



FITTING INSTRUCTIONS

Part Number: **4140138**

Product Description: **SUPPLEMENTARY BRACE KIT | 22+ RAPTOR CANOPY INSTALL**

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AUSTRALIA 3137

PARTS LISTING

PART NO.	QTY	DESCRIPTION
180302	4	CABLE TIE BLACK
3195597R/L	1R 1L	PLATE NUT SUITS J BRACE
4584310	2	WASHER FLAT M6x25x2.8 ZNB480
4584424	4	WASHER FLAT M6x18x3 BTZP480
5848531	2	PACKER UPRIGHT J BRACE
5848532	2	PACKER HORIZONTAL J BRACE
6151859	2	SCREW M6x16mm TORX PAN ZNB 480
6151965	4	BOLT HXHD FL M10x1.5x30 ZNB480
665003	4	RIVET POP 3/16 DIA 1.5 DOME x1"
W715694	8	TRIM PIN 6.5-6.8 SCRIVET PLA 2.5-7
W720803	4	TRIM PIN 6.5-6.8 SCRIVET PLA 2.5-7
4681796R/L	1R 1L	J BRACE SUITS RAPTOR

TOOLS REQUIRED

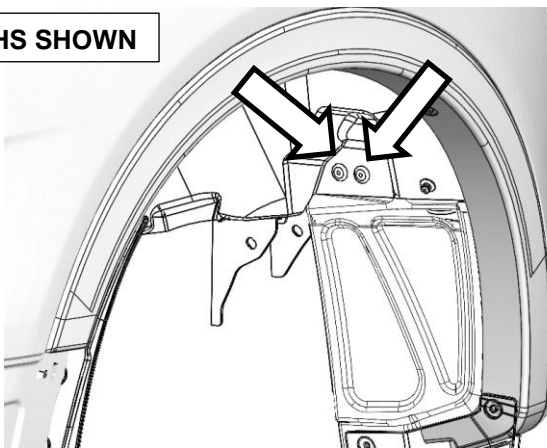
STUBBY PHILLIPS HEAD SCREWDRIVER
PISTOL DRILL
HAMMER
Ø3mm PIN PUNCH
Ø6.5mm DRILL BIT
TORQUE WRENCH
SOCKET SET
RIVET GUN

FITTING PROCEDURE

1. Raise vehicle on hoist and remove rear wheels.

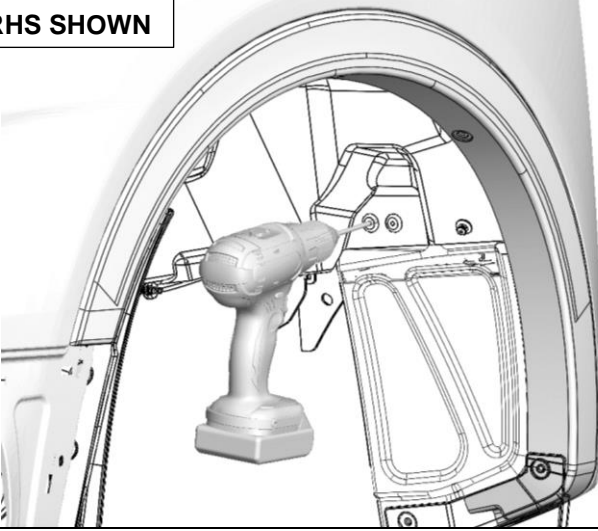
NOTE - Fitment can be performed on ground level if a hoist is unavailable.

RHS SHOWN



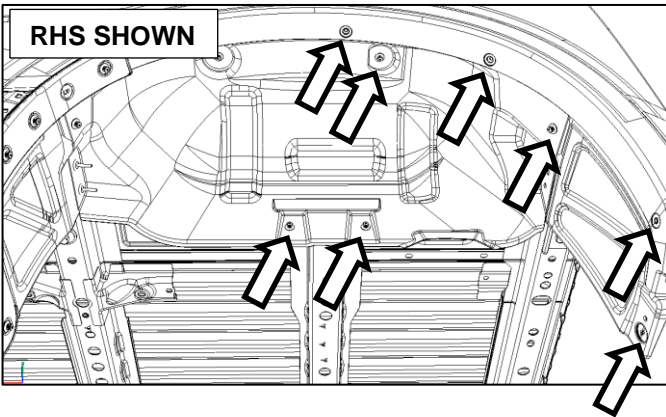
2. Punch out the cores of both black rivets located in the front of both rear wheel arches, using a Ø3mm pin punch & hammer.

