



INSTALLATION INSTRUCTIONS

Trans4mer Grille Guard/Winch Mount Kit 39680 (Black) & 39681 (Chrome) For Ford 4x4 F150, F250 Light Duty & Expedition

As you read these instructions, you will see **NOTES**, **CAUTIONS** and **WARNINGS**. Each message has a specific purpose. **NOTES** are additional information to help you complete a procedure. **CAUTIONS** are safety messages that indicate a potentially hazardous situation which, if not avoided, may result in minor or moderate injury. A **CAUTION** may also be used to alert against unsafe practice. **WARNINGS** are safety messages that indicate a potentially hazardous situation, which, if not avoided could result in serious injury. **CAUTIONS** and **WARNINGS** identify the hazard, indicate how to avoid the hazard, and advise of the probable consequence of not avoiding the hazard. **PLEASE WORK SAFELY!**

NOTE: This installation requires some hole drilling. These trucks have very large variations in the bumper to frame alignment and this requires that certain parts be custom drilled to fit each vehicle. Make sure you have a drill motor and sharp 3/8" & 7/16" drills available.

PARTS LIST

PART NO.	QUANTITY	DESCRIPTION
39583	2	SIDE MEMBER, BLK
or 39584	2	SIDE MEMBER, CHR
29366	1	2-1/2" TUBE, BLK
or 29399	1	2-1/2" TUBE, CHR
29365	1	1-1/2" TUBE, BLK
or 29398	1	1-1/2" TUBE, CHR
39585	1	UPPER BRKT, RH
39586	1	UPPER BRKT, LH
39506	1	FRM EXT ASSY, RH
39507	1	FRM EXT ASSY, LH
39883	1	BRACE, RH
38884	1	BRACE, LH
39710	4	SHIM PLATE
34074	1	SEALANT, SILICONE
39511	2	SPACER TUBE

TORQUE SPECIFICATIONS

<u>BOLT SIZE</u>	<u>TORQUE</u>
3/8 inch	30 lb. ft. (40.7 N-m)
7/16 inch	50 lb. ft. (67.8 N-m)
1/2 inch	75 lb. ft. (101.7 N-m)
10 mm	32 lb. ft. (43.4 N-m)
12 mm	58 lb. ft. (78.6 N-m)

This WARN Trans4mer system can be customized to give your Ford truck a wide variety of looks, front-end protection and winch mounting capability. The system starts with this strong two-tube Grille Guard that attaches to the truck's frame with brackets designed by Warn engineers to handle up to a 12000 lb winch. It is durable and good-looking, even as a stand alone Grill Guard, but can be easily upgraded with some great options! You can add a third large size tube (Light Bar) that adds even more protection and includes tabs for mounting auxiliary lights. The tubes can be mounted in a variety of positions to achieve the look and function that you desire. You can mount a Winch Carrier Bracket that provides a permanent mount for a Warn winch. You may also add a Receiver Bracket that will handle the Warn Multi-mount winch system, a draw bar or any other accessory that fits the standard 2-inch receiver tube. Finally, Brush Guards that protect the headlights and front corners of the truck can be easily added to any of the options above.

NOTE: Follow the step by step sequence for fastest installation. Do not securely tighten bolts until directed.

1. Take careful note of the space between the top of the bumper and bottom of the grille and light area. Check the side to side alignment of the bumper and whether the space is even all the way along. You will want to reinstall the bumper as good or even better than the factory alignment. There is plenty of adjustment available.
2. Remove the bumper. First pry out the 3 plastic fasteners holding the rubber baffle to the bottom of the bumper. Then remove the 4 nuts (use 13/16" deep socket) that attach the bumper brackets to the frame tower. **Leave bumper brackets attached to bumper.**
3. Remove the tow hooks. Install the RH & LH Frame Extensions as shown in **Figure 1**. Use the furnished 1/2" x 2" bolts and flatwashers to secure the tow hook and thread them into the Frame Extensions. Insert the Spacer Tube thru the large holes in the frame and Frame Extensions and position the tube ends inside the frame. Insert the large bolt with flatwashers thru the frame and tube. **Leave bolts slightly loose.**

