

SBC X3 SLIDER INSTALL

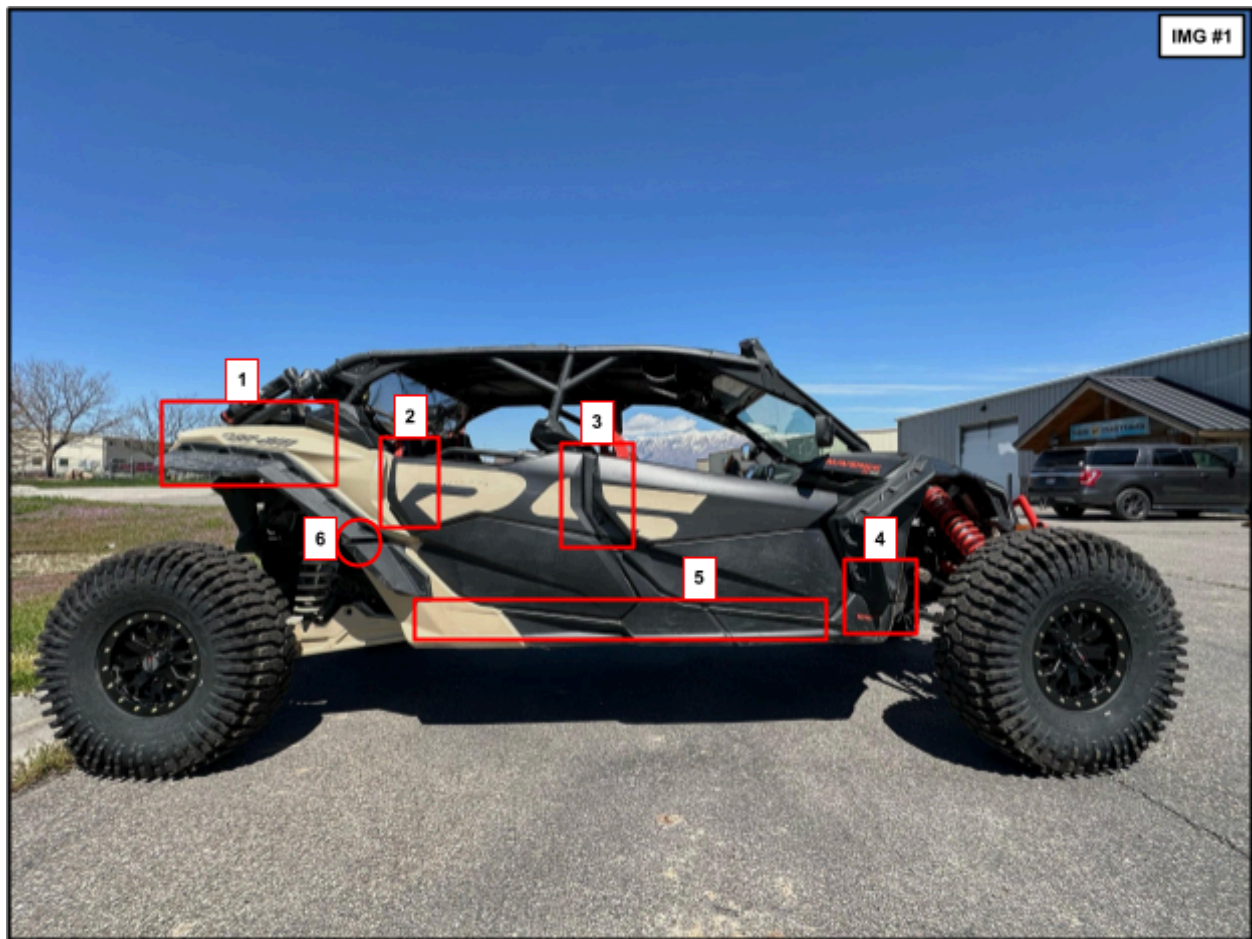


Image Zones for Installation Work: 1) Rear Quarter-Panel, 2) Rear Door Hinge, 3) Front Door Hinge, 4) Front Wheel-Well & Kick Panel, 5) Rocker-Panel, 6) Rear Wheel-Well

Tools Needed:

- | | | |
|----------------------------|--------------------------------------|-----------------|
| - Drill | - 3/16in. Drill Bit | - Hammer |
| - Cold Chisel | - Pin Punch | - T-30 Torx Bit |
| - T-20 Torx Bit | - 5mm Allen Wrench | - 1/2in. Socket |
| - 9/16in. Socket | - 9/16in. Open End Wrench | - Rivet Gun |
| - Impact Driver or Ratchet | - PPE (Safety Glasses, Gloves, etc.) | |

Job Duration: 2-3 Hours

DISCLAIMER:

Perform this procedure at your own risk. Side By Customs, its owner(s), and its employee(s) are in no way responsible for any bodily injury or property damage that may occur during the execution of the procedure described in this document.

