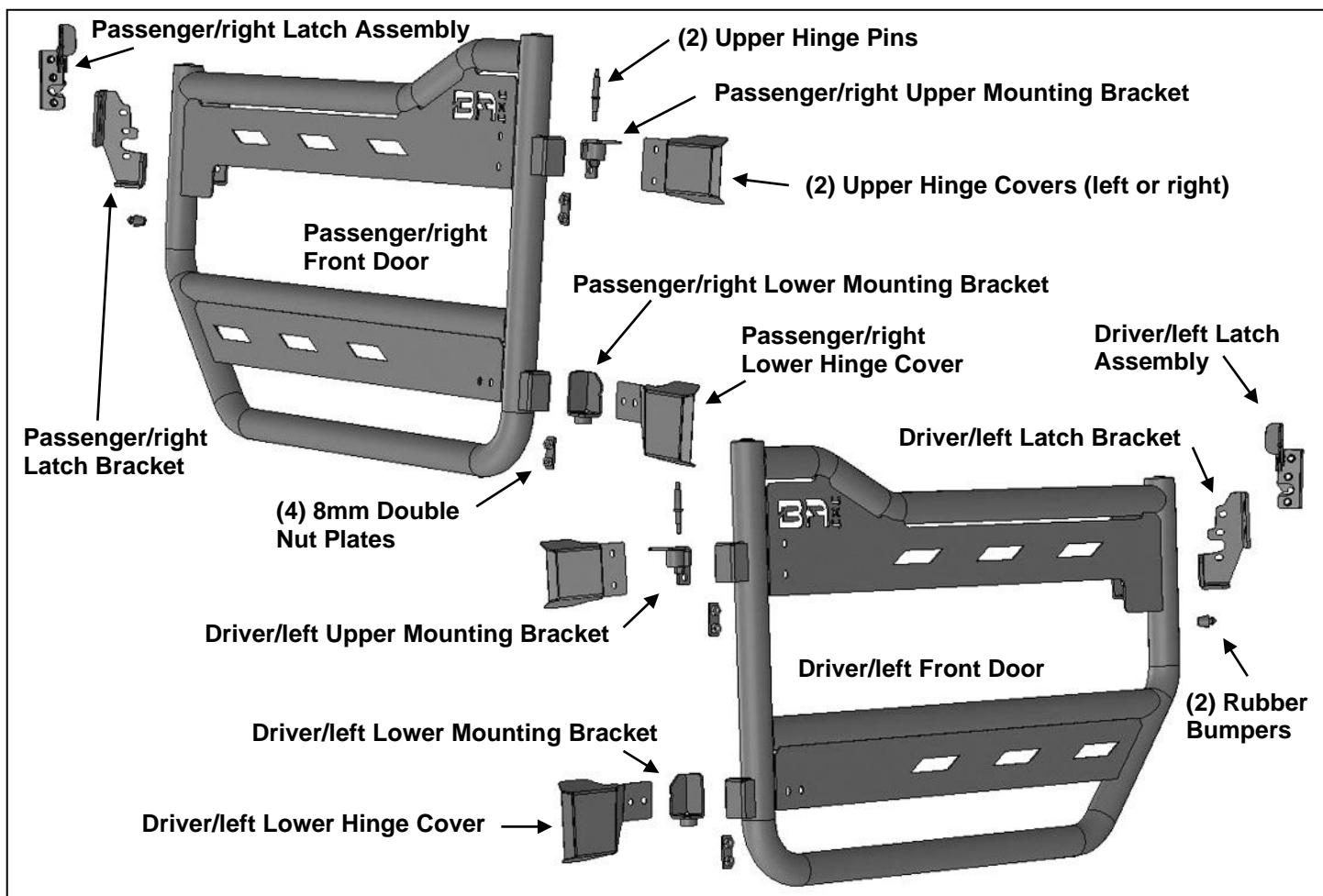


2021-2024 FORD BRONCO FRONT TUBE DOORS PART #FB-6154

PARTS LIST:

