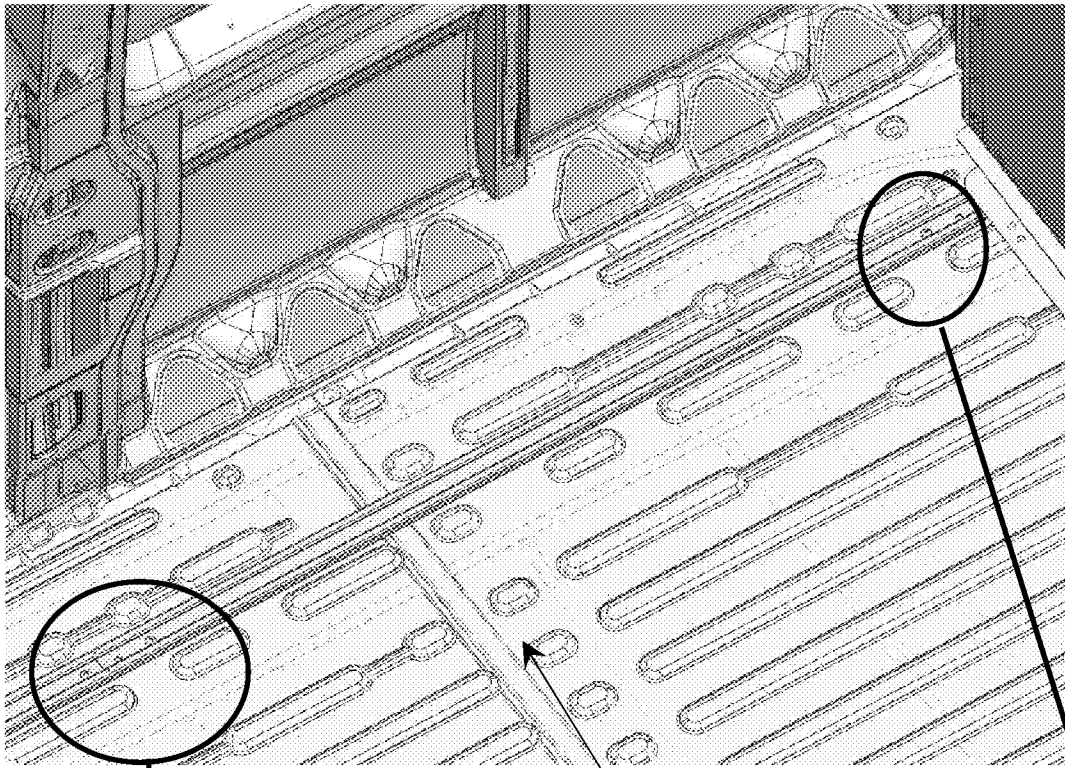


**TOUCHING TO  
APPROXIMATELY 1/4" AWAY  
FROM FOOTER RAIL**

**IF YOU HAVE THE PLUS THREE PARTITION.**  
1) REMOVE 3" FROM THIS END OF THE RAIL  
2) DRILL A .344 HOLE 1" FROM THE CUT END  
3) DRILL AND SET PLUSNUT.

