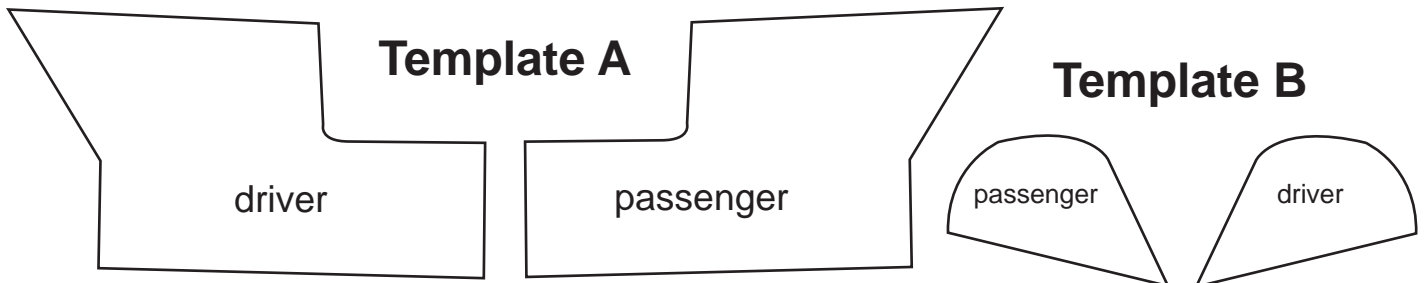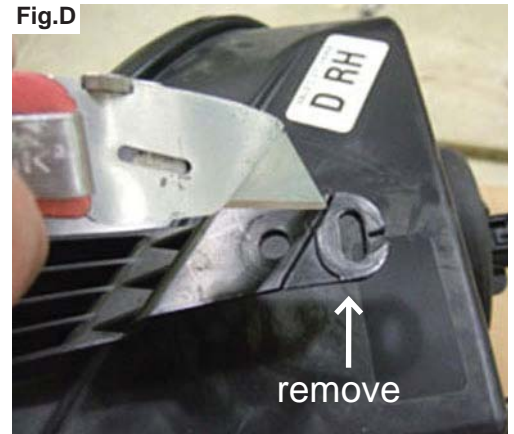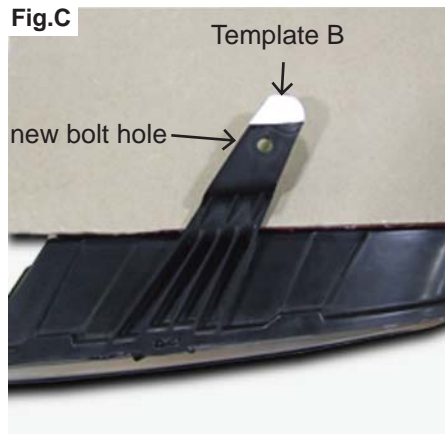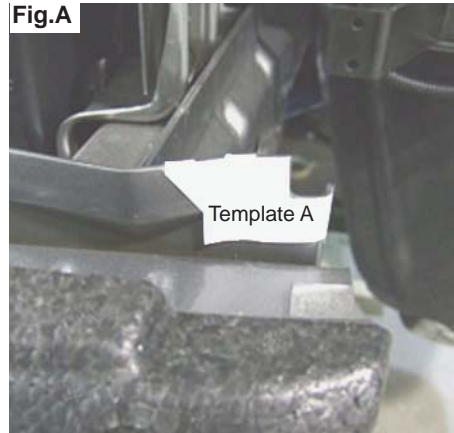# PART# 3350 (KIT# 8030)
05-08 MUSTANG STALKER FRONT BUMPER

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!