1	Driver/left Front Door	4	8mm Double Nut Plates
1	Passenger/right Front Door	6	8mm x 35mm Button Head Bolts
1	Driver/left Upper Mounting Bracket	4	8mm x 25mm Button Head Bolts
1	Passenger/right Upper Mounting Bracket	2	8mm x 30mm Hex Bolts
1	Driver/left Lower Mounting Bracket	8	8mm x 25mm Hex Bolts
1	Passenger/right Mounting Bracket	18	8mm x 16mm x 1.6mm Flat Washers
2	Upper Hinge Pins	10	8mm Lock Washers
2	Upper Hinge Cover Plates	10	8mm Nylon Lock Nuts
1	Driver/left Lower Hinge Cover Plate	8	6mm x 20mm Button Head Bolts
1	Passenger/right Lower Hinge Cover Plate	20	6mm x 18mm x 1.6mm Flat Washers
1	Driver/left Latch Assembly	12	6mm Lock Washers
1	Passenger/right Latch Assembly	12	6mm Hex Nuts
1	Driver/left Latch Bracket	1	5mm Wrench
1	Passenger/right Latch Bracket	1	4mm Wrench
2	Rubber Bumpers		





INSTALLATION INSTRUCTIONS

PROCEDURE:

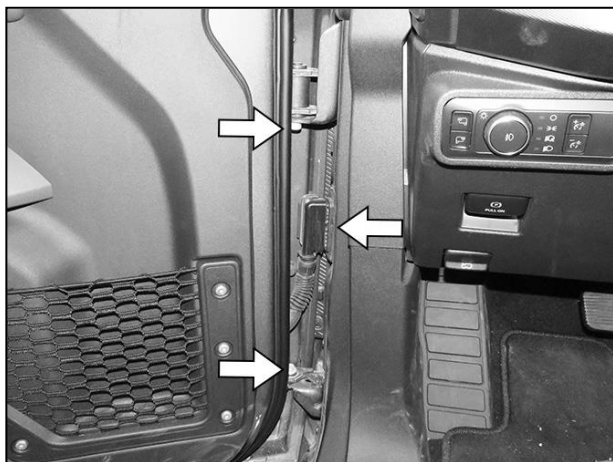
REMOVE CONTENTS FROM BOX. VERIFY ALL PARTS ARE PRESENT. READ INSTRUCTIONS CAREFULLY BEFORE STARTING INSTALLATION. ASSISTANCE IS RECOMMENDED.

1. Start installation at the driver/left front door. Unplug the wiring harness leading to the door, **(Figure 1)**.
2. Remove the hardware attaching the top and bottom hinges to the door frame and remove the door, **(Figure 1)**. Refer to owner's manual for full door removal instructions.
3. Select (1) Hinge Pin, **(Figure 2)**. Slide the Pin down into the upper door mount on the vehicle, **(Figure 3)**. Attach the Pin to the mount with the included (1) 6mm Flat Washer, (1) 6mm Lock Washer and (1) 6mm Hex Nut, **(Figure 4)**. Tighten Hex Nut.
4. Carefully unwrap the driver/left Tubular Door assembly. Select the Upper Door Mounting Bracket, **(Figure 5)**. Attach the Bracket to the back of the Door with the included (2) 8mm x 25mm Hex Bolts, (2) 8mm Lock Washers, (2) 8mm Flat Washers and (1) 8mm Double Nut Plate, **(Figure 6)**. Do not fully tighten hardware.
5. Next, select the Lower Door Mounting Bracket, **(Figure 7)**. Attach the Bracket to the lower mount on the back of the Door with the included (2) 8mm x 25mm Hex Bolts, (2) 8mm Lock Washers, (2) 8mm Flat Washers and (1) 8mm Double Nut Plate. Do not fully tighten hardware.
6. Select the driver/left Latch Mounting Bracket, **(Figure 8)**. Attach the Bracket to the mount on the rear of the Door with the included (2) 8mm x 25mm Button Head Bolts, (4) 8mm Flat Washers and (2) 8mm Nylon Lock Nuts. Do not fully tighten hardware at this time. Push (1) Rubber Bumper into the hole in the Latch Mounting Bracket.
7. Attach the driver/left Latch Assembly to the Mounting Bracket with the included (3) 8mm x 35mm Button Head Bolts and (3) 8mm Nylon Lock Nuts, **(Figure 9)**. Do not fully tighten hardware at this time.
8. Apply a small amount of waterproof grease to the Hinge Pin and lower door Mounting Bracket. **NOTE:** Grease not included.
9. Carefully hold the door in place over the hinges on the vehicle. Guide the Upper Door Mounting Bracket down and onto the Hinge Pin, **(Figures 10 & 11)**. Slide the Lower Mounting Bracket over the lower door mount. Secure the Door Bracket to the Hinge Pin with (1) 6mm Flat Washer, (1) 6mm Lock Washer and (1) 6mm Hex Nut, **(Figure 11)**. Leave Hex Nut loose.
10. Attach the bottom Hinge Bracket to the top of the lower hinge with the included (1) 8mm x 30mm Hex Bolt, (1) 8mm Lock Washer and (1) 8mm x 25mm Flat Washer, **(Figures 10 & 12)**. Do not fully tighten hardware at this time.
11. Open and close the door a few times to center the hinge pin in the hinge. Center the Door assembly in the opening in the vehicle. Adjust as necessary and fully tighten Hinge to Door hardware only.
12. Adjust the position of the Latch assembly. Slowly close the door and check to see if the Latch is lined up with the striker, **(Figure 13)**.
13. Adjust the Latch up or down to line up with striker, **(Figure 13)**. **IMPORTANT:** Make sure Latch will fully close and open properly before fully tightening Latch hardware, **(Figure 14)**.
14. Once Door is fully adjusted, tighten the top 6mm Hex Nut and bottom 8mm Hex Bolt hardware on the Hinges until there is slight resistance in the door operation, **(Figures 10—12)**.
15. Select (1) Upper Hinge Cover, **(Figure 15)**. Attach the Cover to the outside of the Door with the included (2) 6mm x 20mm Button Head Bolts, (4) 6mm Flat Washers, (2) 6mm Lock Washers and (2) 6mm Hex Nuts, **(Figure 16)**. Next, Select the driver/left Lower Hinge Cover, **(Figure 17)**. Repeat this Step to attach the Lower Hinge Cover, **(Figure 18)**.
16. Repeat **Steps 1—15** to install the passenger/right Door assembly.
17. Do periodic inspections to the installation to make sure that all hardware is secure and tight.