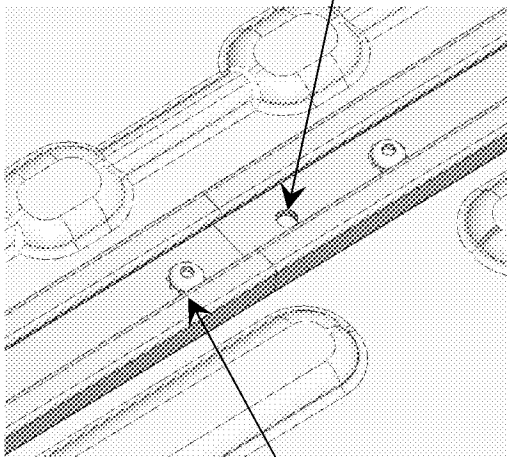


**STEP 2B - ADD STREET SIDE FRONT FLOOR RAIL WITH ADRIAN PARTITION.**

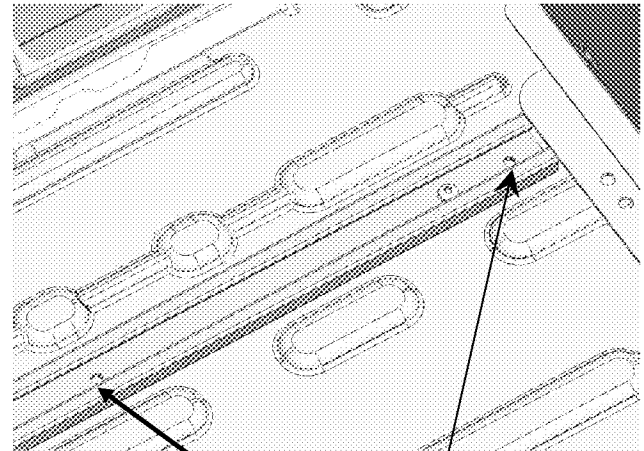


HOLE NOT USED

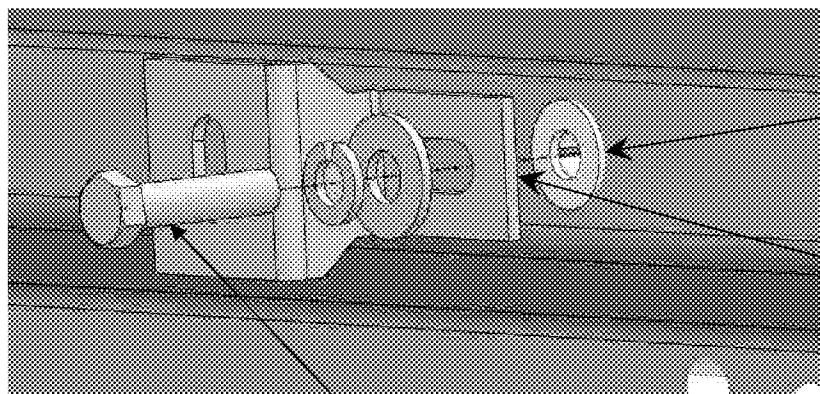
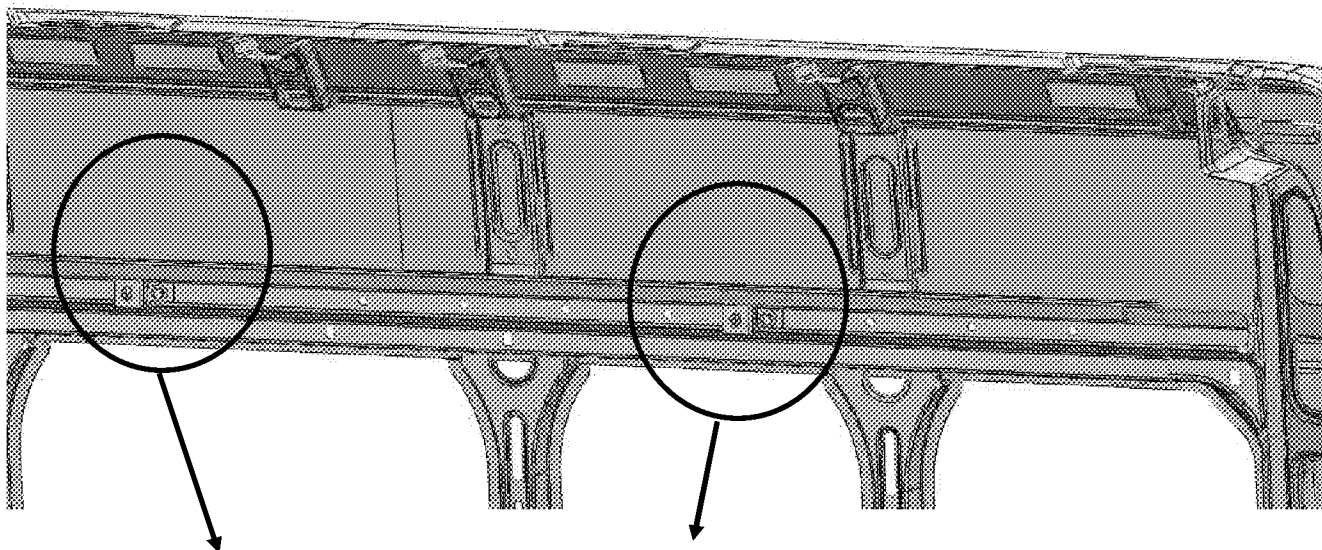
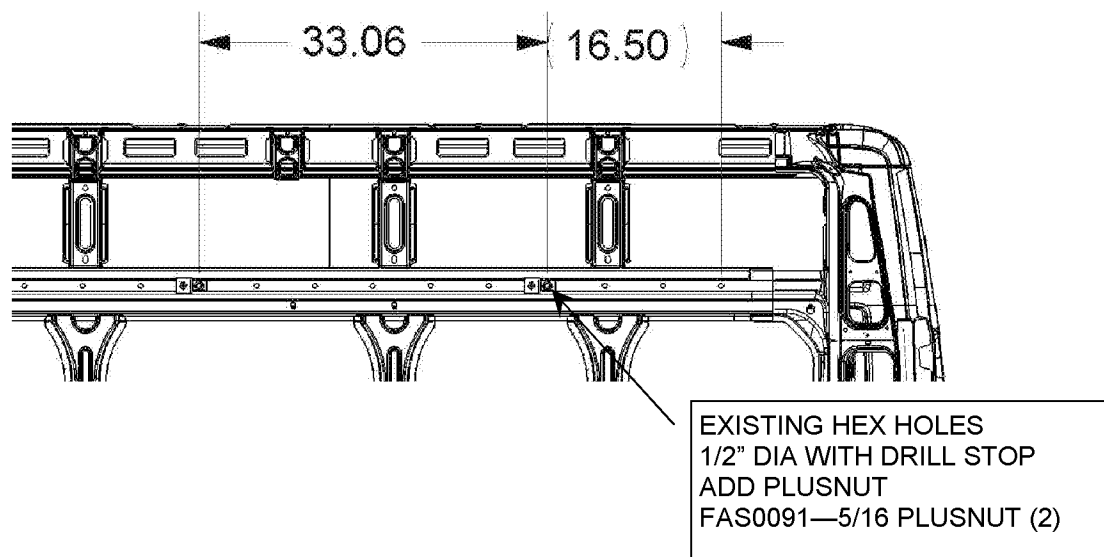
41" LG RAIL  
45720



