



INSTRUCTIONS—INSTRUCCIONES—CONSIGNES

APPLICATION: 2003-2010 KIA SORRENTO
APP PART # 23-2440, 23-2445
E SERIES STEP BARS

AUTOMOTIVE PRODUCTS, INC.

ITEM	QUANTITY	DESCRIPTION	TOOLS NEEDED
1	2	STEP BARS	3/4" SOCKET
2	2	FRONT MOUNTING BRACKETS	13MM SOCKET
3,4	2	REAR MOUNTING BRACKET (3) DRIVERS SIDE, (4) PASSENGER SIDE	10MM SOCKET
5,6	2	FRONT SUPPORT BRACKET (5) DRIVERS SIDE , (6) PASSENGER SIDE 03-05 MODELS	13MM WRENCH
7,8	2	FRONT SUPPORT BRACKET (7) DRIVERS SIDE, (8) PASSENGER SIDE 06-UP	10MM WRENCH
9	2	REAR SUPPORT BRACKETS	RATCHET
10	4	1/2" X 2" HEX HEAD BOLTS	TORQUE WRENCH
11	4	1/2" LOCK WASHERS	
12	4	1/2" ID X 1-1/2" OD X 1/8" FLAT WASHERS	
13	2	M10-1.50MM X 30 MM HEX HEAD BOLTS	
14	2	M10-1.50MM X 35MM BOLT PLATES	
15	4	M10 LOCK WASHERS	
16	4	M10 HEX NUTS	
17	6	M10, 30MM OD X 2.5MM FLAT WASHERS	
18	4	M6-1.00MM X 25MM HEX HEAD BOLTS	
19	4	M6 LOCK WASHERS	
20	4	M6, 22MM OD X 2MM FLAT WASHERS	

1. Remove all contents from box, verify all parts listed are present and free from damage. Carefully read and understand all instructions before attempting installation.
2. From underside of vehicle, remove the driver side front and rear body mount nuts.
3. Starting on the driver side front, partially attach driver side front Mounting Bracket to body mount using the factory hardware (Figure 1 & 3). **06-UP Models** Locate the two holes in the bottom of the body mount, and then insert (1) M10 Bolt Plate through the rear factory hole, so bolt drops through front hole. Partially install the shorter angle bend of front Support Bracket to already inserted Bolt Plate using the included (1) M10 Lock Washer, (1) M10 Flat Washer, and (1) M10 Hex Nut (Figures 1 & 2). Do not tighten at this time. **03-05 Models** There is a factory threaded hole in the frame located by the rear side of front body mount. Partially install the shorter angle bend of front Support Bracket to factory threaded hole using the included (1) M6 Hex Head Bolt, (1) M6 Lock Washer, and (1) M6 Flat Washer. Do not tighten at this time (Figure 4).
4. Loosely attach opposite side of front Support Bracket to rear hole in the already install Mounting Bracket using the included (1) M10 Hex Head Bolt, (1) M10 Lock Washer, (2) M10 Flat Washer, and (1) M10 Hex Nut (Figure 2 & 4).
5. Loosely attach the driver side rear Mounting Bracket to body mount using the factory hardware (Figure 5).
6. Remove the 6mm factory bolt holding the electrical metal wire strap located in the frame by the rear tire (Figure 6). Position rear

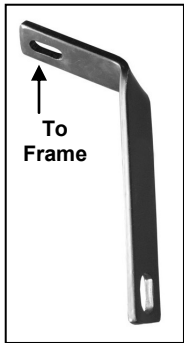


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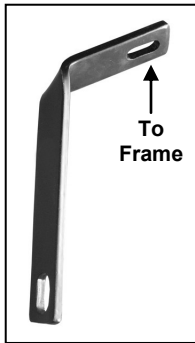
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Support Bracket over metal wire strap and secure them by replacing the factory bolt with the included (1) M6 Hex Head Bolt, (1) M6 Lock Washer, and (1) M6 Flat Washer (Figure 7). NOTE: There are two hole sizes in the Support Bracket use the smaller one to attach it to frame. Do not tighten at this time.

