

20563
08-10 FORD
SUPER DUTY



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BILLET INSERT – 3 PC

Tools Required:

Phillips / Slotted Screwdrivers
8mm Socket
5/16" Wrench
Drill & 3/16" Bit
Die Grinder & Cutting / Sanding Discs
Masking Tape

Hardware / Parts Included:

3 Billet Inserts (Center, Right, Left)
8 #8 x 3/4" Phillips Screws
8 #8 U-Nuts
4 6-32 x 2" Machine Screws
4 6-32 Nylon Lock Nuts
4 1 1/2" J Hooks

Read and understand instructions before attempting installation

Step 1

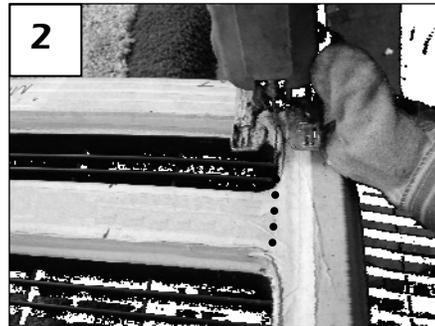
This billet grille will fit XLT model factory chrome grilles and FX4 model factory painted grilles. The center section of the OE grille must be cut for installation. Apply masking tape to the face of the grille to prevent scratching.

Remove seven plastic fasteners inside the top opening of the factory grille. Open the hood; remove two 8mm bolts behind the grille; securing it to the hood supports. Pry the grille assembly up to release the clips securing the grille assembly to the hood. Carefully follow the instructions for your model in Step 2 or 3.

Step 2

XLT Model w/Chrome Grille

From the front; cut the inner cross bar mesh along the top; make your cuts below the solid plastic that retains the seven mounting holes along the top. Now cut the mesh in the lower opening; cut at the base of the bars.



Draw a vertical straight line on each end of the center opening (across the two center cross bars) (1). Make your first cut 1/8" inside each line (better to cut less and make a second cut than cutting too much material). Use a die grinder or jig-saw to make your cuts (2). The center section securing the Ford logo can now be removed from the OE grille.

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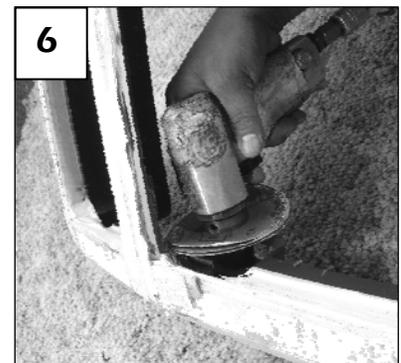
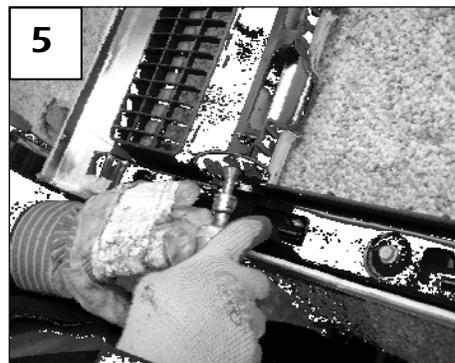
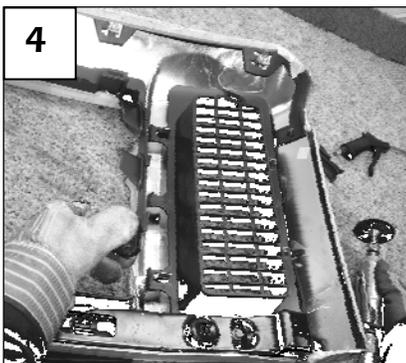
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The OE black plastic inserts secured to the side openings (3) must be retained for installation.

Place the grille face down. Trim the material on the inside edge of the mounting tabs; securing the OE side opening inserts (4). Do not cut the tabs securing the side inserts.



