

## **INSTALLATION INSTRUCTIONS**

Note: This mini instruction sheet is a summary of the detailed instruction sheet provided with each part.

### HARDWARE SUPPLIED FOR MOST ROLL PANS:

- \* #8 self-taping screws (for mounting roll pan)
- \* License plate light kit (if required)
- \* Mounting brackets (if required)
- \* 1/4" bolts, washers and nuts (if required)

### TOOLS REQUIRED:

- \* Drill
- \* Mig welder (if required)
- \* Die grinder (if required)
- \* 1/8" Drill bit
- \* Masking tape
- \* Plasma Cutter (if required)
- \* 9/32" Drill bit
- \* Measuring tape
- \* Torch (if required)
- \* Phillips screwdriver
- \* C-Clamps

### READ ALL INSTRUCTIONS CAREFULLY

Important: Always test fit product on vehicle before painting, drilling or cutting. Parts that have been modified, prepped or painted cannot be returned. NO EXCEPTIONS

#### Instructions for installing roll pans (Bolt-on):

Remove rear bumper and tailgate from vehicle. Use masking tape to protect the edges of the body during test fitting. Line up the bottom of the roll pan so that it is flush with the bottom of the vehicle. The top of the roll pan should be lined-up with the body lines of the vehicle. Use two of the #8 screws provided to attach the top of the roll pan to the back of the bed. Reinstall tailgate and check for clearance, making sure the tailgate opens and shuts without hitting the roll pan. Remove tailgate and finish installing the mounting screws. Most bolt-on roll pans are secure on the bottom with two brackets that mount up to the frame or with two #8 screws that mount into the lower fender lip. Once the roll pan has been test fitted, remove to be prepped for paint. A light coat of body filler is used to fill the seams around the license plate box and at the end of the roll pan. For good paint adhesion, sand down the roll pan completely before applying any primer or paint.

#### Instructions for installing roll pans (Weld-on):

Remove rear bumper and tailgate from vehicle. Test fit the roll pan up to the body, lining up the bottom of the roll pan with the bottom of the vehicle and lining up the top of the roll pan with the body lines of the vehicle. Using C-clamps, clamp the roll pan to the body. Reinstall the tailgate and check for clearance, making sure the tailgate opens and shuts without hitting the roll pan. Adjust if need to. Remove tailgate and roll pan from vehicle. Using a sander, remove any paint on the body where the roll pan will be welded. Clamp roll pan back onto rear of vehicle. Using a wire feed mig welder tack weld the roll pan on. Some roll pans need a little forming to the body. By using a body hammer, tap the roll pan lip flat against the body. Tack weld then hammer form the roll pan to the body. Make sure good penetration is made, especially at the top corners of the body where the roll pan is at, (this is a common area for stress cracks). Once the roll pan has been welded on, grind down the welds for body filler and prep roll pan for paint. Apply some seam sealer to the back side of the roll pan where the roll pan is welded to the body to keep moisture out.

#### Instructions for painting roll pans:

All SIR MICHAEL'S roll pans need light body prep before primer or paint can be applied. Due to the raw steel used, light sanding may be needed to remove some surface rust. All SIR MICHAEL'S roll pans are stitch welded with full penetration to both parts. The reason the roll pan is not fully welded in these areas is due to the possibility of warping the part from too much heat during the welding process.

To finish off the roll pan correctly, sand down the roll pan completely using a D.A. sander with 80 grit sand paper, lightly sand down welds around the license plate box and end caps. Once fully sanded apply a light coat of body filler around the license plate box and end caps. Sand down body filler to smooth out areas. Once completed apply a good coat of quality primer. Block sand roll pan with 180 grit sand paper, smoothing out any sand scratches and reprimer. Block sand roll pan with 320 grit, fix any imperfections in the primer coat and apply another primer coat. Block sand and prep for paint.