

20594 **07-12 FORD** **EXPEDITION**



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2007-12 FORD EXPEDITION **BILLET INSERT**

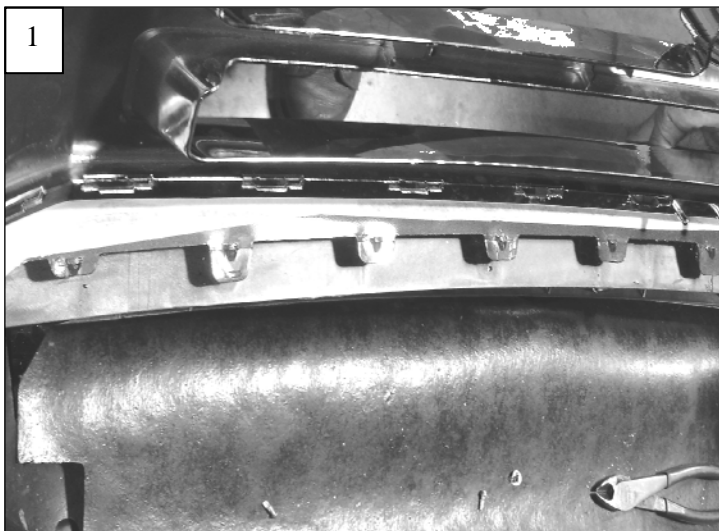
Tools Required:

Phillips / Slotted Screwdrivers
Drill & 1/8" Drill Bit
10mm Socket or Nut Driver
Jig Saw
Die Grinder w/cut off wheel & sanding discs

Hardware Included:

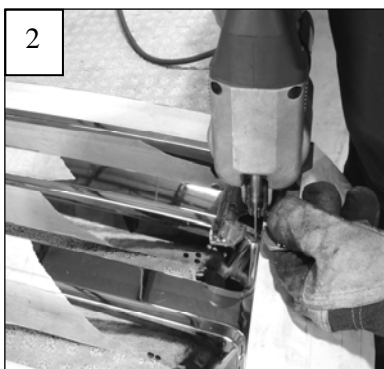
1 Full Opening Billet Grill Insert (20 bars)
4 #8 x 3/4 Phillips Screws
4 #8 Flat Nuts
4 Pressure Clips (19369)

Read and understand instructions before attempting installation



Step 1

Remove the [12] plastic rivet/screw fasteners securing the radiator cover and remove. Remove the [4] torque screws securing the grille to the core support. Remove the plastic fastener securing the flexible radiator shield to the black portion of the grille (on each end). Remove the [4] metal pressure clips along the bottom of the grille; these secure the flexible radiator shield to the grille and bumper cover. Pull the grille forward; use a slotted screwdriver to release the [12] molded clips along the bottom of the grille (1); these secure the grille to the bumper cover. A slotted screwdriver can be used to release these clips.



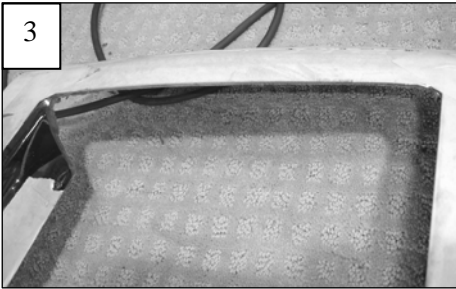
Step 2

Apply masking tape to the face of the grille to prevent scratching. Use the tape to draw a straight edge down each end of the grille opening (*where the center cross bars meet the outer edge*).

Use a jig saw or die grinder (2) to cut the center cross bars from the factory grille. Do not cut the inner lip along the top and bottom of the opening. Make your first cuts 1/8" inside the outer edge (*better to cut less than cut too much*).

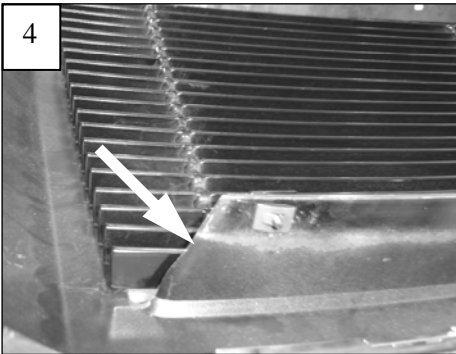
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Step 3

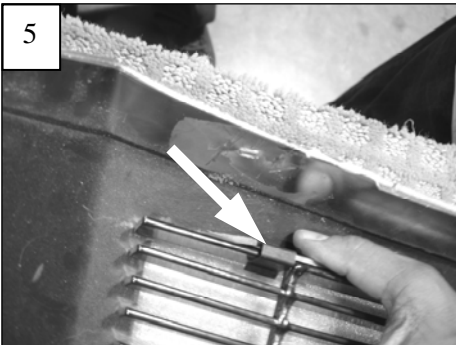
Use a die grinder with a sanding wheel or a file to smooth your cuts. The final result should leave a clean straight edge on each end of the opening (3).



Step 4

The remaining plastic lip above and below the billet is left in tact for mounting purposes; however a small portion of the plastic in each corner must be trimmed to allow proper fitment (4).

The length of the grille is longer than the opening to hide the ends of the billet bars. Test fit the billet behind the opening with the four mounting tabs along the bottom. The billet must sit flush to the face of the factory grille.



Step 5

Center the insert behind the factory grille opening with the four mounting tabs at the bottom. We suggest using needle nose vice grips to hold the insert in place. Drill four 1/8" holes aligned with the mounting tabs. Secure them using the screws and flat nuts. Install the four pressure clips next to the vertical rods in the grille insert (5).

If a bumper insert is going to be installed; install at this time and then re-install the grille assembly onto the vehicle.

Thank you for purchasing a T-Rex Billet Grille. 12/30/06

