

PART # 3351

05-09 MUSTANG STALKER REAR BUMPER

Notice: Pre fit Before Painting! Then remove parts, paint them and re-install.

Painted or Altered Parts are Non-Refundable!

The surface that is in contact with the 3M 2-sided tape must be cleaned with isopropyl alcohol & the temperature must be a minimum of 75 degrees F, before applying . Allow the 2-sided tape to dry 24 hours before driving.

Pre-fitting the rear bumper: Remove the rear bumper from the car. Next, remove the parking lights and the tag light with the wire harness. **(The tag light and wire harness do not get reused.)** Remove the stud mounting bracket from the bumper, use a 3/16" drill bit to drill out the four visible rivets and the two rivets under the foam gaskets **as shown in fig.A and fig.A1.**

Fig. A



Fig. A1



Reinstall the marker lights and stud mounting bracket to the Stalker rear bumper. Use the supplied silver rivets to install the stud mounting bracket **as shown in fig.B.** Remove the muffler hanger bracket that holds the rear end of the mufflers to the car. Cut out the supplied template and tape it to the hanger **as shown in fig.C.** Drill a 11/32" hole in the marked location. Remove the excess rubber from the drilled area and install the supplied threaded U-clip, H-plate, and 1" bolt **as shown in fig. D.** Use low or medium strength Loctite to keep the bolt from loosening do to vibration. **(Do this to both sides.)** This will allow the exhaust tip to move up and help center it in the exhaust opening. Reinstall the muffler hangers on the car.

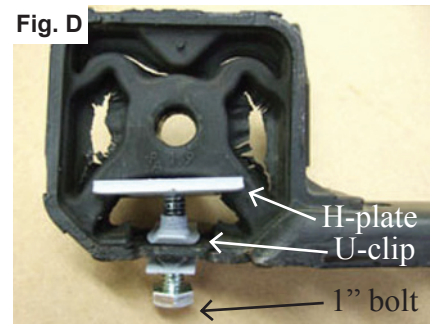
Fig. B



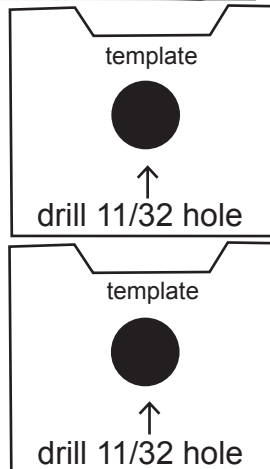
Fig. C



Fig. D

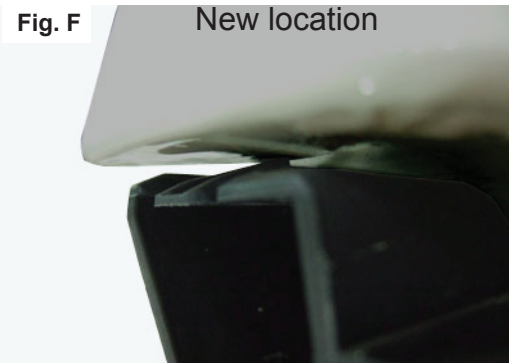
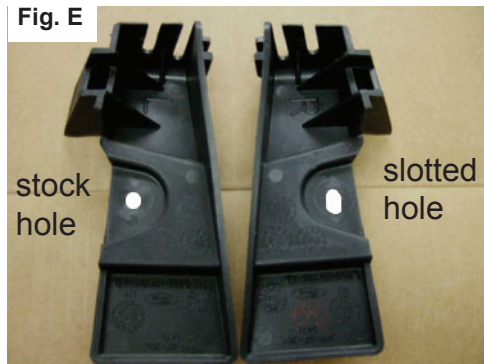


PART # 3351		
QTY	DESCRIPTION	HARDWARE #
8	SILVER RIVETS	0155970
7	THREADED U-CLIPS	WE911
7	3/4" BOLTS	13003
9	WASHERS	33004
8	SMALL BLACK SCREWS	10947-01704
12	SMALL ALLENS SCREWS	92210A145
2	EXHAUST BEZELS	TMW-051
2	1" BOLTS	10947-01380
2	H-PLATE	TMW-052
2	30MM BOLTS	91280A338
8FT	BLACK WIRE	7587K55
1	TAG LIGHT	SIR300105
1	1/4" ROLL OF 2-SIDED TAPE	VHB-144
1	license plate panel	4355