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.
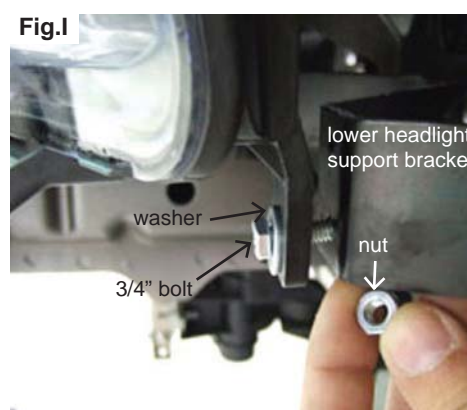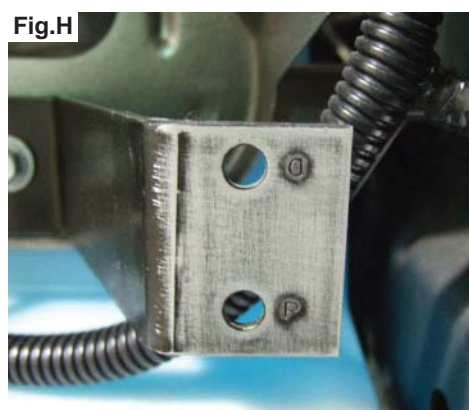
Pre-fitting the headlights: Remove the front bumper and headlights from the car. The headlights are relocated to fit in the stalker bumper and some cutting is involved. Cut out **templates A** and tape them to the corner of the impact bar **as shown in fig.A.** Then, trace the out side edge of the template and cut it out with a saw-zaw **as shown in fig.B.** This will allow the corner of the headlight to clear the impact bar. Cut out **templates B** and tape them to the top mounting point of each headlight **as shown in fig.C.** Use a razor knife to score the plastic mounting tab along the edge of the template and snap off the excess peice **as shown in fig.D.** This will allow the top mounting bracket to clear the radiator support.

Fig.A — Template A

Fig.B — scrap

Fig.C — Template B / new bolt hole

Fig.D — D RH / remove

Template A — driver — passenger

Template B — passenger — driver

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**Relocating the headlights:** Remove the left and right top bumper support brackets **as shown in fig.E.** Then, use the supplied 30mm bolts , washers, and aluminum spacers to secure the top bumper support brackets to the opposite side of the car that they came off of **as shown in fig.F. (Put the left bracket on the right side of the radiator support and the right bracket on the left side of the radiator support.)**

Fig.E

top bumper
support bracket

remove

Fig.F

top bumper
support bracket

aluminum
spacer

radiator
support

30mm bolt   washer
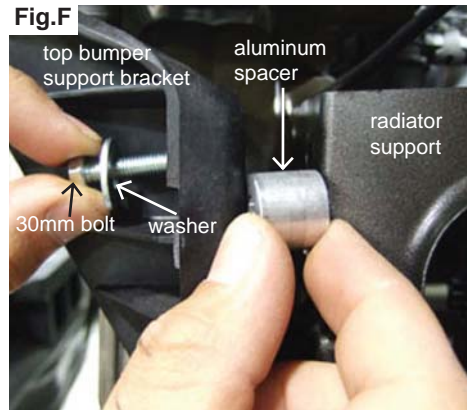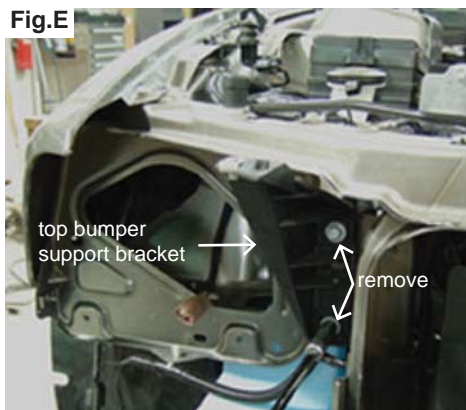
Use the factory headlight bolts to install the supplied lower headlight brackets to the factory lower headlight mounting points **as shown in fig.G.** The two holes where the bottom of the headlight mounts to the bracket are stamped "D" for driver and "P" for passenger **as shown in fig.H.** Use the supplied 3/4" bolts, washers, and nuts to secure the bottom of the headlight to the lower holes in the headlight bracket **as shown in fig.I.** The stamping should match the side you are working on.

