

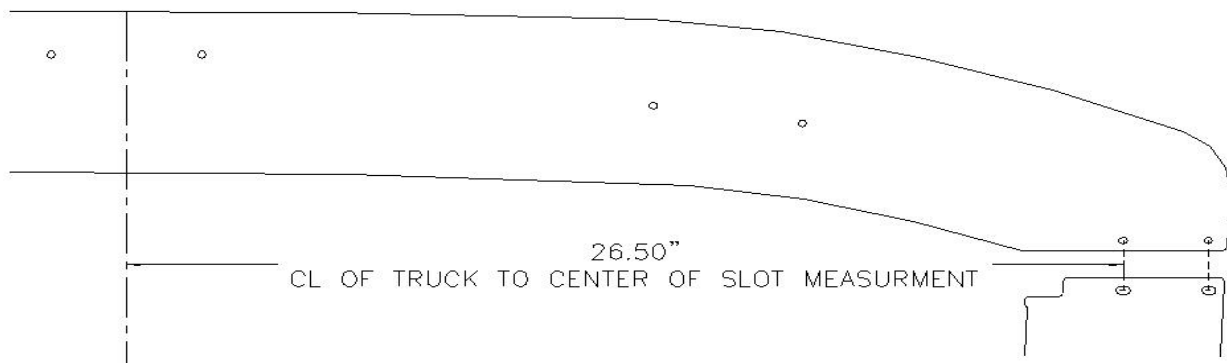
Stainless Steel Accessories

NEW CASCADIA – FRONT GRILLE SURROUND installation instructions

09/02/2021

INSTALLATION TIP: Use pieces of masking tape to mark the outer (Chrome) edge of the OEM Grille on the sides where it contacts the front of the hood prior to removal; this will help ensure proper Surround coverage when installing.

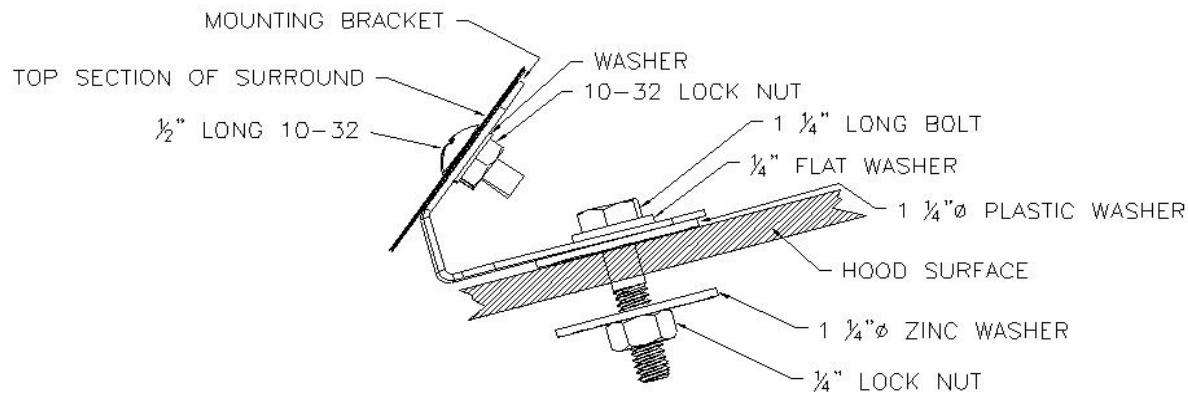
1. Remove OEM Grille from truck - From inside hood remove two nuts on either side, then gently pry/pop off FREIGHTLINER® emblem from front grille, removing two bolts from behind emblem; 3 bolts will also need to be removed from the lower plastic grille and finally a center bolt. The front grille can now be removed. (some effort may be required as it is also clipped in)
2. Attach driver and passenger sides of Surround with ¼” zinc fasteners into holes where grill hardware was removed . Don’t tighten fasteners.
3. Apply Trimguard to bottom edge of Surround top section along the arced section.
4. Loosely attach top section of Surround to sides with ½” long 10-32 hardware. Top section of Surround goes over top of side pieces.
5. Centerline of hood to first hole (horizontally) should measure approximately 26 3/8” – 26 ½”. Doing a visual check to ensure everything looks evenly aligned is advised.



6. When centered; tighten ¼” zinc hardware used to secure sides to the front of the truck ensuring that the sides haven’t dropped down and that the holes in the tabs are evenly centered within the holes from the OEM Grille.



7. Drill top tab locations (7/32") from Surround sides and install 3/4" long 10-32 fasteners.
8. Contour Surround sides to hood of truck while ensuring sides are covering previously placed masking tape. Mark and drill lower tab mounting hole locations 7/32".
9. Remove 1/4" Zinc fasteners and install 3/4" long 10-32 fastener in bottom tab from sides.
10. Remove top section of Surround.
11. Peel plastic from sides where OEM Grille will sit against the Stainless, then re-install OEM Grille and temporarily fasten to hold in place. Two bolts under the FREIGHTLINER® emblem works well.
12. Peel protective plastic from around the holes of the top section and attach outer mounting brackets and center grab handle with 1/2" long 10-32 hardware leaving loose enough for adjustment.



