



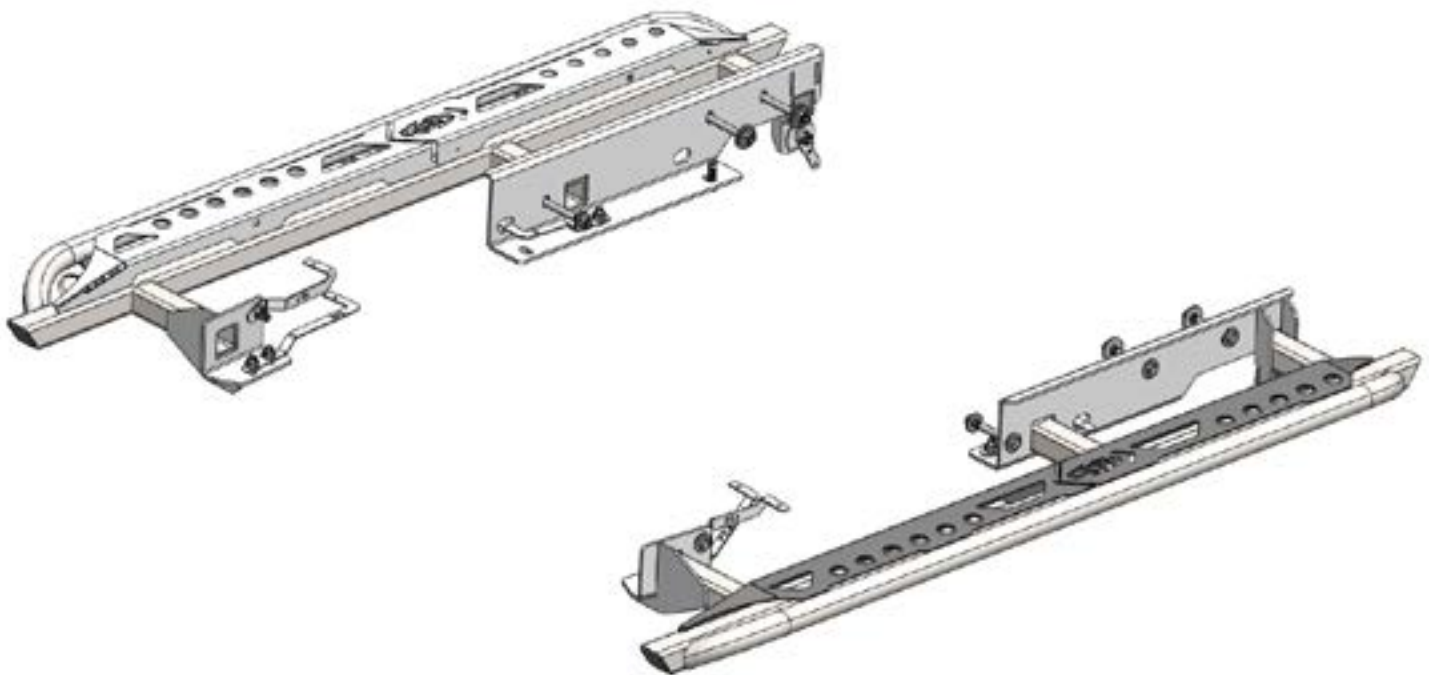
SIGNATURE SERIES

BRONCO

BRONCO 4DR
SIGNATURE SLIDERS



VERIFY YOU HAVE ALL THE COMPONENTS BEFORE STARTING THE INSTALLATION. REFER TO THE ENGINEERING DRAWINGS AT THE END OF THIS DOCUMENT FOR A COMPLETE PARTS LIST



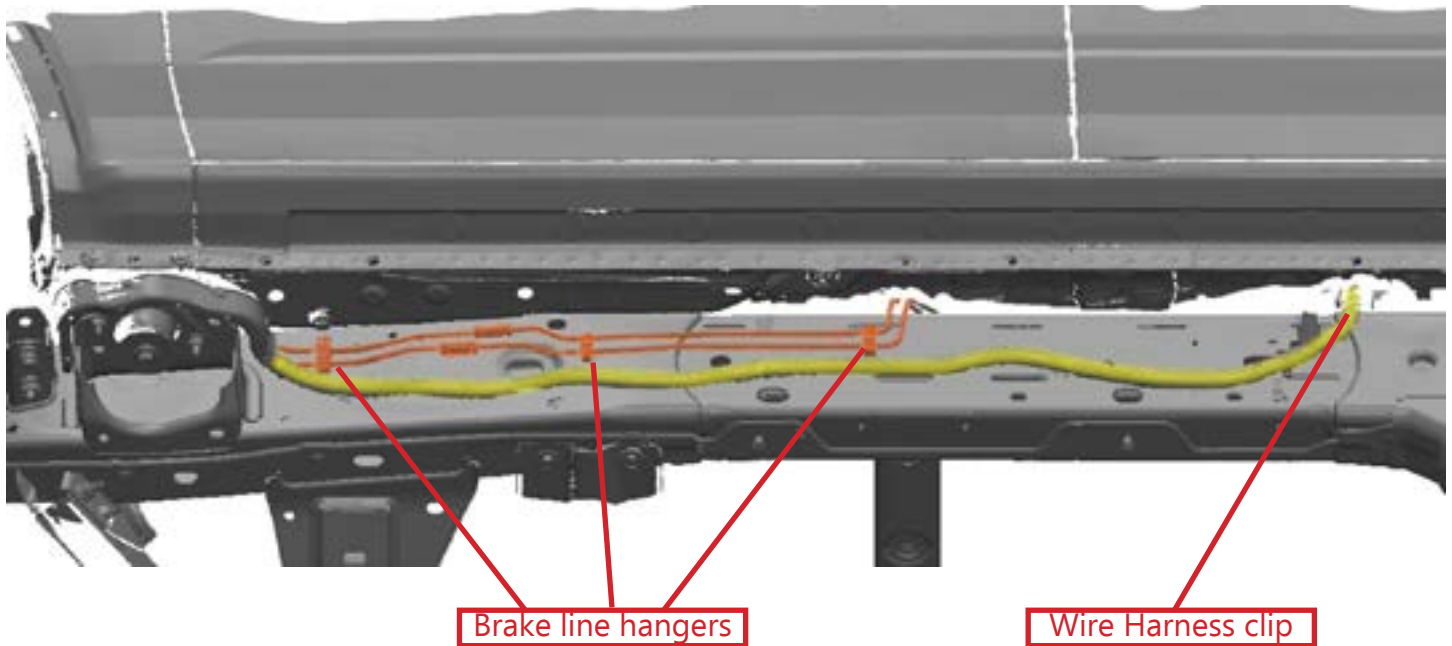
Refer to the Engineering drawing included with this document for the correct hardware required at each step of the installation. Verify you have all components before proceeding with your install. Read and understand the instructions before you start your installation.

Prep the frame before installation:

The driver side of your frame has a wire harness and some brake lines that need to be repositioned prior to installing your sliders. The image below highlights the wire harness and brake line.

Use a small pry tool or flat blade screwdriver to pry the 3 plastic hangers on the brake line from the frame. Also pry the multiple wire harness hangers from the frame.

Towards the back of the frame the wire harness loops up and over the top of the frame rail. There is a plastic clip on the wire harness that is snapped into the top of the frame rail. Push up on this plastic clip to pop it off the frame slightly. Leave everything loose while you install your sliders, you will resecure them after installation.



Check the bottom and side of your Bronco Frame where your sliders will mount. Some welds may be excessive or drippy and need to be ground flat with a hand grinder for proper slider positioning.

Use an angle grinder with a flap disc or other grinder to flatten and smooth out the welds if needed. Be sure to clean up the area after grinding and touch up with Rustoleum or equivalent spray paint to prevent rust.