Fig.G

stock mounting
locations

frame rail

lower headlight
support bracket

Fig.H

Fig.I

lower headlight
support bracket

washer

3/4" bolt

nut
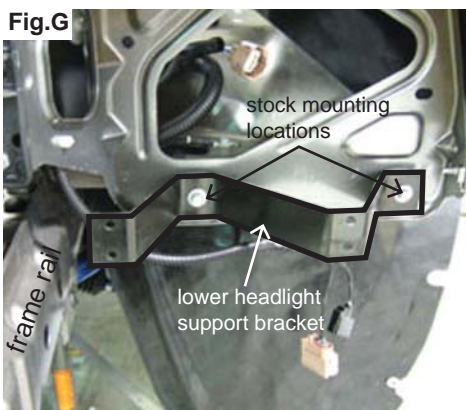
With the bottom of the headlight bolted to the bracket, use the supplied 10mm bolts and washers to secure the top of the headlight to the upper headlight mounting bracket. Push the bracket to the radiator support and mark the mounting holes with a marker **as shown in fig.J. (With the bottom of the headlight bolted to the bottom bracket, the top of the light will aline itself to the proper location on the radiator support.)** Drill the marked holes out with a 1/8" drill bit **as shown in fig. K.** To aviod drilling into the headlight remove it before drilling. After the holes have been drilled, use the supplied small black rivets to secure the upper mounting bracket to the radiator support.

Fig.J

mark holes

upper mounting bracket

10mm bolt
and washer

Fig.K

drill here

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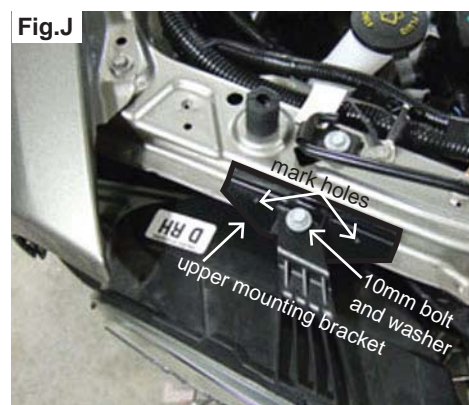
Pre-fitting the front bumper: Cut out **template C** and tape it to the front of the fender **as shown in fig.L.** Drill a 1/4" hole in the marked locations. Repeat the procces for the other fender. Next, install the marker lights from the factory bumper into the stalker bumper. Use two small black screws on the outside edge of the marker light and a silver screw with a turn button on the inside edge of the light **as shown in fig.M and fig.M1.**

Fig.L

Fig.M

silver screw with turn button

small black screws
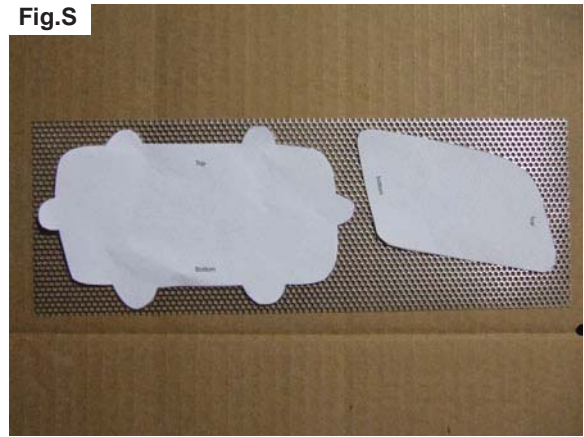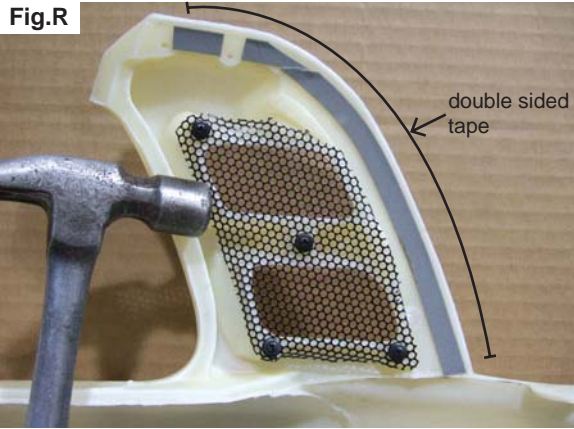
Fig.M1

