



Ford Transit™

# Bulkhead

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## Kit 23003586SK and 23003587SK

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### Customer Service

**574-848-2073**

**Monday–Friday 8 a.m. to 5 p.m. Eastern Standard Time Zone**

**Email: [Parts@Utilimaster.com](mailto:Parts@Utilimaster.com)**

*NOTE: The information in this document is generic. Images and procedures may differ from those for vehicles you are servicing. Because Utilimaster manufactures customized vehicle solutions, this document cannot list and illustrate every possible option for every vehicle. The most common body options are described here. Use this information as a guideline.*

Document Part Number: 03104504-N002EN

– Revision B –

## Introduction

This document provides instructions for the installation of a standard bulkhead and the bulkhead with passenger jump seat into the Ford Transit™ cargo van. **For the bulkhead with jump seat option, the van MUST be ordered without the passenger seat from the factory.**

This manual contains drawings and photos to aid in servicing the vehicle. It may include maintenance information on some items installed but not manufactured by Utilimaster Corporation. Items such as drivetrain components and certain interior furnishings may be covered by separate manufacturer-supplied information. Information provided here is intended to assist Utilimaster customers and is in no way meant to replace or supersede instructions provided by other suppliers for their products.



*Bulkhead kit  
(Shelving not included)*

## Notes, Cautions, and Warnings

Reading through the procedures, you will see NOTES, CAUTIONS, and WARNINGS. Each is there for a specific purpose.

**NOTES** give additional information that will help you complete the procedure.

**CAUTIONS** warn against making an error that could damage the vehicle.

**WARNINGS** remind you to be careful when there is risk of personal injury.



***When you see this symbol, read this statement first! This alert highlights information that may reduce the risk of personal injury or vehicle damage.***

Below are some basic WARNINGS that you should heed when you work on the vehicle's body. They are not all-inclusive and common sense must be used when servicing vehicles.

- Always read and understand all instructions before starting.
- Always wear safety glasses and other appropriate protective equipment (gloves, steel-toed shoes, face shields, knee pads, hearing protection).
- Put the transmission in Park, and set the parking brake before working on the vehicle.
- Be sure that the ignition switch is Off unless otherwise required by the procedure.
- Keep your hair, clothing, and body away from all moving parts such as engine pulleys and power tools.
- Always remove rings, watches, hanging jewelry, and loose clothing before working in tight areas.
- Read and understand all warning labels.
- Always use proper ladders or scaffolding to perform required jobs.
- Always make sure tools are in proper working condition and have guards and safety devices in place.
- Use only the recommended tools for a specific job.
- If at any time you lack confidence in performing a specific repair procedure or in operating the tools safely to perform the repair, STOP! Call your Utilimaster representative.

## Recommended Tools



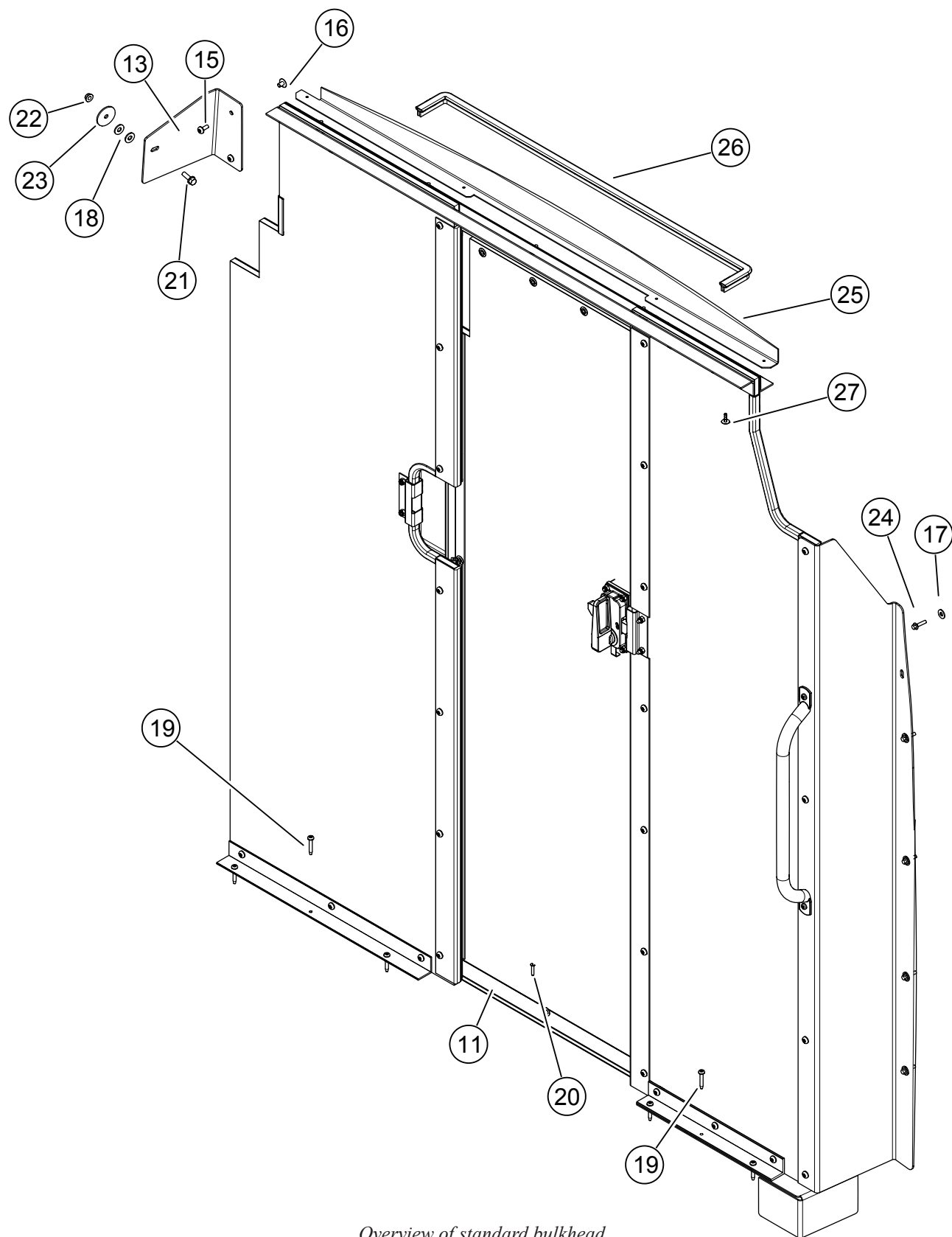
**WARNING:** Always wear safety glasses and other proper protective equipment (gloves, steel-toed shoes, face shields, knee pads, hearing protection) as appropriate to the process.

