



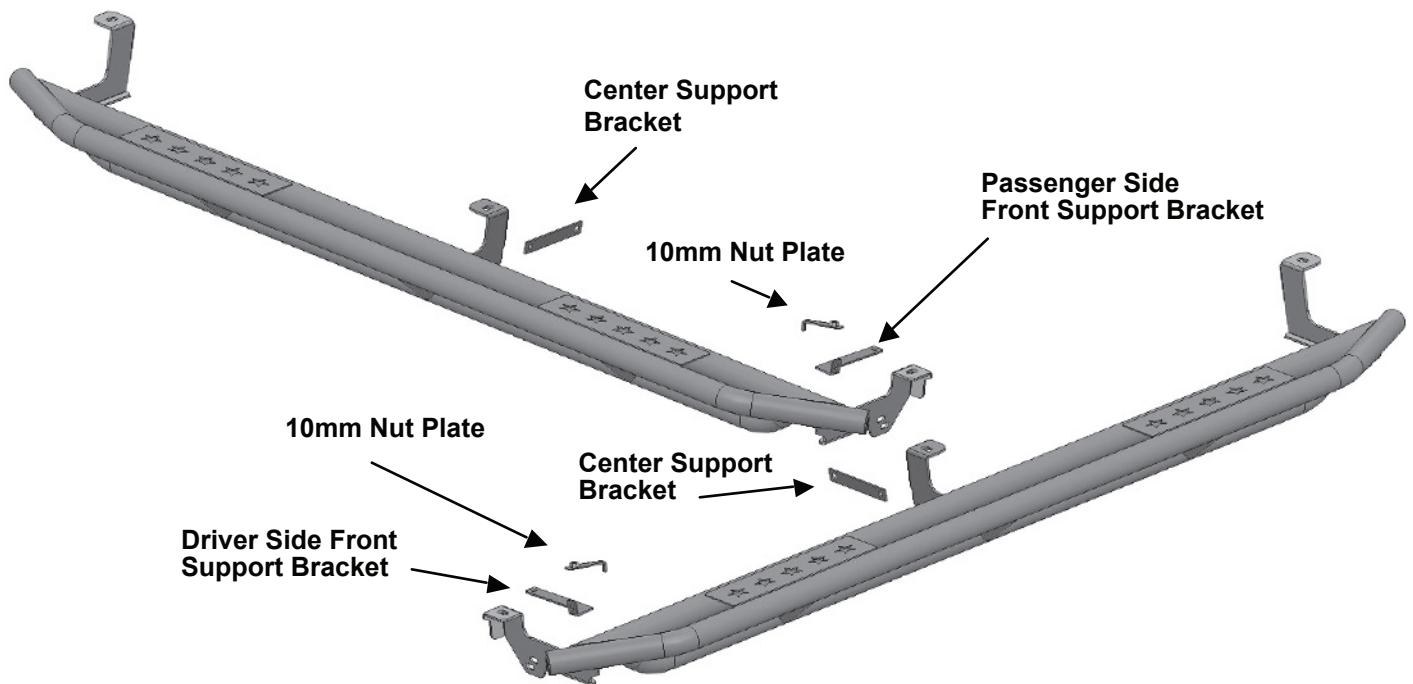
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TG-AM2C20108

STAR ARMOR®

Parts List

x1 Driver Side Armor	x2 12-1.75mm x 30mm Hex Bolts	x6 10-1.50mm x 30mm Hex Bolts
x1 Passenger Side Armor	x4 12mm x 32mm x 3mm Flat Washers	x6 10mm Lock Washers
x1 Driver/Left Front Support Bracket	x2 12mm Lock Washers	x4 10mm Hex Nuts
x1 Passenger/Right Front Support Bracket	x2 12mm Hex Nuts	x2 10mm Nut Plates
x2 Center Support Brackets	x10 10mm x 20mm OD x 2mm Flat Washers	