TRANSFER HOLE LOCATIONS  
REMOVE RAIL  
DRILL AND SET PLUSNUTS  
FAS0091—5/16 PLUSNUT (3)  
FAS0048— BUTTON HD (3)  
FAS0085—STAR WASHER (3)



HOLES NOT USED

**STEP 3 CURB SIDE UPPER RAIL**

FAS0091—PLUSNUT (2)

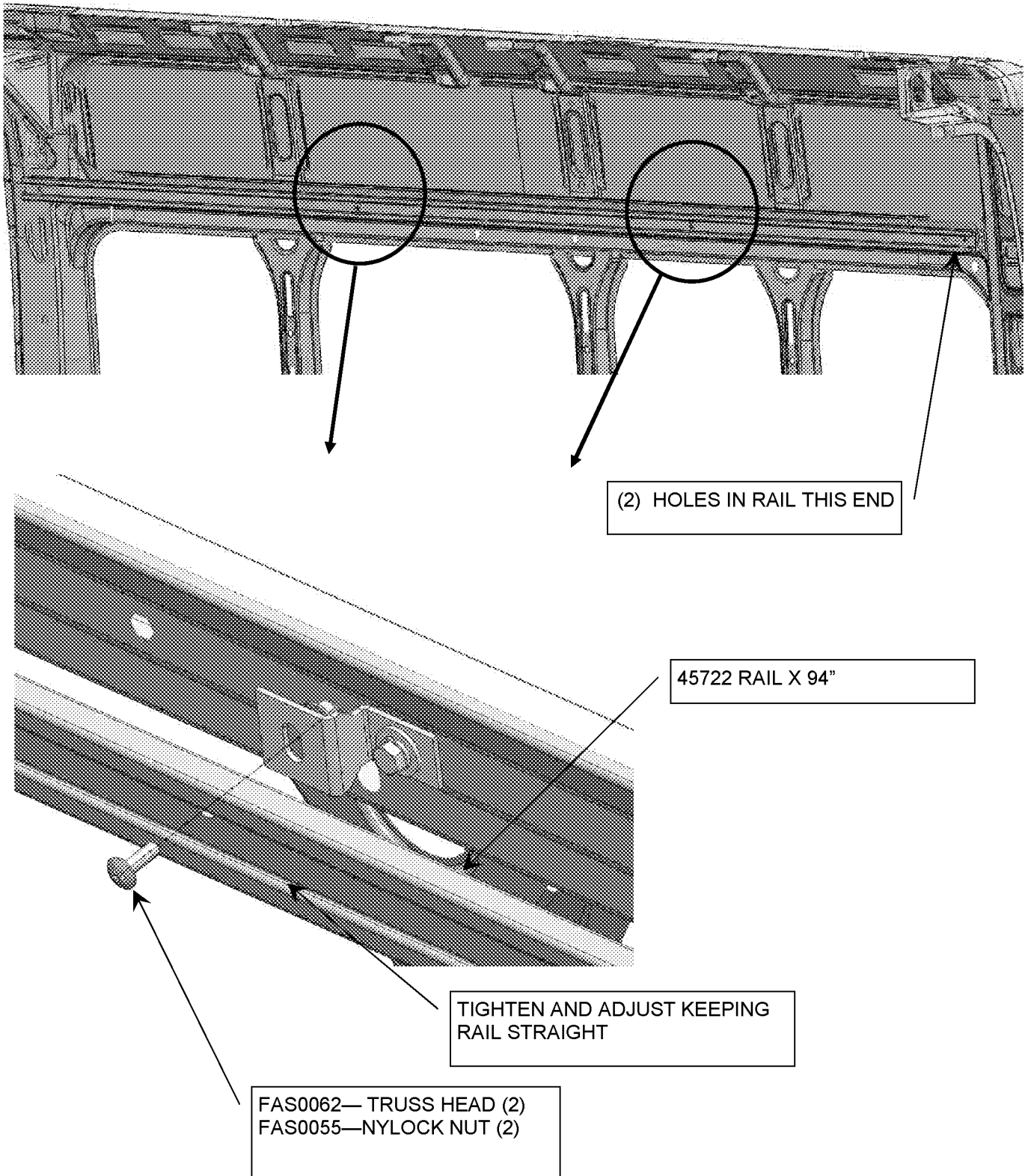
45718-G (2)