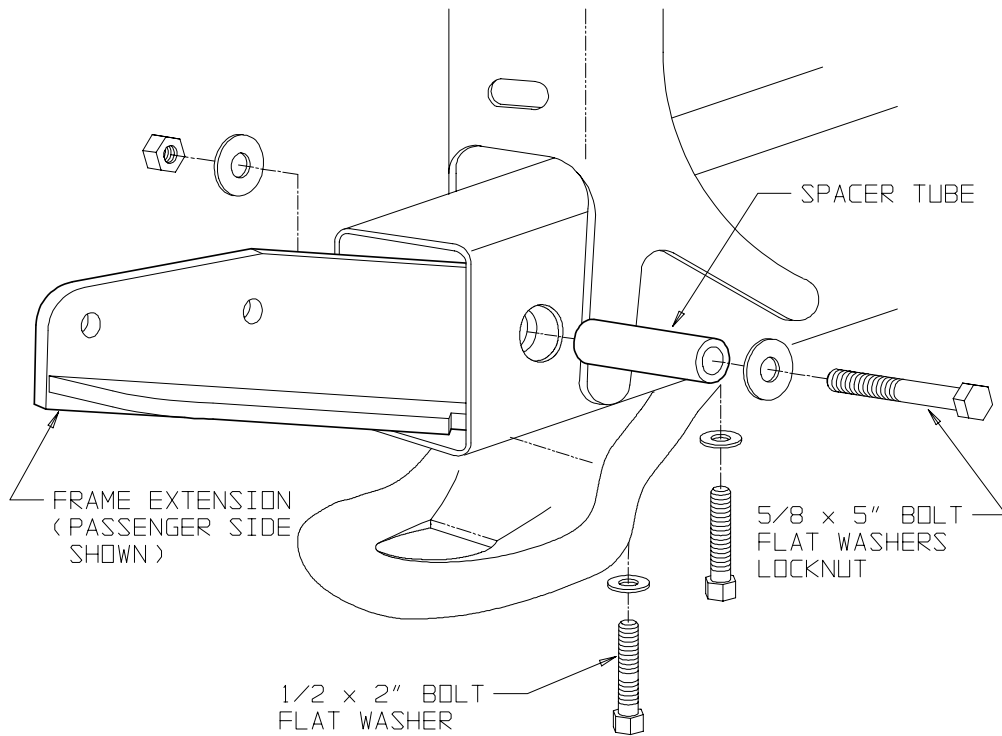
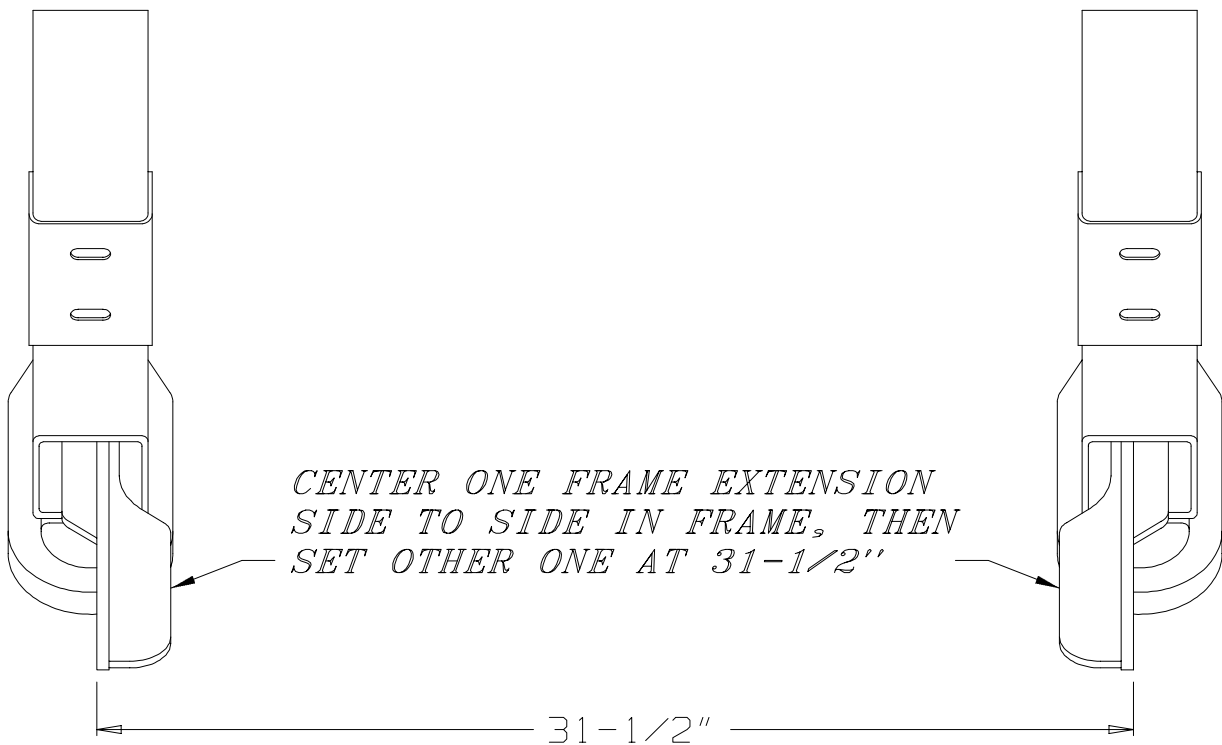


