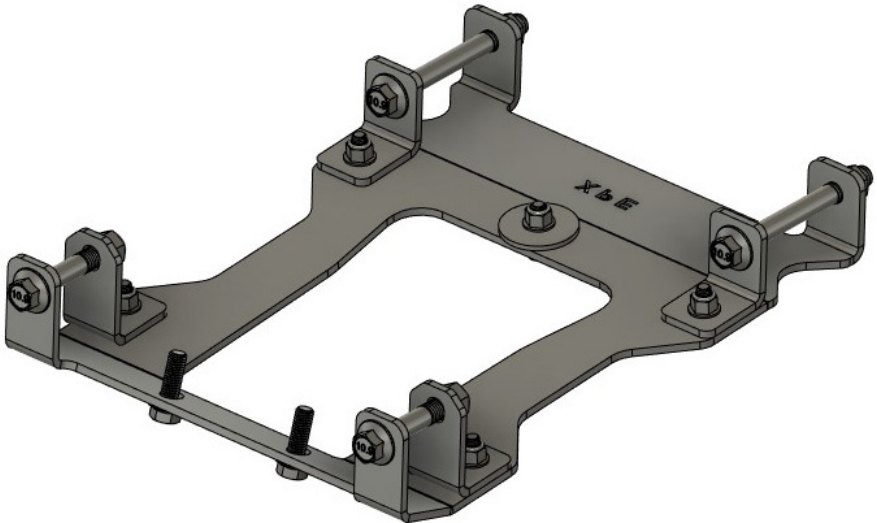


Polaris Xpedition
Front Frame Stiffener

SKU: TF200902



Thumper Fab

5103 Elysian Fields Rd, Marshall, TX 75672

Customer Service: 903-472-0928

Polaris Xpedition

Front Frame Stiffener



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PARTS

REF	QTY	DESCRIPTION
1	1	MAIN PLATE
2	2	REAR L-BRACKET
3	2	FRONT L-BRACKET
4	1	CENTER WASHER
HARDWARE		
A	2	M12-1.75mm X 110mm Flanged Head Bolt
B	2	M12 X 1.75mm, 70mm Flanged Head Bolt
C	4	M12 X 1.75MM Flanged Locknut
D	2	M10 x 1.5mm x 30mm Flanged Head Bolt
E	5	M8 X 1.25MM X 25 MM Flanged Head Bolt
F	5	M8 X 1.25MM Flanged Locknut

TOOLS

- Impact
- 18mm Socket
- 18mm Wrench
- 16mm Socket
- 16mm Wrench
- 15mm Socket
- 15mm Wrench
-
-

