



INSTALLATION INSTRUCTIONS FOR MOUNTING

LUVERNE GRILLE GUARD WITH THE FOLLOWING MODEL NO.:
331120/331123 & 341120/341123 ON:

2011 AND NEWER F-250 – F-550 SUPER DUTY SERIES TRUCKS

1. READ THE INSTRUCTIONS COMPLETELY AND CHECK TO MAKE SURE THAT ALL OF THE REQUIRED PARTS ARE ON HAND BEFORE STARTING THE INSTALLATION. THE CARTON SHOULD CONTAIN:

- (1) OUTER RING PACKAGE
 - (1) OUTER RING ASSEMBLY
- (1) UPRIGHT PACKAGE
 - (1) UPRIGHT ASSEMBLY, LH
 - (1) UPRIGHT ASSEMBLY, RH
 - (1) FRAME BRACE, LH
 - (1) FRAME BRACE, RH
 - (1) HARDWARE PACKAGE
 - (1) CUSTOMER SERVICE PACKAGE

REFER TO SHEETS #1, #2, #3 & #4 FOR GUARD ASSEMBLY & INSTALLATION INSTRUCTIONS 2-11

2. ON THE LEFT SIDE OF THE VEHICLE, LOOSEN AND REMOVE THE TWO BOLTS IN THE FACE OF THE BUMPER, THAT SECURE THE BUMPER TO THE FRAME, ALSO REMOVE THE TWO BOLT RETAINER WASHERS BETWEEN THE BUMPER MOUNTING PLATE AND THE FRAME MOUNTING PLATE. REMOVE THE PLASTIC RATCHET FASTENER SECURING THE RUBBER SHIELD TO THE TOW HOOK BRACKET.
3. REMOVE THE TWO OUTSIDE BOLTS THAT SECURE THE TOW HOOK AND BUMPER MOUNTING BRACKET TO THE FRAME. INSTALL TWO OF THE M12 X 1.75 X 65mm BOLTS (ITEM #12) IN PLACE OF THE FACTORY BOLTS, TIGHTEN TO 75 FOOT POUNDS OF TORQUE.
4. INSTALL THE LEFT HAND FRAME BRACE (ITEM #4) ON TOP OF THE TOW HOOK AND INSTALL, 7/16" FLAT WASHERS (ITEM #19) AND M12 X 1.75 SERRATED FLANGE NUTS (ITEM #14) ON THE BOLTS. FINGER TIGHTEN AT THIS TIME.
5. ON THE LEFT HAND UPRIGHT (ITEM #2), INSTALL THE TWO 1/2"-13 X 2" ROUND HEAD BOLTS (ITEM #10) IN THE HOLES OF THE MOUNTING BRACKETS, PLACE THE SPACER PLATE (ITEM #6) ON THE BOLTS AND INSTALL THE TWO PUSH NUTS (ITEM #15) ON THE BOLTS.
6. INSERT THE ASSEMBLED UPRIGHT INTO THE HOLES IN THE BUMPER AND FASTEN WITH 1/2" FLAT WASHERS (ITEM #18), 1/2" LOCK WASHERS (ITEM #16) AND 1/2" HEX NUTS (ITEM #13) AS SHOWN IN FIG. 1 & 2. HAND TIGHTEN ONLY AT THIS TIME.
7. REPEAT STEPS 2 & 6 FOR THE OPPOSITE SIDE.

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8. INSTALL THE RING (ITEM #1) BY LOWERING IT DOWN FROM THE TOP AND BEHIND THE UPRIGHTS, (TAKING CARE NOT TO SCRAPE THE ENDS OF THE RING AGAINST THE SIDE OF THE VEHICLE.) AND SLIDE THE RING INTO THE NOTCHES OF THE UPRIGHTS. FASTEN WITH 7/16"-14 X 1-1/2" HEX BOLTS (ITEM #11), 7/16" FLAT WASHERS (ITEM #20) AND 7/16" LOCK WASHERS (ITEM #18) INTO THE 7/16"-14 CAPTIVE NUTS (ITEM #21) IN THE UPRIGHT MOUNTING PLATES.
9. CHECK THAT THE GRILL GUARD IS CENTERED AND VERTICAL ON THE BUMPER AND THE UPRIGHTS ARE STRAIGHT UP AND DOWN. THEN TIGHTEN THE FOUR 7/16" BOLTS SECURING THE RING TO THE UPRIGHTS. TIGHTEN TO 54 FOOT-POUNDS OF TORQUE.
10. TIGHTEN THE FOUR 1/2" NUTS (ITEM #14) SECURING THE UPRIGHTS TO THE BUMPER MOUNTING BRACKET AND THE FOUR M12 X 1.75 HEX FLANGE NUTS (ITEM #15) THAT SECURE THE MOUNTING BRACE TO THE TOP OF THE FRAME, TO 75 FOOT-POUNDS OF TORQUE.
11. REINSTALL THE RUBBER SHIELD ON THE LEFT SIDE WITH RATCHET FASTENER IN THE HARDWARE PACKGE (PART #22).

SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	202523	1	RING WELDMENT - CHROME
1	202529	1	RING WELDMENT - BLACK
2	202507	1	UPRIGHT WELDMENT - CHROME, LH
2	202527	1	UPRIGHT WELDMENT - BLACK, LH
3	202508	1	UPRIGHT WELDMENT - CHROME, RH
3	202528	1	UPRIGHT WELDMENT - BLACK, RH
4	202515	1	MOUNTING BRACE - LH
5	202516	1	MOUNTING BRACE - RH
6	202361	2	SPACER PLATE - FRAME BRACKET
7	202518	2	TAPPING BAR - 16.000"
8	200856	2	TAPPING BAR - 11.000"
9	202517	2	RUBBER EXTRUSION - MACHINED, 32.688"
10	107422	4	ROUND HEAD BOLT - 1/2"-13 X 2, ZP
11	100070	4	HEX HEAD SCREW - 7/16"-14 X 1-1/2", ZP
12	104987	4	HEX HEAD SCREW - M12 X 1.75 X 65mm, ZP
13	103715	10	SELF TAPPING SCREW - 1/4"-20 X 5/8", ZP
14	100124	4	HEX NUT - 1/2"-13, ZP
15	100794	4	HEX FLANGE NUT - M12 X 1.75, ZP
16	108733	4	PUSHNUT - 1/2", ZP
17	100121	4	LOCK WASHER - 1/2", ZP
18	100078	4	LOCK WASHER - 7/16", ZP
19	100118	4	FLAT WASHER - 1/2", ZP
20	100081	8	FLAT WASHER - 7/16", ZP
21	100083	4	CAPTIVE NUT - 7/16"-14
22	105515	1	RATCHET FASTENER - 1/4 X 1, BLACK
23	105293	4	TUBE PLUG - Ø1-1/4"
24	106902	1	MATTE BLACK DECAL - LH
25	106901	1	MATTE BLACK DECAL - RH
26	100252	1	DECAL - LOGO, 1 X 3



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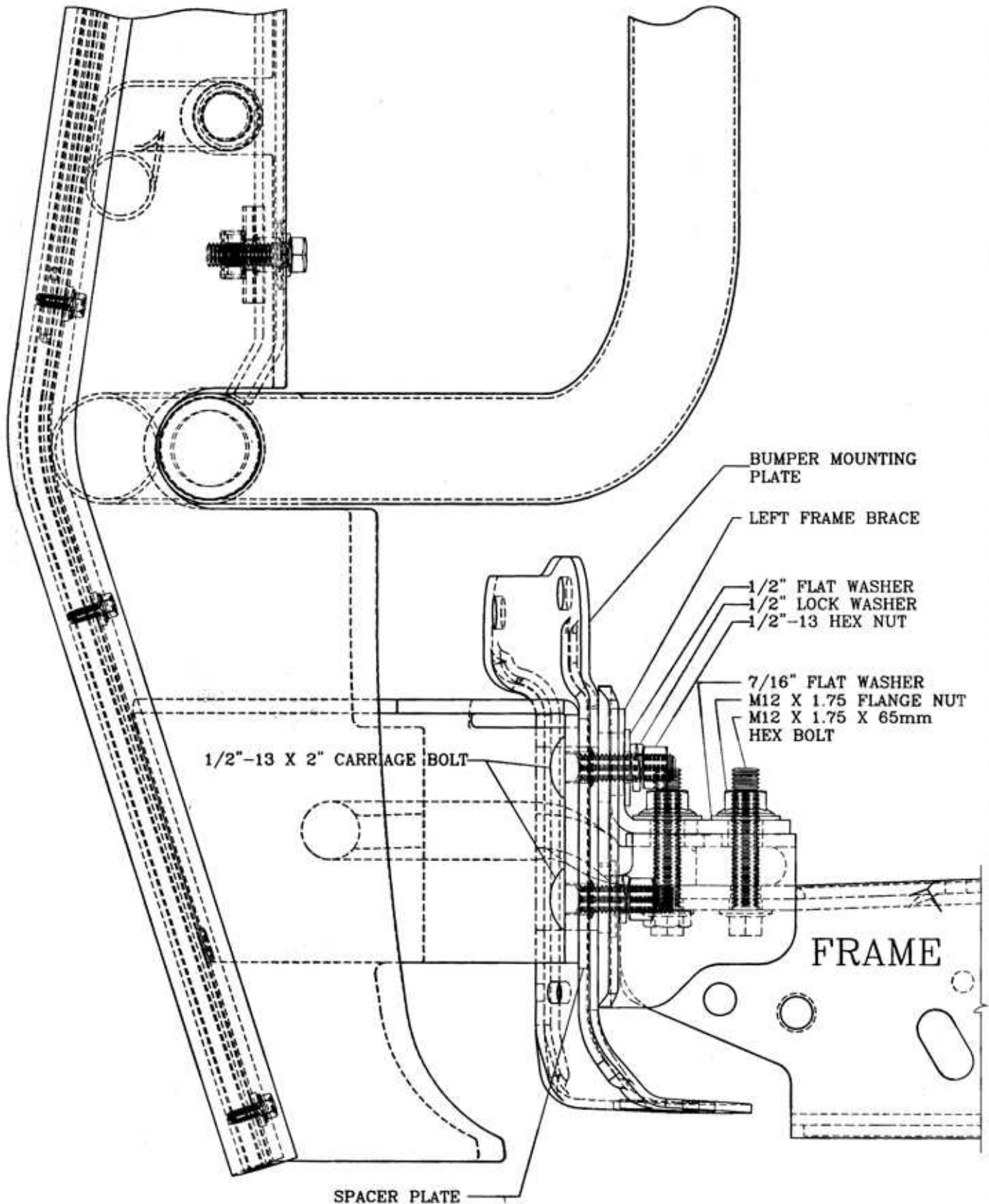


