



## INSTALLATION INSTRUCTIONS FOR MOUNTING

LUVERNE GRILLE GUARD WITH THE FOLLOWING MODEL NO.:  
331120/331123 & 341120/341123 ON:

2011 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, LH
    - (1) UPRIGHT ASSEMBLY, RH
    - (1) FRAME BRACE, LH
    - (1) FRAME BRACE, RH
    - (2) UPRIGHT COVERS (**CHROME GUARDS ONLY**)
    - (1) HARDWARE PACKAGE
    - (1) CUSTOMER SERVICE PACKAGE

### **REFER TO SHEETS #1, #2, #3, #4 & 5 FOR GUARD ASSEMBLY & INSTALLATION INSTRUCTIONS 2-14**

2. ON THE LEFT SIDE OF THE VEHICLE, LOOSEN AND REMOVE THE TWO BOLTS IN THE FACE OF THE BUMPER, THAT SECURE THE BUMPER TO THE FRAME, ALSO REMOVE THE TWO BOLT RETAINER WASHERS BETWEEN THE BUMPER MOUNTING PLATE AND THE FRAME MOUNTING PLATE.
3. IF THE VEHICLE HAS AN ANTI-CLIMB OVER BRACKET REMOVE THE OUTSIDE BOLT SET THAT ATTACHES IT TO THE FRAME.
4. INSTALL THE 5/8"-11 CLIPPED HEAD CARRIAGE BOLT (ITEM #12) BY INSERTING THE HEAD INTO THE SLOTTED HOLE IN THE FRAME AND ROTATING IT 90°. INSTALL THE 3/4" WASHER (ITEM #22) ON THE BOLT ALONG WITH A 5/8"-11 SERRATED FLANGE NUT (ITEM #16). SNUG UP BUT DO NOT TIGHTEN.
5. INSTALL THE LEFT HAND T-BOLT ASSEMBLY (ITEM #6) THROUGH THE HOLES IN THE FRAME FROM THE INSIDE. INSTALL TWO M12 X 1.75 FLANGE NUTS (ITEM #18) ON THE BOLTS AND SNUG UP.
6. INSTALL M12 X 1.75 (ITEM #18) AND 5/8"-11 (ITEM #16) FLANGE NUTS WITH THE FLANGE FACING OUT, ONTO THE THREE BOLTS IN THE SIDE OF THE FRAME. SET THE FACE OF THE NUT SO THAT IS 1-3/8" FROM THE OUTSIDE OF THE FRAME. SEE DETAIL "A".
7. INSTALL THE LEFT HAND FRAME BRACE (ITEM #4) ONTO THE BOLTS AND INSTALL, M12 X 1.75 (ITEM #18) AND 5/8"-11 (ITEM #16) FLANGE NUTS ON THE ENDS OF THE BOLTS. FINGER TIGHTEN AT THIS TIME.



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8. ON THE LEFT HAND UPRIGHT (ITEM #2), INSTALL THE TWO 1/2"-13 X 2" ROUND HEAD BOLTS (ITEM #13) IN THE HOLES OF THE MOUNTING BRACKETS, PLACE THE SPACER PLATE (ITEM #8) ON THE BOLTS AND INSTALL THE TWO PUSH NUTS (ITEM #19) ON THE BOLTS.
9. INSERT THE ASSEMBLED UPRIGHT INTO THE HOLES IN THE BUMPER AND FASTEN WITH 1/2" FLAT WASHERS (ITEM #23), 1/2" LOCK WASHERS (ITEM #20) AND 1/2" HEX NUTS (ITEM #17) AS SHOWN IN FIG. 1 & 2. HAND TIGHTEN ONLY AT THIS TIME.
10. REPEAT STEPS 2 THRU 9 FOR THE OPPOSITE SIDE.
11. 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 THE UPRIGHT COVERS (ITEM #21) (**CHROME GUARDS ONLY**), 7/16"-14 X 1-1/4" HEX BOLTS (ITEM #14) AND 7/16" FLAT WASHERS (ITEM #24) INTO THE 7/16"-14 CAPTIVE NUTS (ITEM #25) IN THE UPRIGHT MOUNTING PLATES.
12. 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.
13. TIGHTEN THE FOUR 1/2" NUTS (ITEM #17) SECURING THE UPRIGHTS TO THE BUMPER MOUNTING BRACKET AND THE MOUNTING BRACES TO 75 FOOT-POUNDS OF TORQUE.
14. TIGHTEN THE NUTS THAT SECURE THE MOUNTING BRACKET BRACE TO THE FRAME TO 54 FOOT-POUNDS OF TORQUE.