FAS0086 5/16 FLAT WASHER (2)  
FAS0098 5/16 LOCK WASHER (2)  
FAS0093 5/16-18 X 1.25 (2)

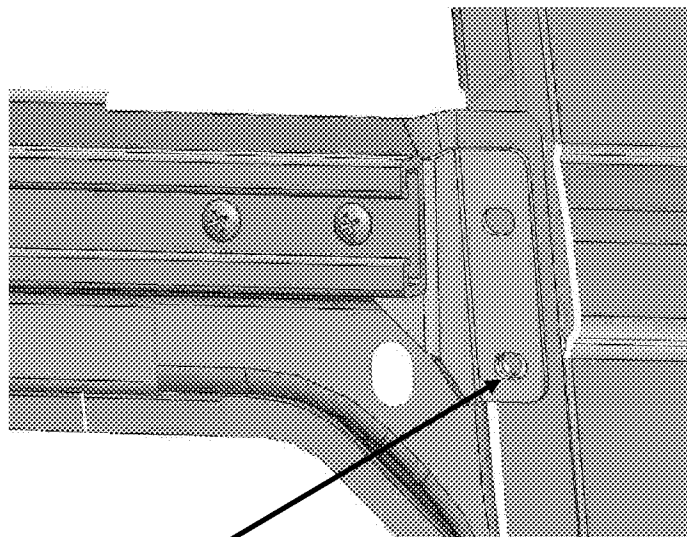
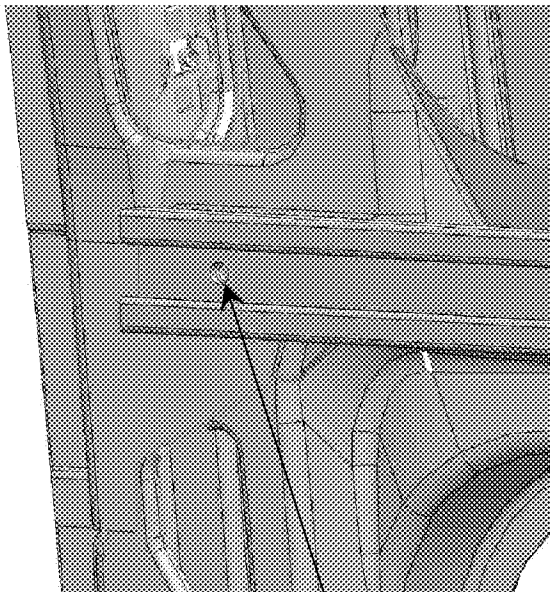