Below are some tools that you will need for this process. There may be other commonly used hand tools required but not specifically mentioned.

- Drill with #11, 7/32", and 5/16" bits with drill stop
- Reciprocating saw or band saw
- Torx bit set and driver
- Standard and metric combination and ratchet wrench sets including swivel adapter and extensions
- Center punch
- Rivet gun
- 19-3/8" wood block

## Kit Part List for Standard Bulkhead

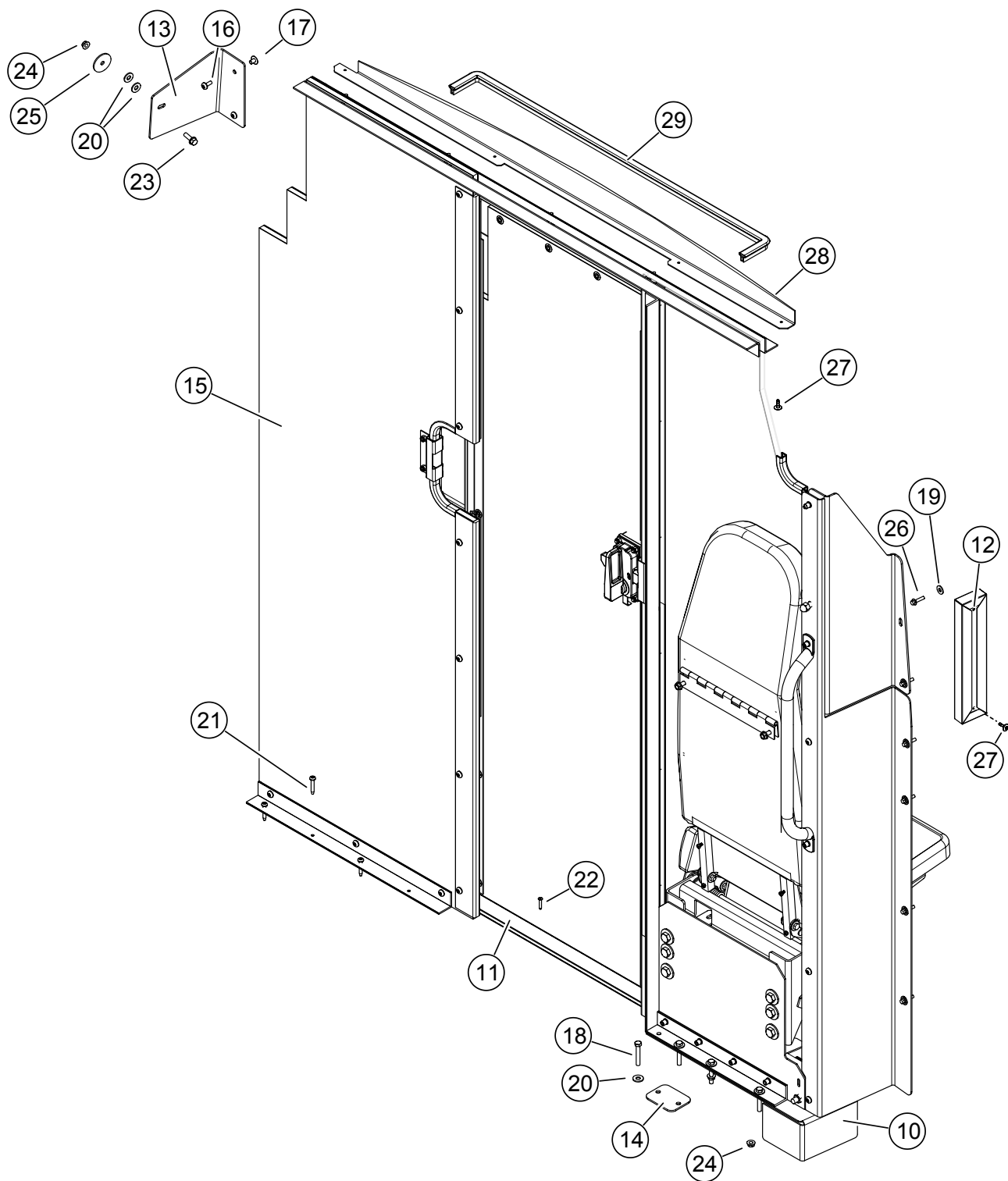
23003587SK		Transit-STANDARD BULKHEAD	
BOM ID	Part Number	Description	Qty
0	23003587SK	23003587b BULKHEAD BLNDX ASSY TRANSIT	
11	06000270-04600	AE GUIDE RAIL SOLID	1
12	06939297	CLOSEOUT RH STEPWELL TRNST	1
13	22826239	BRACE LH BULKHEAD TRNST	1
14	23003589	BULKHEAD BLNDX SUBASM TRNST	1
15	11001401	SCREW 1/4-20 x 11/16 PAN TORX	2
16	11007502	T NUT 1/4-20 x 7/16 RDBSE ZN	2
17	11008114	WASHER 1/4 FLAT ZINC 3/4"OD	5
18	11008417	WASHER 5/16 FLAT	2
19	11300120	SCREW 1/4-20 x 1-1/2M TORX PN S&LF	6
20	11400803	RIVET POP	8
21	11600237	BOLT HEX FLG 5/16-18 x 1	1
22	11600238	NUT 5/16-18 FLG LKWX GR8 ZN	1
23	11600895	5/16" WASHER-ZINC	1
24	UT29-BB1-004	BOLT M6-1.00 x 25 FLG G8.8 BZ PTCH	5
25	06940268	CLOSEOUT BLKHD ROOF TRNST	1
26	05402186-05100	SEAL HOOD FIBERGLASS 51.00"	1
27	11401216	RIVET 3/16	4
NS_1	03104504-N002EN	TRANSIT BULKHEAD INSTALL INSTRUCTION	1