RHS SHOWN



3. Drill out the remainder of the rivets with a $\text{\O}6.5\text{mm}$ drill bit.

RHS SHOWN

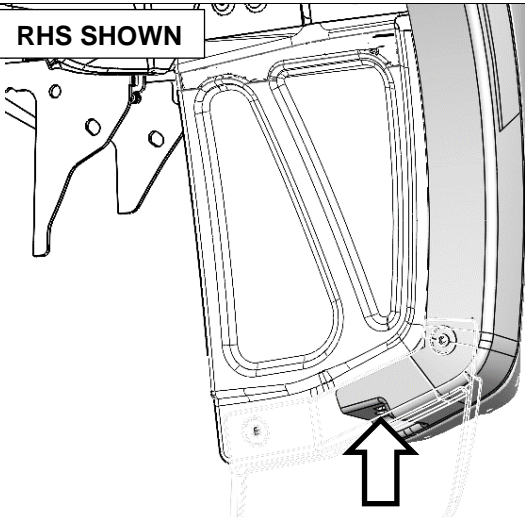


4. Remove 8 screws from the front half of each wheel arch liner by undoing the middle screw.



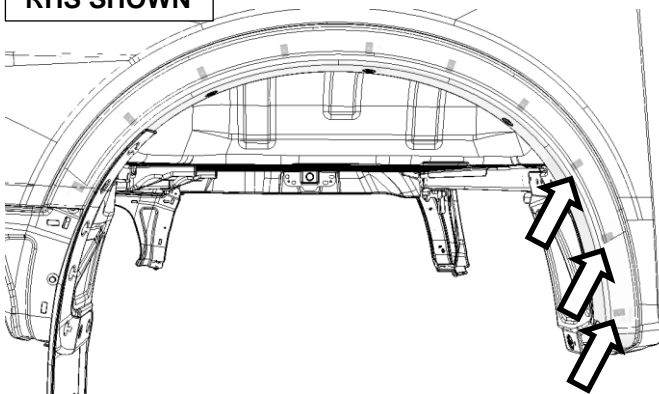
Some screws may be damaged on removal, some replacements have been provided.

RHS SHOWN



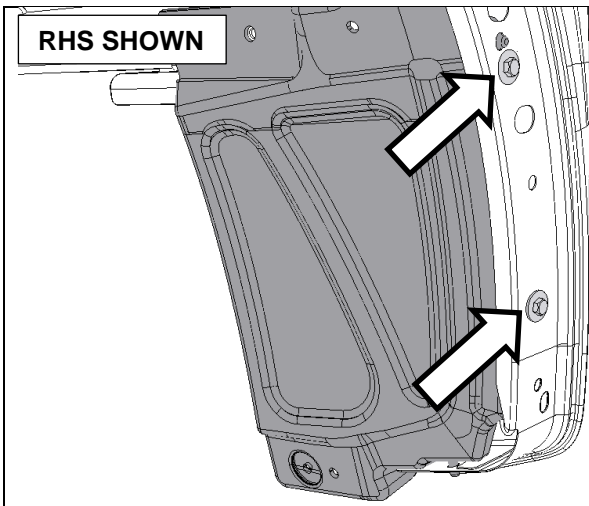
5. Remove the M6 fastener from the lower wheel arch moulding.

RHS SHOWN

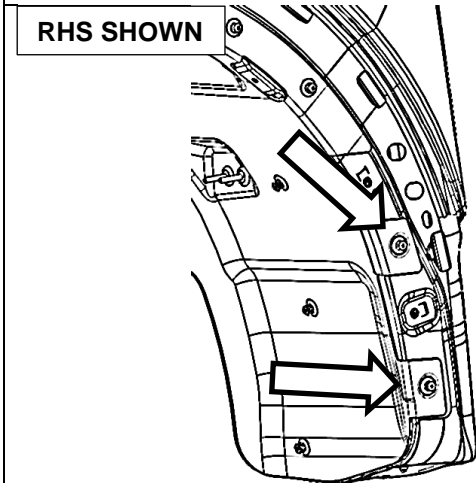


6. Carefully peel the front of the wheel arch flare back far enough to access the two M6 fasteners behind. Clip positions shown.

Some clips may be damaged during disassembly, some replacements have been provided.