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**SERVICE PARTS LIST**

ITEM	PART NO.	QTY	DESCRIPTION
1	202523	1	RING WELDMENT – CHROME
1	202529	1	RING WELDMENT – BLACK
2	202507	1	UPRIGHT WELDMENT – CHROME, LH
2	202527	1	UPRIGHT WELDMENT – BLACK, LH
3	202508	1	UPRIGHT WELDMENT – CHROME, RH
3	202528	1	UPRIGHT WELDMENT – BLACK, RH
4	202574	1	MOUNTING BRACE – LH
5	202575	1	MOUNTING BRACE – RH
6	202576	1	T-BOLT ASSEMBLY - LH, ZP
7	202577	1	T-BOLT ASSYEMBLY - RH, ZP
8	202361	2	SPACER PLATE – FRAME BRACKET
9	202518	2	TAPPING BAR – 16.000”
10	200856	2	TAPPING BAR – 11.000”
11	202517	2	RUBBER EXTRUSION – MACHINED, 32.688”
12	109274	2	ROUND HEAD CLIPPED BOLT – 5/8”-11 X 3, ZP
13	107422	4	ROUND HEAD BOLT – 1/2”-13 X 2, ZP
14	105939	4	HEX HEAD SCREW – 7/16”-14 X 1-1/4”, SST
15	103715	10	SELF TAPPING SCREW – 1/4”-20 X 5/8”, ZP
16	105643	6	HEX FLANGE NUT – 5/8-11, ZP
17	100124	4	HEX NUT – 1/2”-13, ZP
18	100794	12	HEX FLANGE NUT – M12 X 1.75, ZP
19	108733	4	PUSHNUT – 1/2”, ZP
20	100121	4	LOCK WASHER – 1/2”, ZP
21	202546	2	UPRIGHT COVER ( <b>CHROME GUARDS ONLY</b> )
22	100153	2	FLAT WASHER – 3/4”, ZP
23	100118	4	FLAT WASHER – 1/2”, ZP
24	103286	4	FLAT WASHER – 7/16”, SST
25	100083	4	CAPTIVE NUT – 7/16”-14
26	105293	4	TUBE PLUG – Ø1-1/4”
27	106902	1	MATTE BLACK DECAL – LH
28	106901	1	MATTE BLACK DECAL – RH
29	100252	1	DECAL – LOGO, 1 X 3