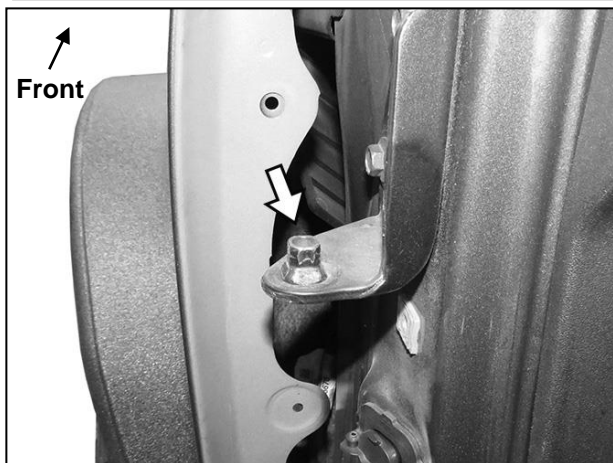
PRODUCT CARE AND MAINTENANCE

- Textured coat finished should be cleaned ONLY with a mild soap on a damp sponge.
- BA recommends wiping down the product with a light coat of lubricate (i.e. WD40) periodically to maintain its luster.
- DO NOT apply polish or wax that requires buffing for removal as this may damage the finish.
- DO NOT coat the product with any type of shine such as Tire Shine or glossy aerosol or gel. This can cause discoloration, staining or bubbling.

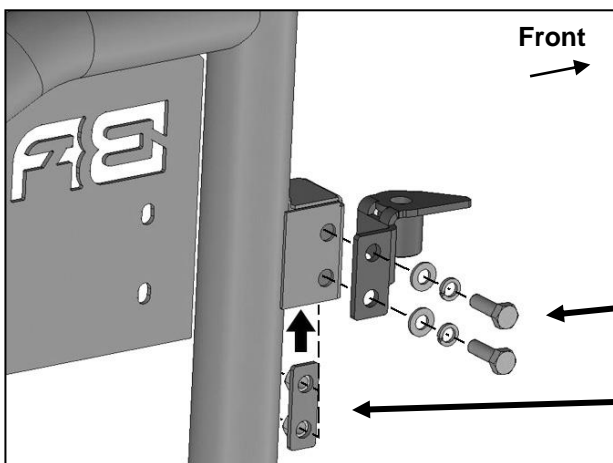
Driver/left Side Installation Pictured



(Fig 1) Unplug wiring harness leading to door. Remove hardware attaching door to vehicle (arrows)



