Work Instruction: Install Front Stinger Bar

ROXOR Stinger Bar Kit (P/N 2302AUA00131N)

**WORK INSTRUCTION OVERVIEW**

**WARNING**

- **DO NOT ATTEMPT THIS PROCEDURE IF YOU DO NOT HAVE PROPER TOOLS, TRAINING, AND FACILITIES.**
- Never consider using a two-post lift that is not certified according to ANSI/ALI ALCTV-2011 or ANSI/UL 201. (autolift.org)
- Read and follow all instructions provided when installing this product. Failure to do so may result in placing occupants at risk of serious injury or death.
- To protect bystanders and the service technician(s), shut vehicle off, remove the Ignition Key and secure vehicle to prevent unintended movement.
- Never operate the vehicle in excess of manufacturer’s specifications.

**TOOLS REQUIRED**

- #27 Torx Bit
- 15 mm Socket
- 16 mm Socket
- 16 mm Box Wrench
- 18 mm Open End Wrench
- Ratchet / Socket Driver
- Torque Wrench (N•m)
- Protective Eye-wear

**TORQUE SPECIFICATION**

Tighten each fastener to the torque specification below:

- **Front Bumper Bolts** – 45 N•m (±5 N•m)
- **Stinger Plate thru Frame Bolts** – 100 N•m (±10 N•m)

**STINGER BAR KIT**

Kit Number - 2302AUA00131N

<table>
<thead>
<tr>
<th>Kit Component</th>
<th>Description</th>
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<tr>
<td><img src="image" alt="Stinger Bar Assembly" /></td>
<td>PN# - 2302AUA00051N</td>
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<tr>
<td><img src="image" alt="Heavy Duty Front Bumper" /></td>
<td>PN# - 2302AUA00021N</td>
<td>1</td>
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<td><img src="image" alt="Hex Bolt - M10 x 30" /></td>
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<td><img src="image" alt="Nylon Lock Nut - M12" /></td>
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**INSTALLATION PROCEDURE**

1. Remove (4) Front Bumper Cover screws with a #27 Torx bit, then lift off cover and remove (4) threaded rubber bushings.

2. Remove (4) stock Front Bumper bolts with a 15 mm socket.

3. Install the (2) rear bolts first, with (2) lock nuts. Use a 16 mm socket and the 18 mm open end wrench and torque to specifications.
4. Maintain alignment of both front mounting holes while torquing rear fasteners.

5. Install the (2) front bolts, with (2) lock washers and (2) nuts and torque to specifications.

6. Install Heavy Duty Front Bumper by hand starting (2) M10 bumper bolts.

7. Finish securing the Heavy Duty Front Bumper with (6) additional M10 bumper bolts, torque to specifications using a 15 mm socket.

8. Installation complete.