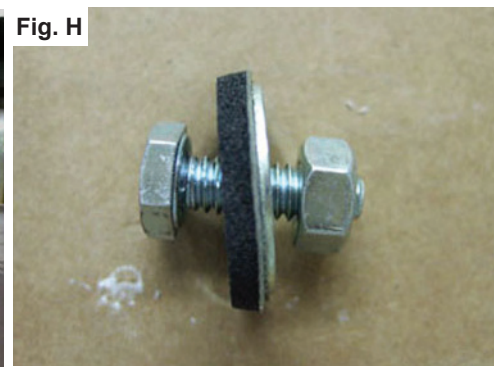
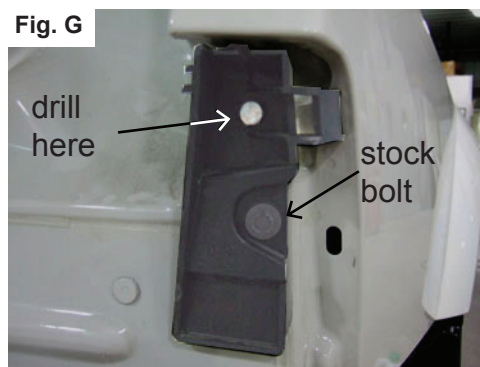


PART # 3351		
QTY	DESCRIPTION	HARDWARE #
1	lower middle section	3351A
2	FOAM GASKETS	P9112
2	NUTS	36102

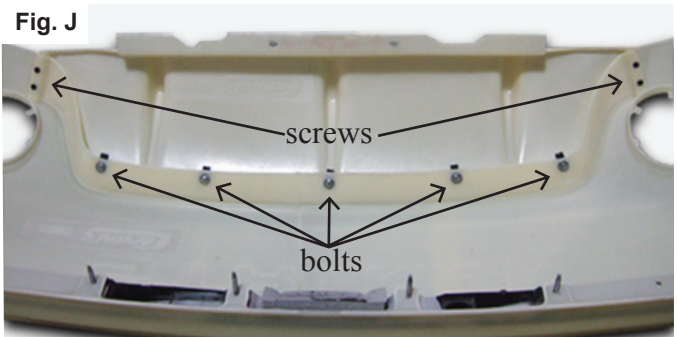
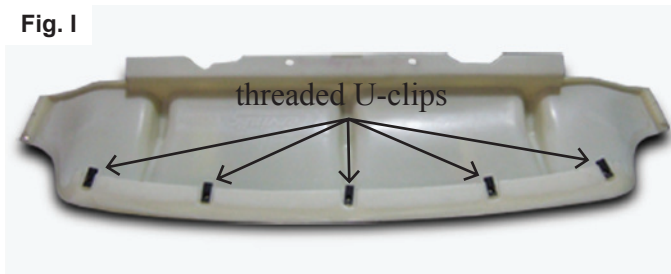
Modifying the bumper brackets: Remove the two bumper brackets that hold the top corners of the bumper to the car. Use a bur tool to slot the mounting hole on each bracket about an 1/8" down **as shown in fig.E.** (The hole has to be slotted enough to slide the bracket up and touch the quarter panel.) Reinstall the mounting brackets to the car so that the bracket touches the quarter panel **as shown in fig.F.**



To keep the top of the bracket from pulling away from the car use a 1/4" drill bit to drill through the top of the bracket into the car **as shown in fig.G.** Center the hole between the support ribs and sides. It should go through the L or R depending on what side you are on. Install the supplied bolt, washer, foam gasket, and nut, **as shown in fig.H.** (The foam gasket and washer go on the inside of the trunk.) Then, reinstall the bumper.



Assembling the rear bumper: Install the five threaded U-clips on the lower middle section of the bumper **as shown in fig.I.** Place the lower middle section in the bottom of the bumper. Use the supplied 3/4" bolts and washers to bolt the middle section to the bumper. Then, install the small black screws to the ends of the middle section through the pre drilled holes in the bumper **as shown in fig.J.**



Use the small allen head screws to install the exhaust trim rings. The stamping in the back of the trim ring goes towards the top of the bumper **as shown in fig.K.** (The trim ring is designed to be used with an exhaust tip 2-1/2" in diameter or smaller. If you have an exhaust tip that is bigger than 2-1/2" in diameter it is necessary to cut the tabs off the bumper and sand the area smooth. To cut the tabs off, score it with a razor knife and bend the tab back. This will give you proper clearance around the exhaust tip.) With the bumper assembled, test fit it to the car and center the exhaust tips in the exhaust openings. Refer to the adjusting the exhaust tip section. (Use the provided 10mm bolts, and washers to bolt the lower bumper to the canister assembly **as shown in fig.L.**) After the bumper is test fit and the exhaust tips aligned, disassemble the bumper and paint it. (Paint the lower middle section of the bumper either semi-gloss black or flat black.) Leave the stud mounting bracket in the bumper while painting.