silver screw
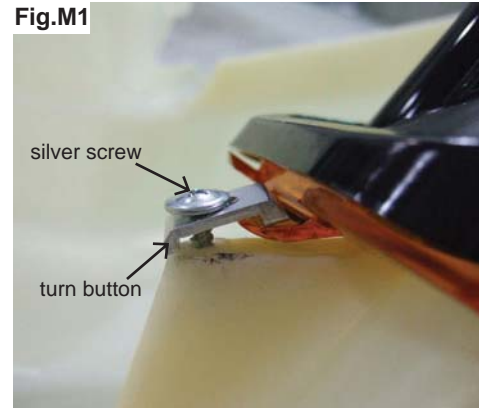
turn button

Reuse the factory hardware to install the bumper to the car. Use two small black screws to secure the top of the bumper to the fender throught the pre-drilled 1/4" holes in the fender **as shown in fig.N.** Then, use two small black screws with two turn buttons to secure the outer edge of the bumper to the fender **as shown in fig.O.**
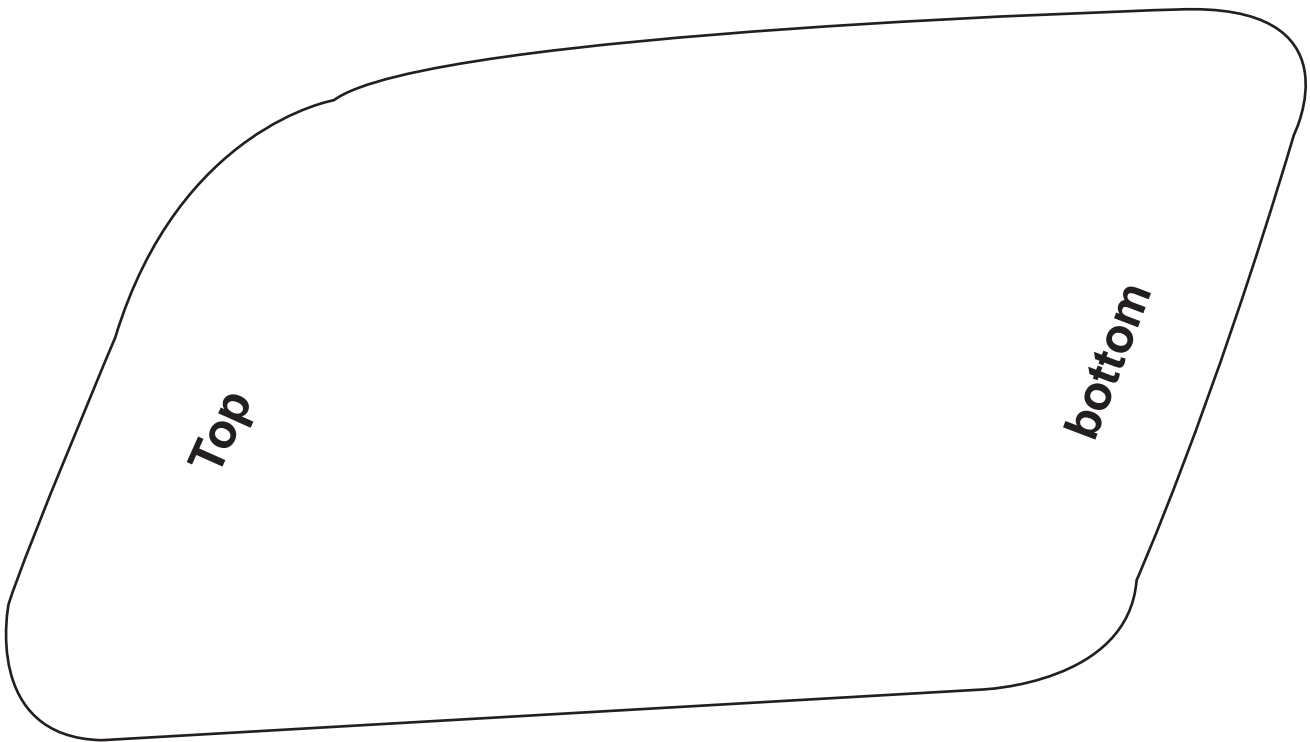
Fig.N