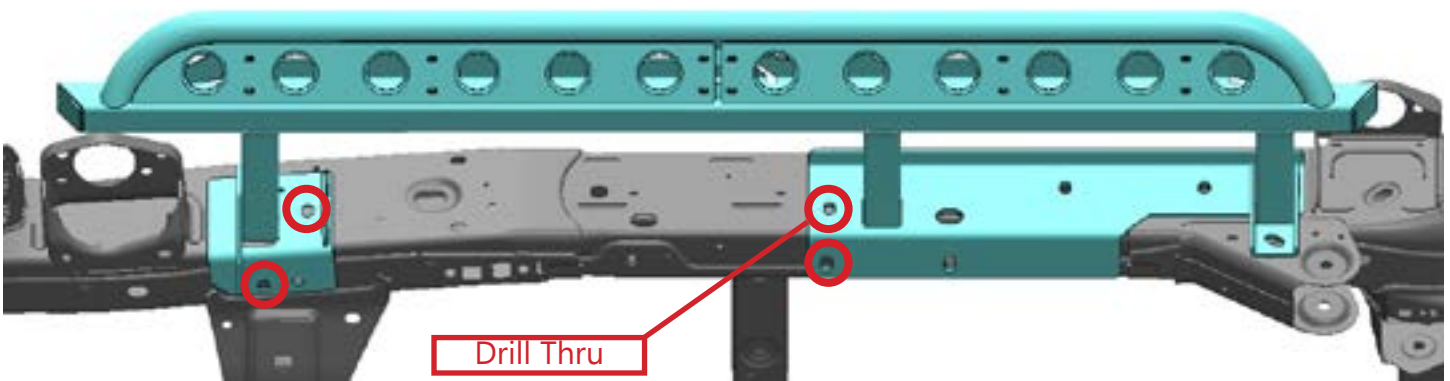
Drilling the Mounting Holes:

We recommend drilling the optional holes if you intend to use the sliders for anything more than a step. To mark the holes that need drilled you will need to temporarily mount the slider and then use a marker or hole punch to mark the frame. However it is possible to drill the frame with the slider installed if you have a Right Angle Drill.

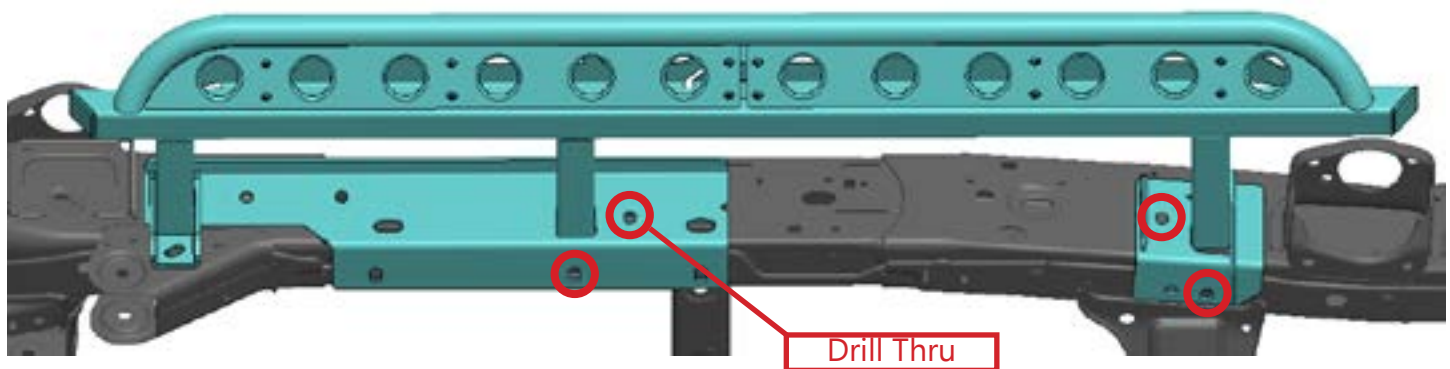
Follow the diagram below which shows the 4 holes (4 on each side) that need drilled for the driver and passenger side sliders. Two of the holes (one on each side) are marked on the diagram as "Drill Thru", these two locations you will drill thru both sides of the frame.

****Be sure to double check the backside of the frame for obstructions before drilling! Especially on the passenger side near the gas tank!****

Driver Side



Passenger Side



To temporarily mount the slider, follow the mounting instructions below. Make sure you install all the bolts into the bottom of the frame rail on the front and rear mounts, and at least 1 into the side of the frame before marking the other holes for drilling. You don't need to fully tighten the bolts at this time, just make sure they are snug before marking the holes.

Once the holes are marked you can remove the slider. Use a center punch to dimple the steel at the center of each marked hole for drilling. We recommend starting with a smaller bit 3/16" or 1/4" inch and then finishing with a 1/2" drill bit.

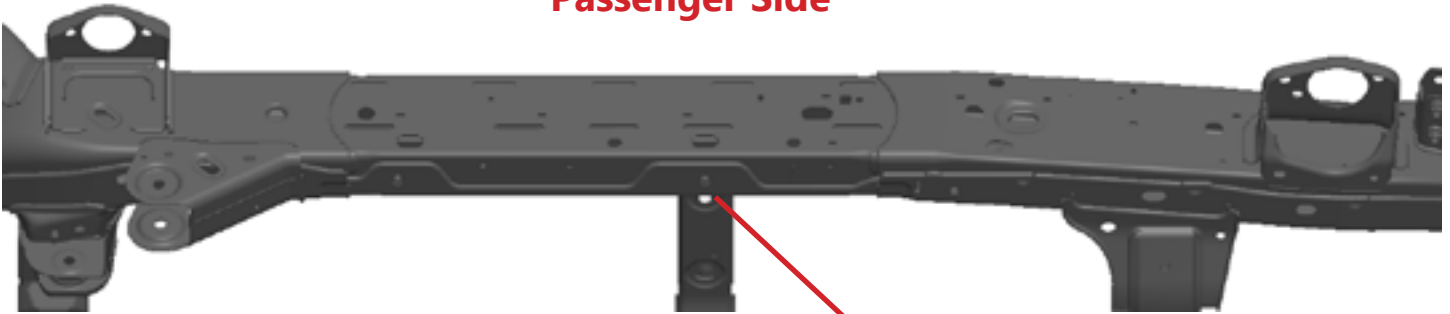
Once all the holes are drilled, clean any burrs off with a file or deburring tool. Clean the area and use a Rustoleum or equivalent spray paint to coat the drilled holes to prevent rust.

Installing the Passenger Side Slider:

Installing the sliders will require 2 people due to the size and weight of the slider.

Start with the Passenger Side slider first, it's a little easier to install because there are no brake lines or wire harness in the way.

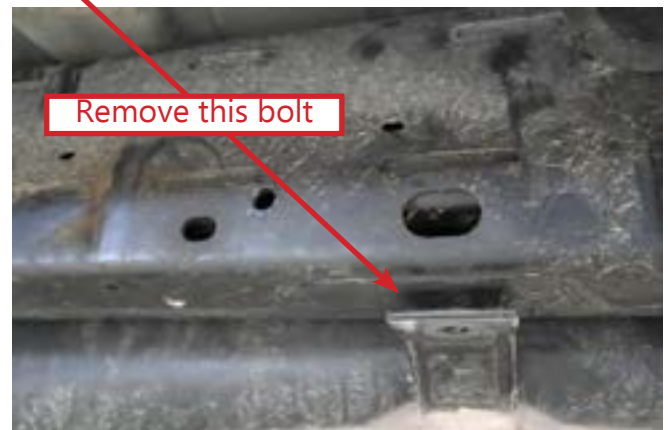
Passenger Side



Start by removing the bolt which holds the gas tank strap or skid plate in place near the center of the frame.

Pull down on the strap slightly to create a gap for the slider mount to fit into. The slider mount will fit between the strap and the frame.

If you have a gas tank skid plate, you may need to loosen several bolts to allow it to drop slightly.



Set the passenger slider into position on the frame.

Make sure the slider mount fits between the gas tank strap or skid plate and the frame.

Loosely reinstall the bolt near the center support to hold the slider in place.



Loosely install the metric M12 x 45mm long hex bolt into the bottom of the frame. There should be a frame nut already in this position for the gas tank skid plate.

The metric bolts in your bolt kit will have the number 8.8 stamped on the head of the bolt.



If you have gas tank skid, your slider mount will fit between the skid and the frame just like in the previous step.