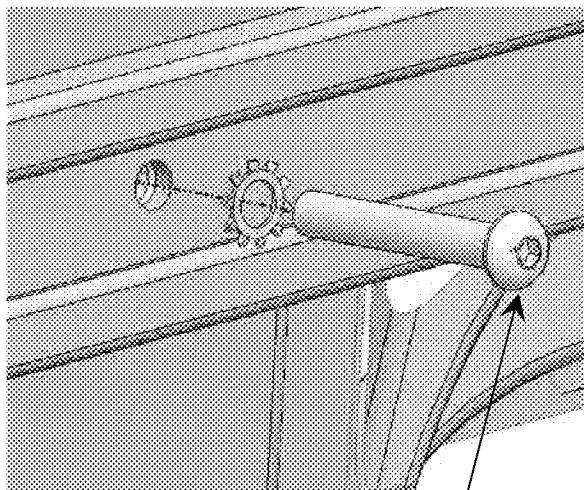
## STEP 3B - ADD CURB SIDE UPPER RAIL TO THE RAIL ADAPTERS



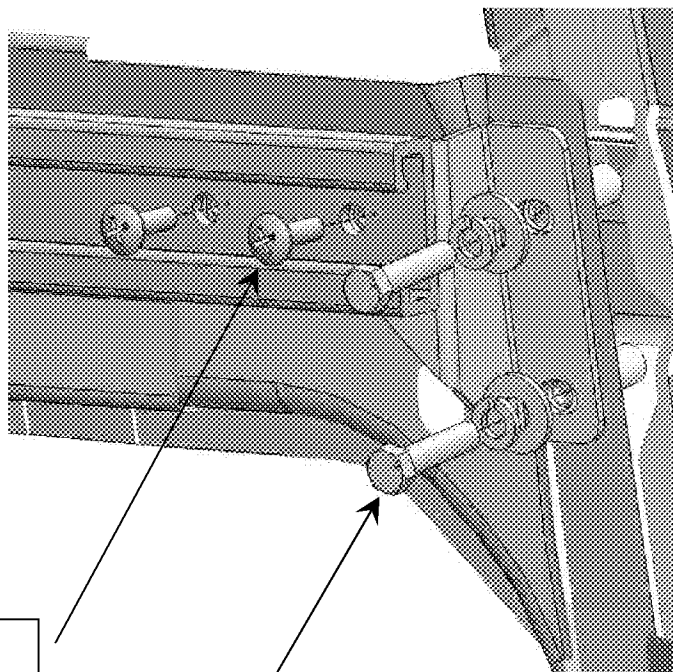


**STEP 3C - ADD CURB SIDE D-PILLAR MTG PLATE**

TRANSFER HOLE LOCATIONS  
REMOVE RAIL  
DRILL AND SET PLUSNUTS  
FAS0091—5/16 PLUSNUT



FAS0091—PLUSNUT  
FAS0048—BUTTON HD  
FAS0085—STAR WASHER



FAS0062— TRUSS HEAD (2)  
FAS0055—NYLOCK NUT (2)

FAS0091—PLUSNUT  
FAS0093— HEX HEAD (2)  
FAS0098—LOCK WASHER (2)  
FAS0086—FLAT WASHER (2)