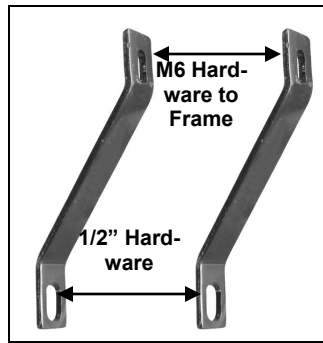
7. With help position Sidebar up to Mounting Brackets and attach it using the included (2) 1/2" Hex Head Bolts, (2) 1/2" Lock Washers, and (2) 1/2" Flat Washers (Figures 8, 9 & 10). NOTE: The opposite side of rear Support Bracket will mount to rear Mounting Bracket using the same 1/2" Hex Head Bolt used to attach Sidebar to rear Mounting Bracket.
8. Level and adjust Side Bar properly; and then tighten all hardware at this time. Torque all 1/2" fasteners to 50-55 ft lbs, M10 to 30-35 ft lbs, and M6 to 25-20 ft lbs.
9. Repeat steps 2-8 for passenger Sidebar.



03-05 Models
Passenger Side
Front Support
Bracket



03-05 Models
Driver Side Front
Support Bracket



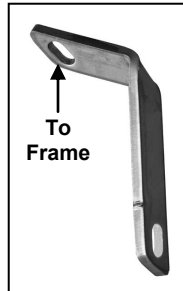
**Rear Support
Brackets**



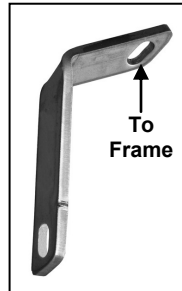
**Driver Side Rear
Mounting Bracket**



**Front Mounting
Brackets**



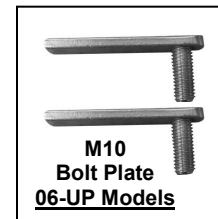
06-UP Models
Passenger Side
Front Support
Bracket



06-UP Models
Driver Side Front
Support Bracket



**Passenger Side Rear
Mounting Bracket**

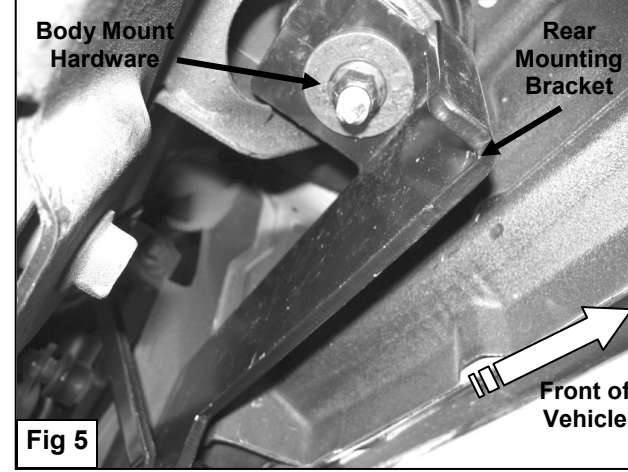
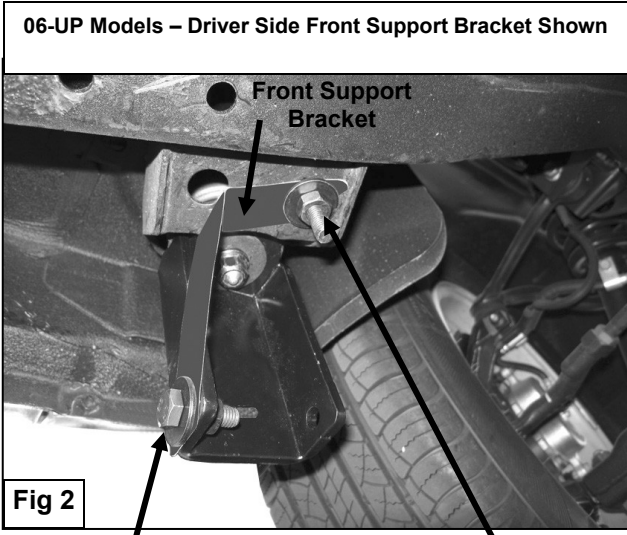
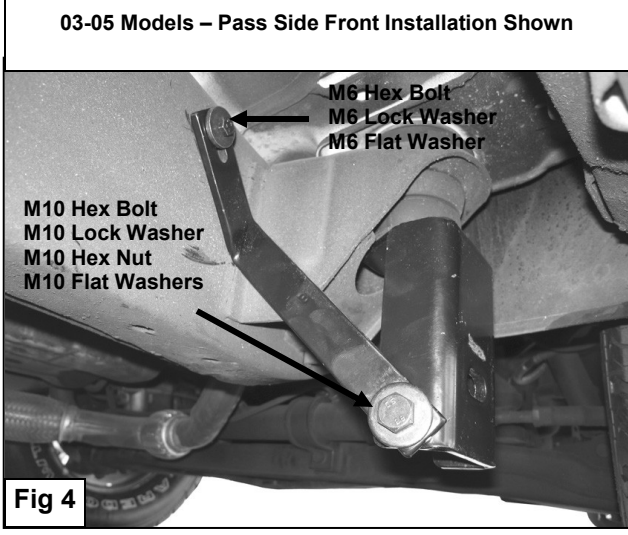
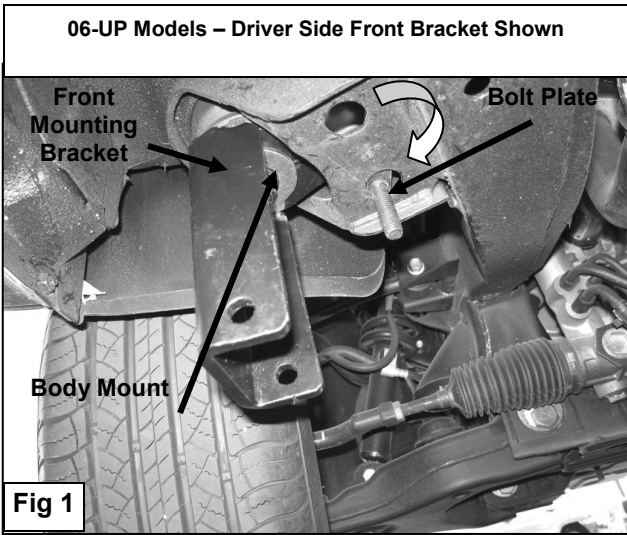