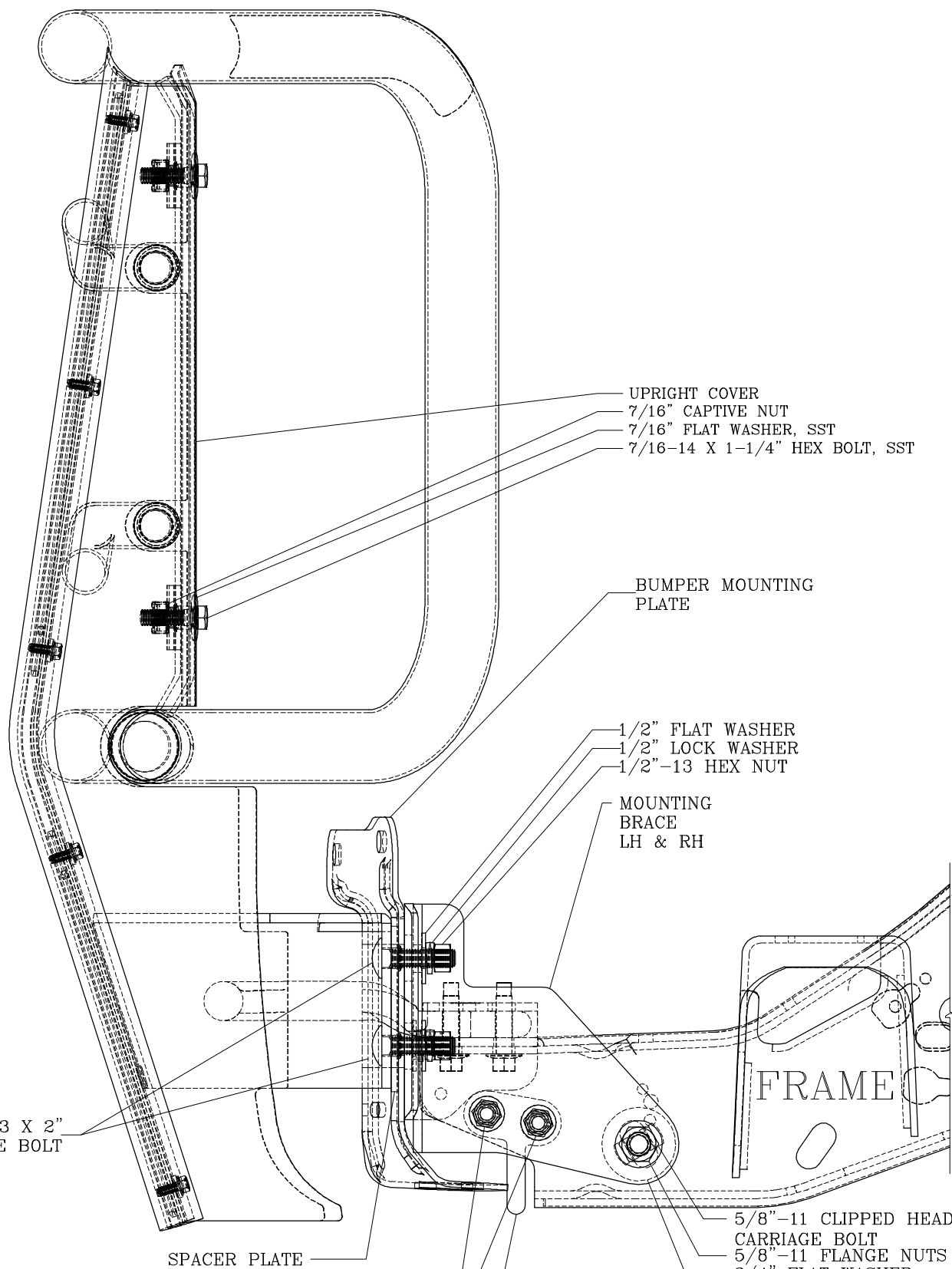


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UPRIGHT COVER  
 7/16" CAPTIVE NUT  
 7/16" FLAT WASHER, SST  
 7/16-14 X 1-1/4" HEX BOLT, SST