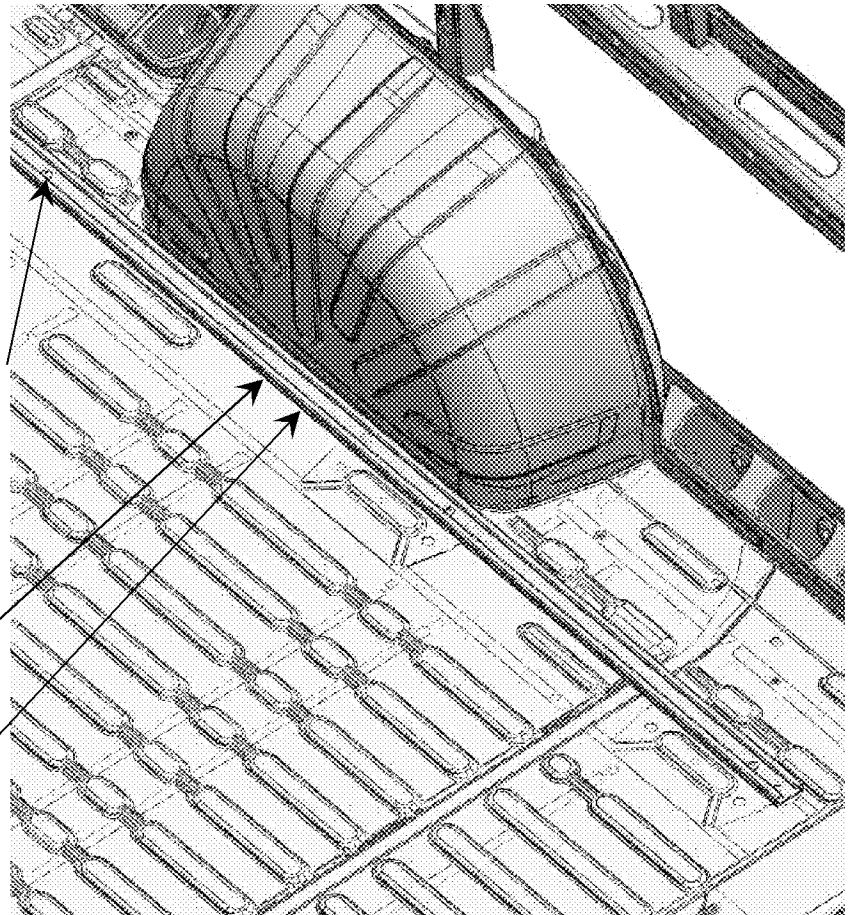


## STEP 4 - ADD CURB SIDE FLOOR RAIL

TRANSFER HOLE LOCATIONS (3)  
REMOVE RAIL  
DRILL AND SET PLUSNUTS  
FAS0091—5/16 PLUSNUT

45722 RAIL X 94"

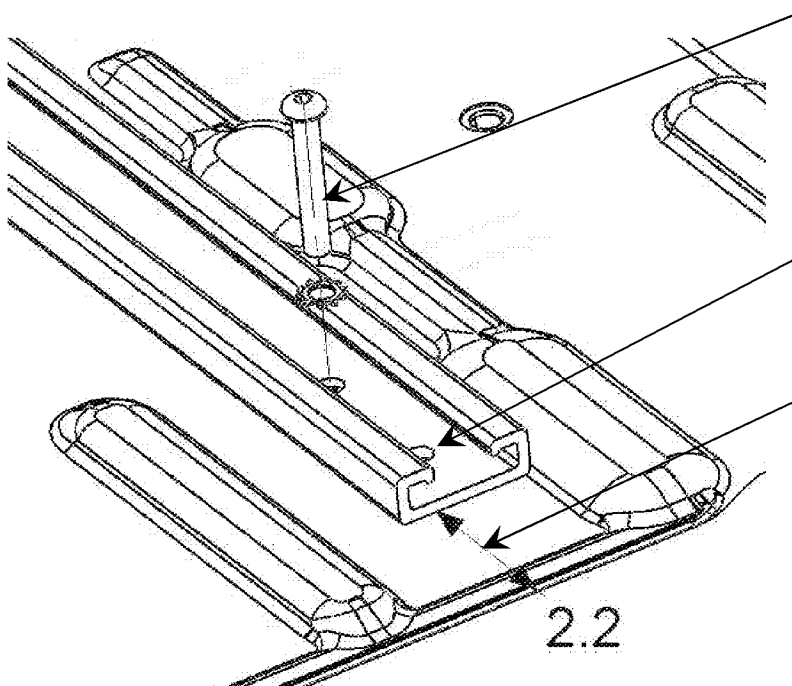
UP AGAINST WHEEL WELL



FAS0091—PLUSNUT (3)  
FAS0048— BUTTON HD (3)  
FAS0085—STAR WASHER (3)