13. Place top section of Surround onto the hood and just above OEM grille. Take note of the holes that join the top to the sides. Some adjustment may be required for alignment!
14. Temporarily fasten top of Surround to the sides and mark hole locations onto the hood ensuring brackets sit nicely on hood surface when doing so.
15. Remove top section and drill mounting hole locations.
16. In some cases the hood may have an empty cavity in behind the Mounting Brackets; this will require the installation of inserts, and will require those hole locations be drilled 27/64". If not all holes can be drilled 9/32" for 1 1/4" long 1/4" hardware. If inserts are used 1" long hardware is used with a flat washer and lock washer.
17. To make installing the fasteners easier for the top section of the surround remove OEM grille and make any adjustments required.



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18. Place top section of Surround onto hood and secure in place leaving fasteners loose enough to allow for final adjustment
19. Peel protective plastic from sides where top section overlaps and install ½” long 10-32 fasteners.
20. Re-install OEM Grille and secure in place with two bolts from in behind FREIGHTLINER® emblem
21. Ensure top section of Surround is sitting properly against OEM grille and tighten Mounting Brackets and Grab Handle fasteners to hood.
22. Tighten ½” long 10-32 hardware to brackets followed by the ends where the top section joins the sides together.
23. Replace lower plastic grille and tighten fasteners that were taken out for OEM Grille removal.
24. Peel remaining protective plastic from Surround and wipe with a soft cloth and glass cleaner if necessary.



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Application Procedures for Pressure-Sensitive Body Side Moldings

Outlined below are the recommended procedures for applying pressure-sensitive body side moldings (BSM).

These procedures address three key points for a successful BSM application.

1. The Body of the vehicle must be clean and dry to achieve the best adhesion.
2. The pressure-sensitive adhesive on the molding must not be contaminated during the application.
3. The molding must be applied to achieve complete contact (bond) of the adhesive to the vehicle. (i.e. Maximum wet-out).

A. INSTALLATION AREA:

1. The installation area should be kept reasonably clean. Any airborne dust, oils, etc. may contaminate the vehicle or BSM adhesive and reduce the bond of the tape.

B. VEHICLE SURFACE PREPARATION:

1. The vehicle surface should be washed with an appropriate solvent, one commonly used system is a 70% mixture of Isopropyl Alcohol and water (Rubbing Alcohol). To assure removal of all contaminants it may be necessary to first wipe with TG Prep, and then use the 70% Isopropyl Alcohol mixture.

- * Use clean lint free wiping cloths or disposable wipes such as Kimwipes.
- * Reprocessed rags should be used as they may contain wax or residue.

2. After washing, the vehicle surface should be thoroughly dried. Again use a clean, dry, lint free cloth.

3. **Vehicle surface application temperatures of 80°F (25°C) to 110°F (44°C) are recommended for best tape adhesion. The warmer surface will help wet-out the adhesive on the tape.**

IMPORTANT NOTE:

During cold weather applications the vehicle surface can be heated with a heat gun or heat lamps, but donot heat the surface of the molding with a heat gun. Application of the BSM at temperatures below 64°F (17°C) or above 110°F (44°C) must be avoided.

C. BODY SIDE MOLDING PREPARATION:

1. The **BSM** should be stored at room temperature in a clean dry area. Cold temperatures require heating to warm the molding to the proper application temperature (i.e. Floor heater or Defroster of vehicle). There is no damage to the tape or molding stored at colder temperatures, but moisture and condensation must be avoided.
2. The molding should be heated up to 80°F (25°C) for application. This will soften the molding, making it easier to conform to the vehicle contours, as well as improve adhesive wet-out.
3. The liner on the adhesive should not be removed until application to the vehicle. This will help prevent contamination of the adhesive surface.



D. BODY SIDE MOLDING APPLICATION:

1. Align the molding with a key feature such as the front and rear bumpers or with a body line to ensure proper molding alignment. Placing ½" masking tape along the desired installation area is an excellent guide for applying the molding straight.
2. Use molding cutters to trim the molding at door jams and body seams. Chrome moldings must be cut with the blade of the cutter coming down on the surface of the chrome finish (Seal all cut ends of chrome moldings with TG End Seal). Be certain to leave enough room for the door to open properly after the molding has been installed. (Bevel cut if necessary).
3. Remove the liner from the tape as you are applying the molding to the vehicle. Be careful not to contaminate the adhesive. Common sources of contamination are: oil from the applicator hands, dust or lint from clothing, work tables, or the floor. Do not touch the adhesive at any time. **Contaminated moldings should not be used.**
4. Apply the moldings with a rolling motion to prevent entrapment of air between the tape and the vehicle surface. Use firm hand pressure to ensure good adhesion of the molding.
5. A roll down with a hard rubber hand roller (TG Roller) is necessary to assure complete wet-out of the adhesive to the vehicle surface. Apply firm pressure while rolling the molding to properly wet-out the adhesive.
6. Check the edges of the molding to assure good tape adhesion. Re-roll with more pressure as necessary to achieve a good bond. Use the blunt end of the roller or screwdriver to press out all molding ends to ensure adhesive bond.



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