FIGURE 1

- Slide one of the Frame Extensions left to right to center it in the frame within the bolt hole clearance. While pulling forward, tighten the bolts securely. Refer to **Figure 2** and set the other Frame Extension to the 31-1/2" dimension over the forward outside surfaces. Tighten both Frame Extensions securely.

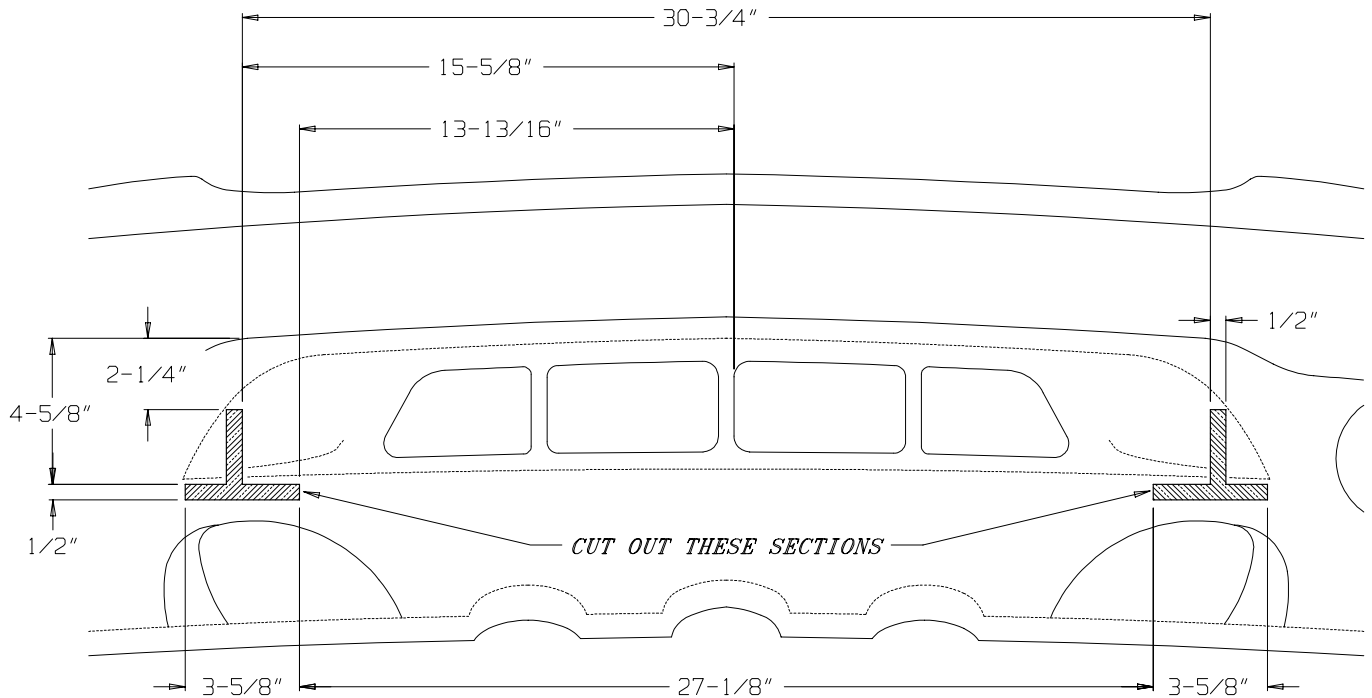
