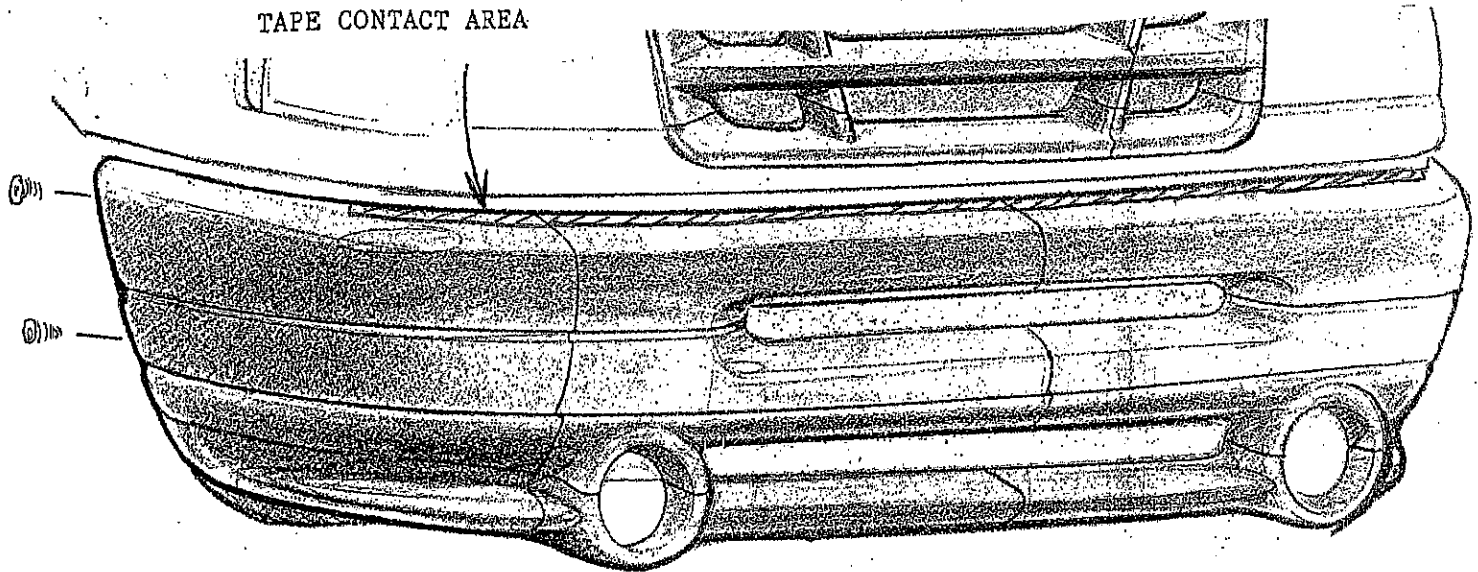


TAPE CONTACT AREA



PART 5531, FORD RANGER AIR DAM, 1993-94, (cannot be used on 4x4 w/ factory fog lights)

PART 5539, FORD RANGER BUMPER COVER, 1994-94

PLEASE READ INSTRUCTION THOROUGHLY BEFORE ATTEMPTING INSTALLATION

TOOLS REQUIRED: Phillips screwdriver, 9/64" & 3/8" drill bits, drill, #7447 3M pads, 10mm socket & wrench, 80 grit sandpaper

REMOVE FROM TRUCK: To install 5531-- The stock plastic valance under the front steel bumper. SAVE the 8 bolts and washers to install the air dam.
To install 5539-- The stock black trim on the face of the bumper

THERE ARE 3 PHASES TO THE INSTALLATION:

1. PRE-FIT and vehicle preparation
2. PREPARATION and painting of parts
3. INSTALLATION of parts on vehicle

BE SURE TO FOLLOW THE SEQUENCE. Helpful hints are provided.

PHASE 1: PRE-FIT (BUMPER COVER)

- A. CLEAN vehicle body with solvent or de-greaser where double-sided tape will contact the body, as indicated in illustration.
- B. PRE-FIT part to vehicle and outline on vehicle with grease pencil or 1/2" masking tape. Locate and drill screw holes.
- C. REMOVE PART

PRE-FIT (AIR DAM)

- A. DRILL OUT the 8- oval shaped holes that are premarked on the top flange of the air dam

PHASE 2) PREPARATION OF PARTS FOR PAINT AND PAINTING

NOTE: If parts are NOT going to be painted proceed to PHASE 3; however, note in PHASE 2 as to how to apply the tape on the part.

- A. CLEAN all paintable surfaces with water and "TING" or "TSP" using a #7447 scotch-brite pad and rinse well.
- B. SAND edges of parts as needed.
- C. SAND paintable surfaces with 320 wet and rinse well.
- D. FILL with a 2 component urethane filler and sand any slight edge or surface imperfections.
- E. PRIMER parts with a catalized primer, let dry and sand 400-600 wet.
- F. IF APPLICABLE:

Clean inside of part where tape is to be applied with acetone or "MEK". Scratch inside of part with 80 grit sandpaper and wipe with acetone or "MEK" and then with "PRO-BOND". Press the tape on the part firmly (to be done before painting).

- G. APPLY base coat and clear coat paint.

NOTE: Polyurethane products are flexible so it is necessary to utilize paints that are flexible or add flex agent to the paint. CONSULT with YOUR paint supplier for their recommendations.

ADHESIVES: Some restylers and converters supplement or use in lieu of the tape a structural adhesive such as DURAMIX, #4125 manufactured by POLYMER ENG. CORP. (800-537-9204).

PHASE 3: INSTALLATION

#5531 AIR DAM

- A) BOLT the air dam to the bumper using the 8 stock bolts and washers.

#5539 BUMPER COVER

- A) Wipe the top of the stock bumper with degreaser.
- B) Sand the top of the stock bumper w/ 80 grit sandpaper where the tape contacts and wipe twice w/ acetone or MEK.
- C) Install the bumper cap pressing down firmly where the tape contacts and secure the screws (2) into the ends of the bumper flanges.

HARDWARE PACKAGE: #5531, no supplied hardware
#5539, 4- 9/64" screws, 8 feet 3/4" tape

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