INSTALLATION INSTRUCTIONS
FOR MOUNTING

LUVERNE GRILLE GUARD WITH THE FOLLOWING MODEL NO.:
321123/321122 ON:

2011 AND NEWER F-250 – F-350 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) GRILLE GUARD WELDMENT

   (1)UPRIGHT/BRACKET PACKAGE
   - (1) MOUNTING BRACKET, LH
   - (1) MOUNTING BRACKET, RH
   - (1) MOUNTING BRACKET BRACE, LH
   - (1) MOUNTING BRACKET BRACE, RH
   - (1) HARDWARE PACKAGE
   - (1) CUSTOMER SERVICE PACKAGE

REFER TO SHEETS #1, #2, & #3 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 x 3” CLIPPED HEAD CARRIAGE BOLT (ITEM #9) BY INSERTING THE HEAD INTO THE SLOTTED HOLE IN THE FRAME AND ROTATING IT 90°. INSTALL THE 3/4” FLAT WASHER (ITEM #17) ON THE BOLT ALONG WITH A 5/8”-11 SERRATED FLANGE NUT (ITEM #12). 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 #14) ON THE BOLTS AND SNUG UP.

6. INSTALL M12 X 1.75 (ITEM #14) AND 5/8”-11 (ITEM #12) 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 #14) AND 5/8”-11 (ITEM #12) FLANGE NUTS ON THE ENDS OF THE BOLTS. FINGER TIGHTEN AT THIS TIME.

LUVERNE TRUCK EQUIPMENT

8. ON THE LEFT HAND MOUNTING BRACKET (ITEM #2), INSTALL THE TWO 1/2”-13 X 2” FLANGE BOLTS (ITEM #10) IN THE HOLES OF THE MOUNTING BRACKETS, PLACE THE SPACER PLATE (ITEM #8) ON THE BOLTS.

9. INSERT THE ASSEMBLED MOUNTING BRACKET INTO THE HOLES IN THE FRAME AND FASTEN WITH 1/2”-13 SERRATED FLANGE NUTS (ITEM #13) AS SHOWN IN ***fig. 1***. HAND TIGHTEN ONLY AT THIS TIME.

10. REPEAT STEPS 2 THRU 9 FOR THE OPPOSITE SIDE.

11. INSTALL THE GRILLE GUARD (ITEM #1) BY INSERTING IT BETWEEN THE LEFT HAND (ITEM #2) AND RIGHT HAND (ITEM #3) MOUNTING BRACKETS AND FASTENING WITH THE 1/2”-13 X 1-1/4” CARRIAGE BOLTS (ITEM #11), 1/2” SAE FLAT WASHERS (ITEM #18)), 1/2” LOCK WASHERS (ITEM #16) AND 1/2”-13 ACORN NUTS (ITEM #15).

12. CHECK THAT THE GRILLE GUARD IS CENTERED AND VERTICAL ON THE BUMPER AND THEN TIGHTEN THE FOUR ½”-13 X 2” BOLTS SECURING THE MOUNTING BRACKETS TO THE FRAME PLATES. TIGHTEN TO 65 FOOT-POUNDS OF TORQUE.

13. TIGHTEN THE FOUR M12 X 1.75 NUTS (ITEM #14) TO 54 FOOT-POUNDS OF TORQUE AND TWO 5/8”-11 (ITEM #12) SECURING THE BRACE BRACKETS TO FRAME TO 83 FOOT-POUNDS OF TORQUE.