FIGURE 2



*CENTER ONE FRAME EXTENSION
SIDE TO SIDE IN FRAME, THEN
SET OTHER ONE AT 31-1/2"*

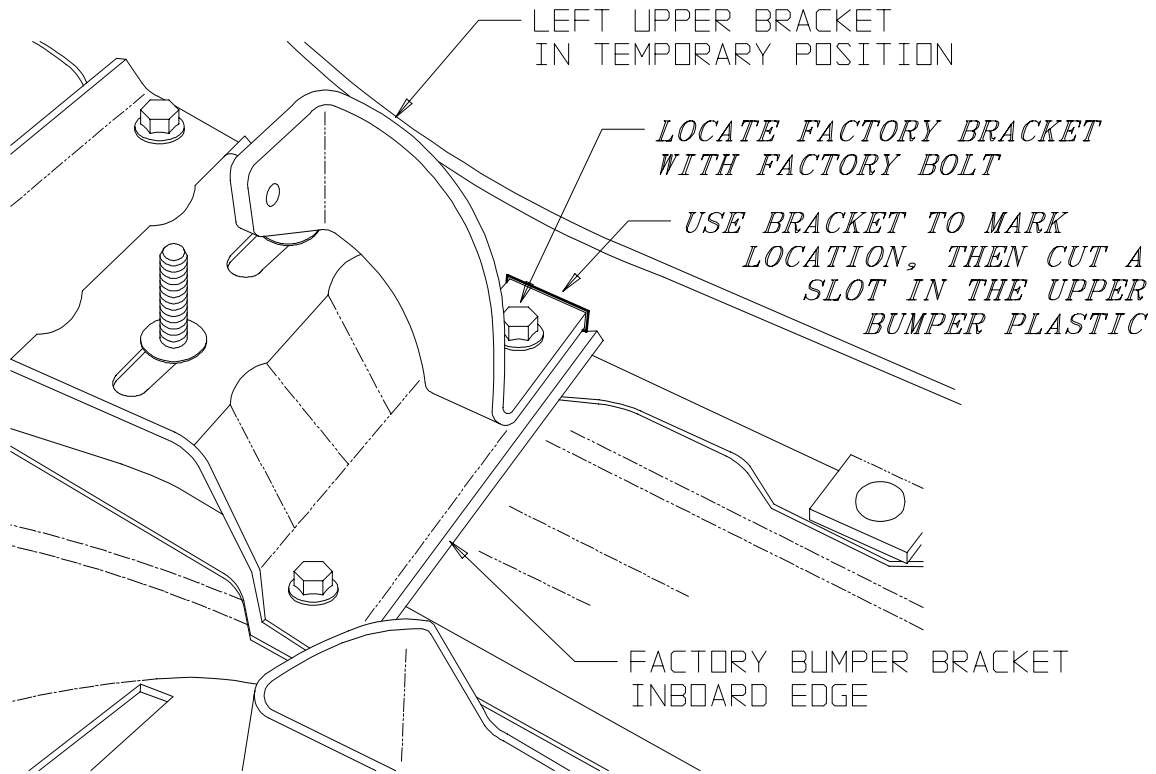
5. Cut openings in the lower plastic portion of the bumper as shown in **Figure 3**. The plastic cuts easily with a small saw blade or Dremel type cutting tool. A sharp knife or Exacto blade is also useful.