BEFORE YOU BEGIN

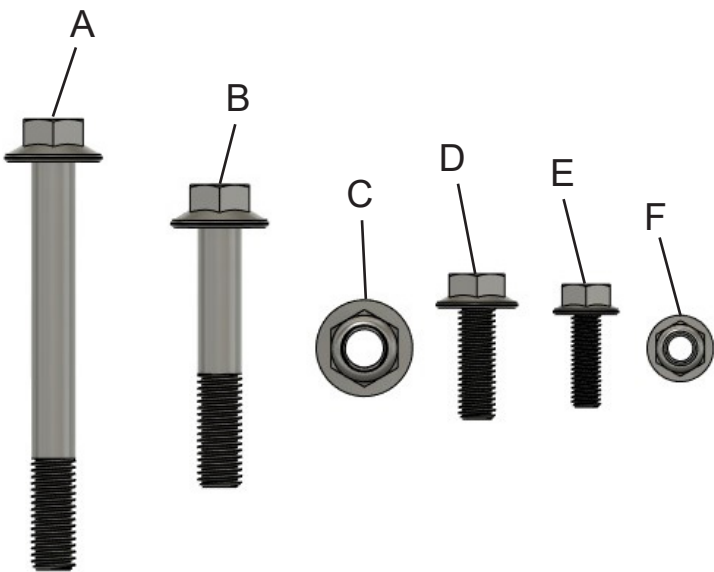
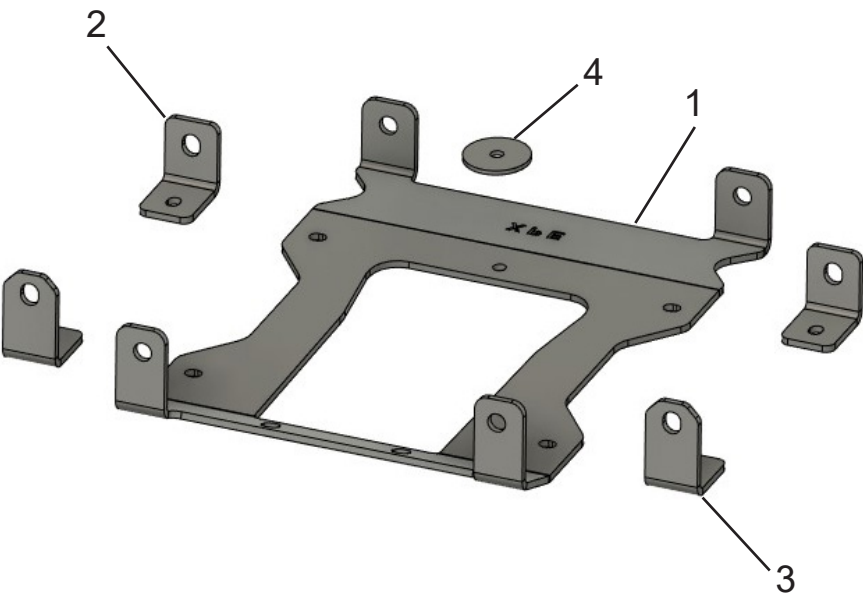
If you do not feel comfortable installing your **Thumper Fab** INSERT PRODUCT, please see your nearest INSERT BRAND® Dealer for

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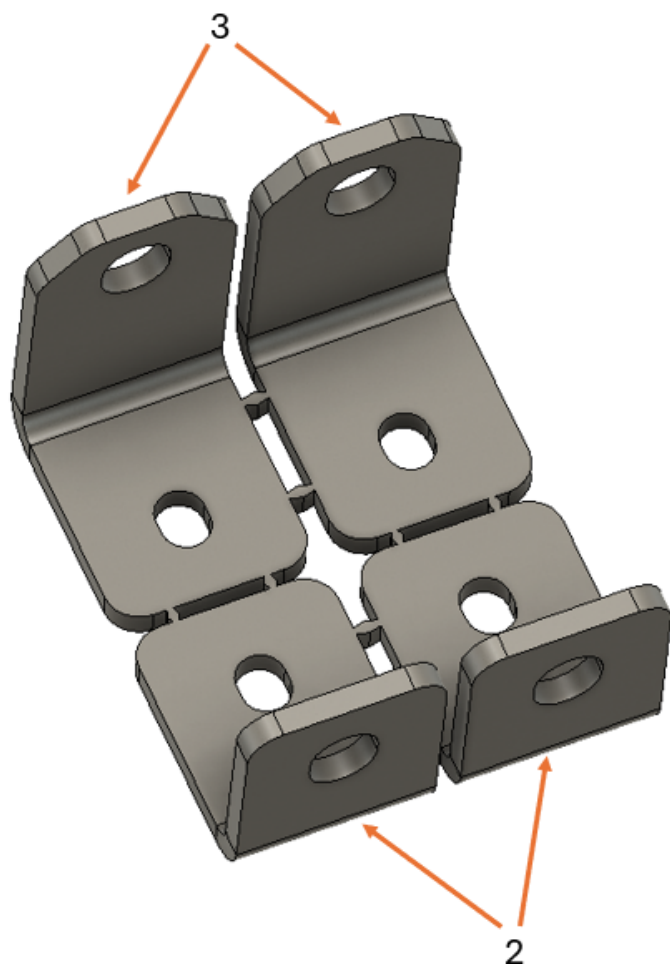
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Small brackets are tabbed together and need to be broken apart before installation. A pair of pliers can be used to break off the small pieces of leftover tabs after the brackets are broken apart. Layout of brackets is shown below in reference to the part list table on Page 2.



