

INSTALLATION INSTRUCTIONS FOR ACI
97 - 04 CUSTOM ROCKERS
AGK700S

IMPORTANT!
READ INSTRUCTIONS BEFORE BEGINNING INSTALLATION

THE INSTALLATION OF THIS ROCKER KIT REQUIRES A SKILLED BODY TECH. THE FOLLOWING INSTRUCTIONS AND CORRESPONDING PICTURES ARE INTENDED TO FACILITATE THE INSTALLATION OF THE PART NUMBER LISTED. PLEASE BE AWARE OF THE "NOTE" AND "TIP" REFERENCE SECTIONS. YOU MAY CALL AMERICAN CUSTOM INDUSTRIES FOR TECHNICAL ADVICE, 8:00AM TO 5:00PM EASTERN, SHOULD YOU NEED ASSISTANCE AT 1-800-822-8020.

1. RAISE CAR AND PLACE SECURELY ON JACK STANDS. REMOVE REAR WHEELS AND TIRES.
2. OPEN DOORS AND COVER DOOR OPENINGS AND DOOR PADS TO ELIMINATE POSSIBILITY OF DUST INFILTRATION INTO CAR.
3. REMOVE REAR INNER SKIRTS. ONCE INNER SKIRTS ARE REMOVED, TAKE A MEASUREMENT BETWEEN THE LOWER EDGE OF THE QUARTER PANEL TO SOME OTHER DISTINCTIVE POINT (SEE FIG. 3A). FABRICATE A GUIDE ACCORDING TO THE MEASUREMENT TAKEN TO SERVE AS AN INSTALLATION JIG (SEE FIG. 3B). THE PURPOSE OF THIS JIG IS TO ENSURE NEW ROCKERS ARE INSTALLED IN THE EXACT POSITION AS THE ORIGINAL ROCKERS.
4. BEGINNING ON THE RIGHT SIDE OF THE CAR, REMOVE THREE (3) TORX HEAD SCREWS LOCATED IN DOOR JAM WHERE QUARTER PANEL ATTACHES TO LOCK PILLAR. **NOTE... USE MASKING TAPE ON FRONT LOWER SECTION OF QUARTER PANEL TO PROTECT PAINT (SEE FIG. 4).**
5. MEASURE NEW ACI ROCKER TO DETERMINE WHERE TO MARK AND CUT ORIGINAL ROCKER.

!!!NOTE!!!

BE SURE ONLY TO MEASURE THE AREA OF THE NEW ROCKER THAT WILL BE EXPOSED AFTER INSTALLATION (SEE FIG. 5A).

MARK CUT LINE ON ORIGINAL ROCKER STARTING AT SILL EDGE DOWN TO BOTTOM OF ROCKER. MARK REMAINING CUT LINE AT DOOR JAM (SEE FIG. 5B).

6. USING A CUT-OFF WHEEL CUT FACTORY ROCKERS WHERE MARKED IN STEP 5. FIGURE 6 SHOWS THE ROCKER AFTER ALL CUTS ARE MADE (SEE FIG. 6).
7. SEPARATE ROCKER FROM FRAME RAIL BY USING A SHARP PUTTY KNIFE TO CUT ADHESIVE ADHERING ROCKER TO FRAME RAIL. **TIP... THE USE OF A HEAT GUN TO WARM THE ADHESIVE WILL MAKE IT EASIER TO CUT. CAUTION MUST BE TAKEN NOT TO OVERHEAT ROCKER SINCE FIBERGLASS AND BONDING ADHESIVE ARE BOTH FLAMMABLE.**
8. LOOKING ON THE INSIDE OF ROCKER TOWARDS FRONT OF CAR, REMOVE ANY ADHESIVE (SEE FIG. 8). FAILURE TO REMOVE ADHESIVE BUILD-UP IN THIS AREA WILL HOLD UP THE INSTALLATION OF YOUR NEW ROCKER.