Overview of standard bulkhead

## Kit Part List for Bulkhead with Jump Seat

23003586SK		Transit–BULKHEAD WITH JUMP SEAT	
BOM ID	Part Number	Description	Qty
0	23003586SK	23003586e BULKHEAD BLNDX ASSY W JMPST TRNST	
10	06939297	CLOSEOUT RH STEPWELL TRNST	1
11	06000270-04600	AE GUIDE RAIL SOLID	1
12	23003625	SUBASM B-PILLAR CUSHION TRNST	1
13	22826239	BRACE LH BULKHEAD TRNST	1
14	22826706	BRACE BULKHEAD FLOOR TRNST	1
15	23003588	BULKHEAD BLNDX SUBASM JMPST TRNST	1
16	11001401	SCREW 1/4-20 X 11/16 PAN TORX	2
17	11007502	T-NUT 1/4-20 X 7/16 RDBSE ZN	2
18	11004482	BOLT HX 5/16-18 X 2 G5Z	4
19	11008114	WASHER 1/4 FLAT ZINC	5
20	11008417	WASHER 5/16 FLAT	6
21	11300120	SCREW 1/4-20 X 1-1/2M TORX PN	7
22	11400803	RIVET POP	8
23	11600237	BOLT HEX FLG 5/16-18 X 1	1
24	11600238	NUT 5/16-18 FLG LKWX GR8 ZN	5
25	11600895	WASHER FEND 5/16 X 1.75 X 1.08 THK	1
26	UT29-BB1-004	BOLT M6-1.00 X 25 FLG G8.8 BZ PTCH	5
27	11401216	RIVET 3/16	6
28	06940268	CLOSEOUT BLKHD ROOF TRNST	1
29	05402186-05100	SEAL HOOD FIBERGLASS	1
NS_1	03104504-N002EN	TRANSIT BULKHEAD INSTALL INSTRUCTIONS	1



*Overview of bulkhead with jump seat*



## Installation Instructions

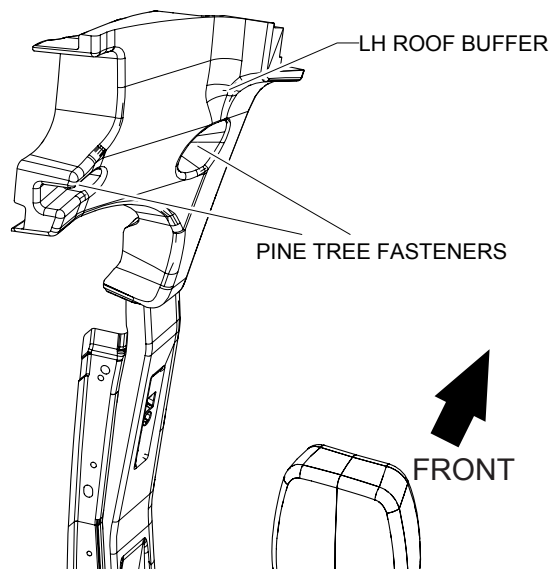
1. Read and understand all instructions before starting work.
2. Validate the packing slip with the list of parts in the instructions.

