



INSTALLATION INSTRUCTIONS
STILLEM GM REAR ROLL PAN KIT
2000-1 Ford F-150 SuperCrew Roll Pan
P/N: KA4929

Materials supplied:

1. 1 ea. REAR ROLL PAN
2. 8 ea. #8 SELF-DRILL & TAP SCREWS

Equipment needed:

1. Double-sided tape
2. 3M Automotive Adhesion Promoter 06396
3. #80 grit sand paper
4. Assorted clamps



WARNING:

**IF YOU ARE NOT EXPERIENCED IN THE
AREA OF BODY REPAIR WE STRONGLY
URGE THAT YOU REFER THIS
INSTALLATION TO YOUR BODY SHOP.**

**NOTES ABOUT INSTALLATION, CLEANING, AND
PAINTING**

1. Pre-fit all pieces to the vehicle. Once you are assured that you have the right aero kit you may proceed. If you don't please call *Stillem* right away. We highly recommend using masking tape anywhere the aero kit pieces may be touching the vehicle body to prevent scratches during the pre-fit.
2. Do any sanding, filing, or spacing necessary (before painting) for a clean tight fit. Spending the extra time now will assure you of a perfect "factory" installation.
3. After the pieces have been painted make sure that the areas where double-sided tape is applied do not have over spray. The surface should be urethane (black) and nothing else.
4. On all the *Stillem* roll pan kits the preferred procedures are:
 - ❖ Pre-fit, sand, and shape.
 - ❖ Paint
 - ❖ Install



PAINTING URETHANE

Urethane components require a special cleaning and painting procedure to obtain a proper finish. Once the urethane components have been properly pre-fitted **CLEAN AND SCRUB THEM!** Using plenty of hot water, plenty of scouring powder (like AJAX® or COMET®) and a #7447 Scotch Brite® pad. Scrub each piece thoroughly until there are no shiny spots. Scrub all surfaces especially the backside top sections that will be against the body. You will be applying double sided tape to this area so **clean and sand it!** The goal is to achieve an even dull finish on all surfaces to be painted. After you've finished scrubbing the parts completely repeat the procedure one more time. If this is not done properly the paint will not stick!

Any automotive primer will provide excellent adhesion to the part if the surface is properly prepared, however, **we do not recommend using lacquer primer on urethane components due to its rigidity.** Elastomeric or acrylic primers can be used but elastomeric primers, due to the flex agent added, are preferred over acrylic primers. Light sanding is recommended after primer has dried and before final color painting.



Installation of kit:

1. Remove the stock bumper and any trailer hitch from the vehicle as shown.
2. Place the new rear roll pan on the vehicle. Use masking tape to hold the roll pan in place.
3. Check the following areas for proper fit.
 - ❖ Corners and edges where the roll pan meets the vehicles rear pan. If you have any embellishment around the roll pan lip it will have to be trimmed for proper fit.
 - ❖ Check the roll pan for any excess material along the top inside edge of its mounting flange, it will have to be trimmed to ensure an even fit.
4. Once satisfied with the gaps and seams use the #8 self drilling & tapping screws as shown in the photo. Do not fully tighten screws for this pre-fitment, tighten at finale painted assembly. Use #8 sheet metal screws on edge of roll pan upper lip to make sure the screws can not be seen. In order to do this you will need to remove the tailgate to install the fasteners.
5. Sand and shape roll pan if needed.
6. Once satisfied with the pre-fitment, remove the all screws and any tape holding the roll pan to the vehicle.
7. Remove the roll pan from vehicle and prepare it for painting, see fist page of instruction on painting urethane.
8. After roll pan has been painted install on to vehicle the same as pre-fitment.
9. Be sure that all gaps and seams stay even through out finale fitment. Ensure that the rear roll pan is installed such that it does not appear to be sagging.



Note: The customer will be responsible for finding an alternative method for lowering the spare tire.



Steve Millen Sportparts, Inc. - 3176 Airway Avenue - Costa Mesa, CA 92626 - Phone. 714-540-5566 - Fax. 714-540-5784 - www.stillen.com