!!!NOTE!!!

THE FOLLOWING STEPS ARE TO INSTALL FASTENERS THAT WILL ASSIST IN HOLDING THE NEW ROCKER IN POSITION WHILE THE BONDING ADHESIVE CURES. IT IS IMPORTANT THAT THE NEW ROCKER IS ALIGNED WITH THE QUARTER PANEL AND DOOR BEFORE YOU START TO DRILL AND INSTALL FASTENERS.

9. TEST FIT NEW ROCKER TO CAR. NOTICE THAT THE SHADED PORTION OF THE NEW ROCKER (SEE FIG. 9) SLIPS UP INSIDE OF ORIGINAL ROCKER.
10. INSTALL FACTORY J-CLIP ON NEW ROCKER AND INSTALL ORIGINAL HEX HEAD SCREW TO SECURE NEW ROCKER TO QUARTER PANEL (SEE FIG. 10).
11. REINSTALL ORIGINAL TORX HEAD SCREWS TO SECURE QUARTER PANEL (SEE FIG 11).

!!!NOTE!!!

BEFORE PROCEEDING TO THE NEXT STEP, MAKE SURE THE GAP BETWEEN DOOR AND ROCKER ARE EVEN.

12. DRILL A 1/8" HOLE THROUGH ORIGINAL ROCKER AND INTO NEW ROCKER (SEE FIG. 12) AND FASTEN WITH A HEX HEAD SCREW.
13. DRILL A 3/16" HOLE THROUGH THE EXISTING HOLE IN NEW ROCKER AND INTO FRAME RAIL (SEE FIG. 13A). INSERT A 3/16" POP-RIVET INTO HOLE TO HOLD NEW ROCKER IN POSITION. **DO NOT PERMANENTLY FASTEN POP-RIVET AT THIS TIME.** MAKE SURE OUTER SKIN OF DOOR AND NEW ROCKER ARE FLUSH (SEE FIG. 13B).
14. DRILL THREE (3) 1/8" HOLES THROUGH ORIGINAL ROCKER AND INTO NEW ROCKER AND FASTEN WITH THREE (3) HEX HEAD SCREWS (SEE FIG. 14).

!!!NOTE!!!

NOW IS THE TIME TO MAKE SURE THE NEW ROCKER PIECE IS INSTALLED IN THE CORRECT POSITION BEFORE BONDING. USE THE JIG FABRICATED IN STEP 3. CHECK

DOOR ALIGNMENT AND GAPS WITH QUARTER PANEL AND NEW ROCKER. MAKE ANY NECESSARY ADJUSTMENTS BEFORE CONTINUING TO THE NEXT STEP.

15. REMOVE ALL HARDWARE INSTALLED IN STEPS 10 – 14 AND RETAIN FOR LATER USE. WASH ROCKER PIECE DOWN WITH A STRONG DETERGENT SUCH AS DISH SOAP TO REMOVE ANY MOLD RELEASE AGENTS PRESENT FROM THE MANUFACTURING PROCESS.
16. LIGHTLY SAND ENTIRE ROCKER PIECE WITH 150 GRIT SAND PAPER.
17. PREPARE THE BONDING SURFACES OF THE NEW ROCKER PIECE AND ORIGINAL ROCKER BY SANDING WITH 80 GRIT SAND PAPER (SEE FIG 17A, 17B, 17C, 17D, & 17E). THE BACKSIDE OF THE ROCKER THAT WILL EVENTUALLY BE BONDED TO THE FRAME RAIL SHOULD BE SANDED WITH 36 GRIT SAND PAPER. **NOTE... ALL BONDING AREAS MUST BE SANDED TO ENSURE ADEQUATE ADHESION.**

!!!CAUTION!!!

AT THIS TIME, MAKE SURE ALL BONDING SURFACES ARE DUST FREE. DO NOT WIPE BONDING AREAS WITH ANY SOLVENTS OR ACETONE!