### Bulkhead Installation

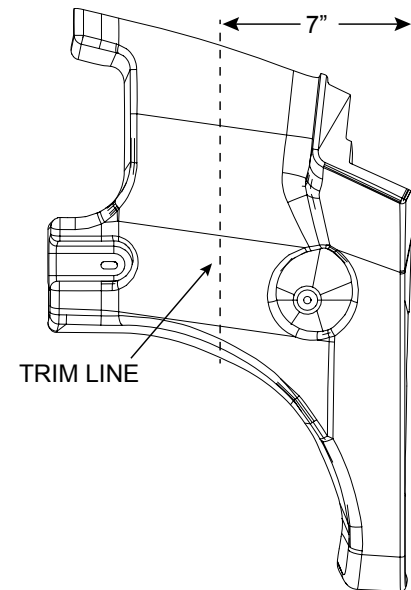


**CAUTION:** Use a drill stop to avoid damage to exterior panels and components.

1. Remove (2) pine tree fasteners securing LH roof buffer to the B-pillar.
2. Trim buffer to 7" and reinstall.

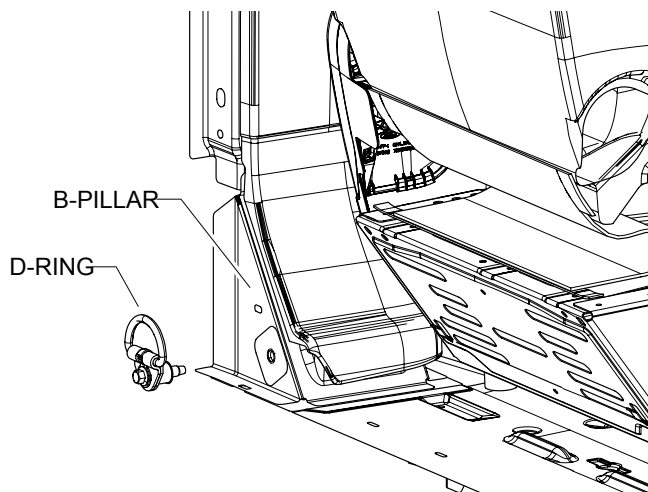


*LH roof buffer and fasteners*



*Trim roof buffer*

3. Remove D-rings from the LH and RH lower B-pillars and discard.
4. Remove the grab handle from the RH B-pillar.

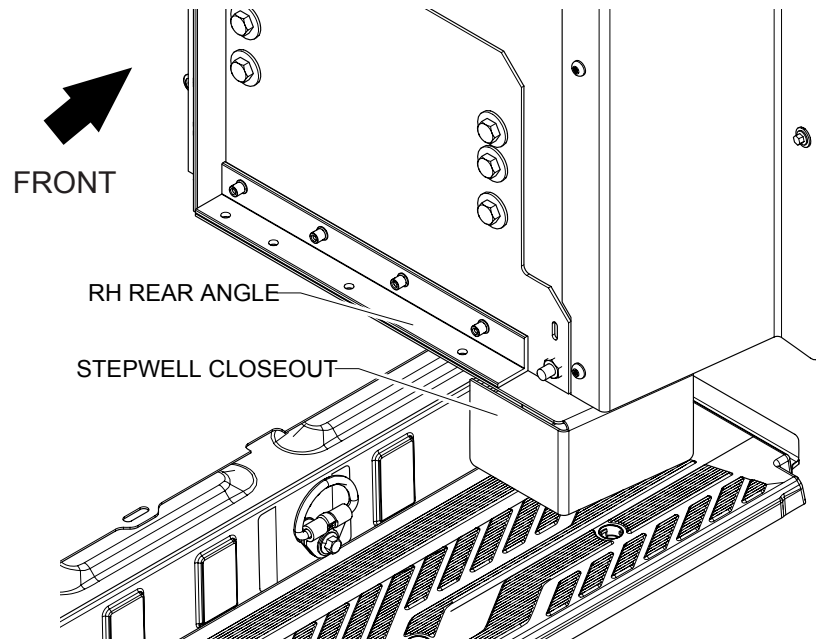


*D-Ring at the LH side B-pillar and cargo grab handle on the RH side B-pillar*



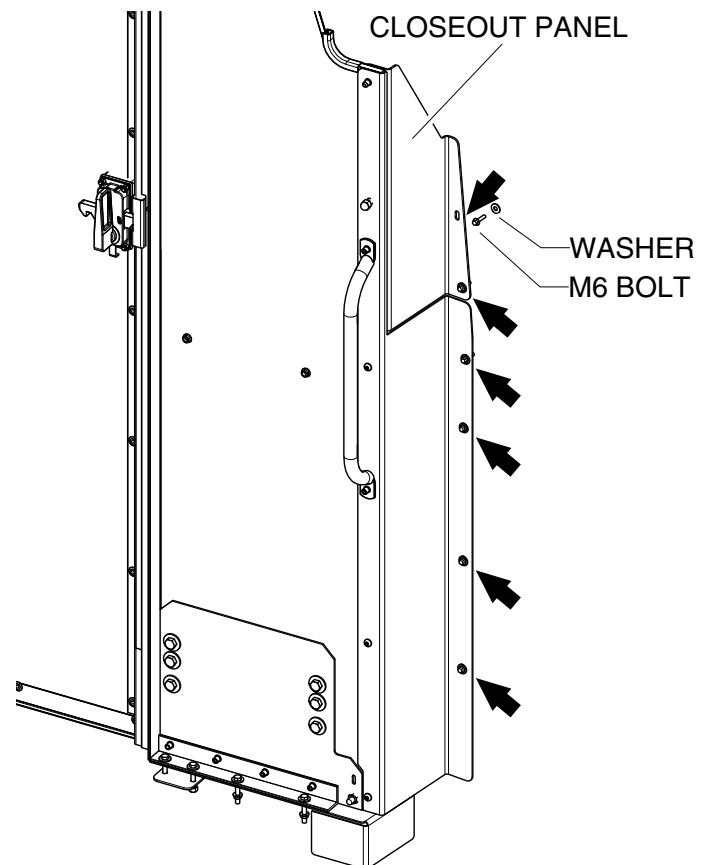


5. Insert the stepwell closeout at the RH side of the cargo floor.
6. Position the bulkhead in the cargo area and tip into place.
7. Align closeout with RH rear angle.



*Align RH stepwell closeout under bulkhead*

8. Use a center punch to align holes in the RH closeout panel with holes in the B-pillar.
9. Secure M6-1.00 x 25 bolts and washers in the RH closeout panel holes.

