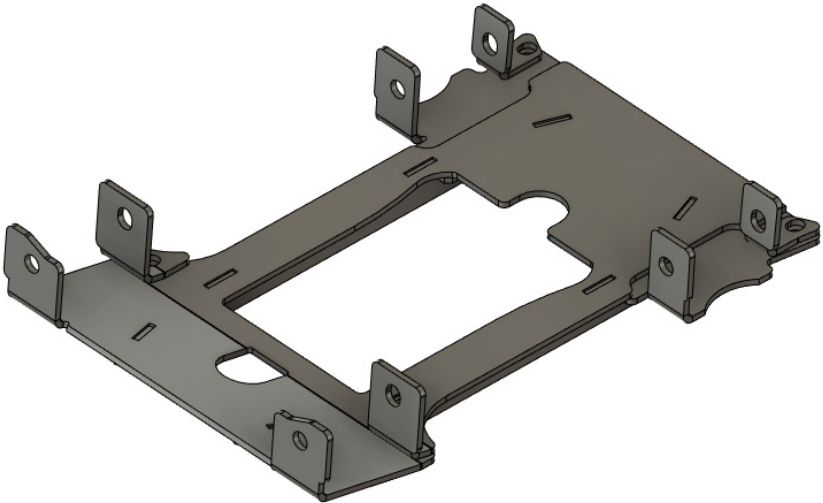


Polaris Ranger XD1500
Front Frame Stiffener

SKU: TF230004



Thumper Fab
5103 Elysian Fields Rd, Marshall, TX 75672
Customer Service: 903-472-0928

Polaris Ranger XD1500

Front Frame Support

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PARTS

REF	QTY	DESCRIPTION
1	1	Base
2	1	Forward Rear Bracket - Driver
3	1	Forward Rear Bracket - Passenger
4	1	AFT Rear Bracket - Driver
5	1	AFT Rear Bracket - Passenger
HARDWARE KIT		
A	4	M10 x 25mm Flange Head Bolts
B	4	M10 Flange Nylon Lock Nuts
C	2	M12 x 110mm Flange Head Bolts
D	2	M12 Flange Nylon Lock Nuts
E	2	M12 x 100mm Flange Head Bolts
F	2	M12 Thin Nylon Lock Nuts

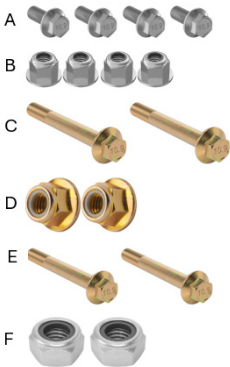
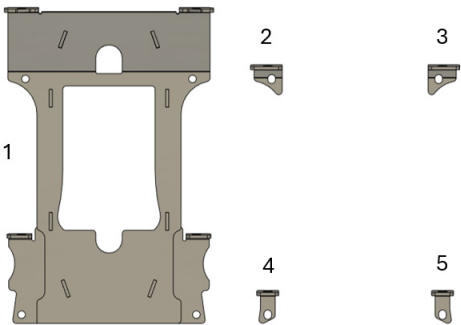
TOOLS

- 15mm Socket and Wrench
- 16mm Socket
- 18mm Socket and Wrench
- Drill
- 7/16" Drill Bit
- Jack
- Pry bar
- Pliers

Torque Specs:

SIZE (STANDARD)	GRADE 5	GRADE 8
5/16"	15 ft/lbs	20 ft/lbs
3/8"	30 ft/lbs	35 ft/lbs
7/16"	45 ft/lbs	60 ft/lbs
1/2"	65 ft/lbs	90 ft/lbs
9/16"	95 ft/lbs	130 ft/lbs
5/8"	135 ft/lbs	175 ft/lbs
3/4"	185 ft/lbs	280 ft/lbs

SIZE (METRIC)	CLASS 8.8	CLASS 10.9
6MM	5 ft/lbs	9 ft/lbs
8MM	18 ft/lbs	23 ft/lbs
10MM	32 ft/lbs	45 ft/lbs
12MM	55 ft/lbs	75 ft/lbs
14MM	85 ft/lbs	120 ft/lbs
16MM	130 ft/lbs	165 ft/lbs
18MM	170 ft/lbs	240 ft/lbs



BEFORE YOU BEGIN

If you do not feel comfortable installing your **Thumper Fab** Frame Support please see your nearest Polaris® Dealer for installation.