!!!NOTE!!!

THE FOLLOWING STEPS INVOLVE THE ACTUAL BONDING OF THE NEW ROCKER TO THE CAR. YOU WILL NEED THE FOLLOWING MATERIALS ON HAND BEFORE INSTALLATION CAN CONTINUE:

1. ONE (1) TUBE OF 3M WINDOW WELD (PN 08609)
2. ONE (1) QUART OF EVERCOAT SMC BONDING ADHESIVE

DURING THE BONDING PROCESS IT IS WISE TO MOVE QUICKLY THROUGH THE STEPS TO AVOID THE ADHESIVE CURING BEFORE YOU ARE FINISHED.

18. USING A CAULKING GUN, SQUEEZE OUT A 1/8" BEAD OF WINDOW WELD ALONG THE LOWER INSIDE EDGE OF NEW ROCKER PIECE (SEE FIG. 18).
19. MIX UP ONE (1) PINT OF THE EVERCOAT BONDING ADHESIVE AND, USING A BONDO SPREADER, APPLY ADHESIVE TO BONDING AREAS OF NEW ROCKER PIECE (SEE FIG 19A & 19B).

!!!CAUTION!!!

ONCE BONDING ADHESIVE IS APPLIED, ROCKER MUST BE INSTALLED IMMEDIATELY!

20. FIT NEW ROCKER INTO POSITION (SEE FIG 20A). FASTEN QUARTER PANEL TO DOOR JAM USING THREE (3) ORIGINAL TORX HEAD SCREWS (SEE FIG 20B). FASTEN ROCKER TO QUARTER PANEL AT WHEEL OPENING WITH ORIGINAL HARDWARE (SEE FIG 20C). REINSTALL THE THREE (3) ALIGNMENT SCREWS PREVIOUSLY INSTALLED IN STEP 14 (SEE FIG. 20D). **NOTE... THE INSTALLATION OF THE THREE (3) ALIGNMENT SCREWS IS TO ASSIST YOU IN RETAIN PROPER ALIGNMENT WHILE THE ADHESIVE CURES. ONCE BONDING ADHESIVE CURES, THE SCREWS WILL BE REMOVED AND THE HOLES WILL**

BE FILLED. FASTEN FRONT OF NEW ROCKER TO ORIGINAL ROCKER WHERE PREVIOUSLY DRILLED IN STEP 12 (SEE FIG 20E). FASTEN NEW ROCKER TO FRAME RAIL WITH THE 3/16" RIVET IN THE LOCATION PREVIOUSLY DRILLED IN STEP 13 (SEE FIG. 20F).

21. USING A BONDO SPREADER, REMOVE ANY EXCESS BONDING ADHESIVE THAT SEEPS OUT BETWEEN ROCKER AND DOOR JAM (SEE FIG. 21). AFTER EXCESS ADHESIVE IS REMOVED, REPOSITION JIG AS IN STEPS 3 AND 14 TO ENSURE EXACT ALIGNMENT. **NOTE... MAKE ANY NECESSARY ADJUSTMENTS NOW, BEFORE THE ADHESIVE CURES COMPLETELY.**
22. ONCE ADHESIVE CURES, REMOVE ALL ALIGNMENT SCREWS. MAKE SURE THE FACTORY DOOR JAM DRAINS HAVE NOT BEEN CLOSED OR FILLED WITH ADHESIVE. ANY NECESSARY BODY WORK TO PREPARE FOR PAINTING MAY BE DONE AT THIS TIME.
23. REPEAT STEPS 4 – 22 ON LEFT SIDE OF VEHICLE.
24. ONCE BOTH ROCKERS ARE INSTALLED, YOU ARE READY TO PRIME AND PAINT.