**M10
Bolt Plate
06-UP Models**



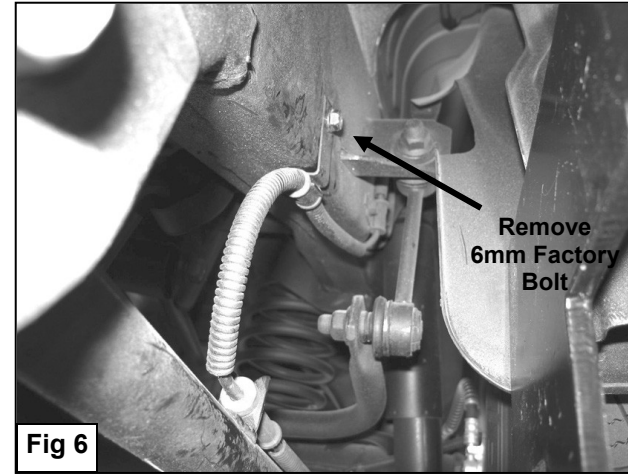
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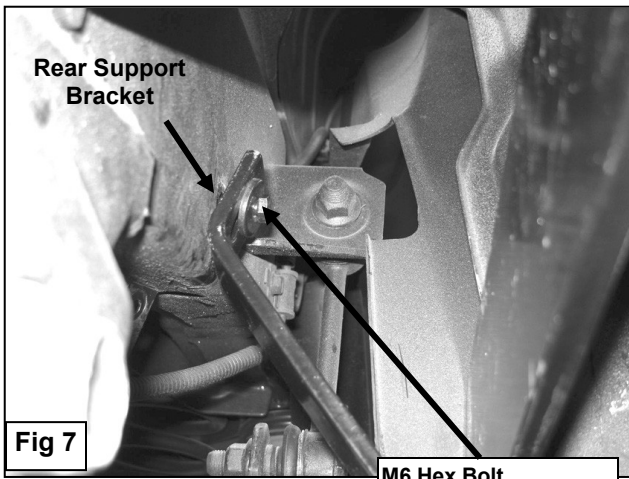
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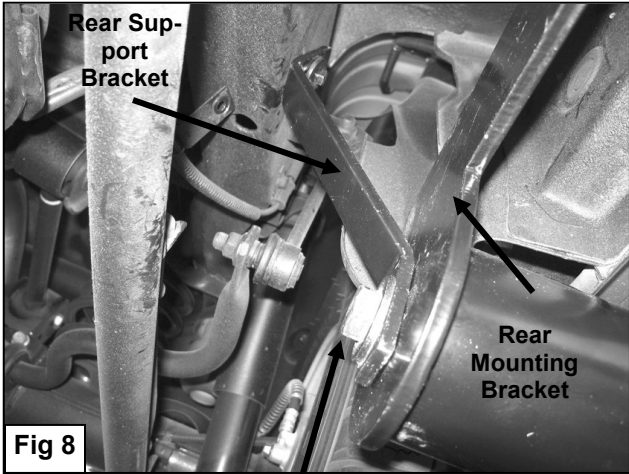
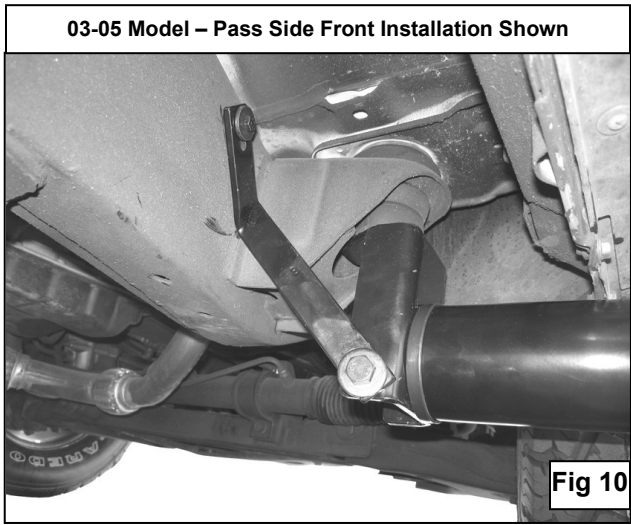
M10 Hex Bolt
M10 Lock Washer
M10 Hex Nut
M10 Flat Washers