FIGURE 3



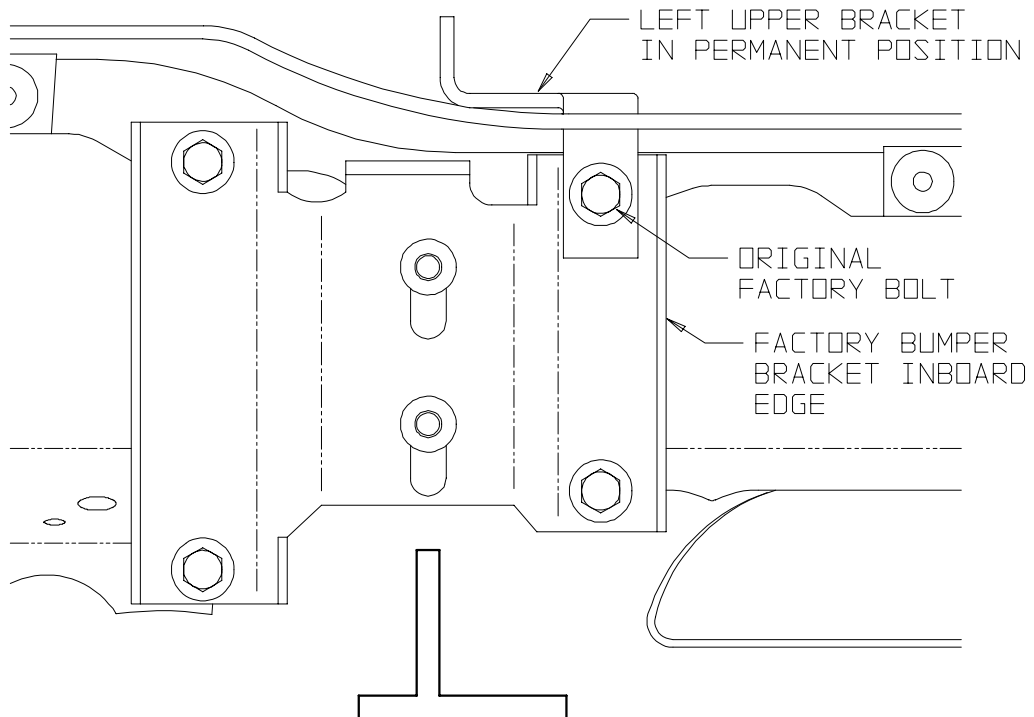
6. Refer to **Figure 4** and temporarily install the Upper Brackets on the backside of the bumper. This is an easy way to locate the correct position for cutting small