FIG. 3A



FIG. 3B

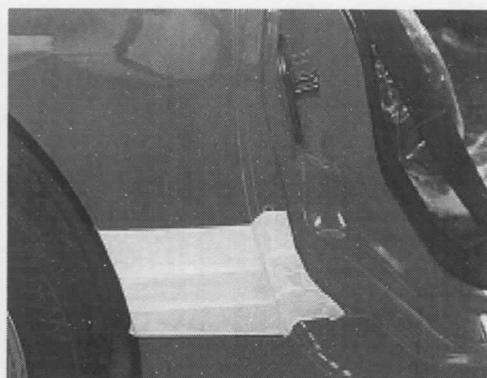


FIG. 4

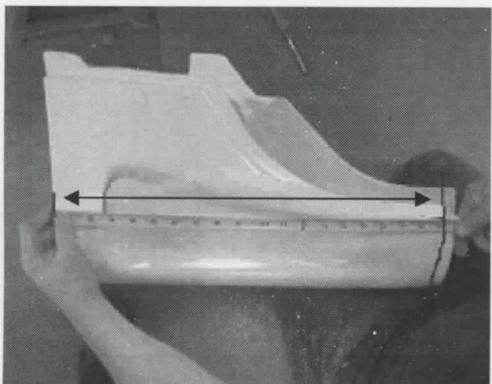


FIG. 5A

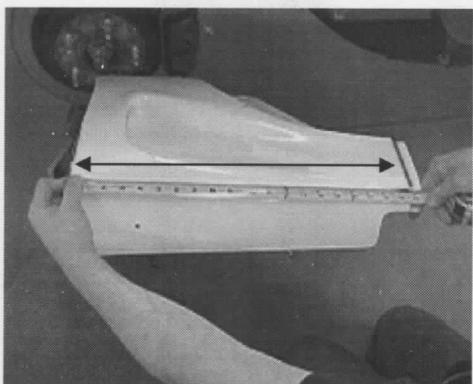


FIG. 5B

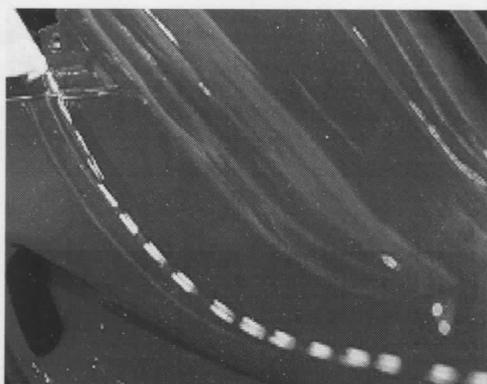


FIG. 5C

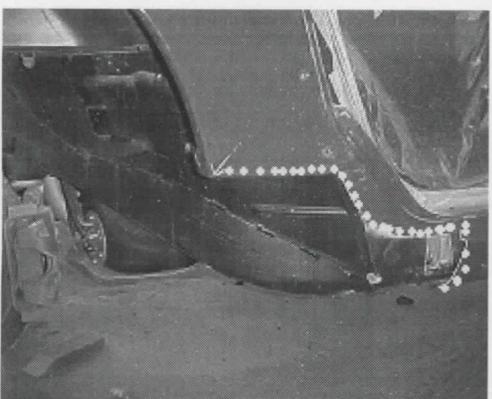


FIG. 6

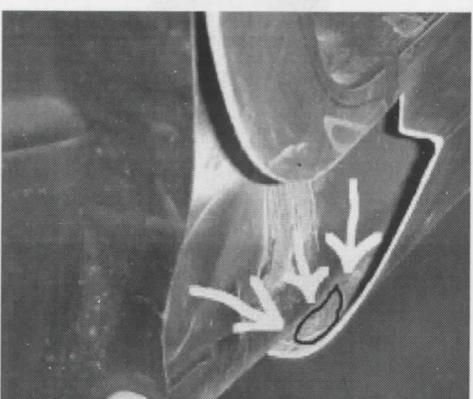


FIG. 8