Please read and be familiar with all procedure steps before starting this installation. This procedure does not account for any aftermarket accessories installed on the vehicle.

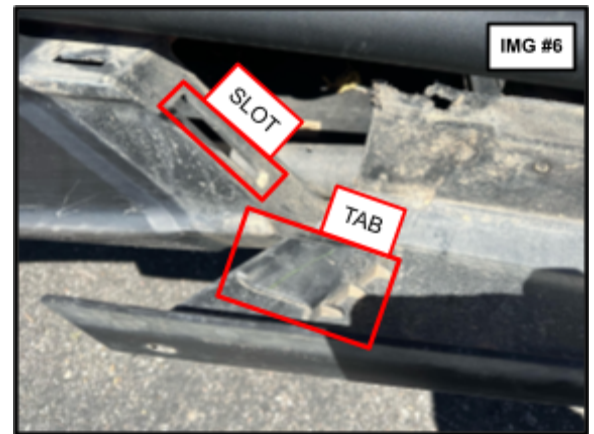
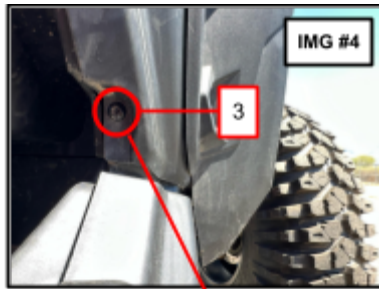
Pictures and verbage included pertain to the Max, however, most all steps apply to the 2 seat X3 as well.

LOWER PLASTICS REMOVAL:

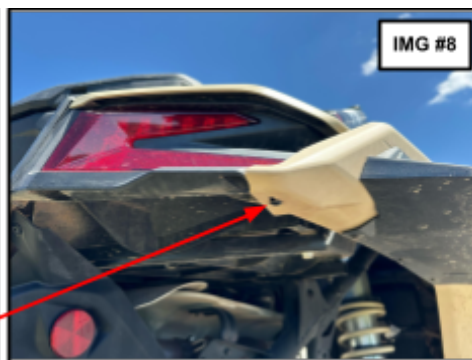
- The lower plastics have three sections referred to as Forward (**FPS**), Center (**CPS**), and Rear Plastic Sections (**RPS**) in this document.
 - ***All steps referring to **CPS** are **ONLY APPLICABLE** to the 4-Seat Vehicle (MAX).***
 - All steps are performed on both sides of the vehicle. Any differences are noted in the applicable steps herein.
1. Using Drill and 3/16" bit, drill out the center and remove all rivet heads securing lower plastics to the vehicle undercarriage. See photo below. DO NOT remove any rivet securing the plastic belly-pan/skid plate.
 - 2-Seat Vehicle has (6) rivets per side, 4-Seat (MAX) Vehicle has (9) rivets per side.
 - It may be necessary to use the hammer and cold chisel to fully remove the rivet heads.