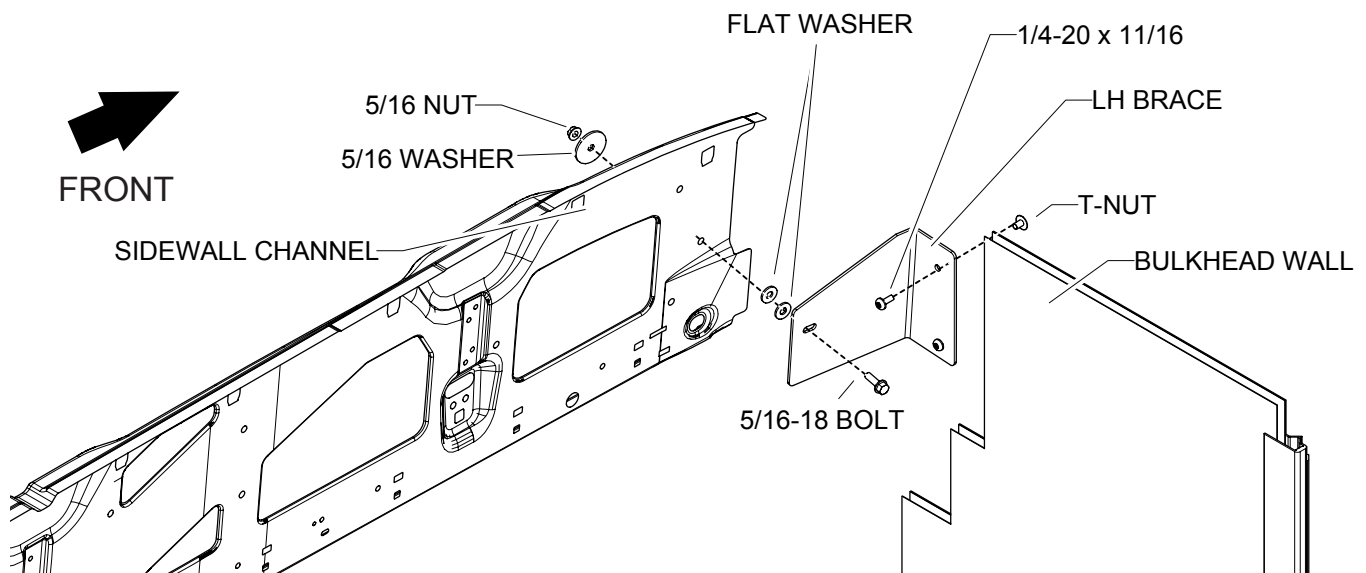


*RH closeout panel and fasteners*



**CAUTION:** Use a drill stop to avoid damage to exterior panels and components.

10. Align the LH bulkhead brace to the sidewall and to the top of the bulkhead wall.
11. Secure 5/16-18 x 1 bolt, washers and nut.
12. Use a drill and the holes in the brace as a guide to drill (2) 5/16" holes through the brace and the bulkhead wall.
13. Secure with (2) 1/4-20 x 11/16 screws and T-nuts.