fig.1

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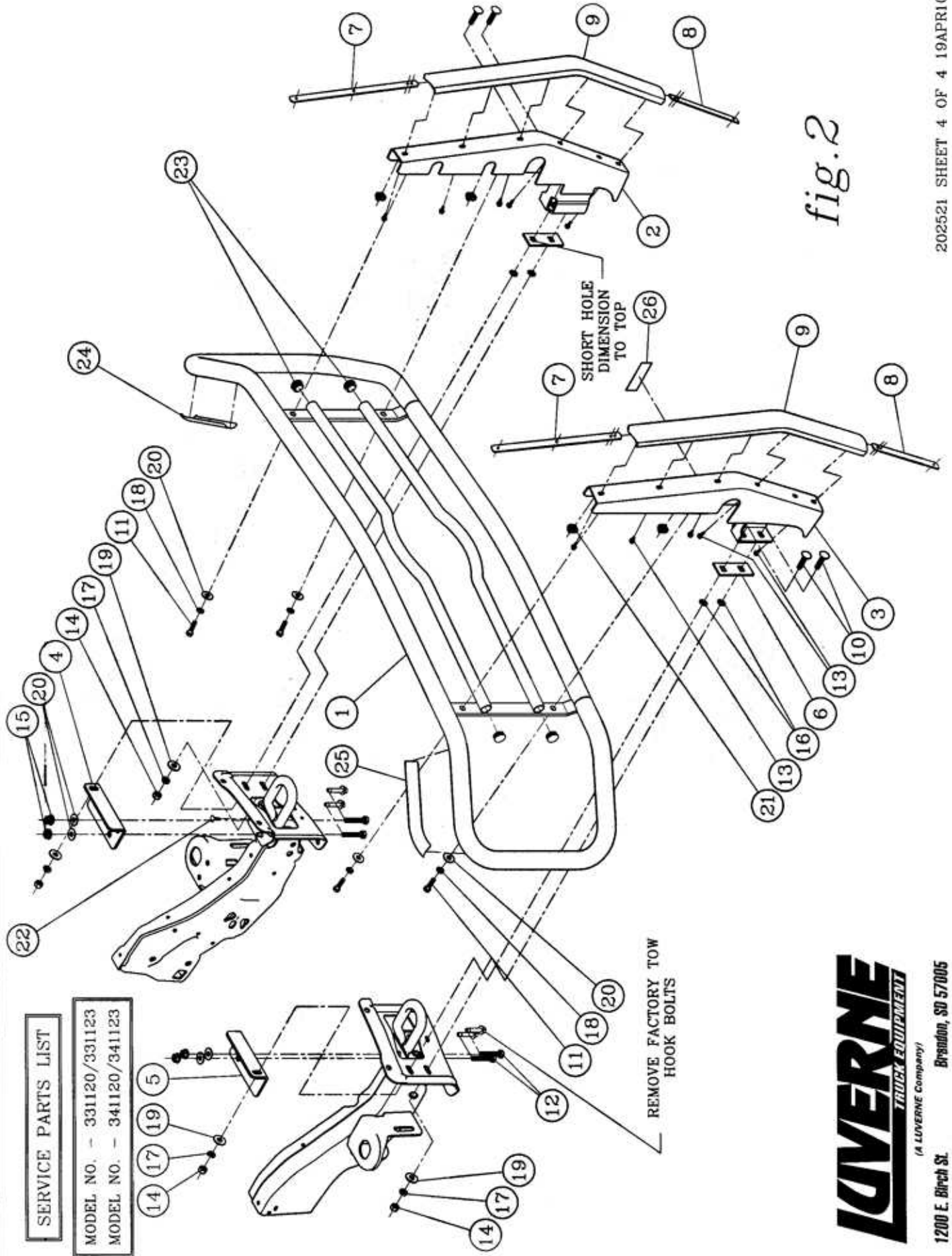
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fig.2



SERVICE PARTS LIST

MODEL NO. - 331120/331123
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