Loosely install the $\text{\O}1/2'' \times 4.50''$ long hex bolts thru the frame on the Rear Mount.

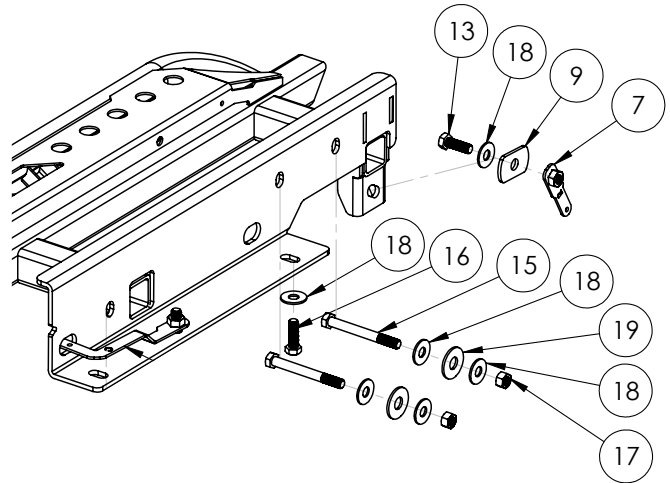
The holes in the frame in these two locations are large. You will need to use two washers on the inside of the frame. Use the larger $\text{\O}5/8''$ washer and a $\text{\O}1/2''$ washer for each bolt.

When these bolts are tightened, be sure to check that they are not rubbing the gas tank.



Metric M12 Bolt

DO NOT FORCE THIS BOLT IF THE THREADS ARE TIGHT. VERIFY YOU HAVE THE CORRECT BOLT BEFORE TIGHTENING.



Install the large Spacer washer between your lower control arm mount and the gusset on the Rear Mount of the slider.



If your lower control arm mount has a cover or skid plate, you may not need this spacer.

Slide the Rear Flag Nut (marked with the letter "R") inside the lower control arm mount.

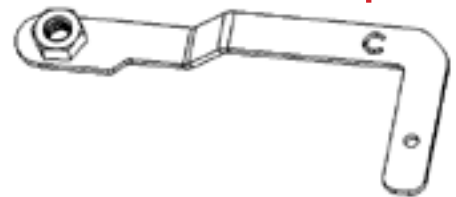
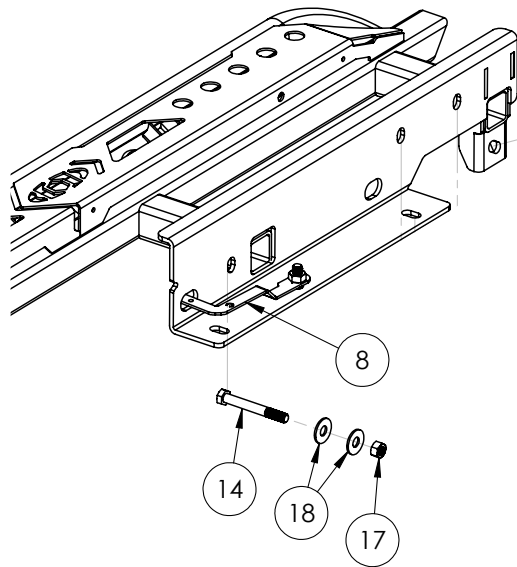
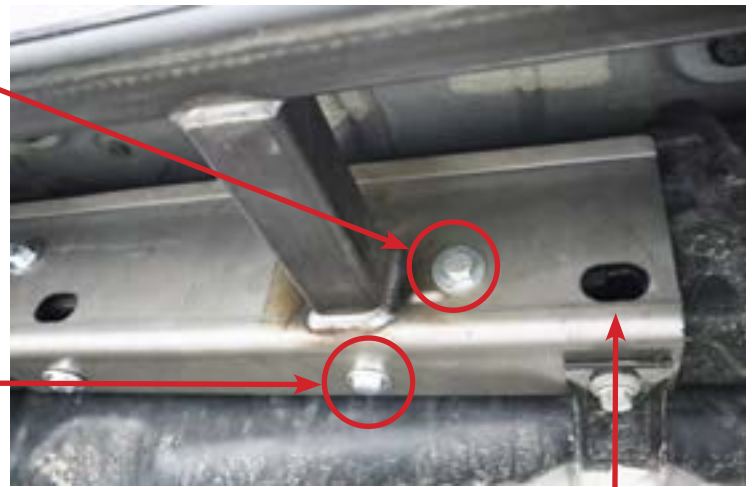
Loosely install $\text{\O}1/2'' \times 1.50''$ long hex bolt.



Loosely install the $\text{\O}1/2'' \times 4.00''$ long hex bolt thru the frame near the center support. (This is one of the holes that needs to be drilled)

When this bolt is tightened, be sure to check that it is not rubbing the gas tank.

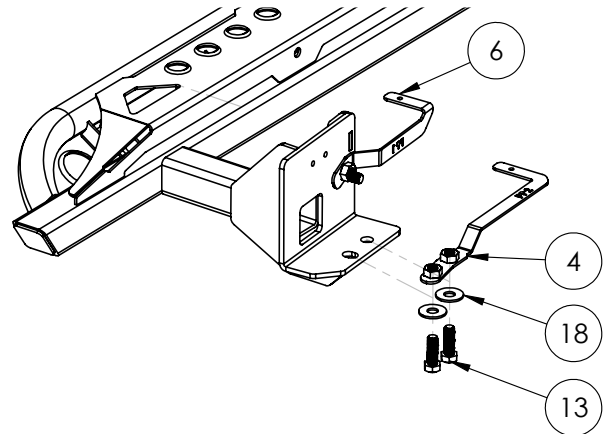
Install one of the Center Flag Nuts (marked with the letter "C") into the frame in the position shown. Then loosely install the $\text{\O}1/2'' \times 1.50''$ long hex bolt thru the bottom of the frame into the flag nut. (This is one of the holes that needs to be drilled)



Install the Front Passenger #1 Flag Nut (marked FP1) into the upper frame hole near the Front Support.



Install the Front Passenger #2 Flag Nut (marked FP2) into the lower frame hole near the Front Support.



The frame already has a hole in this position, loosely install $\text{\O}1/2'' \times 1.50''$ long hex bolt into the flag nut marked "FP2" to hold the front mount in position.

Loosely install $\text{\O}1/2'' \times 1.50''$ long hex bolts into all three mounting hole locations using the flag nuts provided.

(These are two of the holes that need drilled)



When you have all the bolts in place and still loose, begin tightening them by lightly snugging up the bottom bolts first, then lightly snugging up the side bolts.

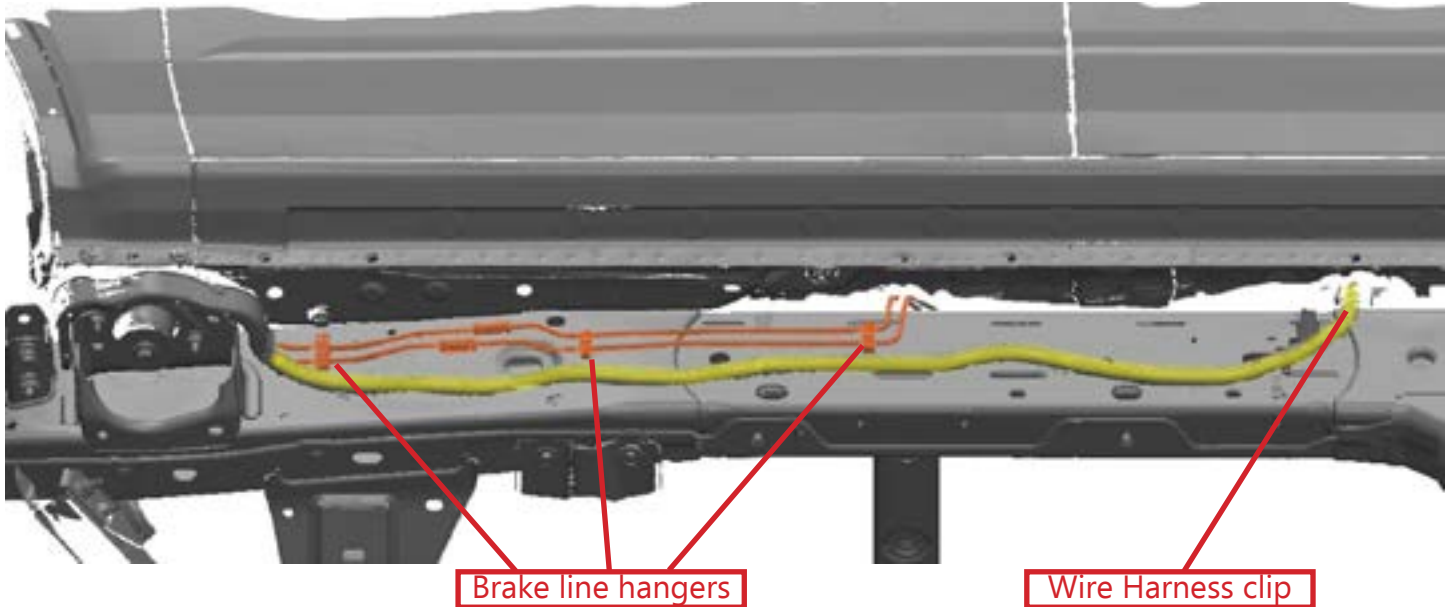
Then finish by tightening the bottom bolts securely, then the side bolts securely.

