



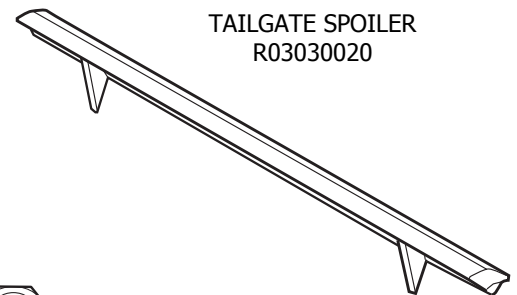
Ford F-150 Rear Tailgate Spoiler Installation Instructions

Application: 2004-06 Ford F-150 Pickup Model

Before installing your Roush Performance Product(s), read through the entire installation procedure and check to make sure all items are present.

Packaging List for Complete Rear Tailgate Spoiler Kit # R03030019

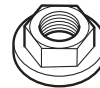
<u>Item</u>	<u>Quantity</u>
Tailgate Spoiler (#R03030020)	1
Hardware Kit, Tailgate Spoiler (#R03030029)	1
Flange-Head Torque Nut, M6	4
Adhesive Tape:	
Base Strips	3
Stanchion Strips	2
Installation Instructions (#R03030048)	1



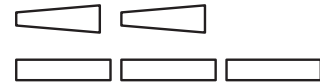
TAILGATE SPOILER
R03030020

Equipment and Supplies Required

Ratchet
10 mm Deep Well Socket
Soft Cloth
Drill
7 mm Drill Bit
Red Loctite®
Masking Tape
Rubbing Alcohol



FLANGE-HEAD
NUT



TAPE STRIPS

Suggested Materials

Dupont® 2319 Plastic Prep, or equivalent
Dupont® 2322S Adhesion Promoter, or equivalent



1. Installation Precautions

1. Place ignition switch in the OFF position.
2. Always apply the parking brake when working on a vehicle.
3. Block the front and rear tire surface to prevent unexpected vehicle movement.
4. Operate the engine only in well-ventilated areas to avoid exposure to carbon monoxide.
5. Do not smoke or use flammable items near or around the fuel system.
6. Use chemicals and cleaners in well-ventilated areas.
7. Batteries produce explosive gases, which can cause personal injury. Therefore, do not allow flames, sparks or flammable substances to come near the battery.
8. Keeps hands and any other objects away from the radiator fan blades.
9. Keep yourself and your clothing away from moving parts when the engine is running.
10. Do not wear loose clothing or jewelry that can get caught in rotating parts or scratch surface finishes.

2. Paint Preparation

1. Wipe each part with plastic prep (Dupont® 2319, or equivalent)
2. Wipe entire part with tack cloth
3. Apply adhesion promoter (Dupont® 2322S, or equivalent) prior to color and clear coat applications.