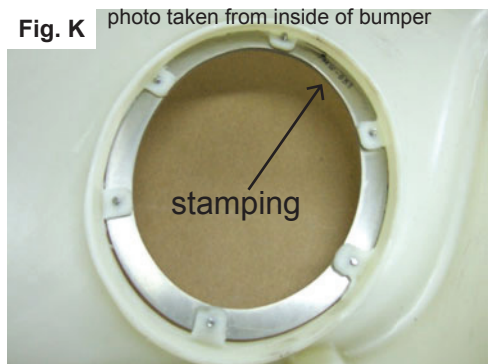


Fig. L



Adjusting the exhaust tips: Align the exhaust tips in the bumper so that the tip is centered in the exhaust opening and the bottom of the tip protrudes a 1/4" past the bumper **as shown in fig.M and fig.M1**. To adjust how far the tip protrudes past the bumper, loosen the two bolt band clamp that holds the exhaust pipe to the H-pipe **as shown in fig. N**. Pull the pipe out until you get the proper alignment. Also, you can rotate the pipe left or right to help center the exhaust tip.

Fig. M



Fig. M1

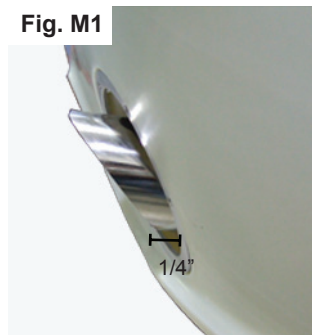
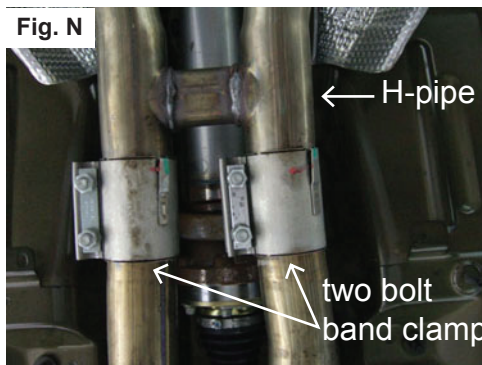


Fig. N



Pre-fitting the licence plate panel: Remove the trunk interior panels, latch cover, and the mustang badge from the trunk lid. Cut out the supplied template and aline it with the bottom and side edges of the trunk **as shown in fig.O**. Drill a 1/4" hole in the marked locations. Then, flip the template over and repeat the procedure for the other side of the trunk. Install the supplied tag light to the licence plate panel with the provided hardware that comes with the tag light. **(You do not have to drill these holes. The provided screws will tap themselves into the plastic.)** Test fit the licence plate panel to the trunk lid. Remove the tag light and paint the panel either semi-gloss black or flat black.

Fig. O

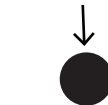


Template

●
↑
drill 1/4" hole

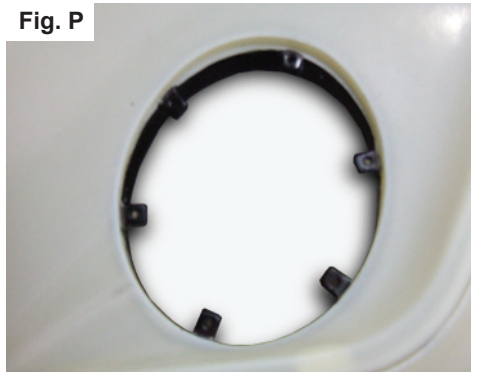
Side edge of trunk

Drill 1/4" hole



Bottom edge of trunk

Final installation of the rear bumper: After the bumper has been painted, paint the exhaust openings from the bezel back with black spray paint **as shown in fig.P**. This area can be seen when the bumper is on the car. Reassemble the bumper and install it on the car with the factory hardware.