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Before Installation

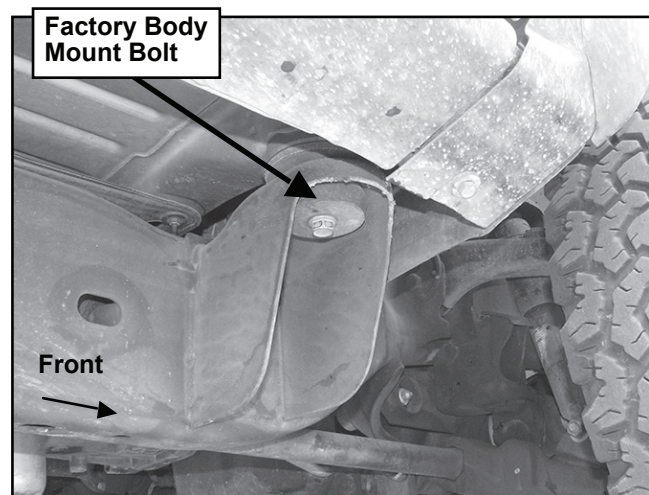
REMOVE CONTENTS FROM BOX. VERIFY ALL PARTS ARE PRESENT. READ INSTRUCTIONS CAREFULLY BEFORE STARTING INSTALLATION. ASSISTANCE IS HIGHLY RECOMMENDED.

Torque Value

Fastener Size	Class 8.8 Tightening Torque (ft-lbs)	Class 10.9 Tightening Torque (ft-lbs)
6mm	6-7	6-7
8mm	15-16	22-23
10mm	31-32	44-45
12mm	54-55	78-79
14mm	87-88	125-126

STEP 1

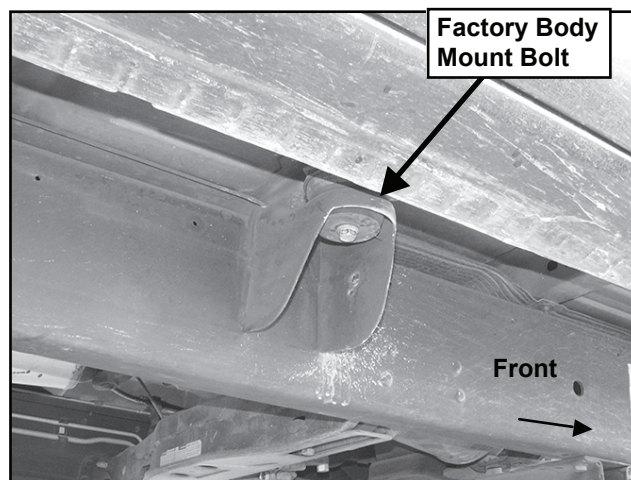
Start the installation under the passenger/right side of the vehicle and remove the long front, center and rear body mount bolts, (Figures 1 & 2). Do not remove bushings.



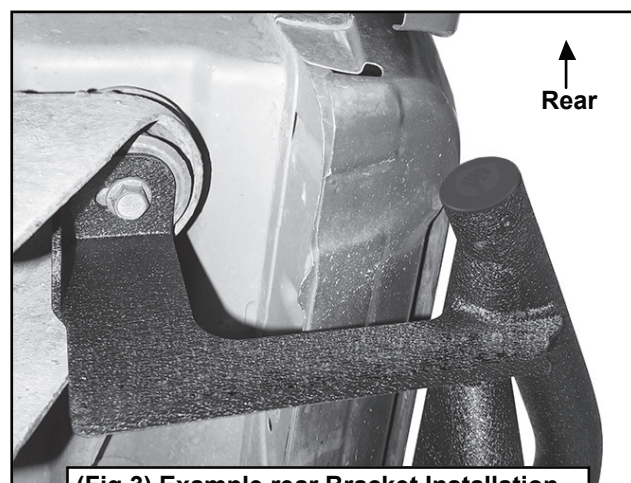
(Fig 1) Passenger/right front body mount

STEP 2

Carefully unpack the Side Armor and select the passenger side assembly. With assistance, hold the Side Armor up in place against the bottom of the body mounts. Reuse the factory body bolts to attach the Side Armor to the body mounts, (Figure 3). Do not tighten hardware at this time.