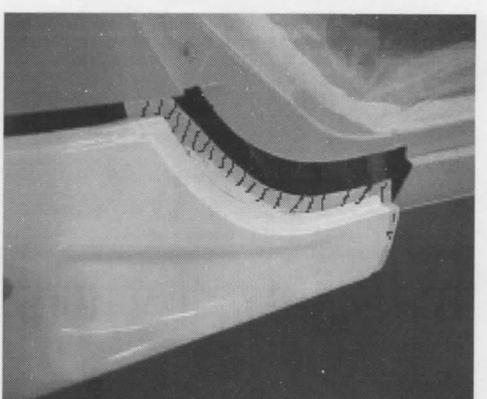


FIG. 9

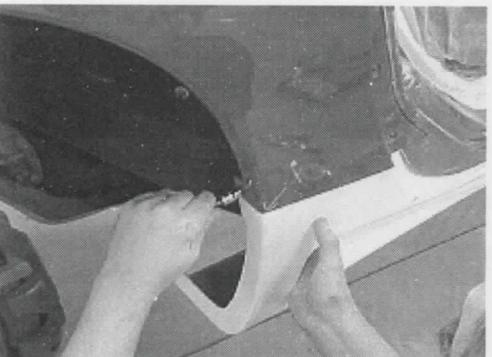


FIG. 10



FIG. 11

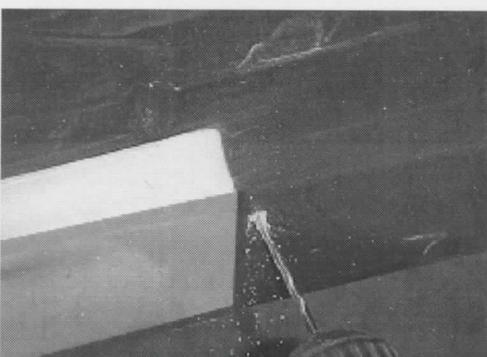


FIG. 12



FIG. 13A

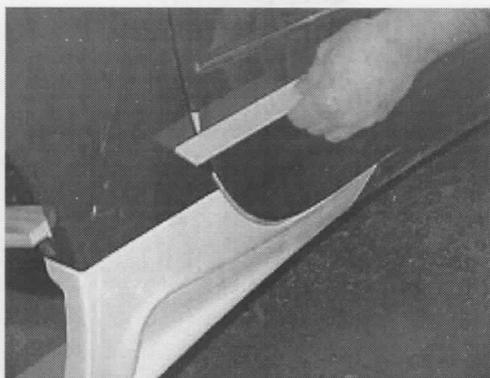


FIG. 13B

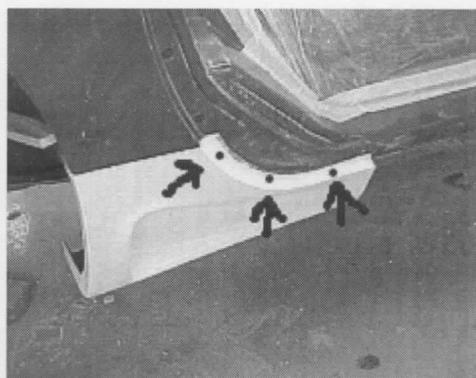


FIG. 14

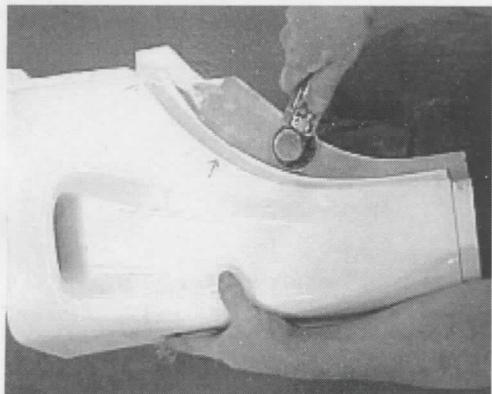


FIG. 17A