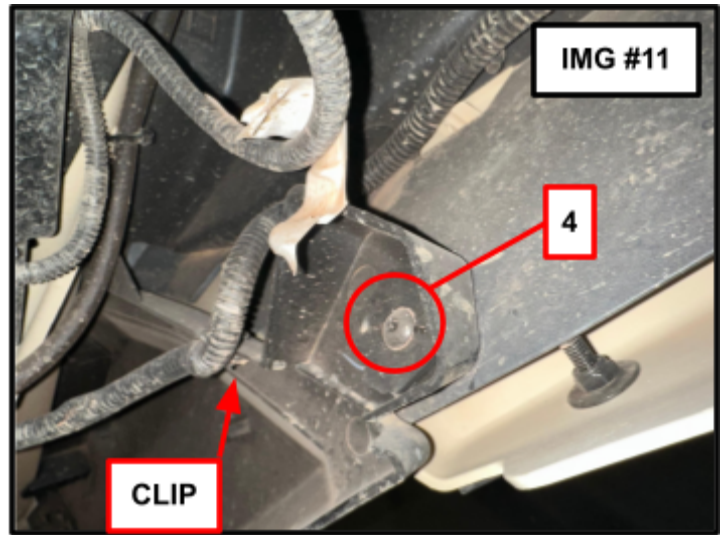
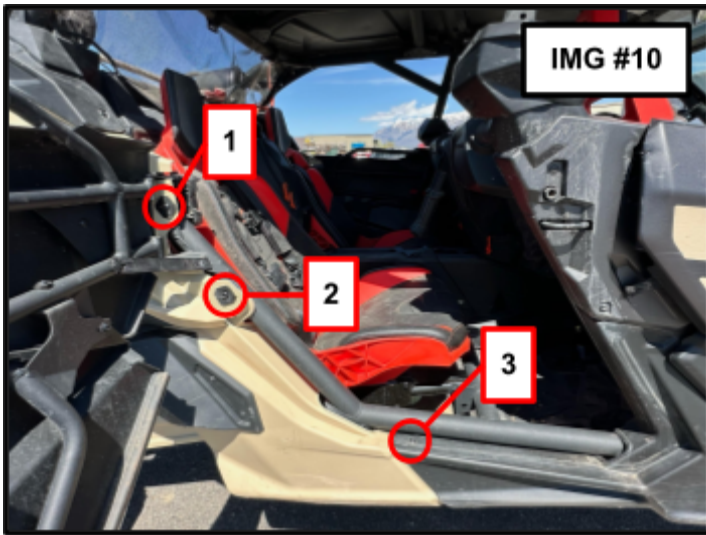
2. Pry the (now free) edge of the plastics downward to clear the remaining rivet shanks.
3. Remove the (4) T-30 screws securing the front plastic section:
 - (2) in the Front Wheel-Well
 - (1) in the Front Kick Panel
 - (1) on top of front seat Rocker Panel



4. Pull front corner of FPS down and away from Front Wheel-Well to separate the overlapped trims.
 - Plastics will flex/deform as they slide free. Bottom-out rotation may be necessary.
 - The rear end of the FPS is tabbed into the CPS via slot, (see image above). This last interlock will come free as you pull the corner out and away.
5. Reinstall T-30 screws #1 and #3*.
 - * Screw #3 only needs to be replaced on the driver's side of the vehicle. Passenger side screw may be discarded.
 - Screw #2 (and threaded clip) and #4 no longer secure anything to the vehicle and may be discarded.
6. Remove (5) T-30 and (1) T-20 screws securing Rear Quarter-Panel to vehicle at top of Rear Quarter-Panel.



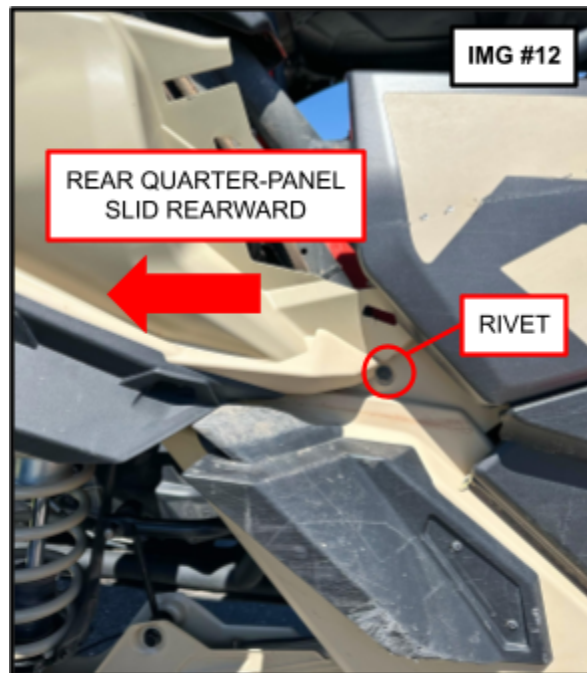
- Remove the (5) trim clips, by hand, by pressing upward from inside the Rear Fender Well after T-30s are removed.
 - It may be necessary to move the rear shock reservoir to access one or more of the T-30 screws, use a 5mm allen wrench to loosen the mounting bracket.
7. Remove remaining (4) T-30 screws and wire harness clip securing Rear Quarter Panel, IMG #10 & #11.



- Screw #4 is accessed from the inside of the Rear Wheel Well behind Area #6 in IMG #1.
- Set aside screw #1 and washer, and screw #4 to be reinstalled later.
- Wire clip will slide off the trim edge by hand.

8. Slide Rear Quarter-Panel backward on the vehicle and close the rear door to expose the rivet in IMG #12.

- It is not necessary to completely remove the quarter-panel to perform this step.