14. TIGHTEN THE NUTS THAT SECURE THE GRILLE GUARD TO THE MOUNTING BRACKETS TO 65 FOOT-POUNDS OF TORQUE.

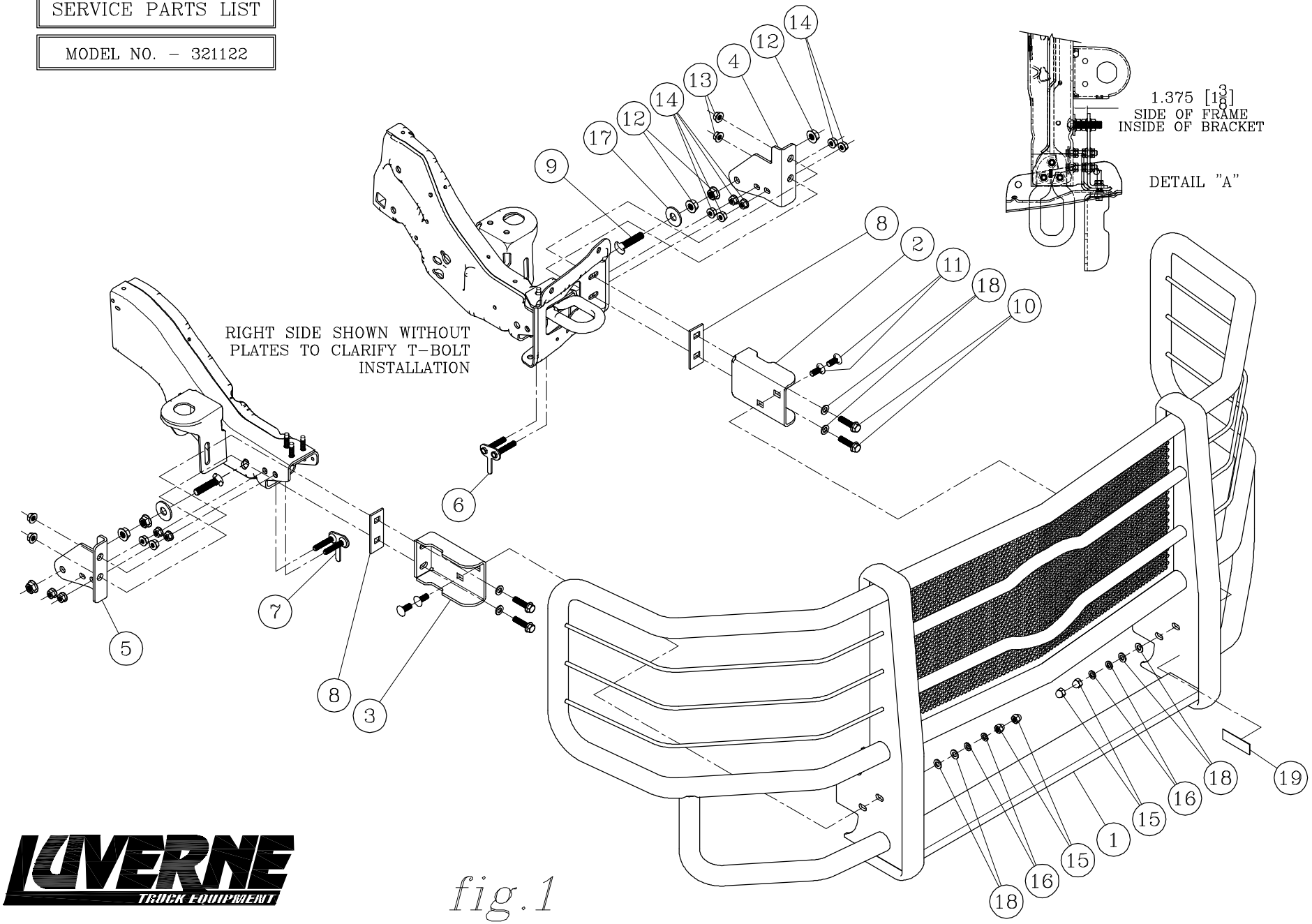
SERVICE PARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
1	109212	1	GRILLE GUARD WELDMENT – BLACK
2	109212	1	MOUNTING BRACKET– LH
3	109212	1	MOUNTING BRACKET– RH
4	202574	1	MOUNTING BRACKET BRACE - LH
5	202575	1	MOUNTING BRACKET BRACE - RH
6	202576	1	T-BOLT ASSEMBLY - LH, ZP
7	202577	1	T-BOLT ASSEMBLY - RH, ZP
8	202361	2	SPACER PLATE – FRAME BRACKET
9	109274	2	ROUND HEAD CLIPPED BOLT – 5/8”-11 X 3”, FT, ZP
10	104249	4	HEX FLANGE SCREW – 1/2”-13 X 2”,YZP
11	109515	4	ROUND HEAD BOLT – 1/2”-13 1-1/4”, BZP
12	105643	6	HEX FLANGE NUT – 5/8”-11, ZP
13	100123	4	HEX FLANGE NUT – 1/2”-13, ZP
14	100794	12	HEX FLANGE NUT – M12 X 1.75, ZP
15	109510	4	ACORN NUT – 1/2”-13, BZP
16	109511	4	LOCK WASHER – 1/2”, BZP
17	100153	2	FLAT WASHER – 3/4”, ZP
18	100940	8	FLAT WASHER – SAE, 1/2”, ZP
19	106888	1	DECAL – LOGO, LUVERNE, 3/4” X 3”

LUVERNE TRUCK EQUIPMENT

SERVICE PARTS LIST

MODEL NO. – 321122



LUVERNE TRUCK EQUIPMENT

fig.1