(Bolt Plate)
M10 Lock Washer
M10 Hex Nut
M10 Flat Washer

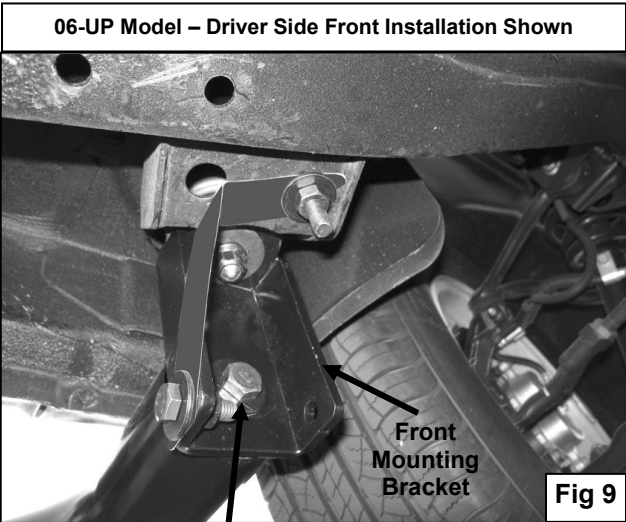
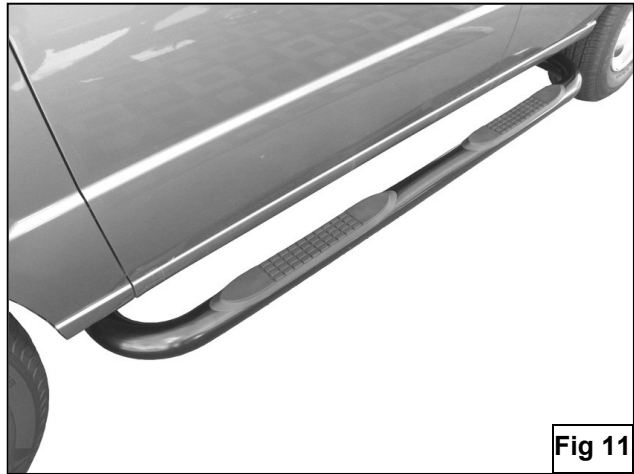




M6 Hex Bolt
M6 Lock Washer
M6 Flat Washer



1/2" Hex Bolt
1/2" Lock Washer
1/2" Flat Washer



1/2" Hex Bolt
1/2" Lock Washer
1/2" Flat Washer



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