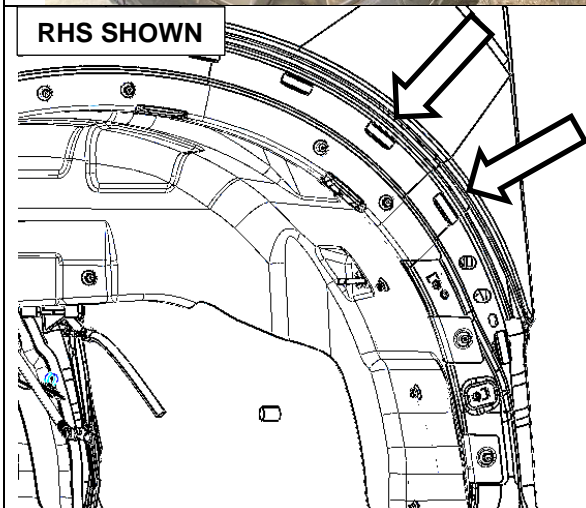
7. Remove M6 bolts and wheel arch mouldings from both sides.



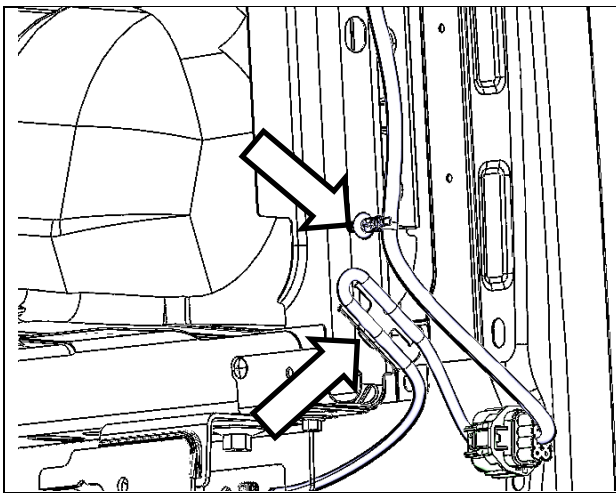
8. Use a stubby screwdriver and trim tool to remove the 2 scrivets holding wheel arch liner.



9. Peel back wheel arch liner.

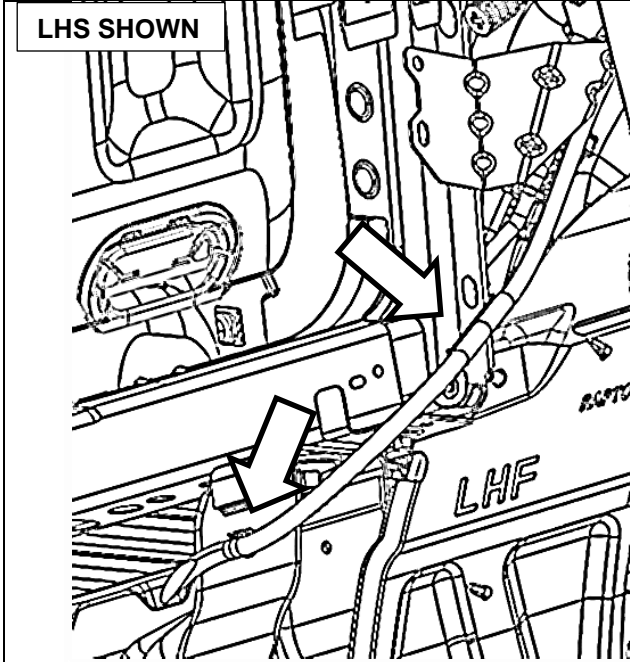


10. With the wheel arch liner removed, clips holding on wheel arch flare can be removed from the inside of the wheel well if necessary.



11. RHS Only.

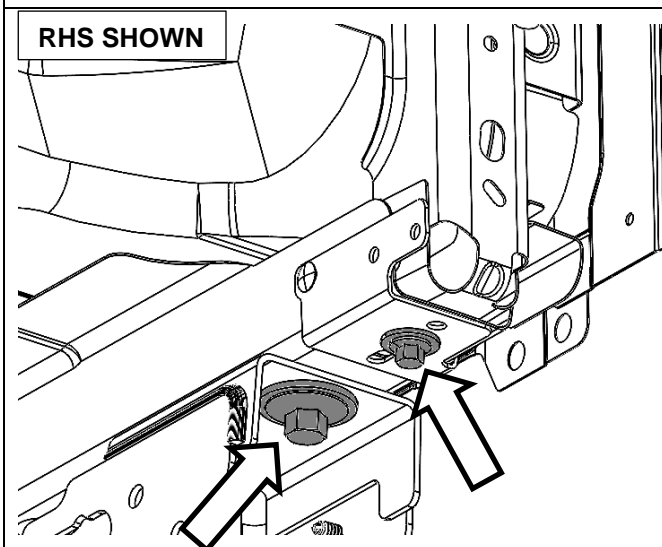
If present, unclip wiring harness retainers in both places shown.