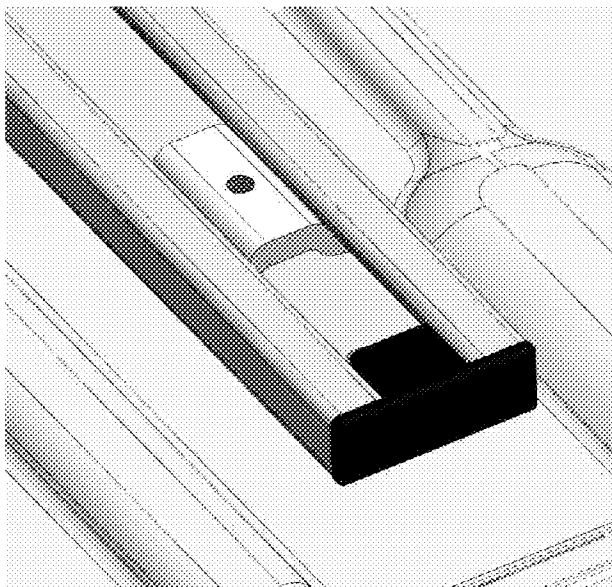
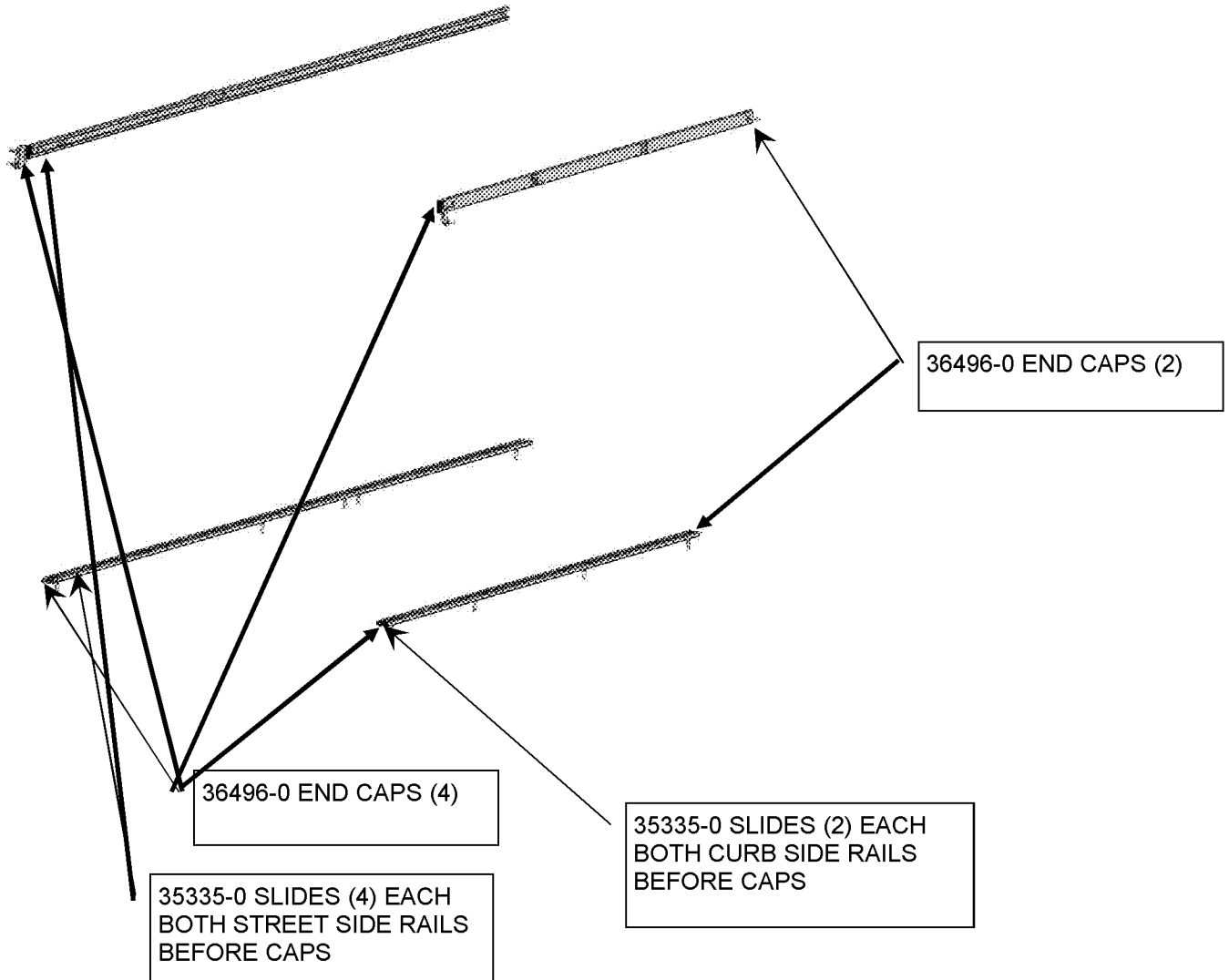
FIRST HOLE NOT USED