small black screws

Fig.O

inside of the fender

turn buttons

small black screws
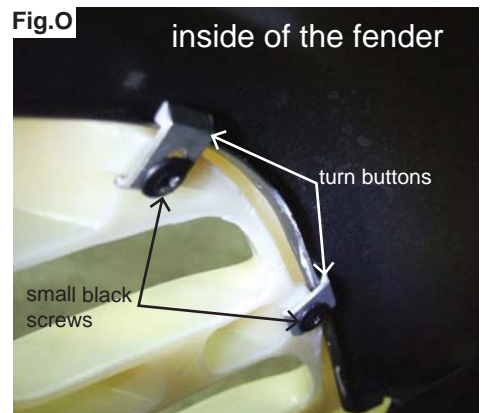
Install four speed nuts to the to the bottom pan **as shown in fig. P.** Use four silver screws to install the bottom pan to the bumper. Screw the stock black cover to the bottom pan with the factory hardware **as shown in fig.Q. (The two end screw locations on the bottom pan do not match up with the stock screw holes in the black cover. Install the two middel screws first. Then drill a 1/4" hole in the black cover through the pre-drilled holes in the bottom pan. Install two speed nuts to the black cover and secure it to the bottom pan.)** Remove the bumper and paint it. Paint the bottom pan flat black or semi gloss black.

