



INSTALLATION INSTRUCTIONS FOR MOUNTING

LUVERNE GRILLE GUARD WITH THE FOLLOWING MODEL NO.:
330820/330823 & 340820/340823 ON:

2008 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, RH
 - (1) UPRIGHT ASSEMBLY, LH
 - (2) UPRIGHT COVERS (**CHROME GUARDS ONLY**)
 - (1) HARDWARE PACKAGE
 - (1) CUSTOMER SERVICE PACKAGE

REFER TO SHEETS #1, #2, #3 & #4 FOR GUARD ASSEMBLY & INSTALLATION INSTRUCTIONS 2-7

2. LOOSEN AND REMOVE THE TWO BOLTS AND NUTS, IN THE FACE OF THE BUMPER, THAT SECURE THE BUMPER TO THE FRAME, ON THE RIGHT SIDE OF THE VEHICLE. ALSO REMOVE THE TWO BOLT RETAINER WASHERS BETWEEN THE BUMPER MOUNTING PLATE AND THE FRAME MOUNTING PLATE.
3. INSTALL THE RIGHT HAND UPRIGHT (ITEM #2) USING THE TWO ½”-13 X 2” ROUND HEAD BOLTS (ITEM #9) ONE ½”-13 X 1-1/4” HEX HEAD BOLT (ITEM #13), ½” FLAT WASHERS (ITEM #17), ½” LOCK WASHERS (ITEM #15), ½” HEX NUTS (ITEM #12), ½” SERRATED FLANGE NUT (ITEM #11) THE SPACER PLATE (ITEM #20) AND THE RIGHT HAND MOUNTING BRACE (ITEM #4) AS SHOWN IN FIG. 1 & 2. HAND TIGHTEN ONLY AT THIS TIME.
4. REPEAT STEPS 2 & 3 FOR THE OPPOSITE SIDE.
5. 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 UPRIGHT COVERS (ITEM #16) (**CHROME GUARDS ONLY**), 7/16”-14 X 1-1/2” HEX BOLTS (ITEM #14) AND 7/16” FLAT WASHERS (ITEM #18) INTO THE 7/16”-14 CAPTIVE NUTS (ITEM #19) IN THE UPRIGHT MOUNTING PLATES.
6. 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..



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7. TIGHTEN THE FOUR ½” NUTS (ITEM #12) SECURING THE UPRIGHTS TO THE BUMPER MOUNTING BRACKET AND THE TWO ½”-13 X 1-1/4” HEX HEAD BOLTS (ITEM #13) THAT SECURE THE MOUNTING BRACE TO THE SIDE OF THE FRAME, TO 75 FOOT-POUNDS OF TORQUE.

SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	202348	1	RING WELDMENT – CHROME
1	202365	1	RING WELDMENT – BLACK
2	202353	1	UPRIGHT WELDMENT – CHROME, RH
2	202367	1	UPRIGHT WELDMENT – BLACK, RH
3	202354	1	UPRIGHT WELDMENT – CHROME, LH
3	202368	1	UPRIGHT WELDMENT – BLACK, LH
4	202369	1	MOUNTING BRACE - RH
5	202370	1	MOUNTING BRACE - LH
6	202038	2	TAPPING BAR – 11.500”
7	201122	2	TAPPING BAR – 13.000”
8	202003	2	RUBBER EXTRUSION – MACHINED, 30.250”
9	107422	4	ROUND HEAD BOLT – ½”-13 X 2, ZP
10	103715	10	SELF TAPPING SCREW – ¼”-20 X 5/8”, ZP
11	100123	2	SERRATED FLANGE NUT – ½”-13, ZP
12	100124	4	HEX NUT – ½”-13, ZP
13	100086	2	HEX HEAD SCREW – ½”-13 X 1-1/4”, ZP
14	105939	4	HEX HEAD SCREW - 7/16”-14 X 1-1/4”, ZP
15	100121	4	LOCK WASHER – ½”, ZP
16	202545	2	UPRIGHT COVERS (CHROME GUARDS ONLY)
17	100118	6	FLAT WASHER – ½”, ZP
18	103286	4	FLAT WASHER – 7/16”, SST
19	100083	4	CAPTIVE NUT – 7/16”-14
20	202361	2	SPACER PLATE
21	105293	4	TUBE PLUG – Ø1-1/4”
22	100252	1	DECAL – LOGO, 1 X 3

