

# 20585

**00-04 FORD  
EXCURSION  
BILLET INSERT**



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### **TOOLS REQUIRED:**

Phillips & Slotted Screwdrivers  
7/16" Wrench  
Drill, 1/4" & 1/8" Drill Bits  
Die Grinder W/Cut-Off Wheel  
Files or Sandpaper

### **PARTS LIST:**

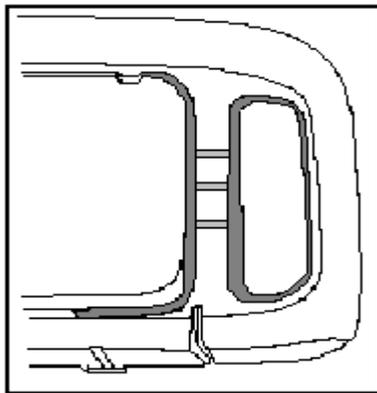
1 Center Billet Insert (25 bars)  
2 Side Billet Inserts (22 bars)  
3 #10 x 1 Phillip Screws  
3 #10 Flat Nuts  
4 1/4-20 x 3/4 Bolts, Nuts, Washers

**Read and understand all instructions before starting installation**

### **STEP 1**

Remove the factory grille shell. Now remove the three plastic inserts from the shell. Use a flat head screwdriver to pry out the plastic clips securing the inserts in place.

### **STEP 2**



The top of the billet has two dowels that point upwards and three mounting tabs on the bottom. Test fit the billet into the shell. It will be necessary to trim the plastic on each end of the grille shell opening so the billet can sit flush; trim about 1/4" – 1/2" of material off each end. This will allow the billet to sit flush. Trim the three supports molded to the back of the vertical bars on each end.

**Note the two dowels that extend on top of the insert.** Align these with the plastic on top of the center opening. Drill a 1/4" hole into the plastic (make sure to drill correctly so the insert is centered). Slide the dowels into the holes; if the insert does not sit square and flush, trim more material as needed.

**Note the molded line around the outer openings** (where the chrome meets the painted area). Cut off the grey plastic material rear of the chrome. This will allow the two small inserts to sit flush to the opening. Trim additional material off the grille as needed so they fit properly.

### **STEP 3**

Once the inserts sit flush to all three openings, secure them to the center billet using the 1/4-20 bolts, nuts and washers provided. Center the billet assembly and drill a 3/16" hole into the plastic aligned with the three lower tabs welded to the bottom of the center insert. Secure the bottom mounting tabs using the screws and flat nuts. Re-install grille assembly on the vehicle.

***Thank you for purchasing your T-Rex Billet Grille. 3/24/06***