

# **20561**

**05-07 FORD  
SUPER DUTY**



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## **3 PC LOOK BILLET INSERT**

### **Recommended Tools:**

Die Grinder w/ Cutting Disc & Sanding Disc  
Drill & 1/8 Drill Bit  
Files  
Phillips / Flat Head Screw Drivers  
Rivet Gun

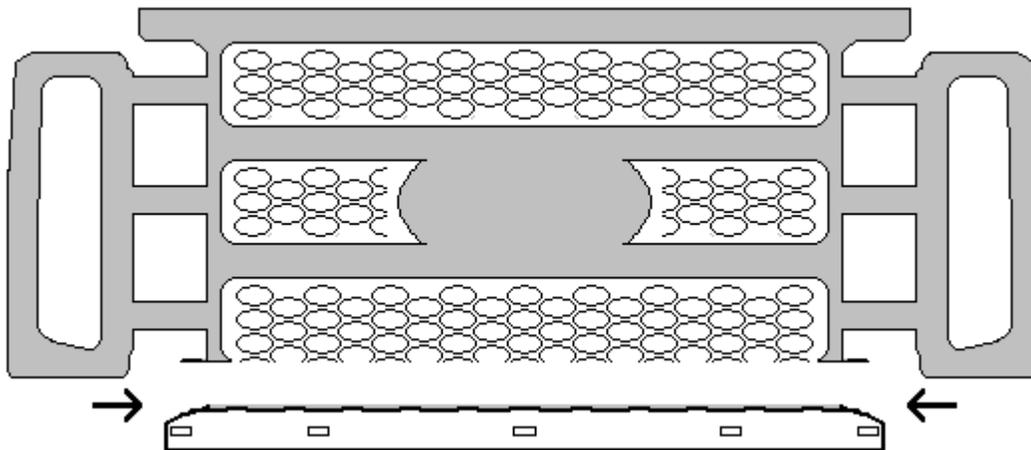
### **Parts List / Hardware:**

1 Billet Insert (24 Bars)  
8 1/8" Rivets

## **Read and understand instructions before attempting 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. Access the lower clips by gently pulling the grille forward; then use a large slotted screwdriver to depress the clips. A basic diagram of the center honeycomb assembly is shown below. Separate this plastic honeycomb center from the outer chrome shell. Use a slotted screwdriver to unclip the mounting tabs. Be careful unfastening six clips along the bottom; this section is re-used to fasten the grille to the vehicle.



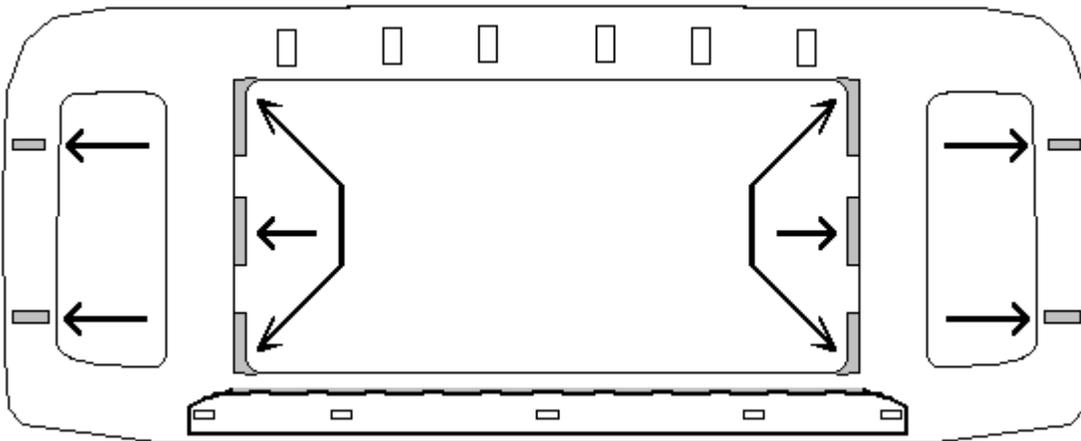
The lower portion of the honeycomb with the grille mounting clips will be re-used. Cut this lower section from the honeycomb center (see the diagram). Make your cut at the base of honeycomb bars. It will be necessary to trim some excess material on each end of this lower section so the billet aligns properly; Wait until the end of Step2 before removing anymore material.

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## **Step 2**

Cut/remove the pair of honeycomb mounting tabs on each end of the grille shell (see the outer arrows). On the front of the grille shell, mask a straight line from top to bottom just outside the center opening. Cut the cross bars from the center opening. Now cut the 1/2" plastic lip left after cutting the cross bars (the 6 center arrows note this area). Be careful when cutting this area; It is highly recommended to use a roll-lock style (or similar) sanding disc when finishing these cuts. Re-install the cut section of the honeycomb (with the mounting clips) onto the grille shell. Test fit the billet in place. Trim any excess material from the shell or lower honey comb section so the billet sits flush to the rear of the chrome shell.



## **Step 3**

The billet insert has 4 mounting tabs on top and 4 tabs on the bottom. The top mounting brackets align with 4 of the 6 mounting locations for the factory honeycomb. The lower tabs are bent at a 90 degree angle and align with the cut section of the honeycomb. It may be necessary to slightly bend the tabs on the billet so they can align at the proper angle. Center the billet into the shell. Mark the mounting tab holes to the grille shell assembly. Make sure the billet is flush to the back of the grille shell. Drill a 1/8" hole at each mark. Be careful not to drill through the front of the grille shell on the upper holes. Rivet the billet in place.

## **Step 4**

Re-install the grille shell assembly onto the vehicle. Installation is now complete.

***Thank you for purchasing your T-Rex billet grille. 12/17/04***