FIG. 17B

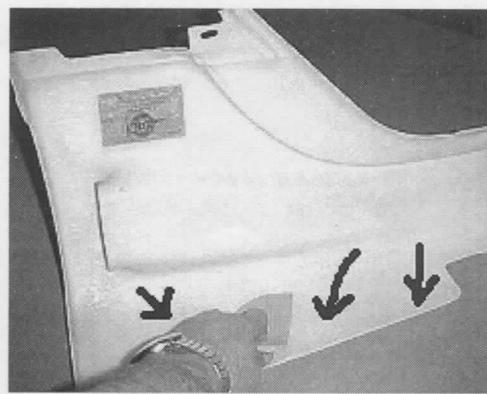


FIG. 17C

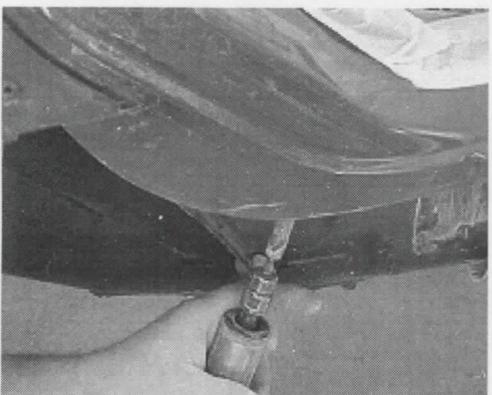


FIG. 17D

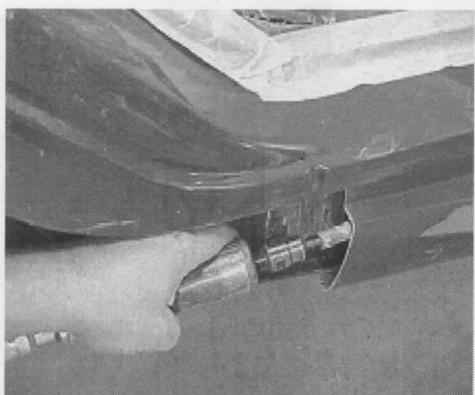


FIG. 17E



FIG. 18

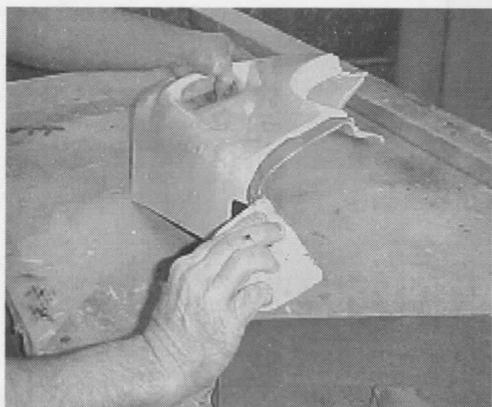


FIG. 19A

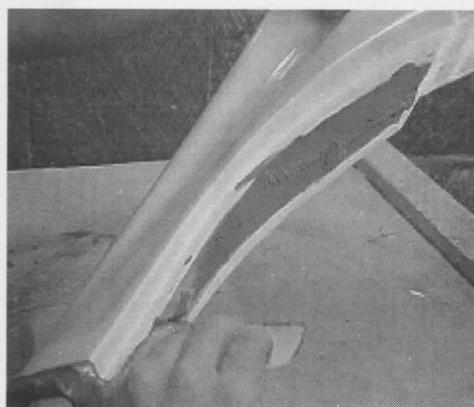


FIG. 19B

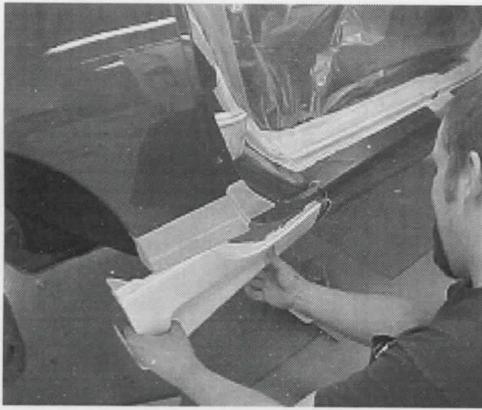


FIG. 20A