slots in the upper bumper plastic. After marking for the cuts, remove the brackets.

FIGURE 4



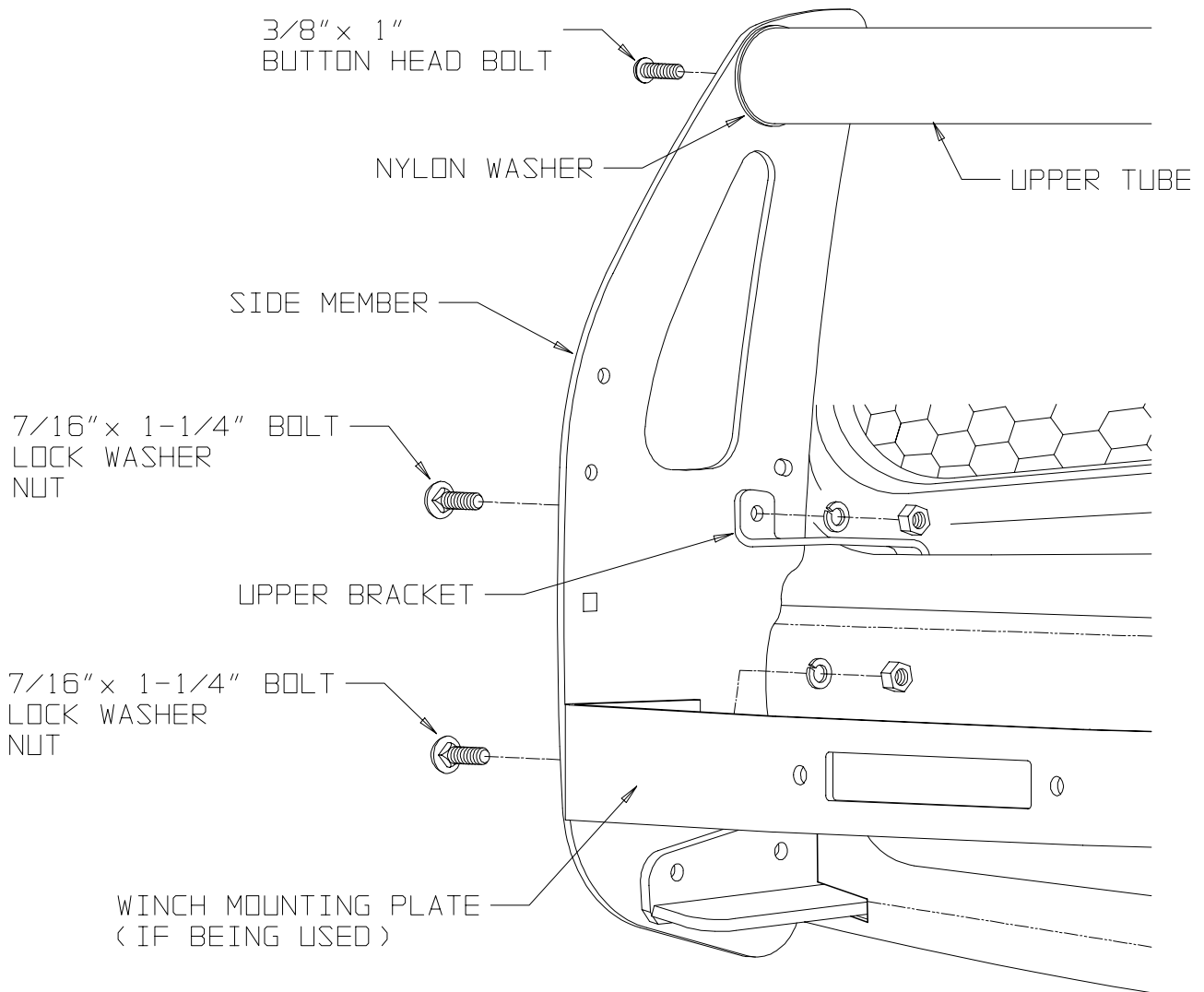
7. Refer to **Figure 5 and 6** and permanently install the Upper Brackets as shown.