(Fig 2) Passenger/right center body mount



(Fig 3) Example rear Bracket Installation

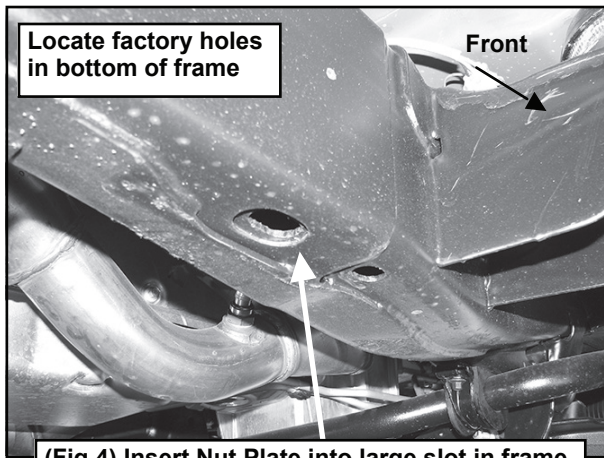


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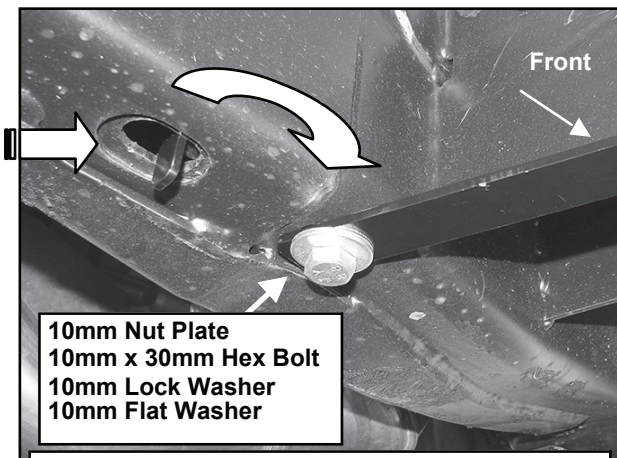
STEP 3

IMPORTANT: 2011-16 25-3500 models, skip to Step 8, front and center Support Brackets are not required. All other models, continue to Step 3.

Move to the passenger side front mounting location. Locate the two factory holes in the bottom of the frame towards the front of the vehicle, (Figure 4). Insert (1) 10mm Nut Plate into the oval hole and line up the threaded nut with the forward round hole, (Figure 5).



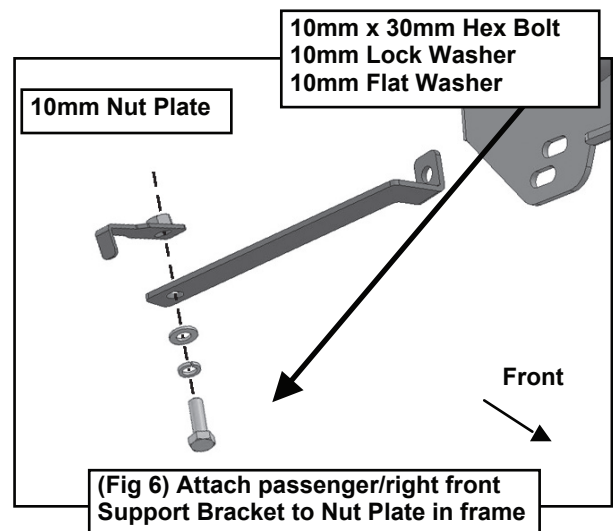
(Fig 4) Insert Nut Plate into large slot in frame



(Fig 5) Line up Nut Plate with small hole in frame

STEP 4

Select the passenger side front Support Bracket, (Figure 6). Attach the flat end of the Support Bracket to the Nut Plate with (1) 10mm x 30mm Hex Bolt, (1) 10mm Lock Washer and (1) 10mm Flat Washer, (Figure 5 & 6). Do not tighten hardware at this time.



STEP 5

Determine the next procedure for your model and year.

All 1500 Models:

Attach the bent end of the Front Support Bracket to the top hole in the Front Mounting Bracket with (1) 10mm x 30mm Hex Bolt, (2) 10mm Flat Washers, (1) 10mm Lock Washer and (1) 10mm Hex Nut, (Figure 7). Do not tighten at this time.

