

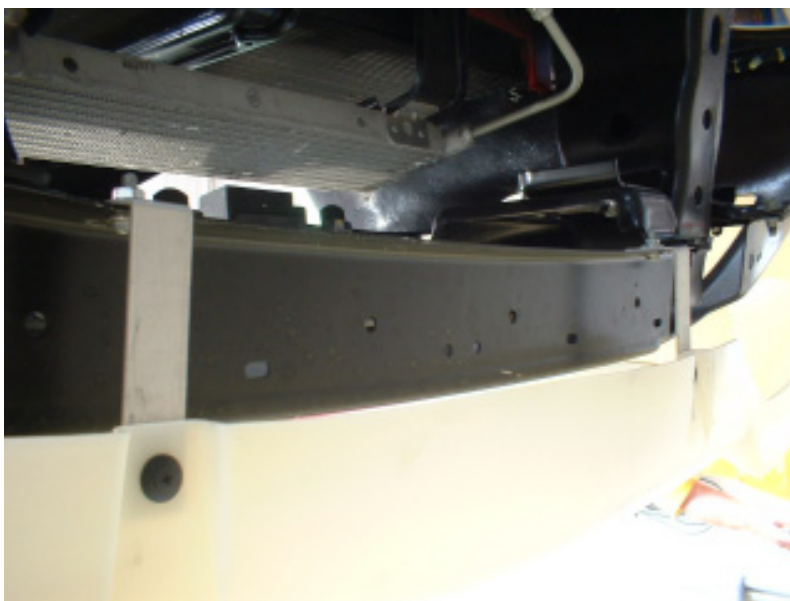
## PART #3346

### 04-05 FORD F-150 FRONT BUMPER

**Notice:** Pre-fit before painting. Install new, unpainted parts according to these instructions. Then remove parts, paint them and re-install.  
**Painted or Altered Parts are Non-Refundable**

**Installation Instructions:** Disconnect and remove the fog lights. Disconnect and remove the headlights. Remove the lower and upper urethane bumper parts. Remove the inner support on the fenders and install it on the new bumper. Hold the new bumper in place and install the factory hardware along the top edge and to the fenders. We have supplied you with 2 braces, in order to support the lower part of the bumper, install them as shown in **Fig A**. (the steel reinforcement has some adjustment up and down, and left to right. If there is any pressure on the new front bumper then the reinforcement needs to be adjusted before proceeding on with these instructions) Align the inner edge of the bumper with the inner edge of the steel reinforcement in the wheel wells and drill a 1/8" hole through the existing 1/8" holes in the bumper. Install the screws provided in the hardware packet. Before installing the newly painted bumper, we recommend that you either sand and paint black or apply a black vinyl decal to the front steel bumper in the areas were the opening can be seen through.

**Fig.A**



#### PAINTING INSTRUCTIONS

**VERY IMPORTANT: The following painting procedures MUST be followed EXACTLY for PROPER ADHESION and to prevent fish eyes.**

1. To remove any mold release contaminants, clean the back of the part first. Using 2 new clean rags, saturate the first rag with plastic prep cleaner\* and begin cleaning. Then use the second rag to remove the prep cleaner. Continuously fold both rags to their clean sides during the process. Use 3 sets of new rags throughout the process. This prevents mold release contaminants from transferring to the painted surface.
2. Repeat step one on the front of the part.
3. Rinse the part with water. Apply a generous amount of Ajax® or sand fix\* to a red scuff pad\* (3M Scotch Brite Brand) and scrub the surface to be painted THOROUGHLY, especially on all the edges and hard to reach areas. Then rinse with water and dry. The scrubbed surface should be dull. If any shiny spots show, repeat the process on those areas.
4. Using another set of clean new rags, again clean the surface to be painted with plastic prep cleaner.
5. Spray the surface to be painted with adhesion promoter\* (follow the instructions on the can for application and drying time).
6. Apply 3 to 4 coats of urethane primer\* with flex additive\* (follow the instructions on the can for application and drying time).
7. Wet sand primer with 600 grit sandpaper. Be careful not to sand through the primer. If you do, you MUST clean those areas with plastic prep cleaner, apply adhesion promoter and prime. Once the primer has dried, wet sand the areas that were touched up. Your surface is now ready for paint.

\* These items can be purchased at any auto body supply store.



<b>PART #3346</b>		
<b>QTY</b>	<b>DESCRIPTION</b>	<b>HARDWARE #</b>
2	L-Braces	TEM-027
4	Hex Bolts	13003
4	Hex Nuts	36102
8	Washers	33004
20	Molding	10947-01704

<b>OPTIONAL FOR PART #3346</b>		
<b>QTY</b>	<b>DESCRIPTION</b>	<b>HARDWARE #</b>
2	Fog Lights	7015
1	Screen Kit	7016