3. Pre-Installation

1. Wear eye protection.
2. Thoroughly clean tailgate before starting installation.



4. **Installation Preparation**

1. Open tailgate and remove eight PT screws securing the inner panel cover and remove cover (see FIGURE A).

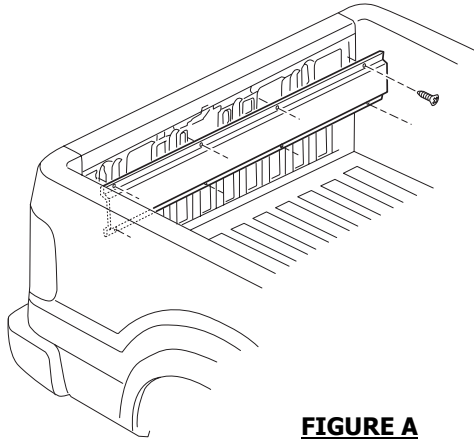


FIGURE A

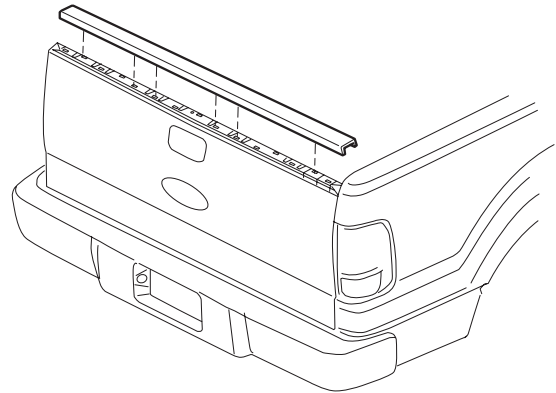


FIGURE B

2. From inside tailgate, release the thirteen tabs securing stock outer trim piece at the top. Then, with protective covering in place on the outer surface (where needed to protect painted tailgate surface), carefully pry up on trim piece to separate it from tailgate. Remove and discard trim piece (see FIGURE B).
3. Close tailgate and clean top surface and down 4" from top with rubbing alcohol.

5. **Spoiler Installation**

1. Remove white protective covering and install the supplied adhesive tape in five locations on underside of spoiler (see FIGURE C).

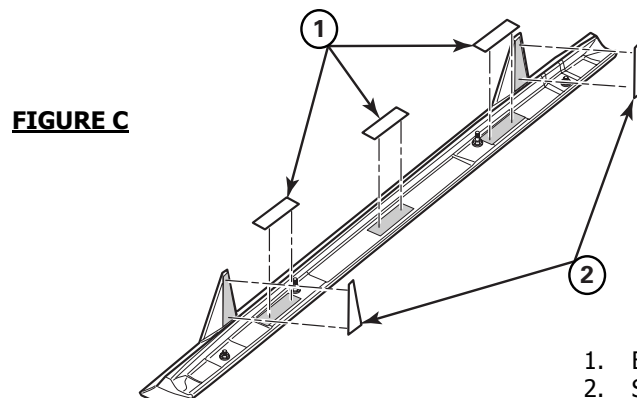


FIGURE C

1. BASE STRIPS
2. STANCHION STRIPS



5. Spoiler Installation (continued)

Note: It is recommended to use an adhesion promoter on the tape mounting areas before applying tape.

2. Peel back corners of red protective covering from tape strips on the base underside of spoiler and stanchions. Peel back covering just enough to allow it to be folded flat against spoiler base and extend beyond edge of spoiler. (This is necessary to provide a tab for full removal of tape covering once spoiler is positioned and properly aligned.)
3. With the tailgate closed (upright), place the spoiler in position at top of tailgate (see FIGURE D). Make sure that folded corners of tape covering extend out from between spoiler and tailgate.

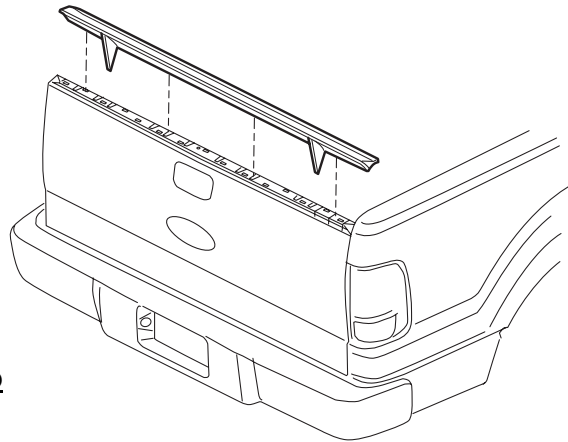


FIGURE D

4. Check alignment of spoiler, side-to-side and at back for full contact of stanchions with tailgate panel. When properly aligned, carefully pull on the exposed tabs to remove the red protective covering from base and stanchion tape strips. Make sure that stanchion pads are in full contact with back of tailgate and press down firmly on the spoiler to secure it in place and seal tape.
5. From inside tailgate, install four M6 flange-head nuts to the spoiler mounting studs. Tighten the nuts to specification, 6 ± 1.5 lb-ft.
6. Lower the tailgate and install the inner cover and eight retaining screws.



Note: If items are missing or for any questions regarding the installation of this kit, please contact Roush Performance toll free at 1-800-59-ROUSH.

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