(Fig 3) Driver/left upper door mount

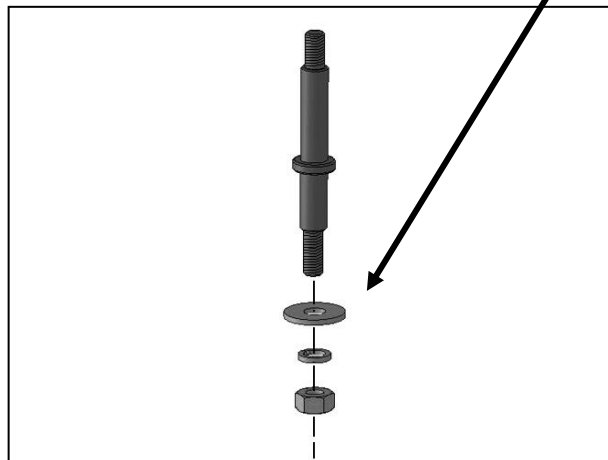


(Fig 5) Attach driver/left Upper Mounting Bracket to mounting tab on back of Door

(2) 8mm x 25mm Hex Bolts
(2) 8mm Lock Washers
(2) 8mm Flat Washers

8mm Double Nut Plate

6mm Flat Washer
6mm Lock Washer
6mm Hex Nut



(Fig 2) Attach Hinge Pin to driver/left upper door mount (Figure 3)

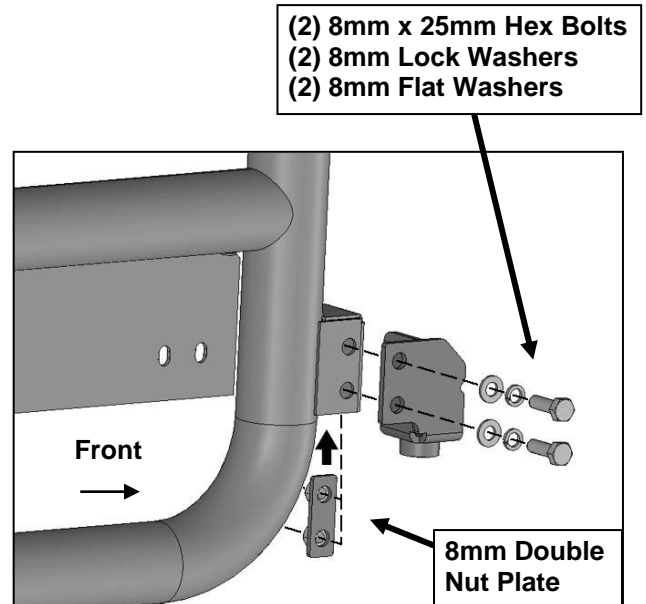


(Fig 4) Upper Hinge Pin installed

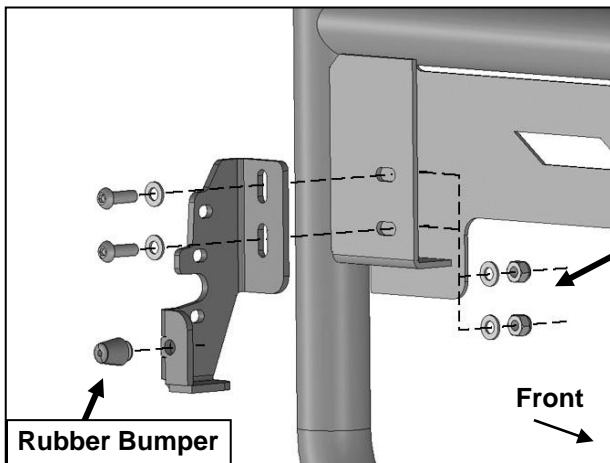
Driver/left Side Installation Pictured



(Fig 6) Driver/left Upper Mounting Bracket attached to back of Door

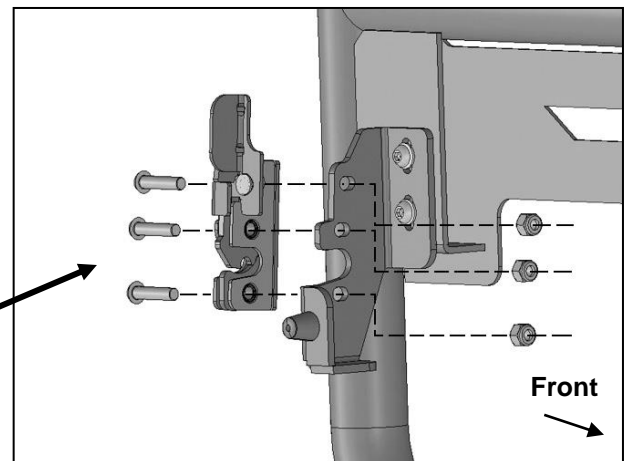


(Fig 7) Attach driver/left Lower Mounting Bracket to mounting tab on back of Door