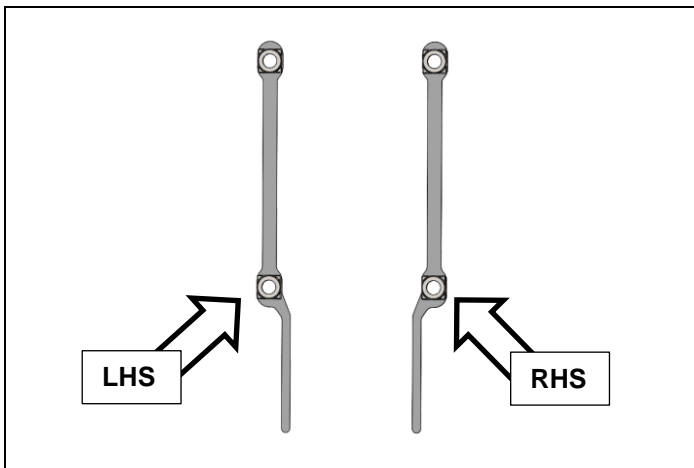
LHS Only.

12. Unclip wiring harness retainers in both places shown.

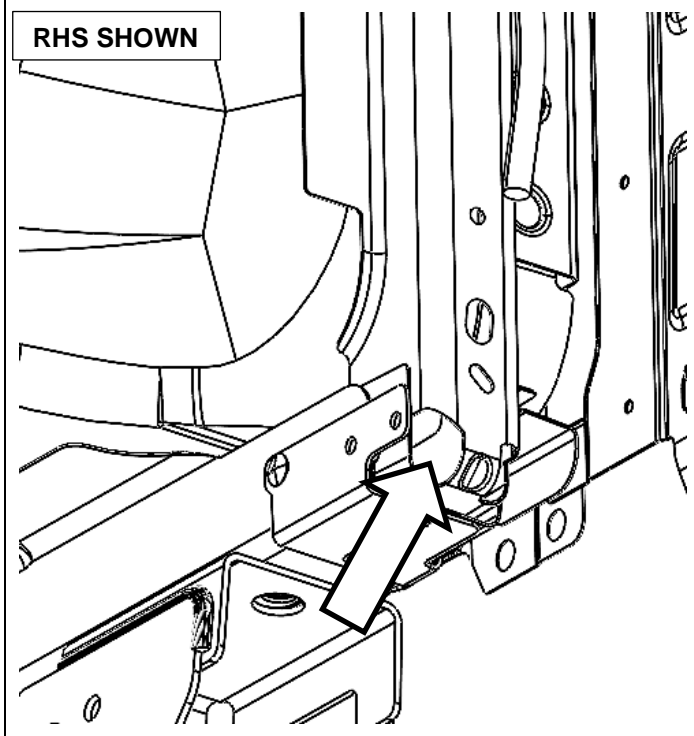
Steps 13 through to 22 are to be completed on both sides of the vehicle. Images depict RHS.



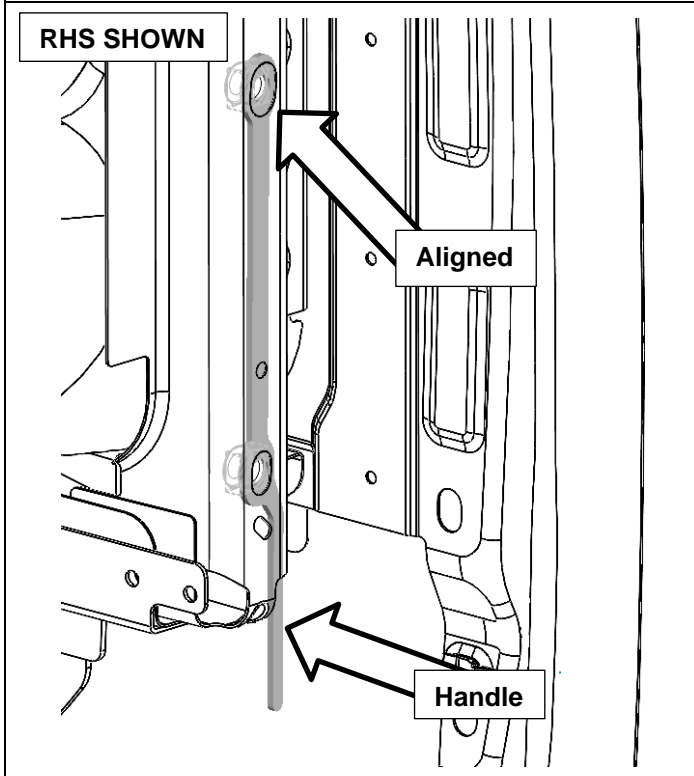
13. Remove M12 & M8 bolts from each side.