APPROX 2 1/4" FROM SEAM  
LINE UP WITH TOP RAIL



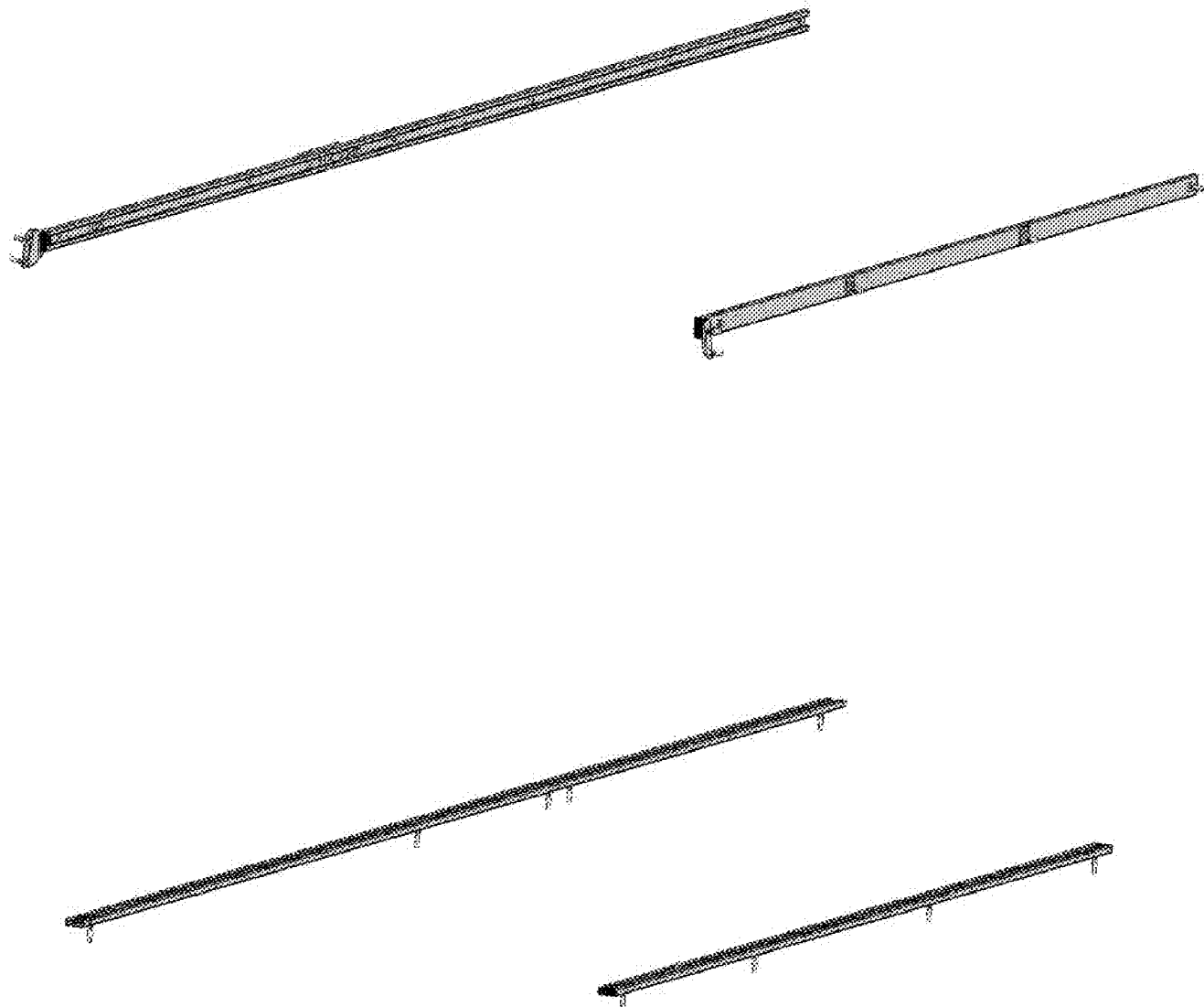


## STEP 5 - ADD SLIDES AND END CAPS TO RAILS





## YOUR INSTALLATION IS NOW COMPLETE



**DOUBLE CHECK ALL FASTENERS LOCATIONS TO BE SURE THAT ALL  
FASTENERS ARE TIGHTENED TO SPECIFICATIONS.  
YOUR INSTALLATION IS NOW COMPLETE!  
STOW THIS COPY IN THE VEHICLE FOR FUTURE REFERENCES!**