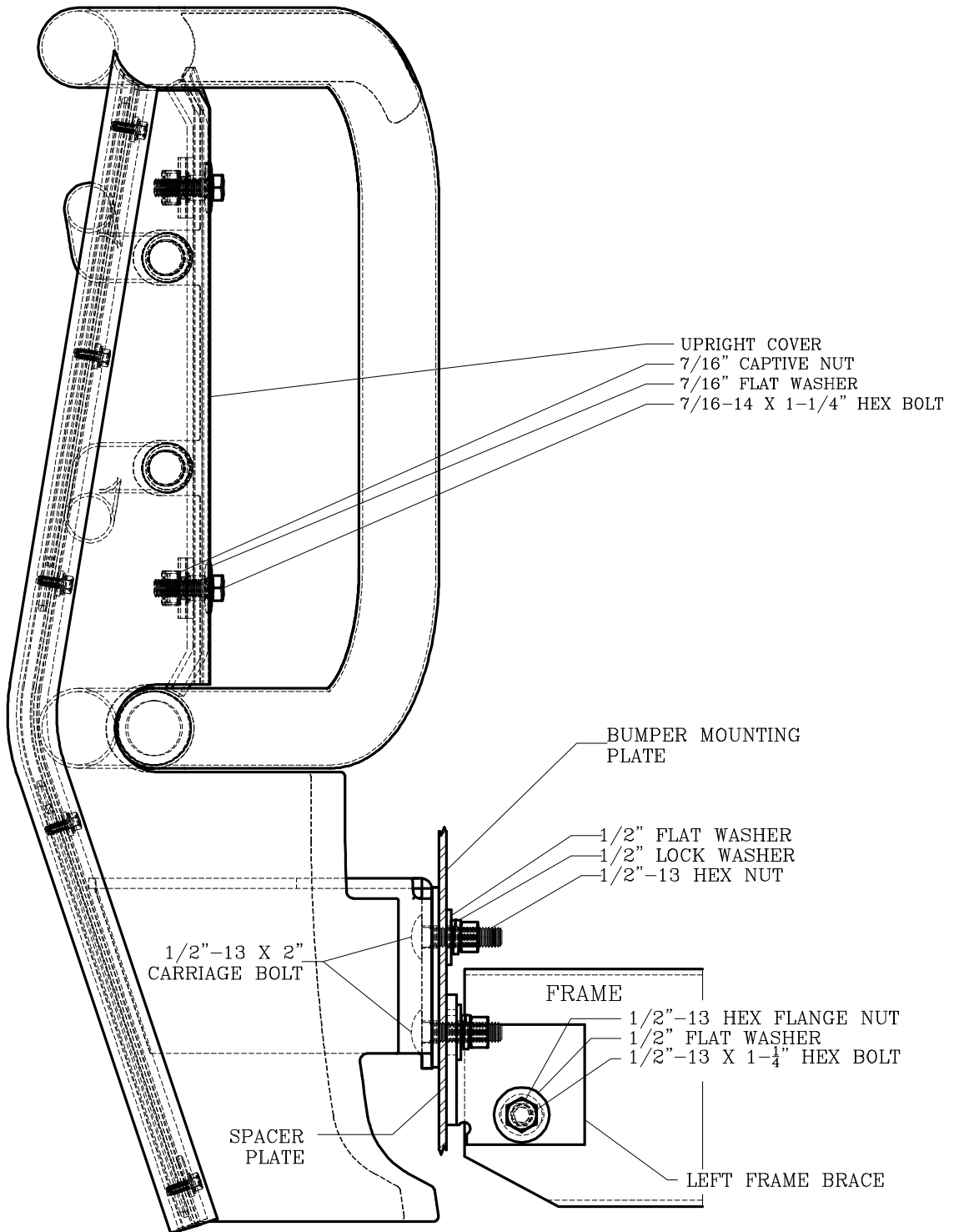


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fig.1

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SERVICE PARTS LIST