FIGURE 5



8. Install the bumper taking care to **line it up very evenly up and down and left to right**. The alignment of the Grille Guard depends upon the alignment of the bumper.
9. Install Side Members to the Upper Brackets as shown in **Figure 6**. Install the Upper Tube and the Winch Carrier (if being used) also at this time.

FIGURE 6



10. Observe the fit of the Frame Extensions to the Side Members and determine the number of Shim Plates to fill the space on each side. (**Figure 7**) Some vehicles may require all 4 on one side and none on the other.

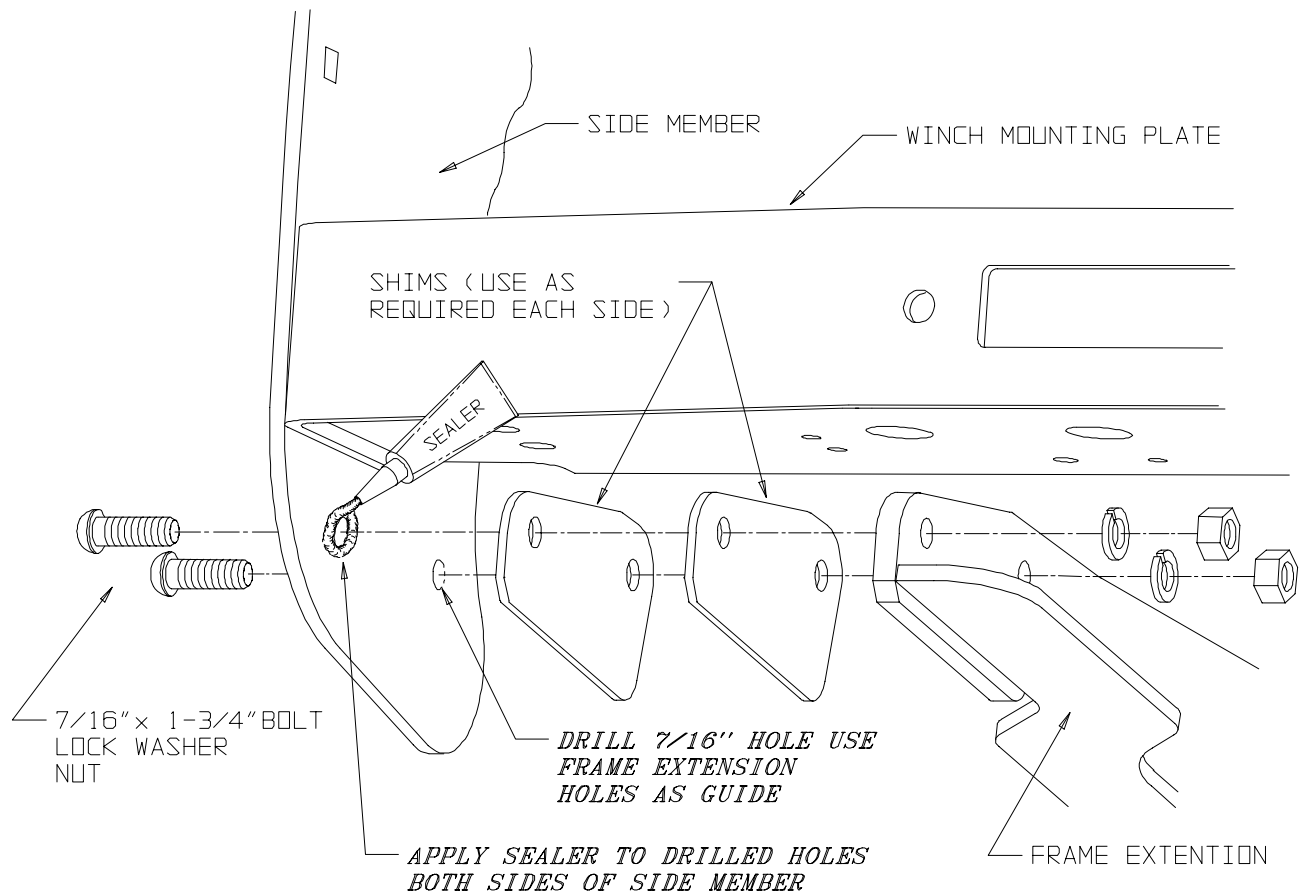




FIGURE 7

11. The back edge of the Side Members should be adjusted to approximately 1/4" clearance to the bumper and lower plastic panel, then clamped to the Frame Extensions with the Shims in place. It is helpful to use a 1/4" spacer like a pencil or small nut at the lower back edges of the Side Members to maintain the clearance. Check all alignments and clearances one more time, then drill the Side Members to match the Frame Extension holes. Use the supplied Silicone Sealer to coat and seal the drilled hole (**Figure 7**). Install bolts and tighten securely.

	WARNING
	<p>Drilling operations can cause flying metal chips. WEAR SAFETY GOGGLES. Flying metal chips can cause eye injury.</p>

12. Refer to **Figure 8** and install the diagonal braces against the inside of the frame, extending forward through the openings in the lower bumper plastic. Install the 4-1/2" bolt thru the vehicle frame and brace. **USE THE THICK SPACER WASHER UNDER THE BOLT HEAD ON THE OUTSIDE OF THE FRAME.** On the driver's side, the cooler lines can be easily bent to obtain bolt clearance. Pull the braces and 4-1/2" bolt forward against the frame slot and line up with the rear winch mounting holes. (**Figure 9**). Mark and drill a 3/8" hole in each brace, then reinstall.