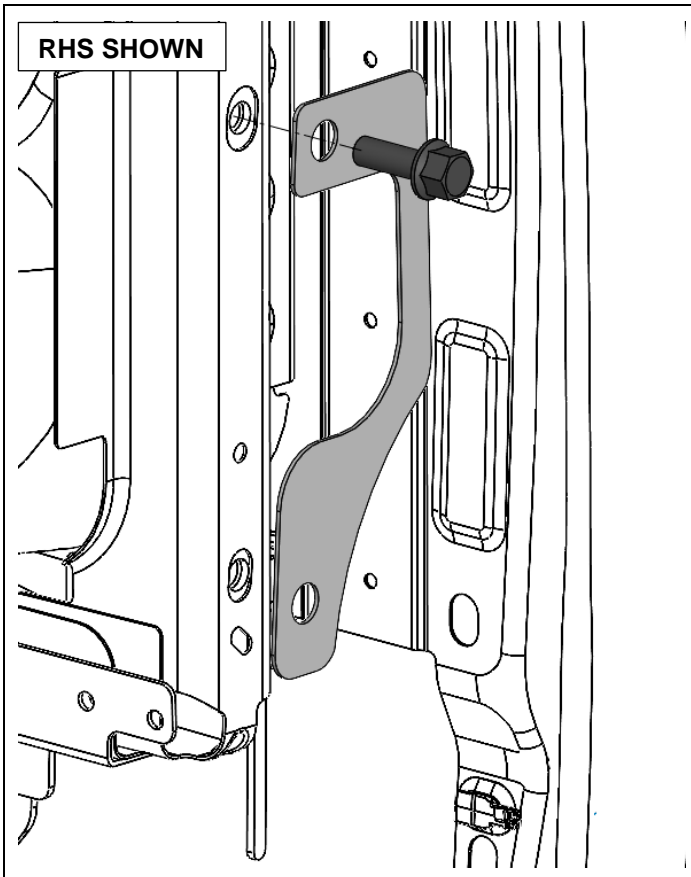
14. Identify the correct nut plate for each side of the vehicle.



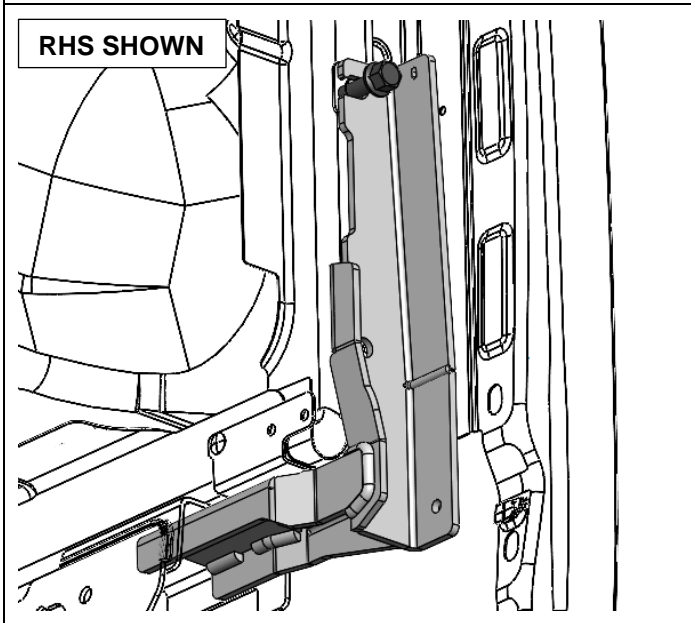
15. Feed the correct nut plate for each side into the vertical channel of the tub through the aperture shown.