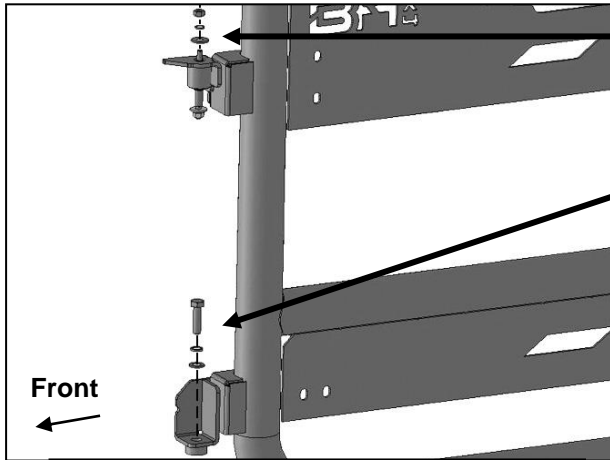
(Fig 8) Attach driver/left Latch Mounting Bracket to mounting tab on back of Door. Push Rubber Bumper into hole in Bracket

(3) 8mm x 35mm Button Head Bolts
(3) 8mm Nylon Lock Nuts



(Fig 9) Attach driver/left Latch to Mounting Bracket

Driver/left Side Installation Pictured

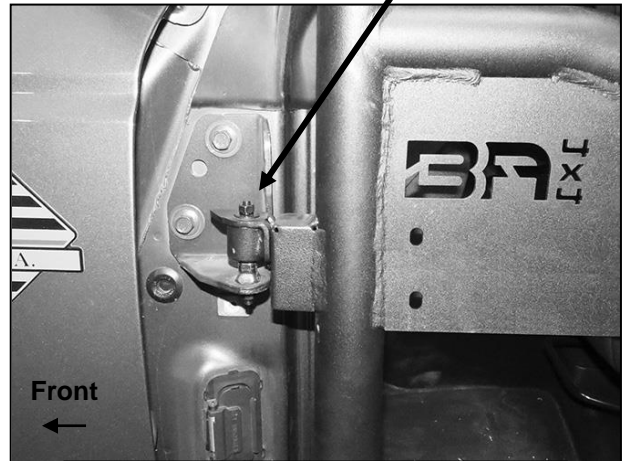


(Fig 10) Lift door, guide upper and lower Mounting Brackets onto Hinge Pin and lower mounting post

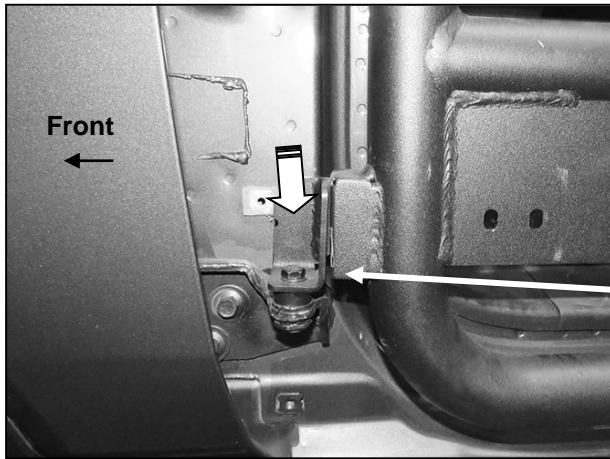
6mm Flat Washer
6mm Lock Washer
6mm Hex Nut

8mm x 30mm Hex Bolt
8mm Lock Washer
8mm Flat Washer

6mm Flat Washer
6mm Lock Washer
6mm Hex Nut

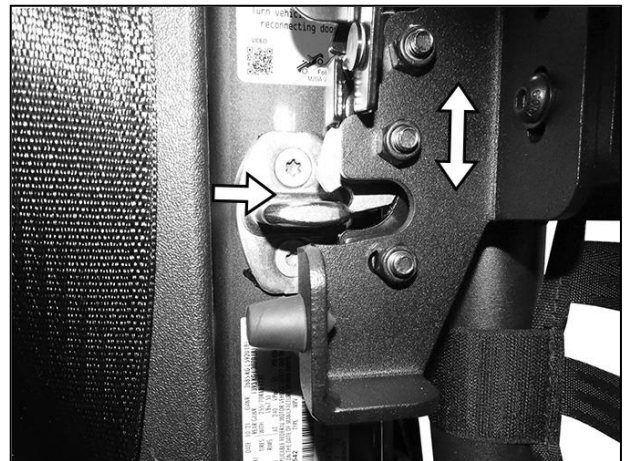


(Fig 11) Attach upper Door Mounting Bracket to Hinge Pin (also see Fig 10)