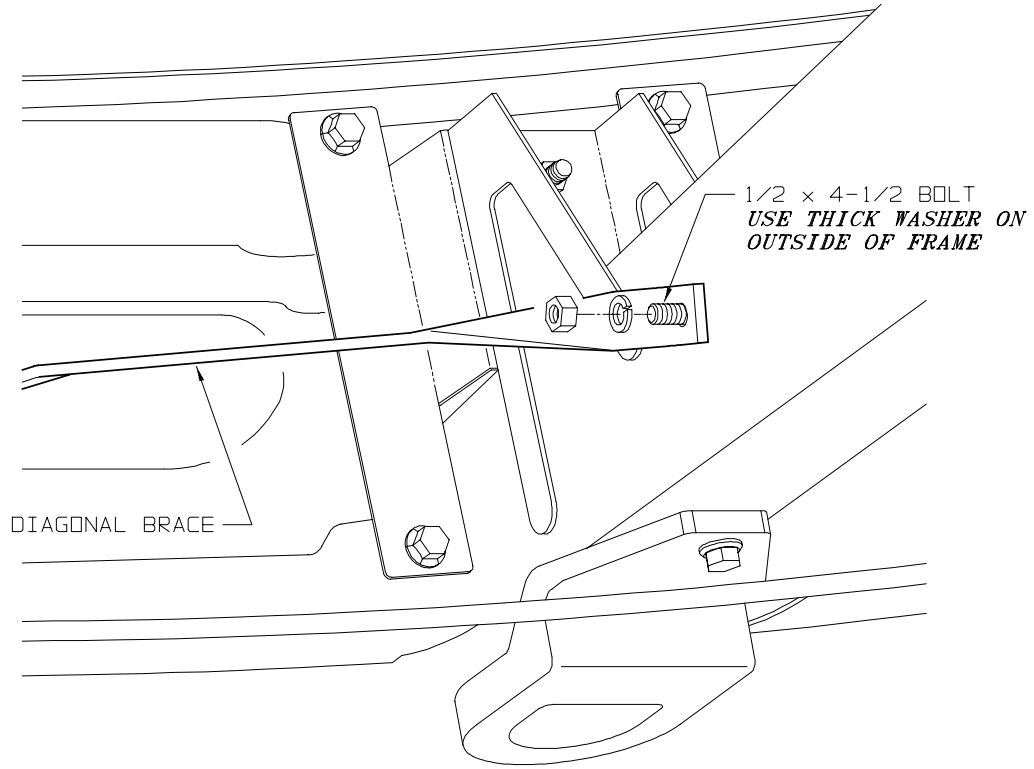
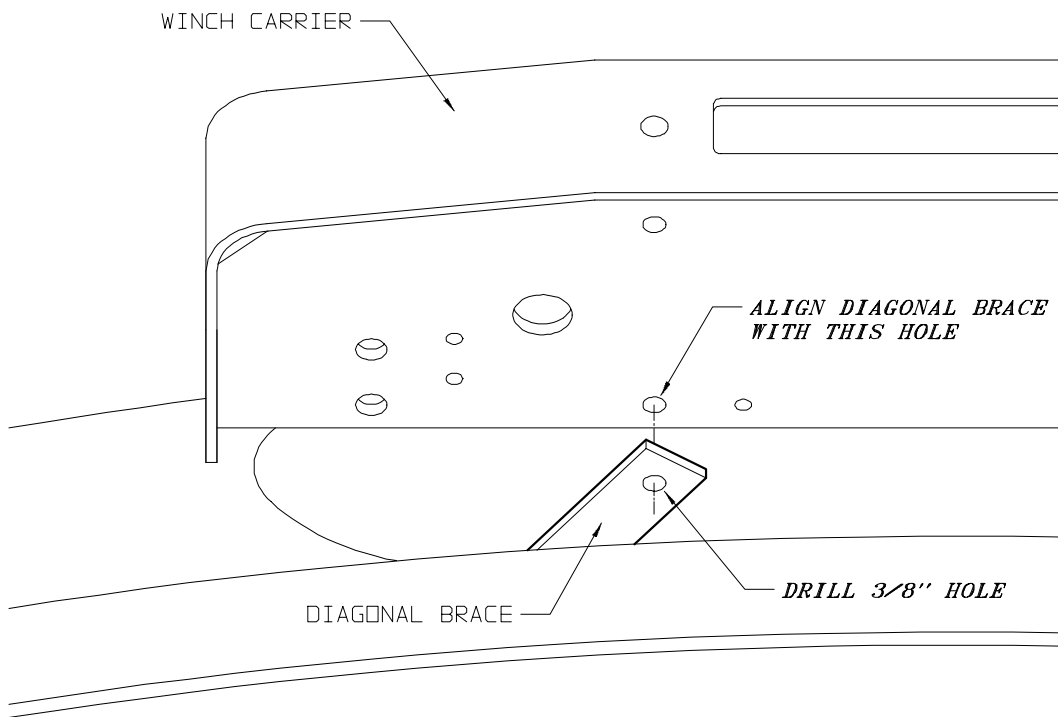


FIGURE 8

FIGURE 9



13. Reinstall the flexible baffle to the back of the bumper.

14. If the Warn M8000 or XD9000 winch is installed, a special bracket is required to mount the control box above the winch drum as shown in **Figure 10**. This bracket is part number 26368 and is available through Warn dealers.

FIGURE 10

