

20580

(16580P)

99-02 FORD

F-150 / Expedition

BILLET INSERT



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99-03 F-150 & 99-02 EXPEDITION

Tools Required:

Phillips and Flat Screw Drivers
7mm Nut Driver
Die Grinder w/Cut-Off Wheel
1/8" & 3/16" Drill Bits
Flat files (or sanding discs for die grinder)

Parts List:

1 - Billet Insert (20 Bars)
2 - #8 Phillip Screws
2 - #8 Flat Nuts
2 - #10 Phillip Screws
2 - #10 Flat Nuts

Read and understand instructions before attempting installation

Step1

Remove the jack handle and black plastic top cover. Pull the headlight retainer clips up; disconnect bulbs and remove both headlights. Unscrew the 7 mm corner light screw and pull the corner lights forward to remove. Remove the six Phillips screws along the top of the grille and the two screws at each end. Note the plastic splash shields below the grille; Remove the two outer plastic fasteners on each end that connect to the fenders.

Step2

Now release the two clips behind the grille shell and remove from the vehicle. Place the grille shell on its face and remove the factory plastic insert. Most of these inserts are held in by 16 plastic tabs and can be unfastened; however some are plastic welded or melted at these tabs. If it is, use a die grinder to cut these welds. Cut or break the tabs off and file smooth so there is a clean edge around the opening.

Step3

Center the billet behind the grille opening with the long flat brackets on top. Be sure there are no gaps between the opening and the insert (it may be necessary to slightly bend the insert to get a perfect fit). Drill a 1/8" hole at each bottom bracket and install the #8 screws and flat nuts. Tighten the screws.

Step4

Install the grille shell back on the vehicle. Fasten with the factory screws. Push the billet insert forward so there is no gap between the billet and the opening; the upper brackets on the billet insert mount to the header panel. Drill a 3/16" hole in the header panel aligned with the holes in the brackets. Fasten with the #10 screws and flat nuts. Re-attach the splash shields with the plastic fasteners. Install the corner lights and headlights back on the vehicle.

Step5

Re-install the plastic top cover and jack handle. Installation complete. *Thank you for purchasing a T-Rex billet grille.*