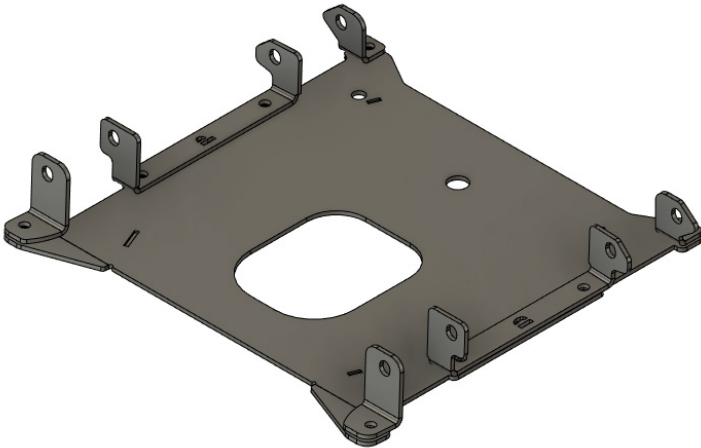


Polaris Ranger XD 1500
Rear Chassis Stiffener

SKU: TF230005



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

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PARTS

REF	QTY	DESCRIPTION
1	1	Base
2	1	Middle Brace - DR
3	1	Middle Brace - PA
4	1	Rear Brace - DR
5	1	Rear Brace - PA
6	1	Front Brace - DR
7	1	Front Brace - PA
HARDWARE KIT		
A	4	M12 x 110mm Flange Head Bolts
B	4	M12 Flange Nylon Lock Nuts
C	8	M10 x 30mm Carraige Bolt
D	8	M10 Flange Nylon Lock Nut
E	8	M10 Flat Washer

TOOLS

- 15mm Socket and Wrench
- 16mm Socket
- 18mm Socket and Wrench

Torque Specs:

SIZE (STANDARD)	GRADE 5	GRADE 8	SIZE (METRIC)	CLASS 8.8	CLASS 10.9
5/16"	15 ft/lbs	20 ft/lbs	6MM	5 ft/lbs	9 ft/lbs
3/8"	30 ft/lbs	35 ft/lbs	8MM	18 ft/lbs	23 ft/lbs
7/16"	45 ft/lbs	60 ft/lbs	10MM	32 ft/lbs	45 ft/lbs
1/2"	65 ft/lbs	90 ft/lbs	12MM	55 ft/lbs	75 ft/lbs
9/16"	95 ft/lbs	130 ft/lbs	14MM	85 ft/lbs	120 ft/lbs
5/8"	135 ft/lbs	175 ft/lbs	16MM	130 ft/lbs	165 ft/lbs
3/4"	185 ft/lbs	280 ft/lbs	18MM	170 ft/lbs	240 ft/lbs

BEFORE YOU BEGIN

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

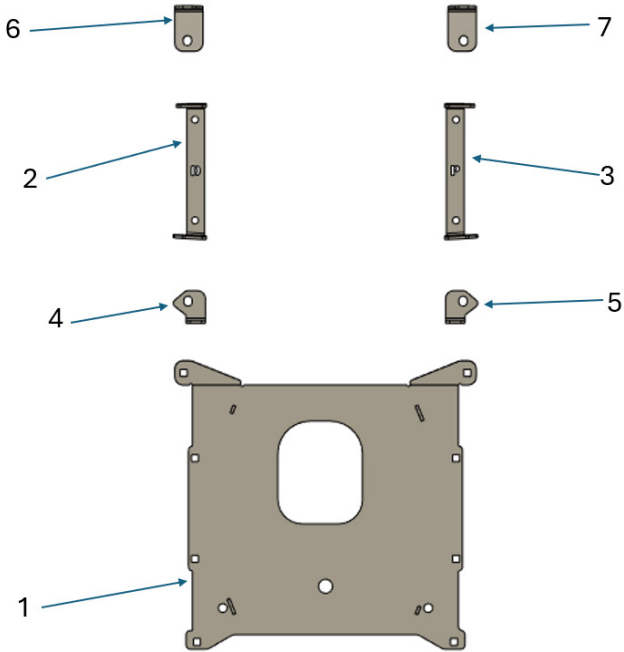
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PARTS



INSTALLATION INSTRUCTIONS

Installation

Remove the rear lower control arm mounting bolts using an 18mm socket and wrench (**FIG 1**).



FIG 1 - Remove OEM Lower Control Arm Mounting Bolts

Insert the driver and passenger side middle braces (**2 & 3**) in between the sections of frame for the lower control arm mounts (**FIG 2**).