MODEL NO. - 330820/330823
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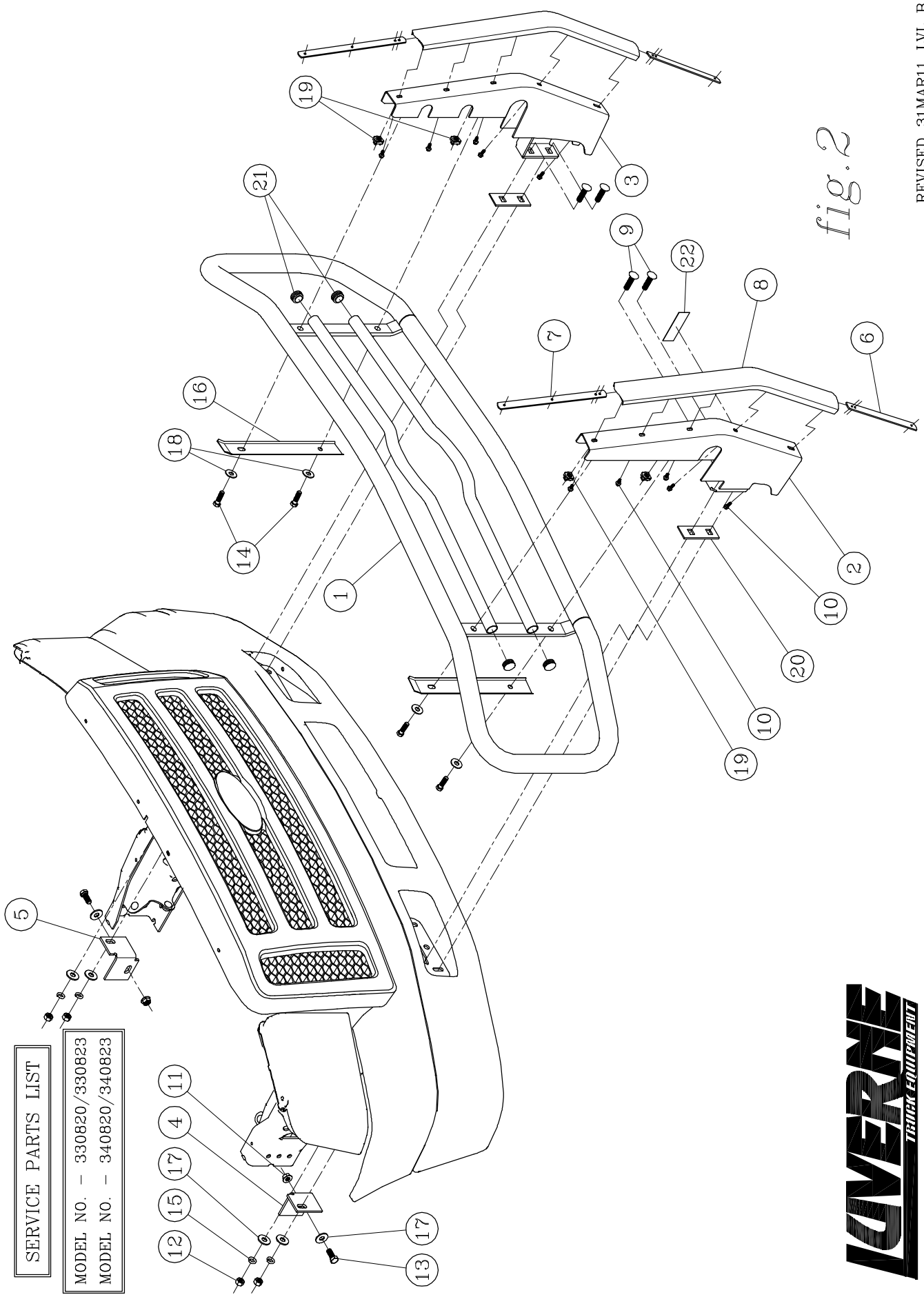


fig. 2

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