BUMPER MOUNTING  
 PLATE

1/2" FLAT WASHER  
 1/2" LOCK WASHER  
 1/2"-13 HEX NUT

MOUNTING  
 BRACE  
 LH & RH

1/2"-13 X 2"  
 CARRIAGE BOLT

SPACER PLATE

FRAME

5/8"-11 CLIPPED HEAD  
 CARRIAGE BOLT  
 5/8"-11 FLANGE NUTS  
 3/4" FLAT WASHER

T-BOLT ASSEMBLY, LH & RH  
 M12 X 1.75 X 65mm  
 M12 X 1.75 FLANGE NUTS



fig. 1

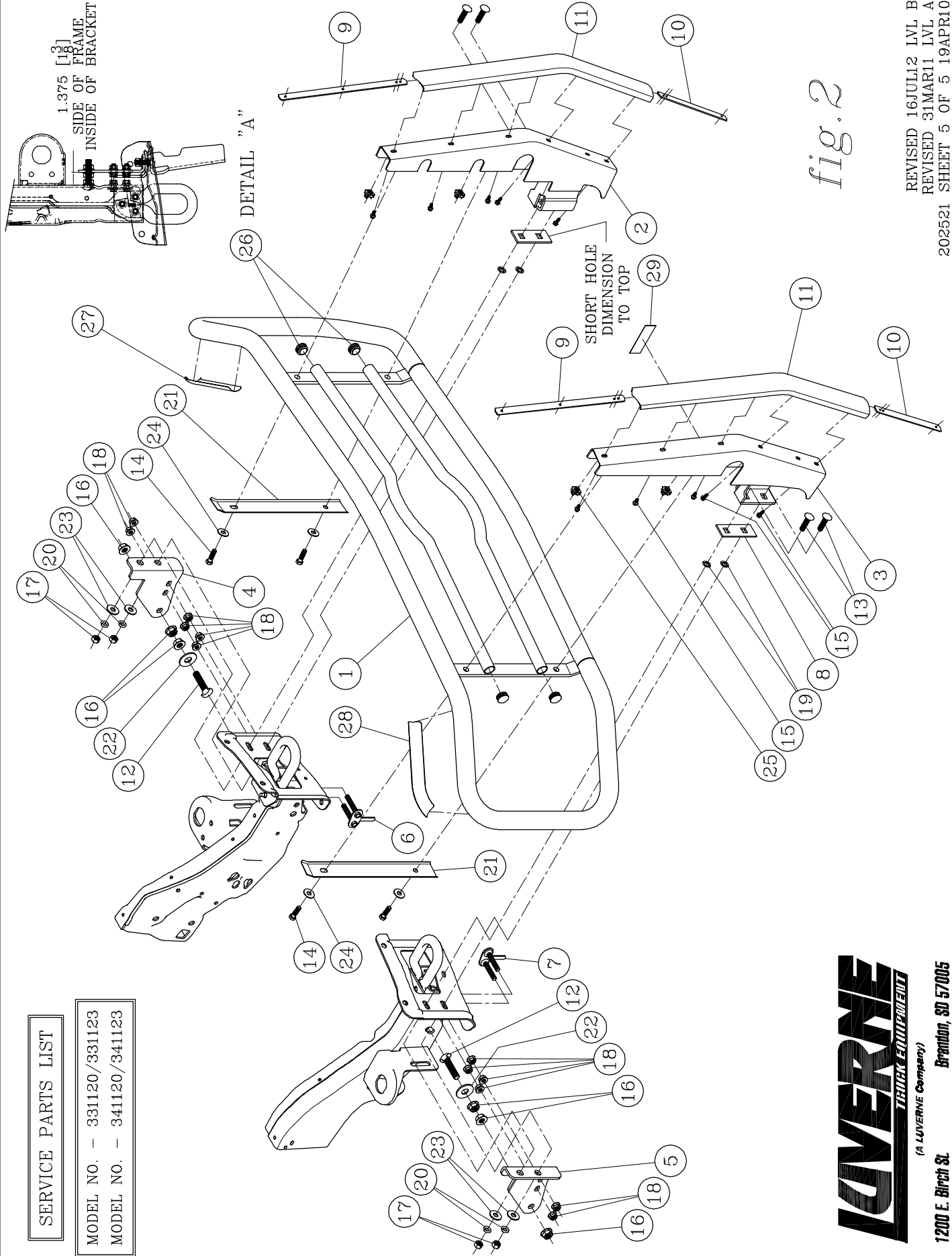
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SERVICE PARTS LIST

MODEL NO. - 331120/331123

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**LOVERNE**  
TRUCK EQUIPMENT  
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