Be sure to check the side bolts near the gas tank to make sure there is no rubbing. If necessary add additional washers to the bolt head to shorten the length of the bolt.

Be sure to re-secure any wire harness that was loosened during assembly.

Installing the Driver Side Slider:

Installing the driver side slider is basically the same as the passenger side, just pay attention to the wire harness and brake lines while working. We zip tied our wire harness to the brake lines to help hold it out of the way.



Driver Side



Start by placing the driver side slider into position on the frame. Make sure not to pinch the brake lines or wire harness.

Loosely install the metric M12 x 45mm long hex bolt into the bottom of the frame. There should be a frame nut already in this position

The metric bolts in your bolt kit will have the number 8.8 stamped on the head of the bolt.



Metric M12 Bolt



DO NOT FORCE THIS BOLT IF THE THREADS ARE TIGHT. VERIFY YOU HAVE THE CORRECT BOLT BEFORE TIGHTENING.

Loosely install the $\text{\O}1/2'' \times 4.50''$ long hex bolts thru the frame on the Rear Mount.

The holes in the frame in these two locations are large. You will need to use two washers on the inside of the frame. Use the larger $\text{\O}5/8''$ washer and a $\text{\O}1/2''$ washer for each bolt.

When these bolts are tightened, be sure to check that they are not rubbing the brake lines on the backside of the frame.



Install the large Spacer washer between your lower control arm mount and the gusset on the Rear Mount of the slider.



If your lower control arm mount has a cover or skid plate, you may not need this Spacer.

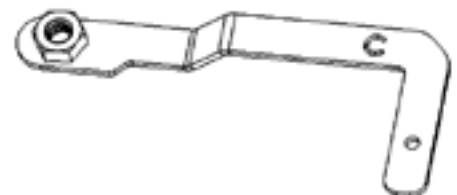
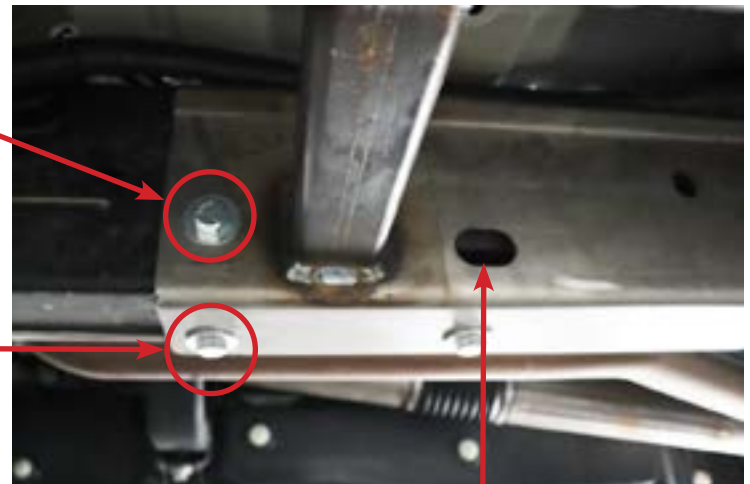
Slide the Rear Flag Nut (marked with the letter "R") inside the lower control arm mount.

Loosely install $\text{\O}1/2'' \times 1.50''$ long hex bolt.



Loosely install the $\text{\O}1/2'' \times 4.50''$ long hex bolt thru the frame near the center support. **(This is one of the holes that needs to be drilled)**

Install one of the Center Flag Nuts (marked with the letter "C") into the frame in the position shown. Then loosely install the $\text{\O}1/2'' \times 1.50''$ long hex bolt thru the bottom of the frame into the flag nut. **(This is one of the holes that needs to be drilled)**



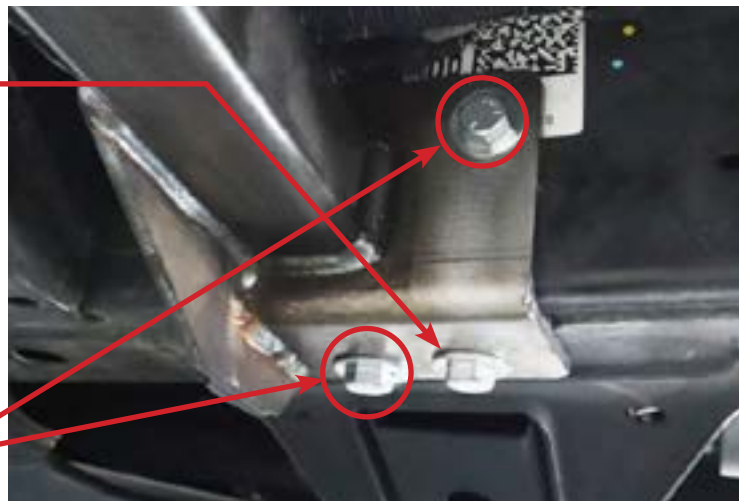
Install the Front Driver #1 Flag Nut (marked FD1) into the upper frame hole near the Front Support.



Install the Front Driver #2 Flag Nut (marked FD2) into the frame hole shown here. This hole is on the backside of the frame rail behind the front support. You can see from this picture frame hole is beside the flex pipe on your exhaust.



The frame already has a hole in this position, loosely install $\text{\O}1/2'' \times 1.50''$ long hex bolt into the flag nut marked "FD2" to hold the front mount in position.



Loosely install $\text{\O}1/2'' \times 1.50''$ long hex bolts into the other two mounting hole locations using the flag nuts provided.

(These are two of the holes that need drilled)

When you have all the bolts in place and still loose, begin tightening them by lightly snugging up the bottom bolts first, then lightly snugging up the side bolts.

Then finish by tightening the bottom bolts securely, then the side bolts securely.

Be sure to check the wire harness and brake lines while tightening to make sure they don't get pinched.

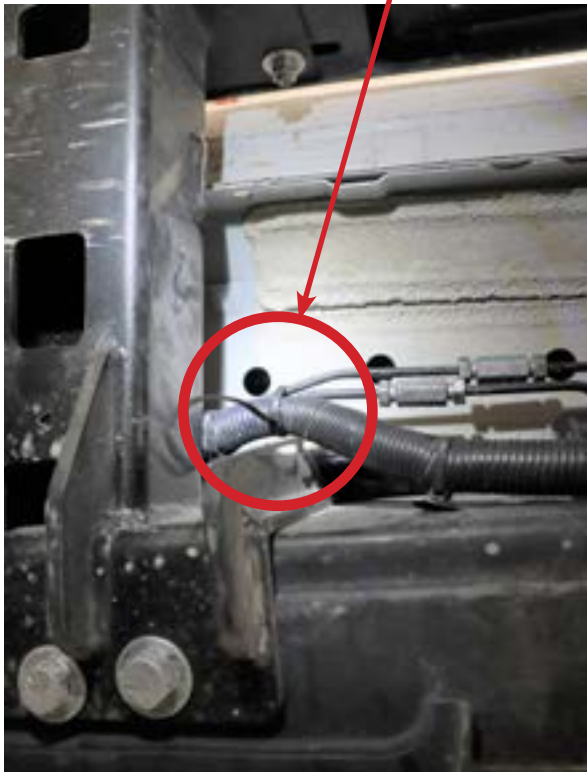
Resecure the Brake Line and Wires:

Once you have your slider mounts installed be sure to secure you brake line and wire harness. You will not be able to resecure all the plastic frame clips. The Destroyer Mounts are shown here, but the process is the same for the Signature Series mounts.