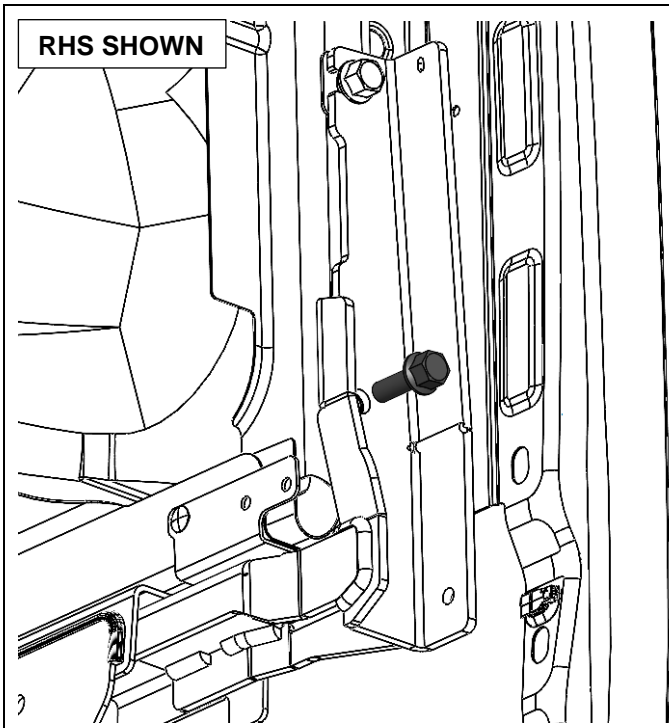
16. Position the nut plate inside the channel so that the nuts are aligned with the slots in the channel and the handle is protruding out the opposite aperture to the one mentioned in step 15.



17. Loosely assemble an M10 Flange bolt through the vertical packing plate and into the top nut on the nut stick.

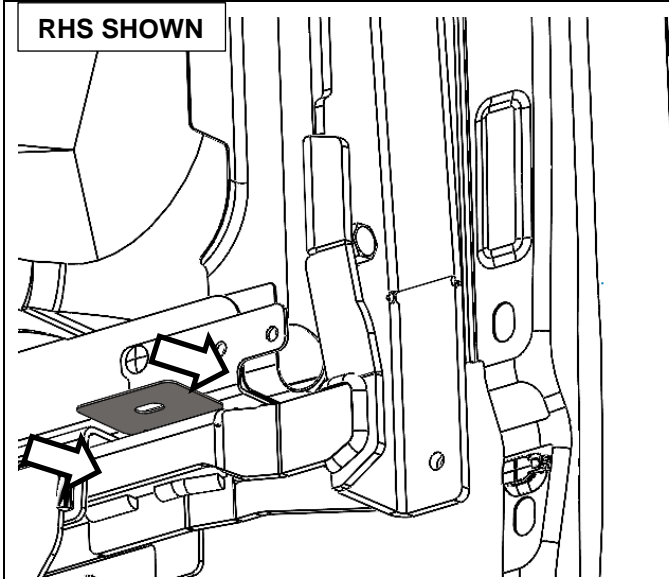


18. Hang J brace from the top bolt fitted in previous step.



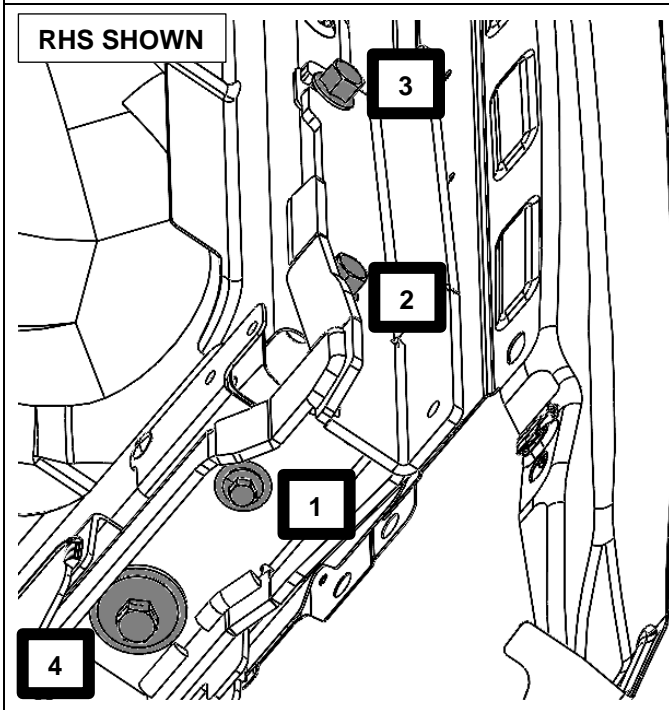
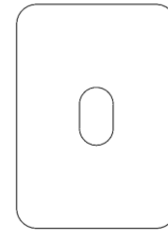
RHS SHOWN