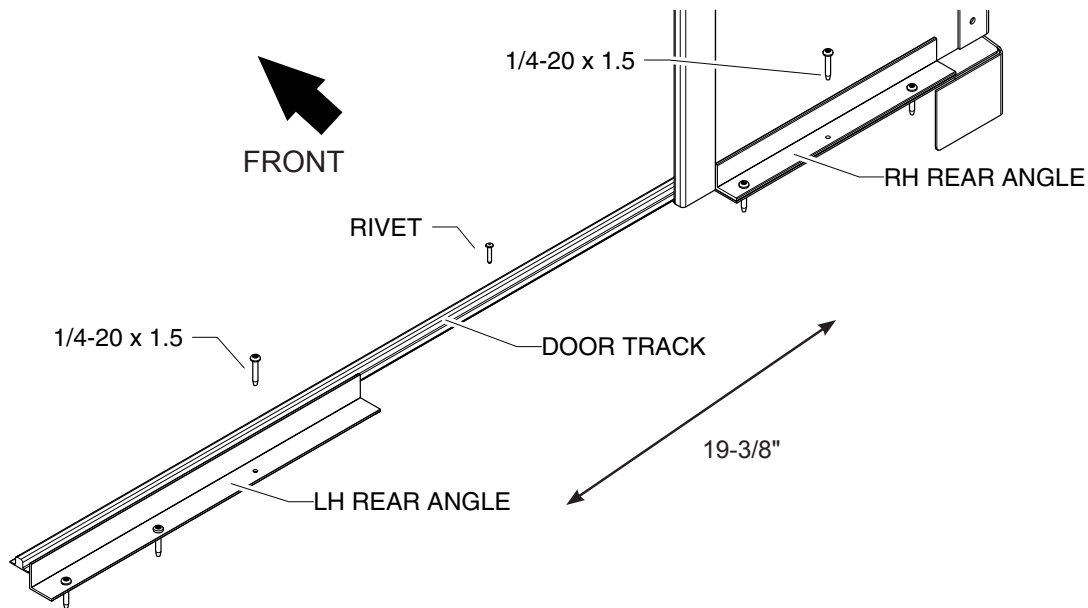


*LH top angle brace and fasteners*

## Standard Bulkhead Floor Fasteners

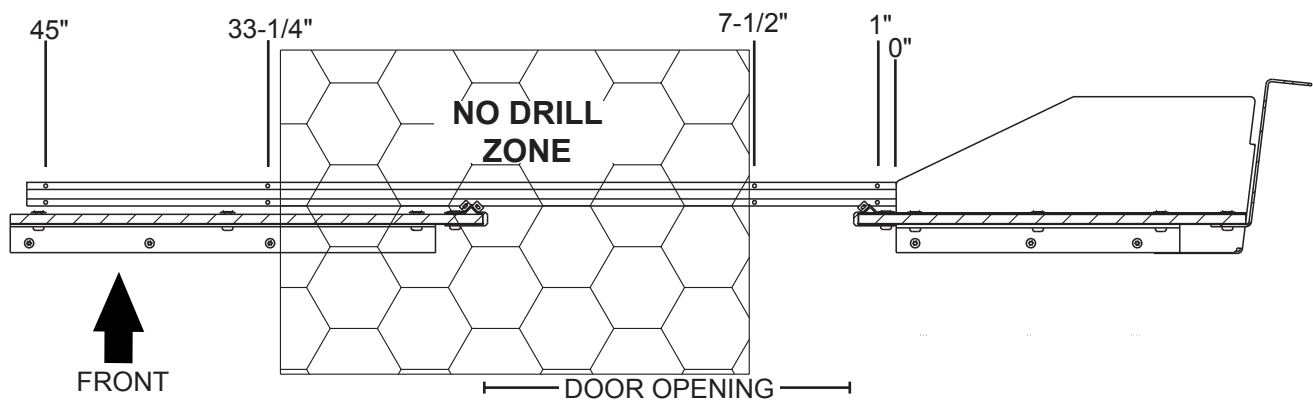


**CAUTION:** Use a drill stop to avoid damage to exterior panels and components.



*Standard bulkhead door track and fasteners (No jump seat)*

1. Use a 19-3/8" wood block to set the door opening.
2. Use the holes in the RH rear floor angle as a guide to drill (3) 7/32" holes into the cargo floor.
3. Secure with (3) 1/4-20 x 1.5 screws.
4. Align the door track with the RH front floor angle. Use a #11 bit and drill stop to drill (8) holes in the door track.
5. Secure door track with (8) rivets.
6. Cycle the door to check for smooth movement.