Check the brake line near the front body mount and make sure its not rubbing. You may need to partially unclip the plastic cover the wire harness travels thru to create some slack.



Here we zip tied the brake lines to the wire harness near the front mount.



Here we left some of the frame clips loose to provide slack.





Once the sliders are installed and secured, install the removeable Cover Plates as shown using the Ø1/4" Button Head Screws.

You may use the holes in the Cover Plates as a high lift jacking point. Just be aware that you may damage the Cover Plate.

You can also remove the cover plates and jack directly on the slider tube.



****Maintenance****

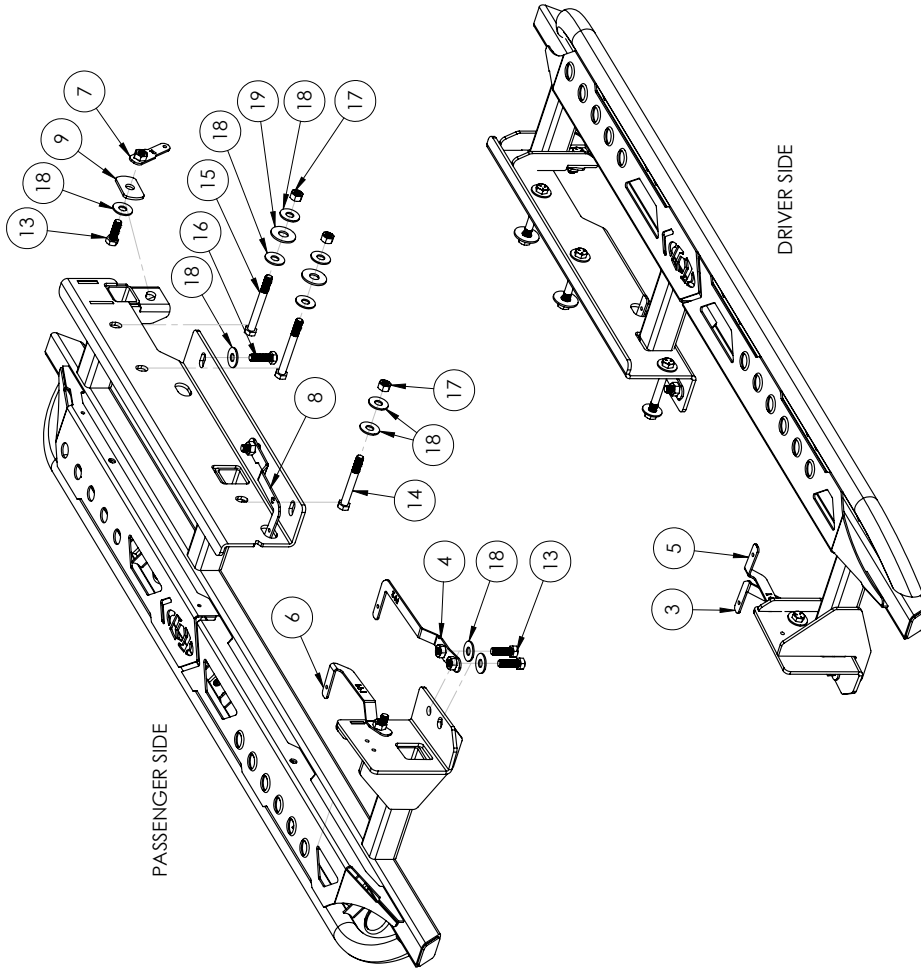
- Periodically check and re-tighten all fasteners.
- Periodically check your Sliders for scratches or dings which can happen over time or after heavy use or highway driving. It is important to address these areas as soon as possible to prevent flaking and corrosion or rust from spreading. We recommend using Rustoleum® brand Black Semi-Gloss Protective Enamel (oil based). Remove loose powder coating, sand the area and clean using alcohol. Apply using a foam brush by dabbing to match the powder coat texture.



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	4BRS2140-05	2021 BRONCO SIGNATURE SLIDER - DS	1
2	4BRS2140-07	2021 BRONCO SIGNATURE SLIDER - PS	1
3	4BRS2021-05	FRONT LOWER FLAG NUT - DS	1
4	4BRS2021-08	FRONT LOWER FLAG NUT - PS	1
5	4BRS2021-06	FRONT SIDE FLAG NUT - DS	1
6	4BRS2021-09	FRONT SIDE FLAG NUT - PS	1
7	4BRS2021-07	REAR FLAG NUT	2
8	4BRS2021-10	CENTER FLAG NUT	2
9	2BRS2021-21	REAR MOUNT SPACER	2
10	2BRS2140-02	LEFT COVER PLATE	2
11	2BRS2140-11	RIGHT COVER PLATE	2
12	BHSCS252008ZP	BHSCS 1/4-20 X 0.50 ZINC PLATE	24
13	HB501324ZPGR5	HEX BOLT 1/2-13 X 1.50 HEX BOLT ZINC PLATE GR5	10
14	HB501364ZPGR5	HEX BOLT 1/2-13 X 4.00 HEX BOLT ZINC PLATE GR5	1
15	HB501372ZPGR5	HEX BOLT 1/2-13 X 4.50 HEX BOLT ZINC PLATE GR5	5
16	HB12175M40ZPCL88	HEX BOLT M12-1.75 x 40mm ZINC PLATE CL8.8	2
17	HN5013ZPGR5	HEX NUT 1/2-13 ZINC PLATE GR5	6
18	FW5022ZP	FLAT WASHER Ø1/2" X 1.375" ZINC PLATE	24
19	FW6228ZP	FLAT WASHER Ø5/8" X 1.75" ZINC PLATE	4

- NOTES:**
- BRS2140 = BARE STEEL OPTION
 - BRS2141 = BLACK POWDER COAT
 - WEIGHT = APPROX 172 LBS

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONS ±0.010 DECIMALS ±0.005 THREE PLACE DECIMAL ±0.005	DRAWN CHECKED ENG APPR. MEG APPR.	NAME MCH	DATE 3/3/2022
LOD LLC.			
DESCRIPTION: 2021 BRONCO SIGNATURE SERIES SLIDERS			
DWG. NO. BRS2140 BRS2141			
SCALE: 1:8 SHEET SIZE: B			
REV B			
SHEET 1 OF 1			

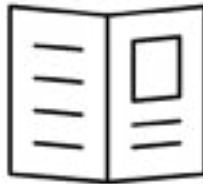




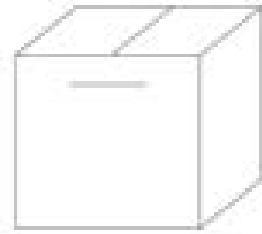
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 SIGNATURE SERIES
 BRONCO 4DR SIGNATURE
 SLIDERS
 SHIPPING SHEET

Packaged by:

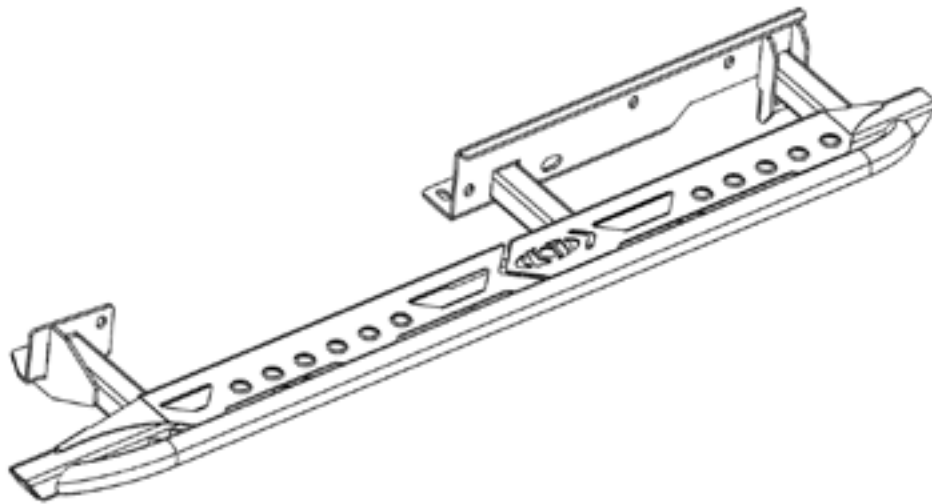
On:



INSTRUCTION
 SHEET



Hardware Kit



BRONCO SIGNATURE
 SLIDER - DS
 4BRS2140-05
(x1)

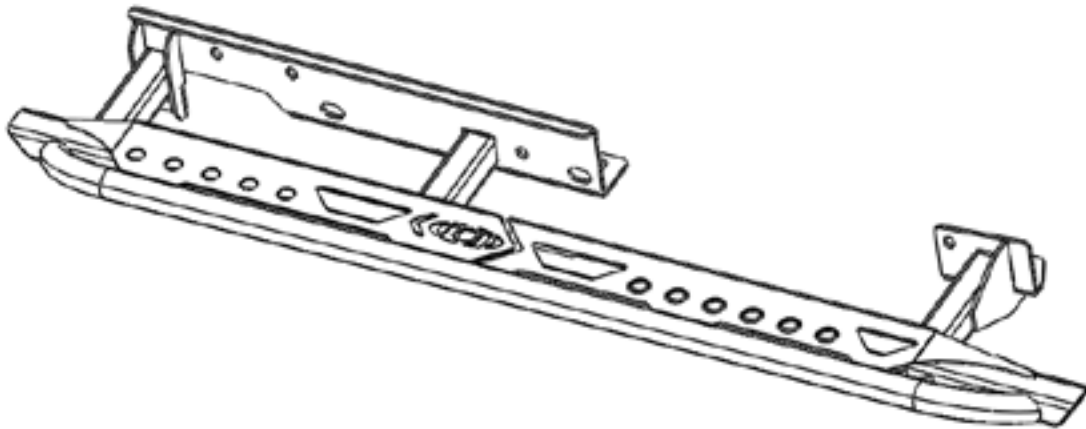




BRONCO
SIGNATURE SERIES
BRONCO 4DR SIGNATURE
SLIDERS
SHIPPING SHEET

Packaged by:

On:



BRONCO SIGNATURE
SLIDER - PS
4BRS2140-07
(x1)





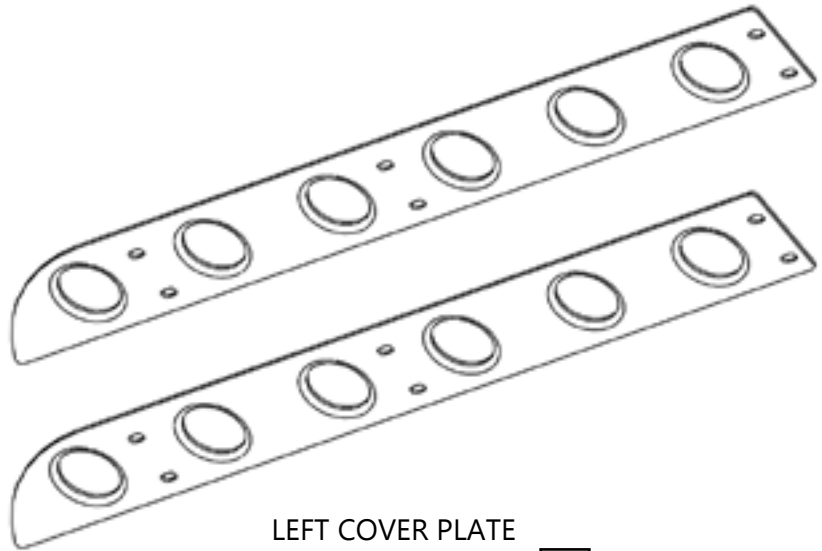
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SIGNATURE SERIES
BRONCO 4DR SIGNATURE
SLIDERS
HARDWARE KIT

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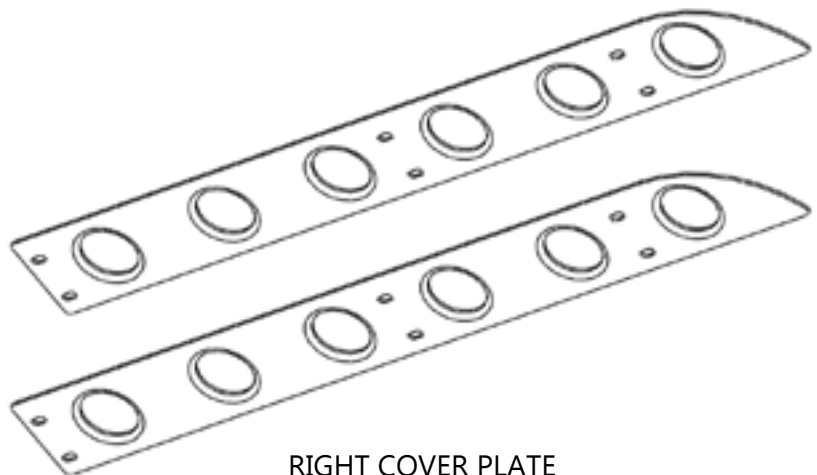
On:



BOLT KIT
(may vary)

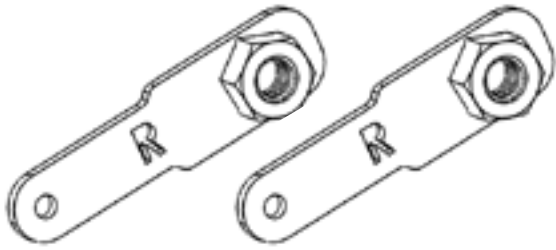


LEFT COVER PLATE
2BRS2140-02
(x2)

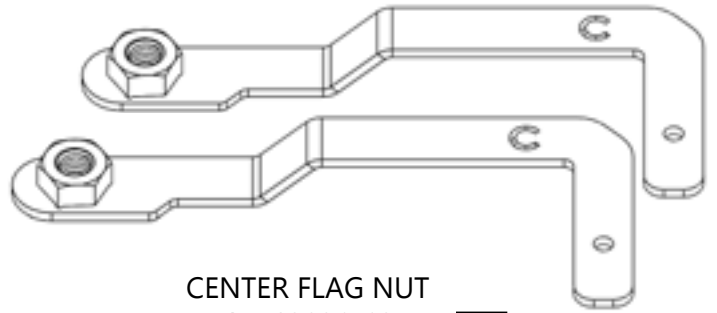


RIGHT COVER PLATE
2BRS2140-11
(x2)

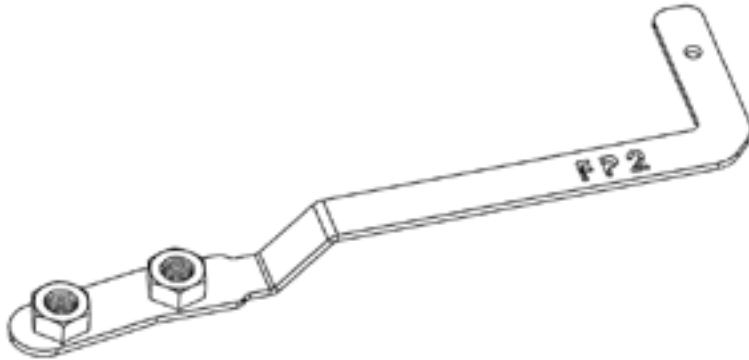




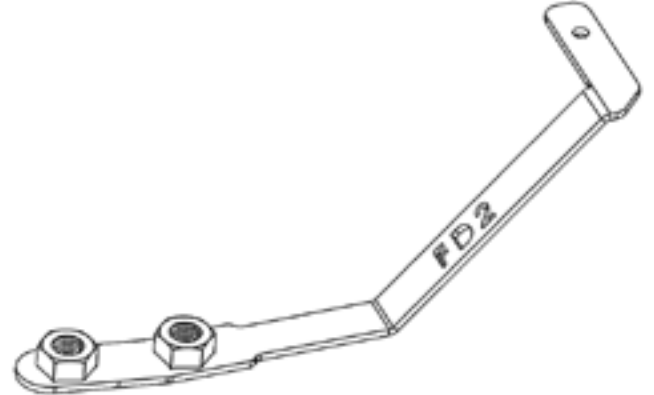
REAR FLAG NUT
4BRS2021-07
(x2)