19. Loosely assemble second M10 Flange Bolt.



RHS SHOWN


20. Slide the horizontal packing plate in between the J brace and the tub and align with the M8 thread in the tub.





RHS SHOWN

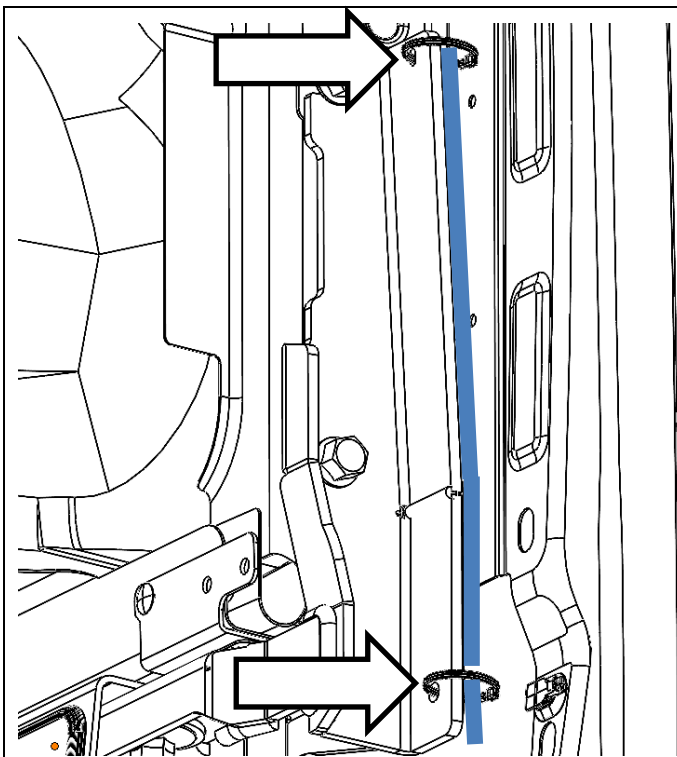
21. Refit original M12 & M8 Bolts removed in step 13.

22. Torque all bolts to specification in order shown.

 M8 - 25 Nm.

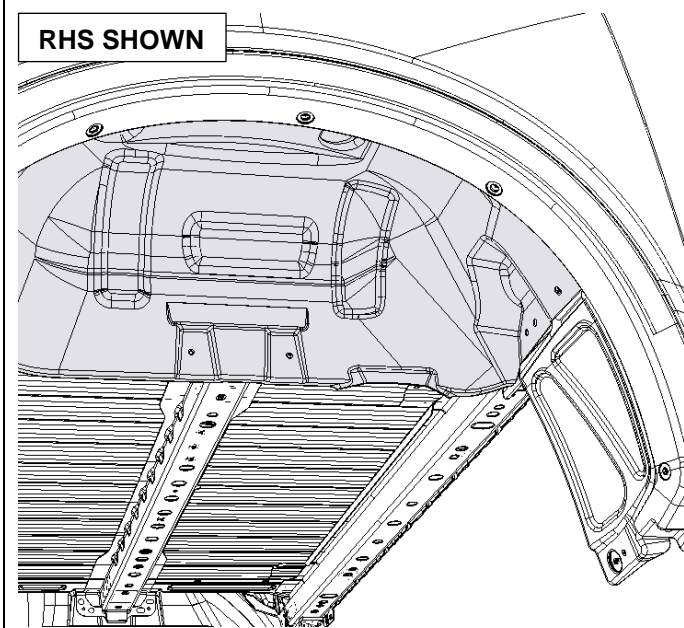
 M10 - 44 Nm.

 M12 - 125 Nm.

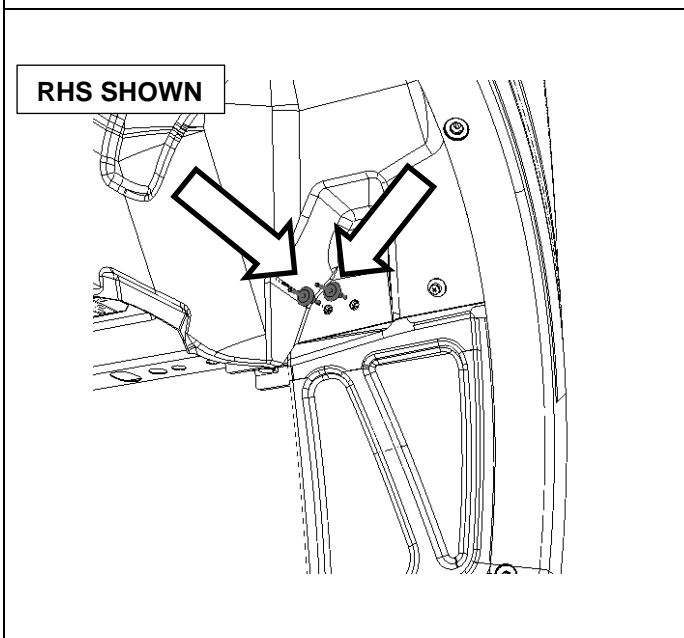
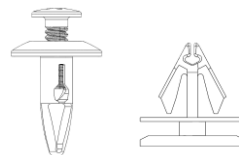


23. On the RHS only, secure wiring harness to the outside face of the J brace using the cable ties supplied.

NOTE – Wiring not present on all models.