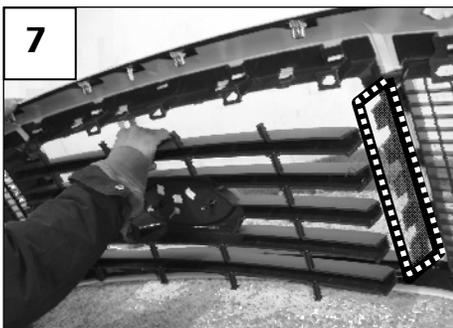
Test fit the center insert behind the OE grille; the ends of the billet bars rest behind the cut edge. Remove any additional material that must be trimmed for installation (4). When completed; the billet will rest flush behind the OE grille opening.

Make additional cuts to finish the required cut edge (5). Use a sanding disc or file to smooth and blend the cuts in each corner (6).

Step 3

FX4 Model w/Painted Grille

Cut the small vertical webbing in the center section of the OE grille; make each cut at the base (where it contacts the inner edge). Now cut the five horizontal inner cross bars from the center of the grille. Do not cut the plastic inner edge circling the webbing and cross bars. Remove the center section securing the Ford logo from the OE grille (7).



The OE black plastic inserts secured to the side openings (3) must be retained for installation.

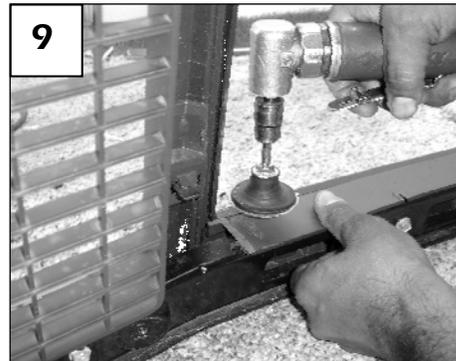
Place the grille face down. Trim the material on the inside edge of the mounting tabs; securing the OE side opening inserts (4). Do not cut the tabs securing the side inserts.

Use a die grinder to cut the plastic edge on each end of the center opening (dotted area in diagram 7). Do not trim any material from the top or bottom of the opening.

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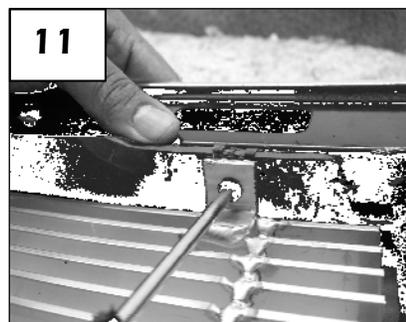
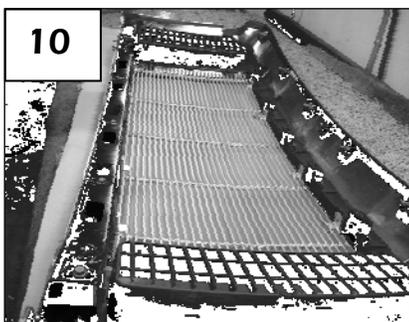
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Make additional cuts to finish the required cut edge (8). Use a sanding disc or file to smooth and blend the cuts in each corner (9).

Test fit the center insert behind the OE grille; the ends of the billet bars rest behind the cut edge. Note the additional material on each end that must be trimmed for installation.



Step 4

Once the proper fit is achieved; center the grille and firmly hold in place (10); vise grip pliers or clamps can be used to retain the grille.

Drill a 1/8" hole aligned with each mounting tab. Slide a u-nut over each hole. Use the #8 screws to secure the grille in place (11).

Step 5

Install the side opening grille inserts. Install a screw from the front; secure a J hook and nut onto each screw. Center one of the inserts; wrap the J hooks around the inner cross bar mesh. Tighten the hardware.



Step 6

Re-install the grille assembly onto the vehicle. Install the plastic fasteners along the top from the rear. ***Thank you for purchasing a T-Rex Billet Grille. 4/6/07***

(Picture shown with optional 25564 Bumper Billet)