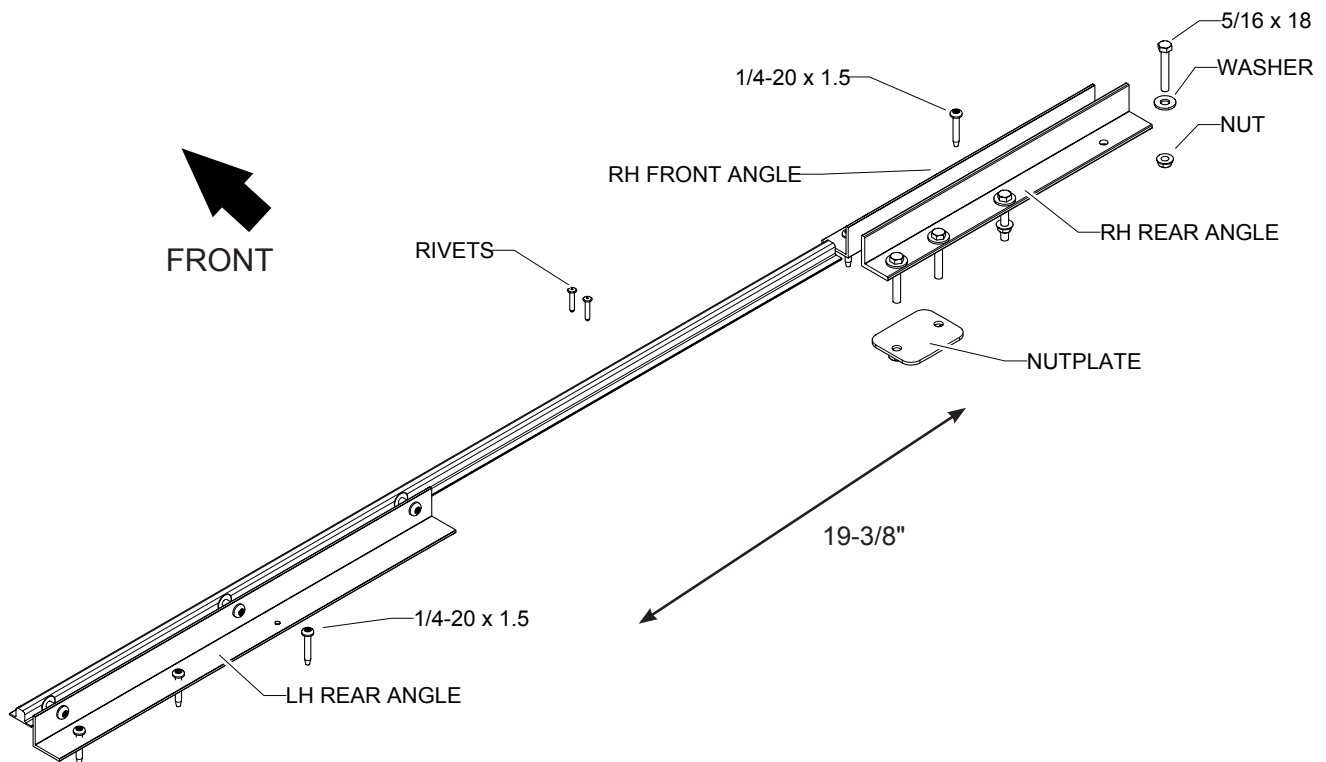


*Rivet hole locations for the door track*

## Bulkhead with Jump Seat Floor Fasteners

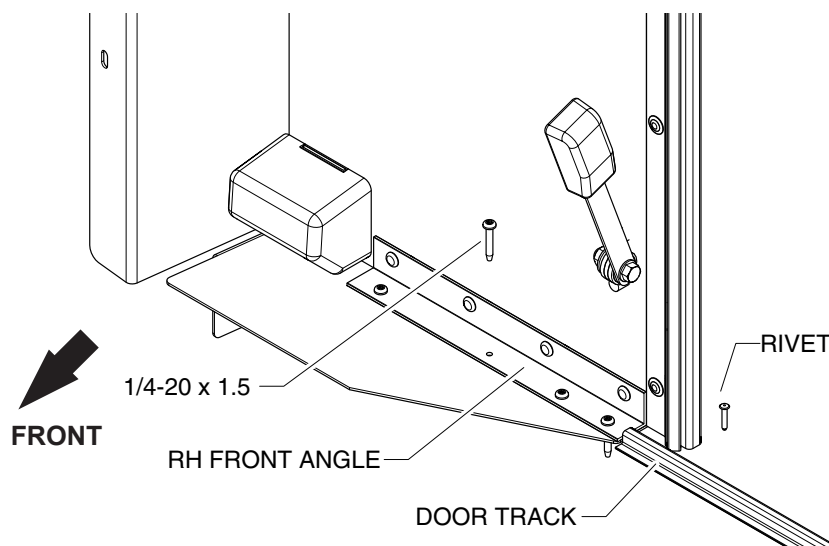


**CAUTION:** Use a drill stop to avoid damage to exterior panels and components.



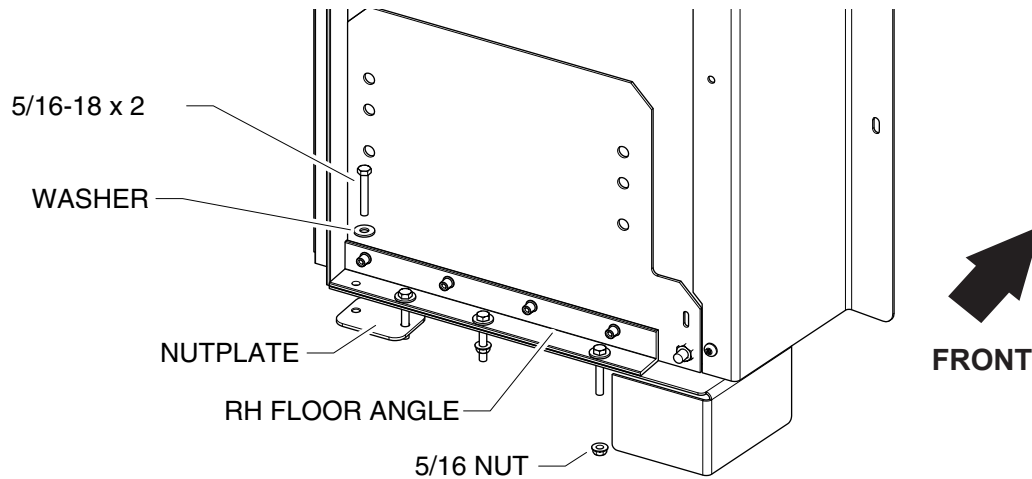
*Bulkhead with jump seat door track and fasteners*

1. Use a 19-3/8" wood block to set the door opening.
2. Use the holes in the RH front angle as a guide to drill 7/32" holes into the RH stepwell closeout panel and the floor.
3. Secure with (4) 1/4-20 x 1.5 screws.



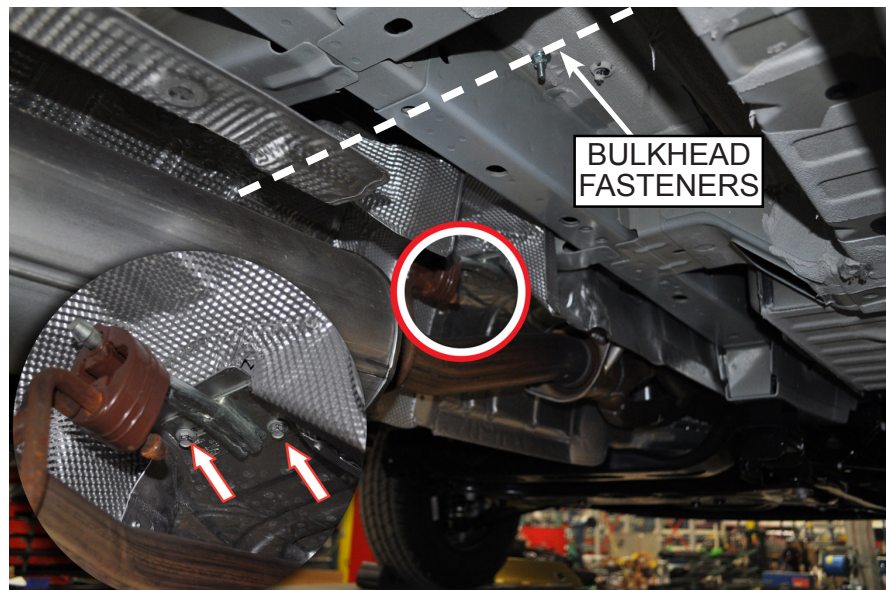
*RH front floor angle and fasteners*

4. Use the holes in the RH rear floor bracket as a guide and a drill stop to drill (4) 5/16" holes through the floor.
5. Secure (2) outboard 5/16-18 x 2 bolts under chassis with nuts.



*RH rear floor angle and plate*

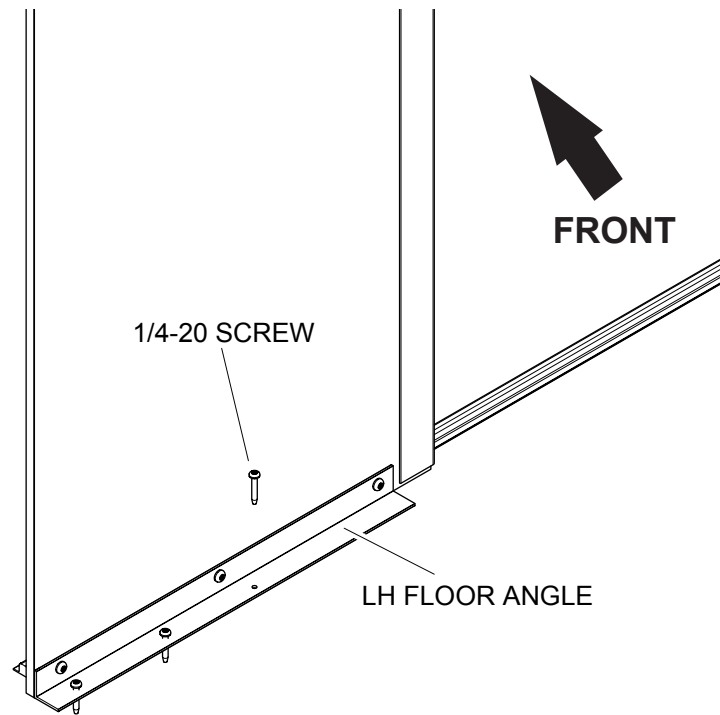
6. Remove (2) fasteners from exhaust hanger and gently pull down on heat shield to access the chassis floor. Set fasteners aside for reuse.
7. Insert (2) 5/16-18 bolts and washers in inboard holes and secure plate with nuts to chassis floor from under the chassis heat shield.