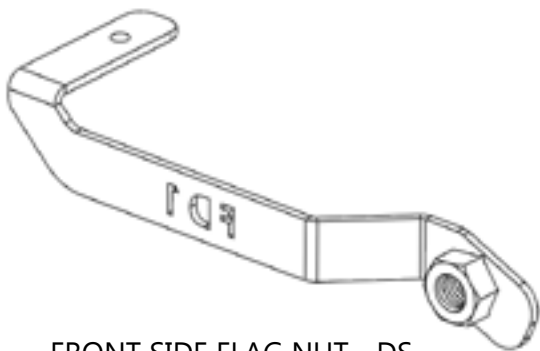
CENTER FLAG NUT
4BRS2021-10
(x2)



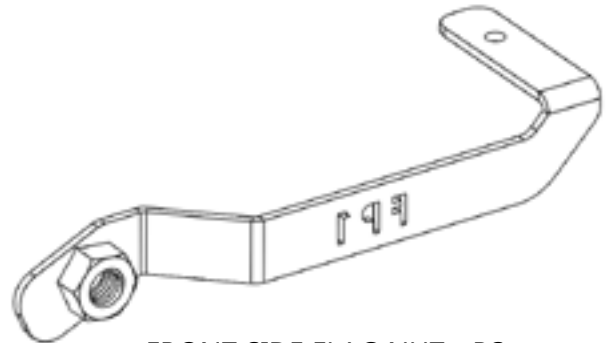
FRONT LOWER FLAG NUT - PS
4BRS2021-08
(x1)



FRONT LOWER FLAG NUT - DS
4BRS2021-05
(x1)



FRONT SIDE FLAG NUT - DS
4BRS2021-06
(x1)



FRONT SIDE FLAG NUT - PS
4BRS2021-09
(x1)



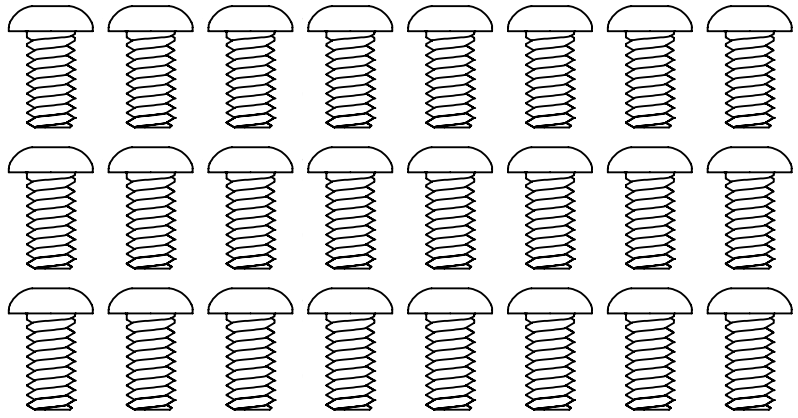
REAR MOUNT SPACER
2BRS2021-21
(x2)



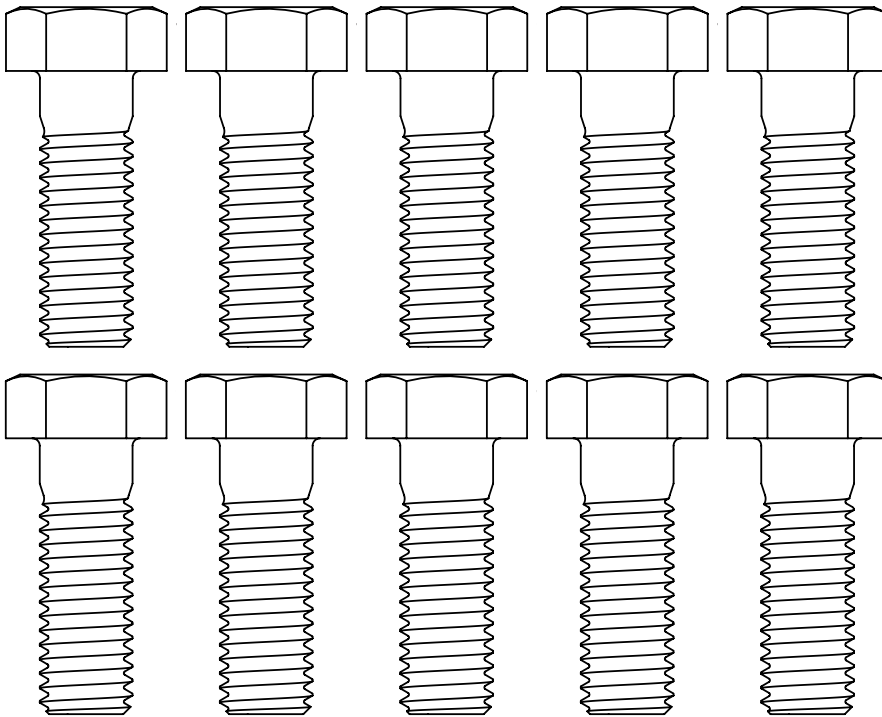
BRONCO
SIGNATURE SERIES
BRONCO SIGNATURE
SLIDERS
BOLT KIT

Packaged by:

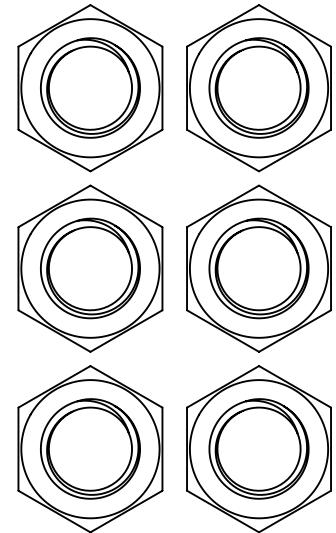
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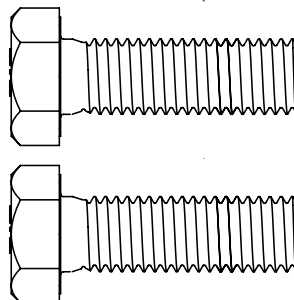
BUTTON HEAD SCREW
1/4-20 X 0.50"
94049
(x24)



HEX BOLT 1/2-13 X 1.50
110120380
(x10)