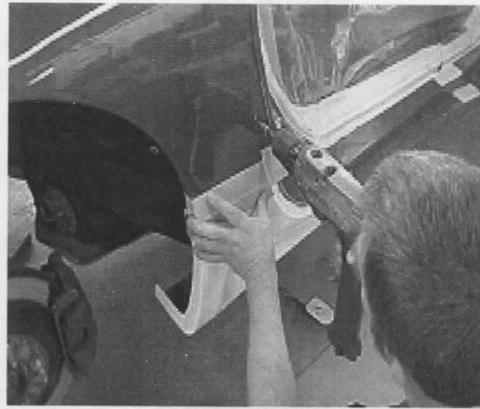


FIG. 20B

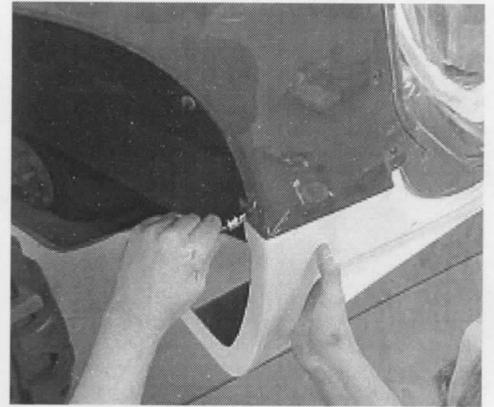


FIG. 20C



FIG. 20D

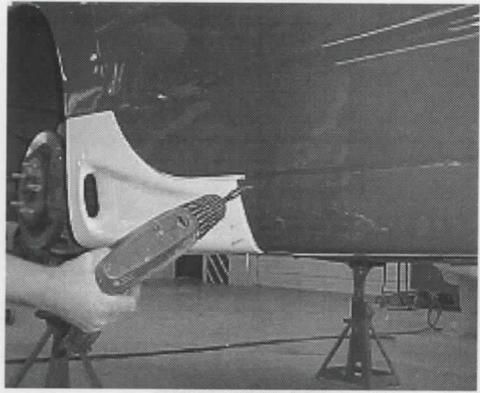


FIG. 20E

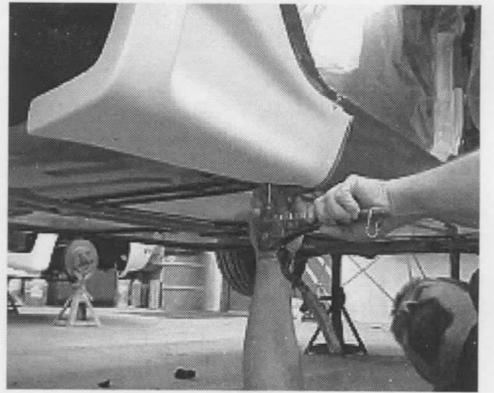


FIG. 20F

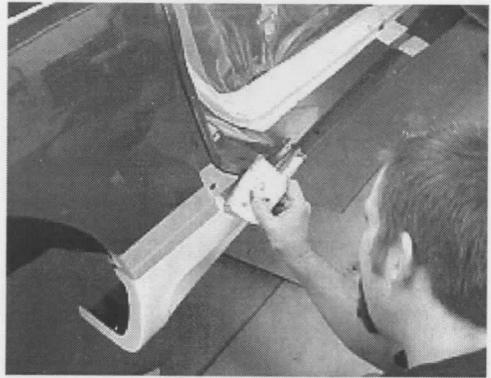


FIG. 21



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