INSTALLATION INSTRUCTIONS

Removing OEM Hardware

First, start by jacking up the unit and placing jack stands underneath. Then remove the OEM Hardware that fastens the lower control arms to the chassis. (FIG. 1)

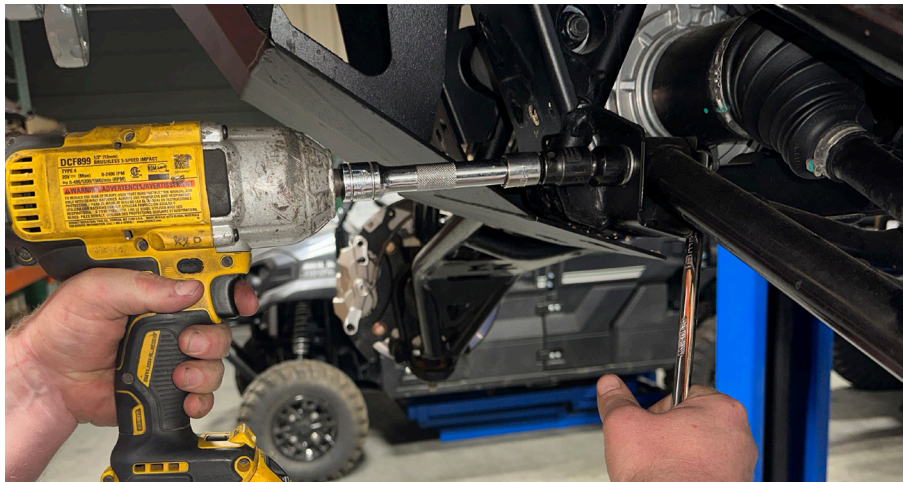


FIG. 1

Install the Main Plate and Front L-Brackets

Next, install the MAIN PLATE into place. Then insert the new M12 x 70mm bolts into the front mounts. After the bolts have been placed through the mounts, locate the Front L-Brackets into place as shown. Then thread a M12 Locknut on the back side. Leave loose for now. (FIG. 2 & 3)



FIG. 2



FIG. 3

INSTALLATION INSTRUCTIONS

Next Install the Rear L-Brackets

Next, place the Rear L-Brackets into place on the front side of the rear mounts. Then, insert a M12 x 110mm bolt through the L-Bracket and through the rear control arm mount. Loosely fasten on the back side with a M12 Locknut. (FIG. 4)



FIG. 4

Next, using the M8 Flanged Head Bolts and fasten the L-Brackets to the Main Plate as shown. (FIG. 5) For the 5th bolt hole in the center of the Main Plate, use the Center Washer on the top to cover the large hole in the frame. (FIG. 6)

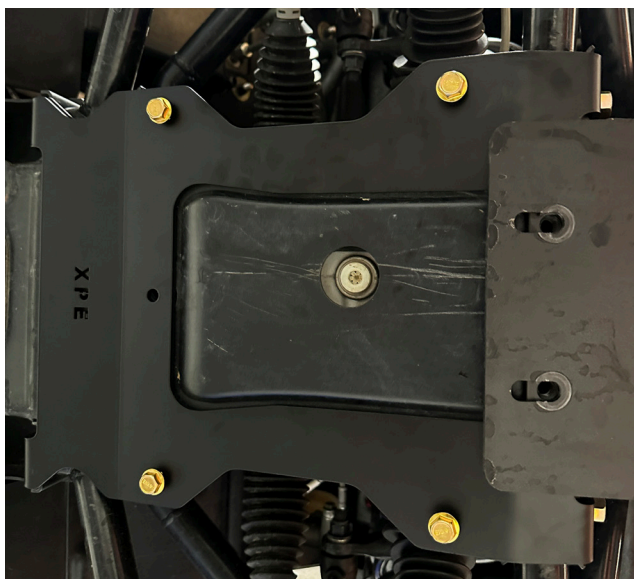


FIG. 5

INSTALLATION INSTRUCTIONS



FIG. 6

Next, thread the M10 bolts provided in the kit into the front (2) threaded hole in the frame at the front of the Main Plate. (FIG. 7)



FIG. 7

Last, go over all hardware and ensure that everything has been tightened properly. (FIG. 8 & 9)



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