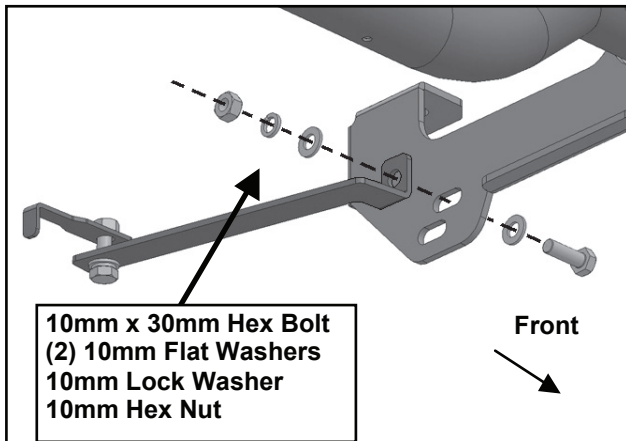
Up to 2010 25-3500 Models only (IMPORTANT: front and center Support Brackets are not required on 2011-16 25-3500 Models-skip to Step 8):

Note that the Front Support Bracket will not reach up to the lower slot in the Mounting Bracket, (Figure 8). Tighten the

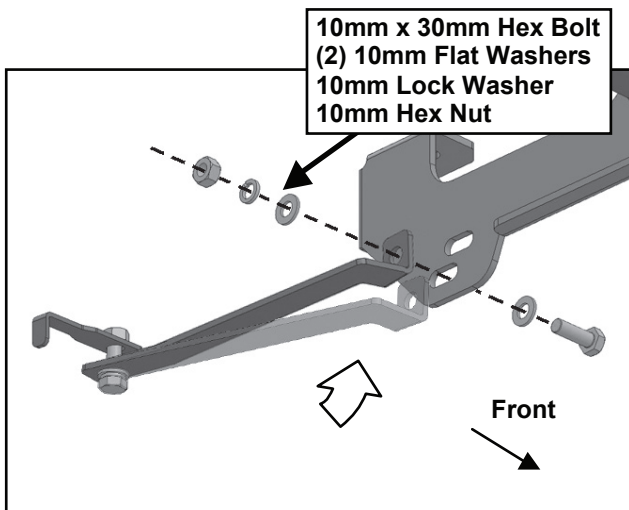


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Support Bracket to the Nut Plate in the frame. Carefully push up on the Support Bracket until it reaches the lower slot, (Figures 8 & 9). Attach the Support Bracket to the back of the Mounting Bracket with (1) 10mm x 30mm Hex Bolt, (2) 10mm Flat Washers, (1) 10mm Lock Washer and (1) 10mm Hex Nut, (Figure 9). Do not tighten at this time.



(Fig 7) Example 1500 front Support Bracket Install



(Fig 8) Example 25-3500 front Support Bracket Installation. Push Bracket up to meet slot

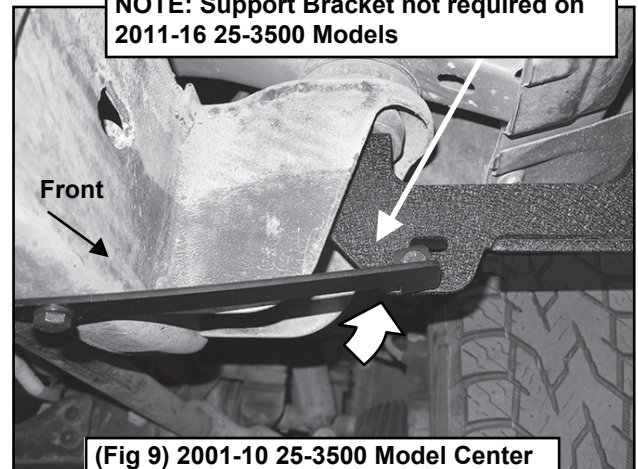
NOTE: Support Brackets not required on 2011-16 25-3500 Models