Polaris Ranger XD1500

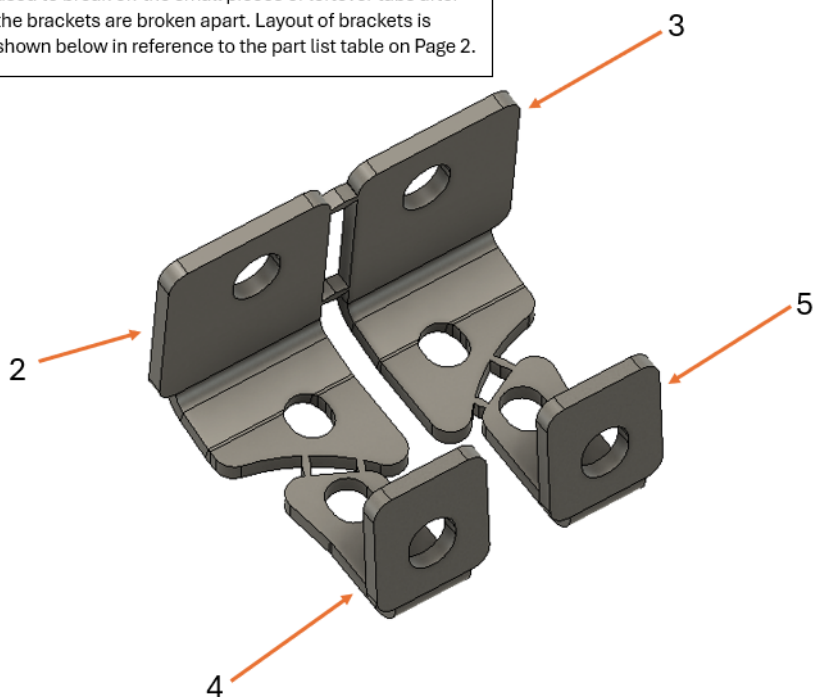
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PARTS

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

Installation Preparation

Begin by lifting the vehicle and remove the front wheels and front bumper. Use an 18mm socket and wrench to remove the 4 x OEM lower control arm mounting bolts. If completing installation on a vehicle with a Thumper Fab Front Bumper, it is required to loosen the bumper by removing 2 lower mounting bolts and prying the bumper away from the lower portion of the vehicle to allow for removal and installation of the front mounting bolts for the lower control arms. Full removal of bumper will allow for an easier installation, but is not required (**FIG 1**).



FIG 1 - Remove the Lower Control Arm Mounting Bolts

Loosley fasten the base to the frame using 2 x M12x110mm flange head bolts (**C**) for the front bushing collars and 2 x M12x100mm flange head bolts (**E**) for the rear bushing collars. Do not thread on M12 lock nuts yet. Depending on variations in frames from Polaris, a jack or pry bar may assist the alignment of the rear holes of the frame stiffener to install the M12 x 100mm flange head bolts (**E**) (**FIG 2 & FIG 3**).



FIG 2 & FIG 3 - Loosley mount Base to Vehicle Frame

INSTALLATION INSTRUCTIONS

Installation

Use a drill with a 7/16" drill bit to drill through the frame of the vehicle using the base as a template for hole drilling locations in the 4 spots highlighted below in red (**FIG 4 & FIG 5**).

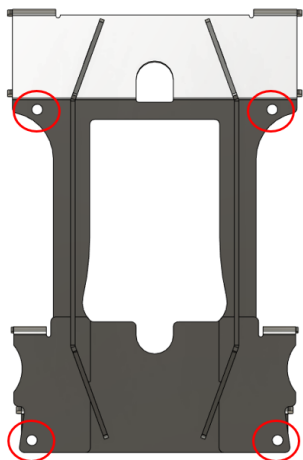


FIG 4 & FIG 5 - Drill holes through frame using the Base as a template

Loosley fasten forward rear brackets to the frame and the base using 2 x M12 flange nylon lock nuts (**D**) to fasten brackets to bushing collar frame tabs along with 2 x M10x25mm flange head bolts (**A**) and 2 x M10 flange nylon lock nuts (**B**) to fasten the base to the frame (**FIG 6**).



FIG 6 - Loosley mount Forward Rear Brackets Driver & Passenger to Frame

INSTALLATION INSTRUCTIONS

Installation

Mount the AFT rear brackets driver & passenger to the frame of the vehicle using 2 x M12 thin nylon lock nuts (**F**) to fasten brackets to bushing collar frame tabs. Also use 2 x M10x25mm flange head bolts (**A**) and 2 x M10 flange nylon lock nuts (**B**) to fasten the base to the underside of the vehicle frame (**FIG 7**).

