

PART #3345

97-03 F-150 FLARESIDE REAR BUMPER INSTRUCTIONS

Notice: Prefit 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

Remove the steel rear bumper and any brackets attached to it, also remove the rear plastic steps and the tailgate from the truck. The Cervini rear bumper is in 3 pieces, attach them together using the bolts, nuts, and washers as shown in fig. A. The center portion of the bumper has 4 pre drilled holes, while holding the bumper centered left to right and even with the metal edge on the bed as show in fig. B, mark the predrilled holes. Remove the bumper and drill the marked holes with a 1/4" drill bit. Reinstall the bumper to the bed using the plastic retainers. Install the screws in the pre drilled holes in each wheel well. For extra support we have supplied you with 2 braces, attach them to the bumper using the plastic retainers, and then mark the holes that needs to be drilled as shown in fig. C. Remove the bumper and drill them with a 1/4" drill bit. Reinstall the bumper and attach the braces using the bolts, nuts, washers and retainers. Included in the hardware packet is a roll of 2-sided tape. After the bumper has been painted, install the tape along the guideline on each side of the bumper where it touches the truck as shown in fig. D. Before installing the bumper to the truck, clean the area where the tape will meet to the truck with isopropyl alcohol. Do not apply tape to the surfaces under 70° F. When installing the tag light use the foam gasket as a template to mark the area where the hole needs to be cut.

Fig. A.

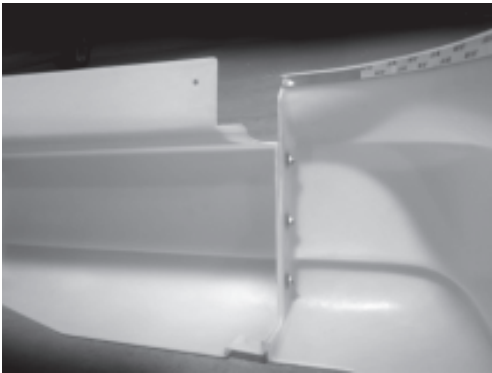


Fig. B.

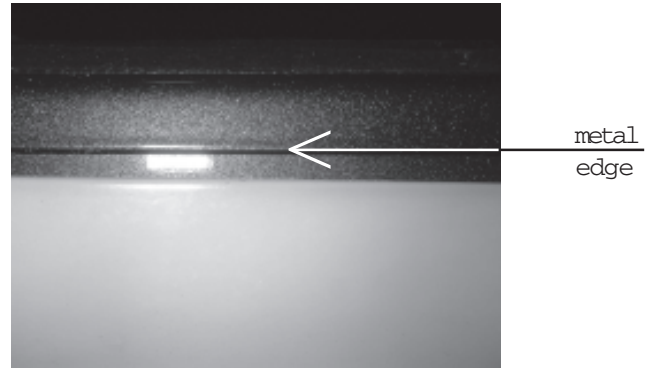


Fig. C.

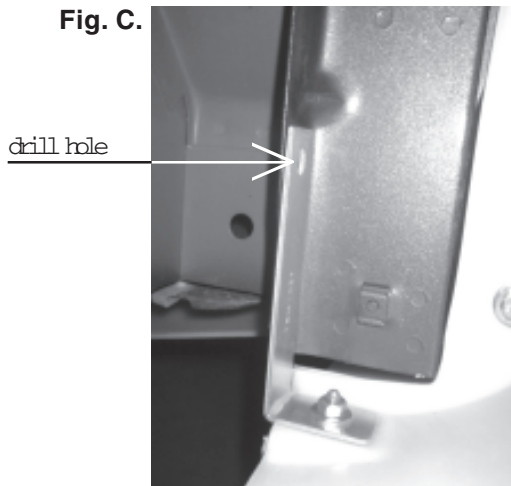


Fig. D.



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.

PART #3345		
QTY	DESC	HARDWARE
2	L-BRACES	TEM-027
8	HEX BOLTS	13003
16	WASHERS	33004
8	HEX NUTS	36102
2	PHILLIPS SCREWS	93406A224
6	RETAINERS	WE2460
1	TAG LIGHT	SIR300105
1ROLL	2-SIDED TAPE	VHB120