STEP 6

Move to the Center Mounting Bracket. Select (1) Center Support Bracket-note the two different sizes of mounting holes in the Bracket, (Figure 10). Slide the end of the Center Support Bracket with the larger mounting hole between the factory body mount and the Center Mounting Bracket, (Figure 11). Attach the Support Bracket to the factory hole or slot in the body mount using the included (1) 12mm x 30mm Hex Bolt, (2) 12mm Flat Washers, (1) 12mm Lock Washer and (1) 12mm Hex Nut, (Figures 10 & 11). **IMPORTANT:** There are multiple slots in the Bracket to allow for several models/years of vehicles. Choose a mounting point for the Support Bracket that cannot come in contact with brake cables or wiring. Do not tighten hardware at this time. **NOTE:** Larger hole on the Center Support Bracket attaches to inside of center body mount, (Figure 11).

IMPORTANT NOTE: 25-3500 Model Front Support Bracket Installation Pictured Bend Support Bracket up by hand to meet the Front Mounting Bracket.

NOTE: Support Bracket not required on 2011-16 25-3500 Models



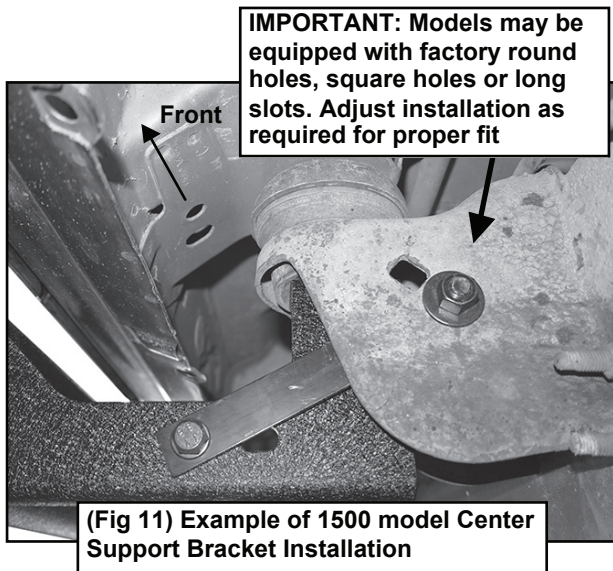
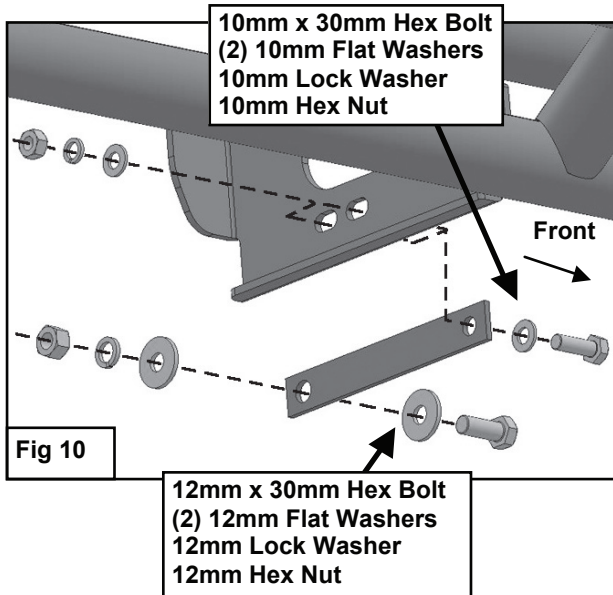
(Fig 9) 2001-10 25-3500 Model Center Support Bracket Installation Pictured



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STEP 7

Attach the opposite end of the Support Bracket to either slot in the Center Bracket with (1) 10mm x 30mm Hex Bolt, (2) 10mm Flat Washers, (1) 10mm Lock Washer and (1) 10mm Hex Nut, (Figure 10 & 11). Do not tighten at this time.



STEP 8

Level and adjust the Side Armor and tighten all hardware.

STEP 9

Repeat Steps 2-8 for driver Side Armor installation.

STEP 10

Do periodic inspections to the installation to make sure that all hardware is secure and tight.