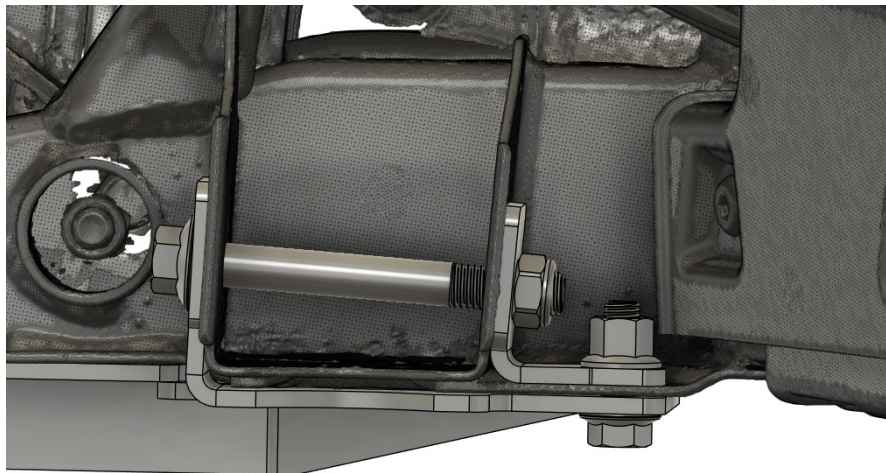


FIG 7 - Mount AFT Rear Brackets Driver & Passenger

Use a 15mm socket and wrench to tighten all M10 hardware before using a 16mm socket and an 18mm wrench to tighten the M12 hardware that fastens the lower control arms to the vehicle. Remount the front bumper and wheels.

INSTALLATION INSTRUCTIONS

PRODUCT DISCLAIMER

The installation of products sold or manufactured by Thumper Fabrication, LLC (Thumper Fab) including, but not limited to suspension components such as lift kits, audio roofs, roll cages, frame stiffener kits, and tires that exceed the original specifications for the vehicle, may change the vehicle's center of gravity and handling characteristics both on- and off-road. You are aware that the installation of tires that are larger than original vehicle specifications may reduce the effectiveness of the braking system. Use of these products may place added stress to the original factory vehicle components which could cause them to weaken or possibly fail.

Products sold or manufactured by Thumper Fab are intended for off-road use only. Operation of a vehicle modified with these products on a road could result in serious bodily injury or death, and such operation may violate the laws of your state or municipality. You agree to operate your vehicle exclusively in the manner intended by the vehicle manufacturer. You agree that failure to safely and reasonably operate your vehicle could result in serious bodily injury or death, and that, as a result of installation of this product(s) to your vehicle, extreme care must be taken to prevent vehicle rollover or loss of control, which may be more likely to occur as a result of said modifications. You will avoid unsafe maneuvers, including sudden sharp turns or other abrupt maneuvers, which could make a vehicular accident more likely. You understand that Thumper Fab is not responsible or liable for any damages or any injuries to yourself or your passengers that could occur upon possible accidents due to driver error, incorrect installations, bad judgment, incompatibility with other aftermarket accessories or natural disasters to the fullest extent allowable by law. You will have all vehicle occupants fasten seatbelts, if equipped, and wear proper safety equipment, such as DOT approved helmet and eye protection prior to operating the vehicle. You understand and acknowledge that failure to wear proper safety equipment may increase the risk of serious bodily injury or death to yourself and any passengers.

Proper installation of products sold or manufactured by Thumper Fab requires knowledge of the factory recommended procedures for removal and installation of original equipment components. Installation of these products without proper knowledge and experience may affect the performance of these components and the safety of the vehicle and cause serious bodily injury or death. It is strongly recommended that a certified mechanic familiar with the installation of similar components perform the product(s) installation.

Prior to installing any products sold or manufactured by Thumper Fab, you will perform or cause to be performed an inspection of their vehicle to confirm its condition is suitable for the installation of these products. A proper inspection of the vehicle includes confirmation that the vehicle has not been in a collision and is free of corrosion. If the vehicle is suspected to have been in a collision or misused, or is otherwise unsuitable for modification, you will not install the product(s). You will continue to inspect the vehicle prior to each use to confirm its condition is suitable for its intended use, and you acknowledge that the failure to do so may result in serious bodily injury or death, as well as damage to the vehicle itself.

You will install any warning labels provided with the product so it may be prominently seen by yourself and all passengers. You will notify all passengers of the modifications performed to your vehicle prior to operation.

Insurance companies may handle coverage of a modified vehicle differently. Please check with your insurance carrier prior to modifying the vehicle to ensure your coverage remains sufficient. Installation of this product(s) may void your vehicle warranty. If this is a concern, please check with the manufacturer or dealer before purchase or installation of this product(s).



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