9. Remove rivet head using same method from step one.

- After rivet head is removed, drive remaining shank into the frame using Pin Punch.

10. Remove RPS from vehicle. It is tabbed into the CPS similar to IMG #6.

11. Reinstall Rear Quarter-Panel with hardware shown in IMGs #7-9 and T-30 screw/washer #1 in IMG #10.

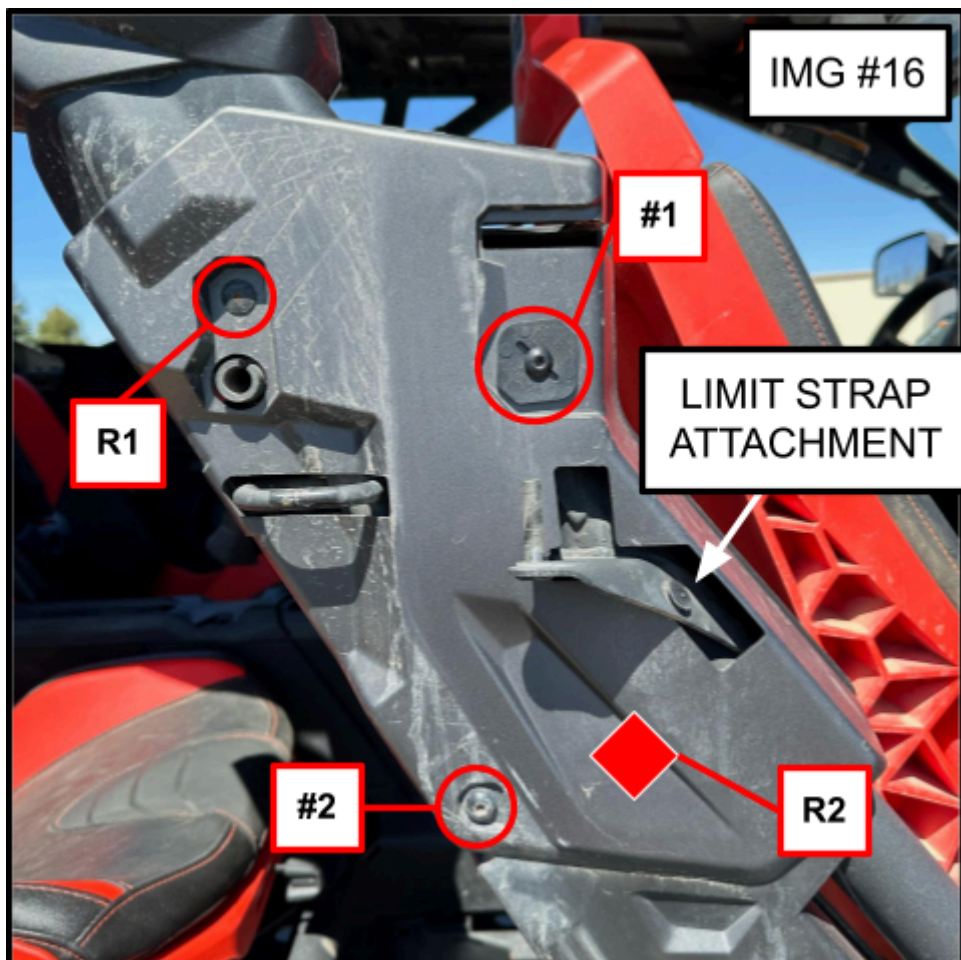
- Keep screw #4 (IMG #11) for install of SBC Slider.
- Wire may be re-secured at owners discretion. Original clip placement is no longer available.

12. Partial Front Door Removal. This step can be performed without detaching the limit strap.

- Remove the (2) 1/2in bolts at the top of the front door hinge, IMG # 13 & #14.
- With front door open, swing upper hinge pivot into the door panel for clearance (IMG #15) and lift door off of hinge pin.
- ★ The door plastics will need to be gently flexed out of the way to allow for door lift.
- Set door aside (in front of rear door), gently, as it is still attached at the limit strap.



13. Remove the Front Hinge/Rear Latch plastic trim to gain access to hidden rivet (R2), IMG #16.



- Remove (2) T-30 screws and rivet (R1) using the same method as Step 1.

- Pull trim from frame and slide along limit strap (not shown in image) to expose hidden rivet (R2).
- Remove R2 using the same method as Step 1.

★ Using Pin Punch, drive remnant rivet shanks into frame at R1 and R2.