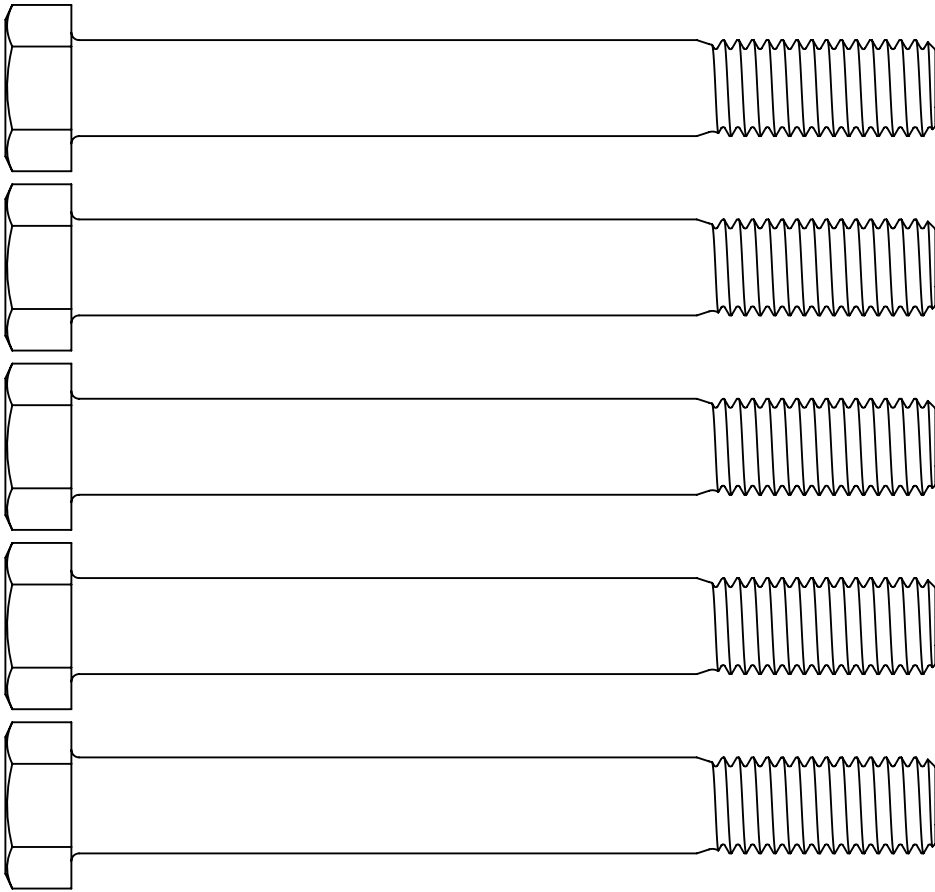


HEX NUT 1/2-13
1136310
(x6)

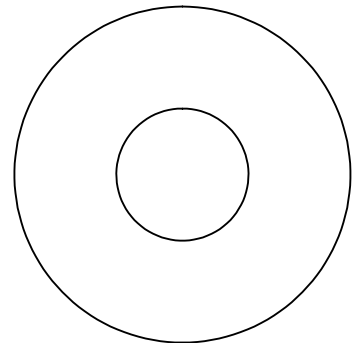
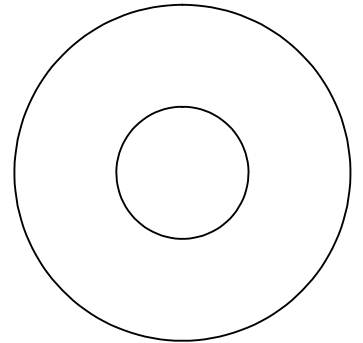
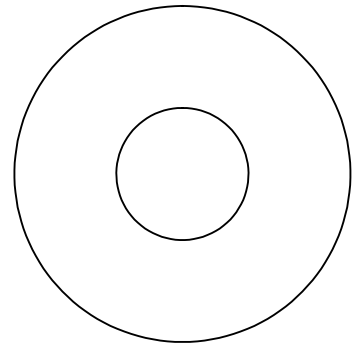
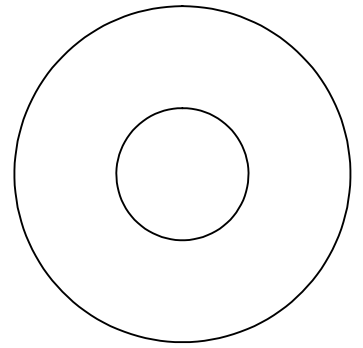


HEX BOLT M12-1.75 X 40MM
0154003
(x2)

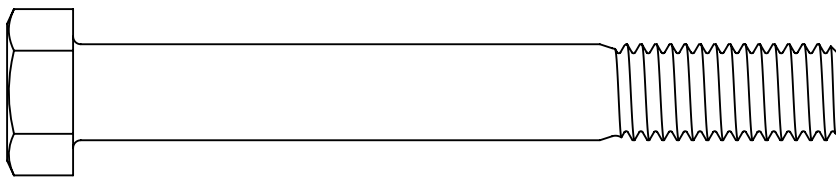




HEX BOLT 1/2-13 X 4.50
110120391
(x5)

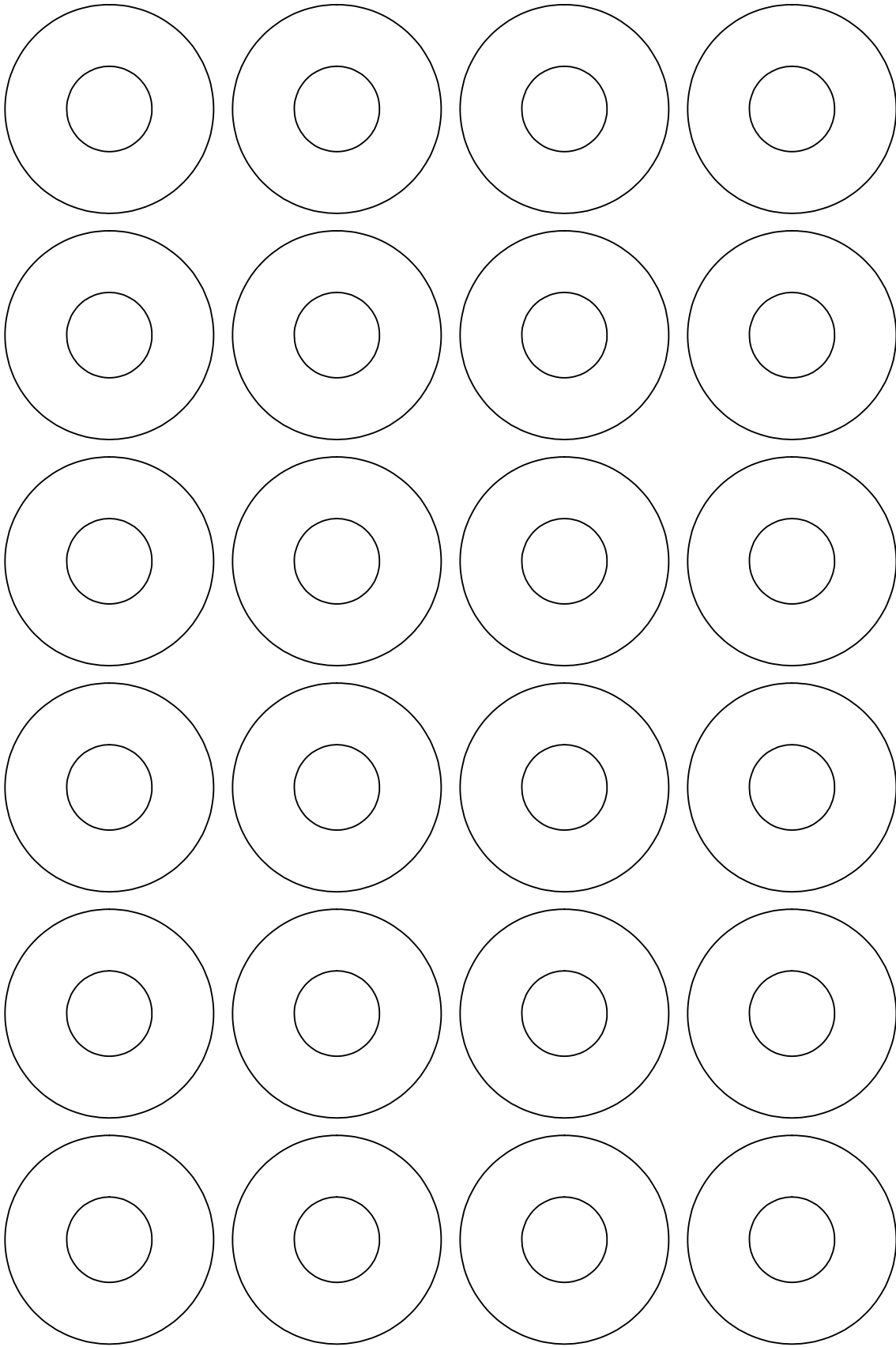


FLAT WASHER
5/8 X 1.75
1133016
(x4)



HEX BOLT 1/2-13 X 4.00
110120390
(x1)





FLAT WASHER
1/2 X 1.375
1133012
(x24)