Fig.P

bottom pan

speed nuts

Fig.Q
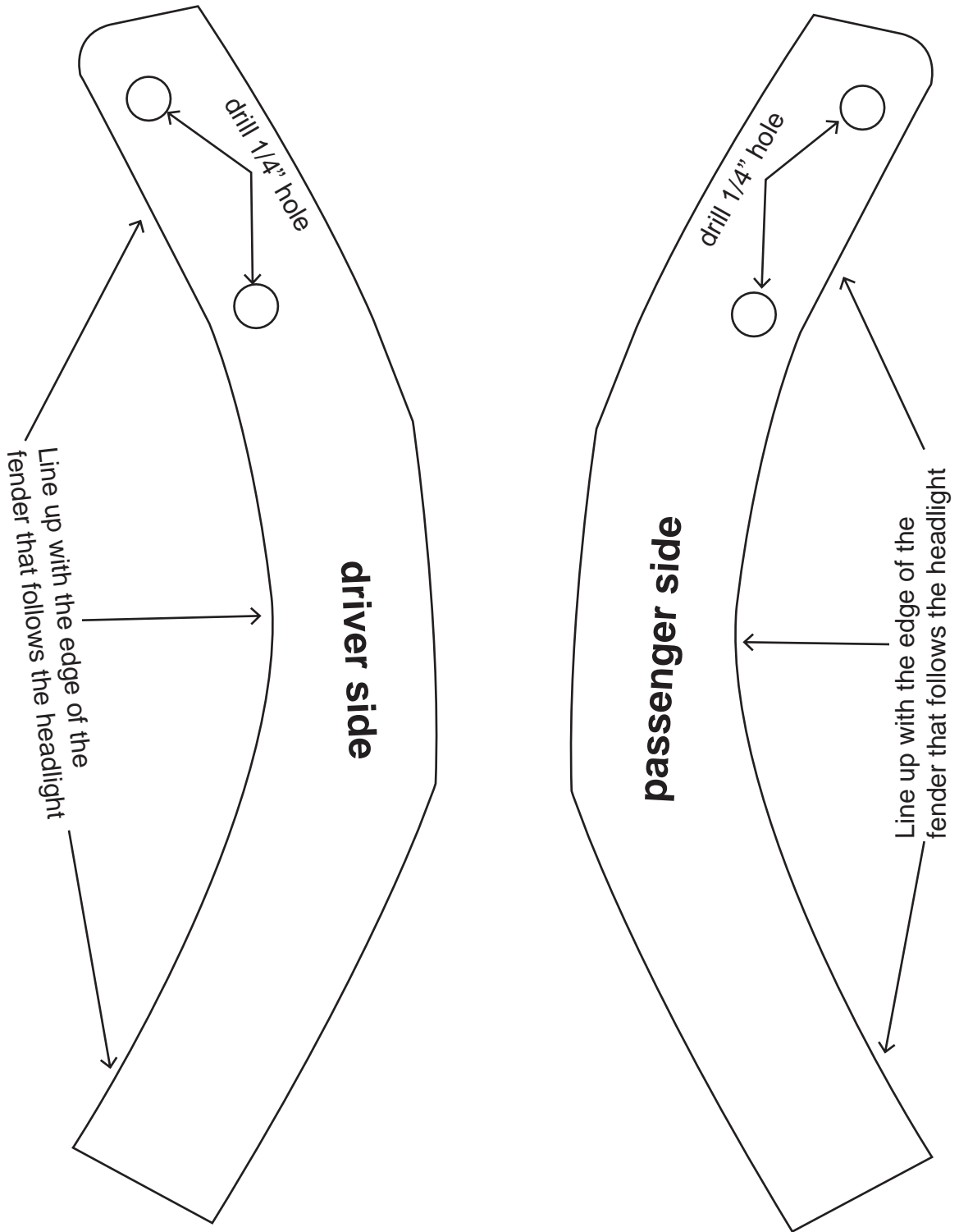

silver screws

bottom pan

stock screws

black cover
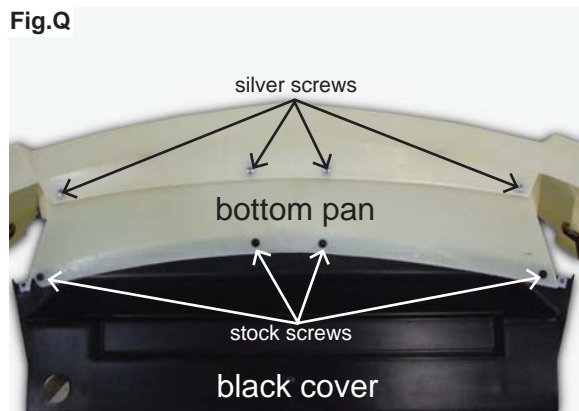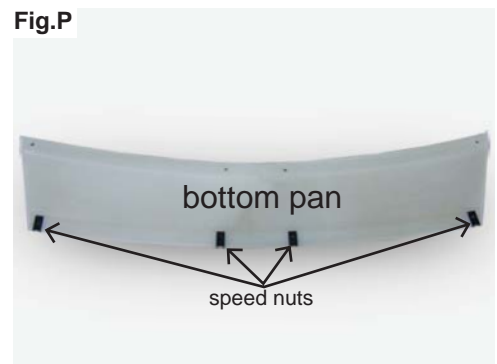
Final installation of the bumper: After the bumper has been painted, install the provided 3M double sided tape along the guidlines an 1/8" away from the outer edge of the bumper **as shown in fig.R.** Do this to both sides of the bumper. Cut out **template D** and the template for the hood screens and tape it to the preferated screen **as shown in fig.S.** Trace the out side edge of the template with a marker and cut it out of the screen with a pair of tin snips. Do this to both screens. After both screens are cut out, paint them flat black or semi gloss black. Use the provided small black screws to install the screen to the bumper **as shown in fig.R.** With a hammer, gently tap the the edges of the screen around the opening. Follow the same procedure as test fitting the bumper to install the bumper to the car. Peel and fold about 2" of the red backing from each piece of tape, then place the bumper on the car 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 backing slowly. After all the backing is removed, firmly press the edges of the bumper to securly adhere the tape.

Fig.R

double sided tape

Fig.S

Template D

Top

bottom

Template C

drill 1/4" hole

drill 1/4" hole

Line up with the edge of the
fender that follows the headlight

Line up with the edge of the
fender that follows the headlight

driver side

passenger side

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PART # 3350		
QTY	DESCRIPTION	HARDWARE #
4	30MM BOLTS	91280A338
2	10MM BOLTS	91280A322
4	3/4" BOLTS	13003
4	NUTS	36102
10	WASHERS	33004
4	ALUMINUM SPACERS	DAD-024
4	SMALL BLACK RIVETS	97526A130
20	SMALL BLACK SCREWS	10947-01704
6	SILVER SCREWS	32144
6	TURN BUTTONS	SV25600
6	SPEED NUTS	WE2255
2	UPPER HEADLIGHT BRACKETS	TMW-049
2	LOWER HEADLIGHT BUCKETS	TMW-050
1	1/2" ROLL OF 2-SIDED TAPE	VHB 50

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 adehsion when it is applyed to a painted surface.

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