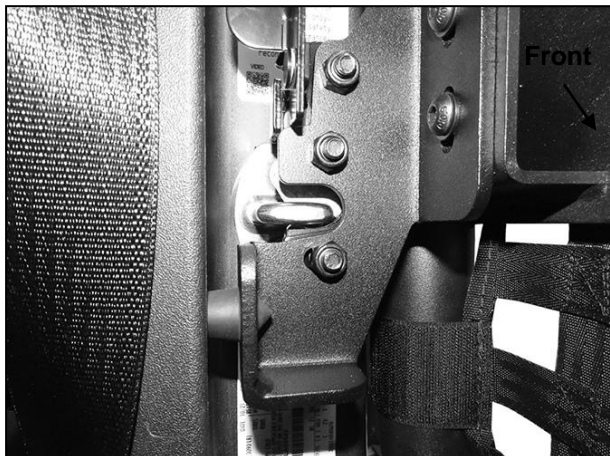


(Fig 12) Attach lower Door Mounting Bracket to door mount (arrow, also see Fig 10)

8mm x 30mm Hex Bolt
8mm Lock Washer
8mm Flat Washer

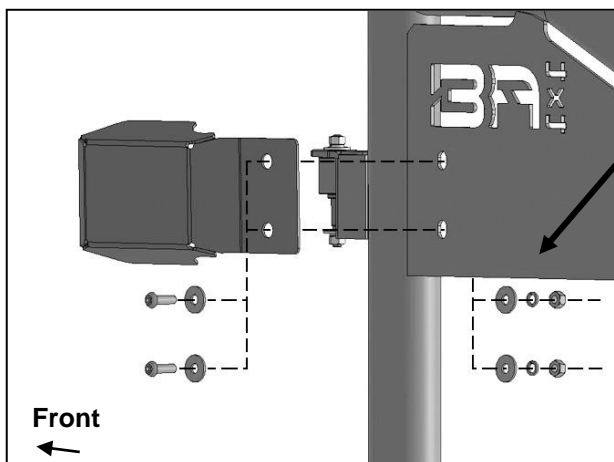


(Fig 13) Open Latch. Adjust latch Bracket up or down for proper operation.



(Fig 14) With Latch fully closed, adjust latch Bracket up or down to rest on striker

Driver/left Side Installation Pictured

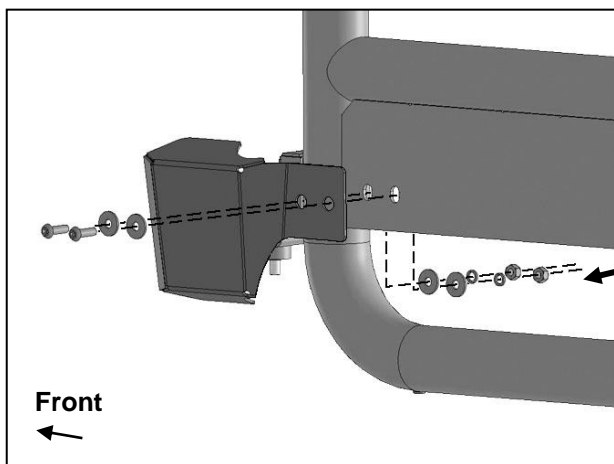


(Fig 15) Attach Upper Hinge Cover to door

- (2) 6mm x 20mm Button Head Bolts
- (4) 6mm Flat Washers
- (2) 6mm Lock Washers
- (2) 6mm Hex Nuts



(Fig 16) Attach Upper Hinge Cover to door



(Fig 17) Attach Lower Hinge Cover to door

- (2) 6mm x 20mm Button Head Bolts
- (4) 6mm Flat Washers
- (2) 6mm Lock Washers
- (2) 6mm Hex Nuts



(Fig 18) Attach Lower Hinge Cover to door



Complete Installation

Webbing Installation

Proceed to lay the door frame onto the webbing in the proper orientation.

Wrap the bottom wrap and attach the Velcro inside.

Wrap the Velcro straps on the sides around the tubing.

Feed the Velcro tabs on the top portion of the webbing through the door.



Wrap and attach the Velcro strips together across the top portion of the door.