*Remove heat shield fasteners*

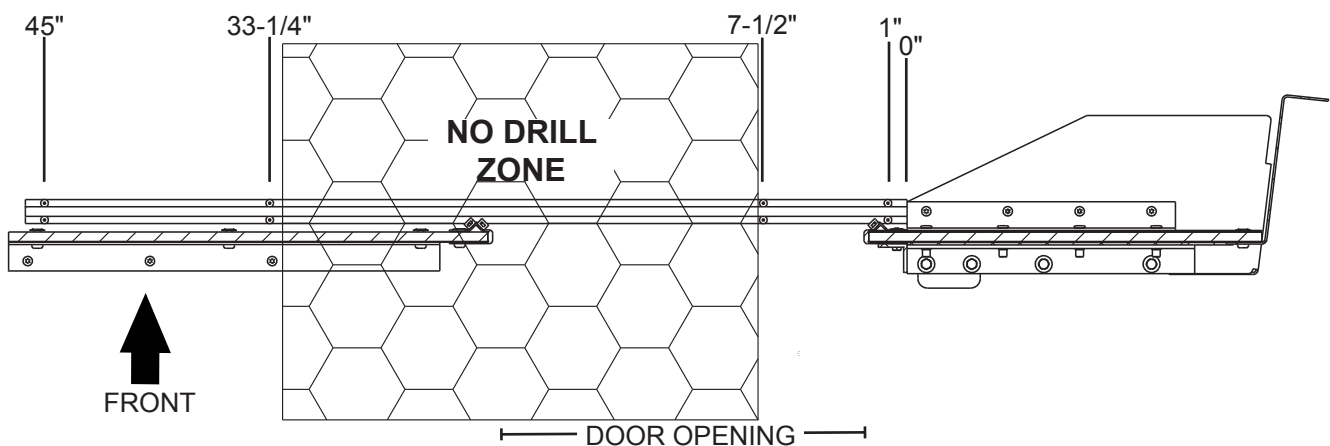
8. Reinstall (2) fasteners at the exhaust hanger.

9. Use the holes in the LH rear angle as a guide to drill (3) 7/32" holes into the cargo floor.
10. Secure with (3) 1/4-20 x 1.5 screws.



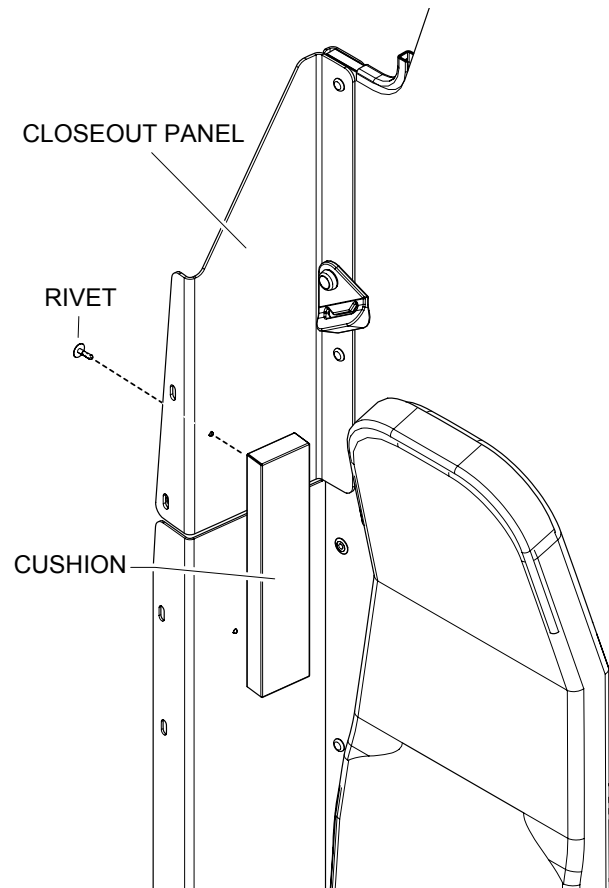
*LH rear floor angle and fasteners*

11. Align the door track with the RH front floor angle. Use a #11 bit and drill stop to drill (8) holes in the door track.
12. Secure door track with (8) rivets.
13. Cycle the door to check for smooth movement.



*Rivet hole locations for the door track*

14. Use (2) 3/16" rivets to secure the B-pillar cushion to the RH closeout panel.



B-Pillar cushion and fasteners

## Load Carrying Modification Label

*NOTICE: Load Carrying Modification Label may be required to satisfy the statutory requirements for labeling contained in Title 49 of the United States Code, Chapter 5 (Motor Vehicle Safety) and regulatory requirements contained in 49 CFR Parts 567 (Certification) and 568 (Vehicles Manufactured in Two or More Stages). A person who alters a vehicle that previously has been certified in accordance with 49 CFR 571.110 may require an altered certification obligation. Altered certification regulations cover all manufacturing performed after the vehicle has been certified in the final stage and before the first purchase of the vehicle in good faith for purpose other than resale.*

*If you have any questions regarding labeling requirements or need to order labels, call NTEA at 1-800-441-6832.*

1. Fill out and apply the Load Carrying Modification Label as required.



## Revision Control

Document Part Number: 03104504-N002EN

Revision: B  
Revision: A

December 2015  
June 2014

## Important Notices

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Title: *Transit—Bulkhead*

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