24. Reassemble wheel arch liner, flare and mouldings following steps 4-10 in reverse order. Replace any damaged clips or scrivets.



25. Install new rivets with M6x18x3 Flat washer under the head of the rivet.

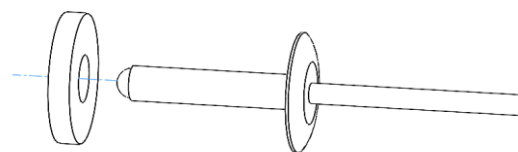
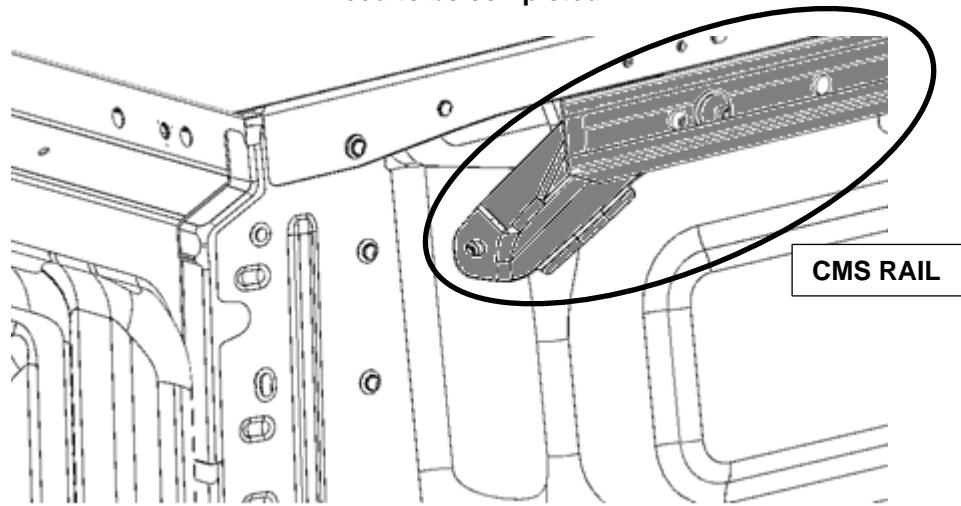
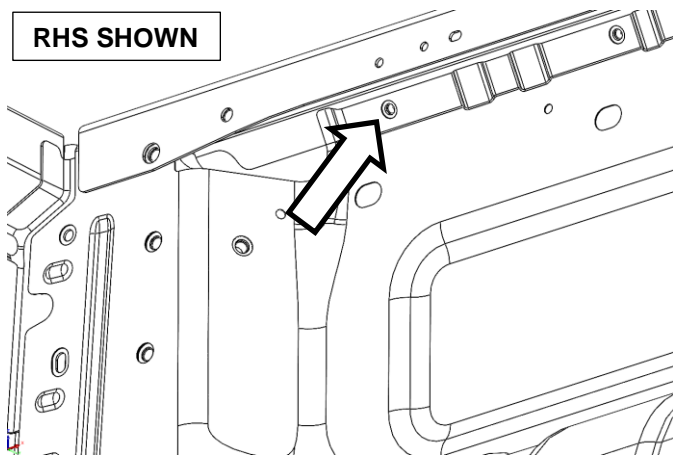


Image depicts CMS rail fitted in RH front corner of tub.
When **NO** Cargo Management System accessory side rails are fitted to the vehicle's tub steps 26 & 27 need to be completed.



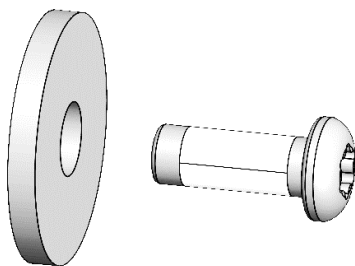
RHS SHOWN




26. Locate the captive nut in each front corner of the tub.

27. Assemble one M6x16 Pan Head Screw and 25mm OD Washer into the captive nut identified in the previous step. Repeat on opposite side.

Torque to specification.



 M6 - 9 Nm.