FIG 2 - Insert Middle Braces into place

INSTALLATION INSTRUCTIONS

Installation

Loosley fasten the base (1) to the middle braces (2 & 3) using 4 x M10 carriage bolts (C), 4 x M10 flange nylon lock nuts (D) and 4 x M10 flat washers placed in between the base and the middle brace. Do not fully tighten (FIG 3).



FIG 3 - Loosley Mount Base to Middle Braces

Mount the driver and passenger side rear brace to the vehicle using 2 x M12 x 110mm flange head bolts (A) and M12 flange nylon lock nuts (B). Do not fully tighten (FIG 4).



FIG 4 - Loosley Mount Rear Braces to Vehicle

INSTALLATION INSTRUCTIONS

Installation

Loosely mount the front braces (**6 & 7**) using 2 x M12 x 110mm flange head bolts (**A**) and M12 flange nylon lock nuts (**B**). Do not fully tighten (**FIG 5**).

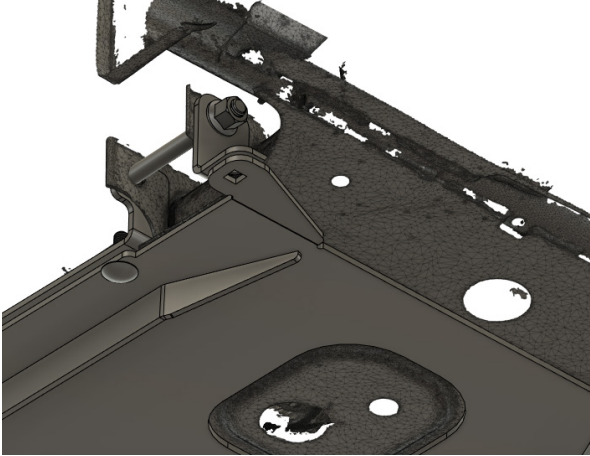


FIG 5 - Loosely Front Braces to Vehicle

Slide the remaining 4 flat washers (**E**) in between the base and the front and rear braces before installing the last 4 x carriage bolts (**C**) and 4 x M10 flange nylon lock nuts (**D**) (**FIG 6**).



FIG 6 - Install remaining Carriage Bolts

INSTALLATION INSTRUCTIONS

Installation

Fully tighten the control arm mounting hardware using a 16mm socket and an 18 mm wrench. Once control arm mounting hardware is tight, tighten all carriage bolts using a 15mm socket or wrench (**FIG 7**).

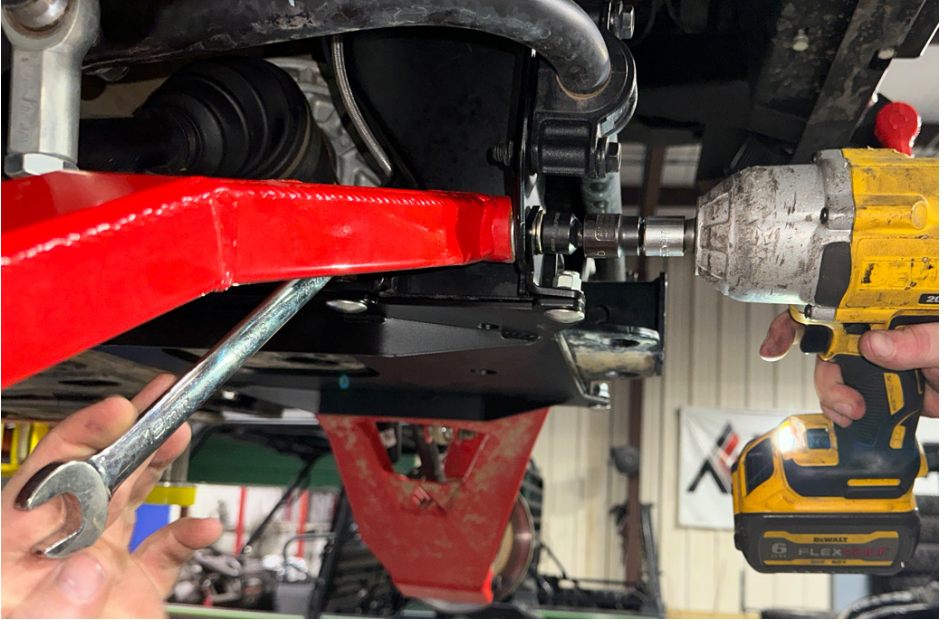


FIG 7 - Tighten all Hardware

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).



THUMPER FAB

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