14. Remove the, now detached, lower CPS from the vehicle.

15. Reinstall Front Hinge/Rear Latch plastic trim.

- Slide trim back along limit strap and resecure screws #1/washer, and #2.
- R2 fastener location will not be reused.
- Replace R1 with supplied rivet or use self-tapping type screw (NOT supplied).

16. Reinstall front door by reversing Step 12.

17. Remove plastic knock-out at lower C-Pillar, IMG #17- #19.



- TIP: A hooked roofer's razor blade is helpful to cut the (4) knock-out tabs.

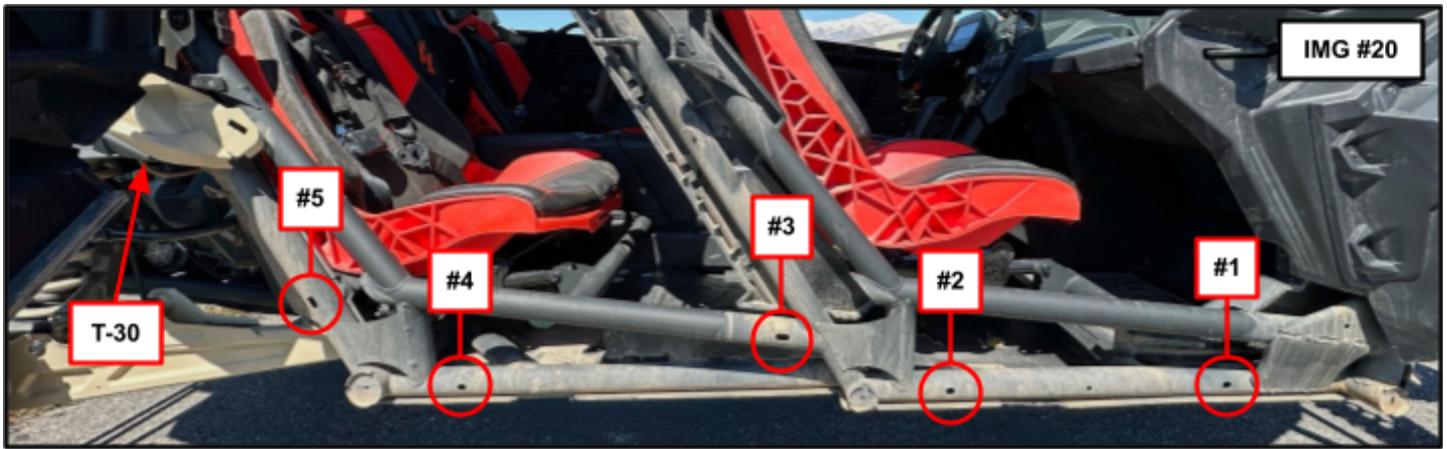
SBC SLIDER INSTALLATION

1. Assemble SBC Sliders

- Install aluminum accent trim to slider skins (front and rear sections) using 1/4-20 x 5/8in T-30 screws and Nylock nuts.
- Attach rear slider section to front section using 4-hole tie-plate with 1/4-20 x 5/8in T-30 screws, washers, and Nylock nuts.
 - ★ Minimize the gap between sections and ensure alignment along that seam.
 - ★ Due to the extreme variability in the frame manufacturing process, it may be necessary to loosen the tie-plate fasteners to facilitate final fitment.

2. Install SBC Slider

- Familiarize yourself with the different access for each of the frame through-holes (IMG #20) for slider mounting.
 - ★ Some access is inside the cabin while the remainder is from under the vehicle.
 - ★ A pen magnet can be useful to place mounting bolts or retrieve them if dropped.



- Fit SBC Slider up to vehicle ensuring that rear-most slotted point lands inside rear wheel-well.
- Support slider in place a stand or a friend and loosely install the (5) $\frac{3}{8}$ -16 x 3in bolts, washers, and Nylock nuts.
 - ★ A hydraulic floor jack can be helpful for support adjustment during install.
 - ★ Each bolt gets 2 washers, one for the slider-side of the bolt and the other for the cabin-side of the frame, adjacent to the Nylock.
- Secure the rear tail-section slider slot to the inside of the rear wheel-well by reinstalling the T-30 (#4) screw from IMG #11 in its original threaded retaining clip and location.
- Tighten the (5) mounting bolts incrementally while adjusting slider fitment. Pull front slider corner-cap as close as possible to front wheel-well plastics for final fitment.
 - ★ Final fit will vary from vehicle to vehicle due to variations in the frame manufacturing process.