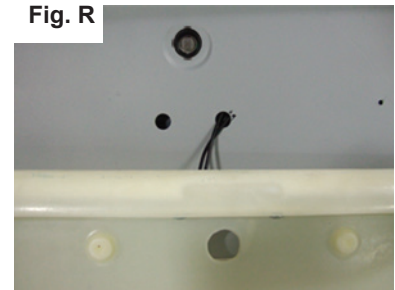


Installing the license plate panel: Included in the hardware packet is a roll of 3M double-sided tape. After the license plate panel has been painted, install the 3M double-sided tape along the guidelines an 1/8" away from the outer edge of the part and two strips down the middle of the part **as shown in fig. Q**. (**Before you go any further disconnect the negative battery terminal.**) In the hardware pack there is an eight foot role of wire, cut a ten inch piece off this wire. The smaller ten inch piece will be your ground wire and longer piece will be your hot wire. Reinstall the tag light and solder the two pieces of wire to the two wire leads from the tag light. (**It does not matter which wire is soldered to which lead from the tag light.**) Run the two wires through the right mustang badge hole in the trunk lid **as shown in fig.R**.

Fig. Q



Fig. R



Pull the wires out the square hole on the under side of the trunk lid and connect the short wire (**ground**), to the black ground wire in the third brake light **as shown in fig.S**. Push the long wire (**hot**), in the black wire loom and run it with the third brake light wire harness **as shown in fig.T**. Run the rest of the wire underneath the back panel and drop it down towards the back seat **as shown in fig.U**. Cut the light green wire with the dark green stripe in the wire harness that runs on the trunk floor and solder the new tag light wire to the factory tag light wire **as shown in fig.V**. (**This is the hot wire for the factory tag light.**)

Fig. S

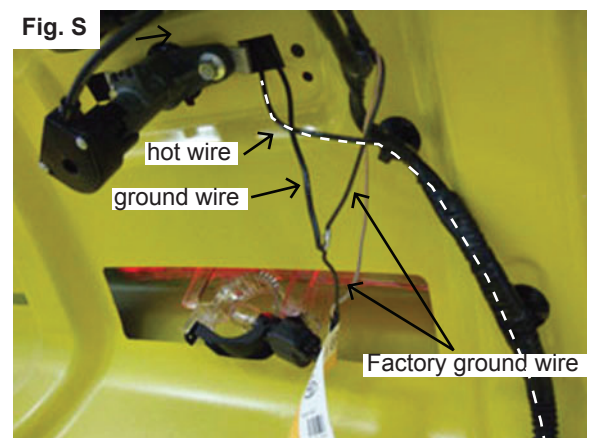


Fig. T

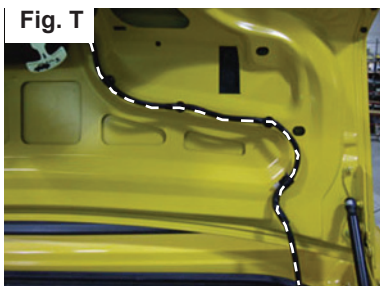


Fig. U

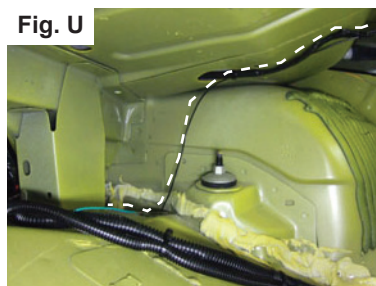
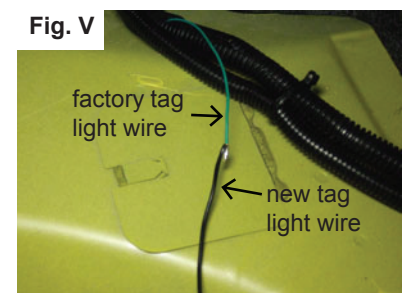


Fig. V



After the wires are soldered together and wrapped with electrical tape, peel and fold about 2" of the red backing from each end of each piece of tape. Then, center the license plate panel on the trunk so that the red backing is exposed and can be pulled. (**This will allow you to get the best possible alignment of the part**). Pull the tape backing slowly. After all the backing is removed, firmly press the edges of the license plate panel to securely adhere the tape. Screw the license plate panel to the trunk with four black screws.



URETHANE 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 where the 2-sided tape is installed, on the back side of the part, and all the 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* including the areas where the 2-sided tape is installed (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.

Note: Make sure you PRIME and PAINT the areas where the 2-sided tape is used as you would if it was the outside of the part. The tape has its best adhesion when it is applied to a painted surface.

