

20574

(16574P)

99-04 FORD

SUPER DUTY

1 PC. FULL OPEN

BILLET INSERT



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SUPER DUTY

1 PC. FULL OPEN

BILLET INSERT

99-04 Ford F-250/350 Super Duty

1 PC. Full Open / Flush Mount

TOOLS REQUIRED:

Phillips Screwdriver
Die Grinder w/ Cut-Off Wheel
2" Sanding Discs for Die Grinder
Drill w/3/16" drill bit
Medium file/sand paper

PARTS LIST:

1 - Billet Insert (26 bars)
6 - #10 x 1 Phillip Screws
6 - #10 Flat Nuts

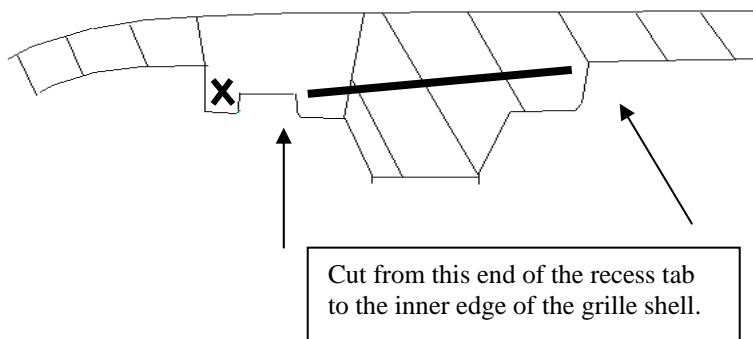
Read and understand all instructions before starting installation

STEP 1

Remove the screws on top of the grille. Now depress the clips on the bottom and remove the grille from the vehicle.

STEP 2

Note the two 3" wide flat tabs on the top of the inner opening. **DO NOT CUT THE TABS OFF;** Note the 'X' in the diagram below (toward the outer edge of the tab). This area is needed to mount the secure the insert to the shell later in step 5. Now make an angled 4" cut as noted by the thick black line in the diagram. No other cutting is needed on the upper edge between the tabs.



STEP 3

The center opening will now be cut out leaving only the outer chrome ring and the 26" section along the top of the grille. Note the contour on the front corner edge around entire opening of the grille shell. From one outer vertical bar on top, make a cut 1/8" back from the edge of the opening around the grille to the other vertical bar on top. When the cut is complete, there should be a 1/16" to 1/8" lip around the rear edge of the chrome ring (*It is better to cut less material and trim if needed rather than cutting too much*). Sand the edges smooth.

STEP 4

Now test fit the billet in the grille to see if more material will need to be trimmed around the chrome ring. Place the grille face down on a table. Center the billet in the shell with the two top brackets aligned with the recessed tabs. The billet should fit flush along the lower and side edges so there is no gap between the billet and the chrome ring (If it does not, trim the needed areas).

STEP 5

Make sure billet rests firmly against the rear of grille with no gaps Mark and drill the two top bracket holes. Fasten using the screws and clips provided. Mark and drill the bottom brackets and fasten with the remaining hardware.

STEP 6

With billet firmly attached to grille shell, re-install grille assembly on the vehicle. Installation complete.
Thank you for purchasing your T-Rex Billet Grille.