Retrofitting New Latch System

Introduction

This document will help you change your latch and replace it with the new latching system. As follows are the included parts, tools required and instructions for removing the old latch and installing the new one.

Retrofit Bumper Latch Kit

- **1 X Drill Guiding Template**
- **1 X Cam Lock Assembly**
- **1 X Mirror Cam Lock Assembly**
- **4 X Cam Bushings**
- **2 X Set Collar**
- **2 X Knob**
- **2 X (Spring #S -1588)**
- **2 X (3/8" Stover Nut GR. C , Plated)**
- **2 X (Hex Cap Bolt – 3/8" NC X 4 ½" GR. 5, Plated)**

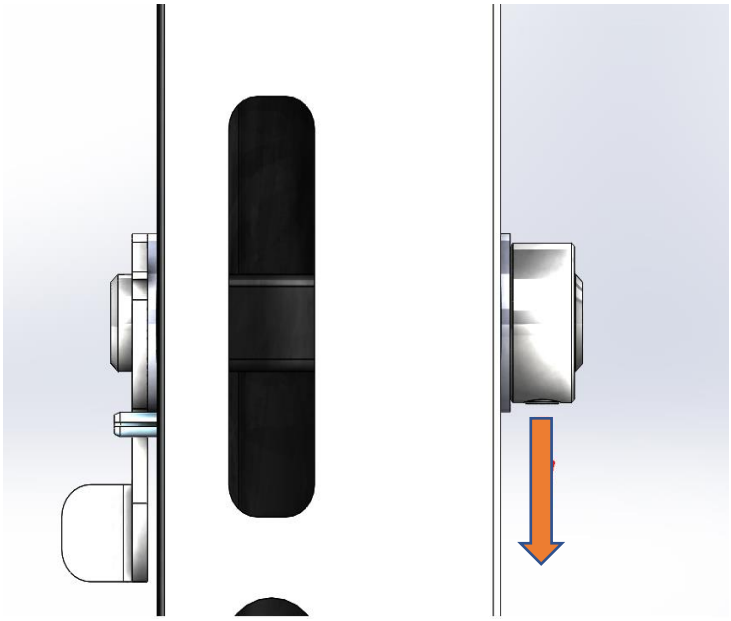
Tools Required

- **1 X Drill**
- **1 X ¼" Drill Bit**
- **1 X 3/8" Drill Bit**
- **1 X Center Punch**
- **1 X Hammer**
- **2 X 9/16" Wrench (or equivalent socket and crescent wrench)**
- **1 X 5/32" Allen Key**
- **1 X Pliers**

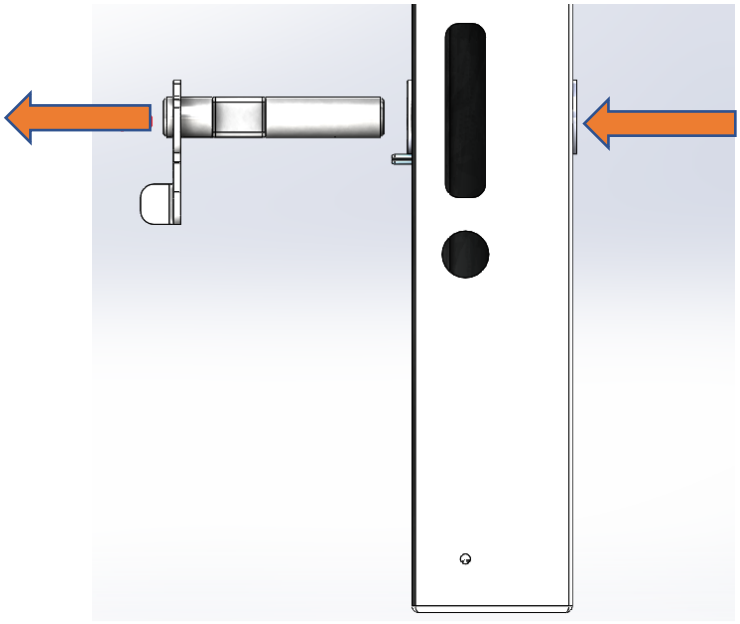
Instructions

The process given in the following instructions is for the replacement of the latching system on the driver's side. The same instructions can be followed for the passenger side but with the addition of using the **Mirror Cam Lock Assembly** instead of the **Cam Lock Assembly.**

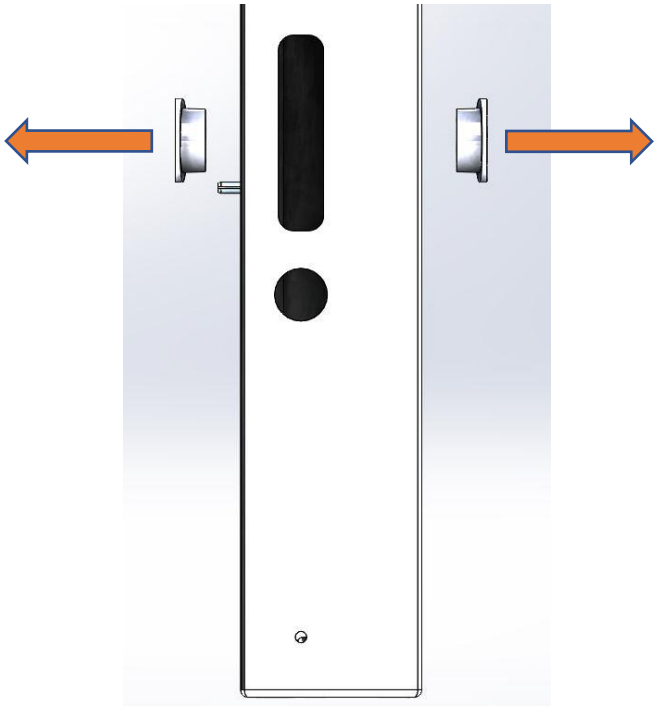
1. Loosen the set screw on the **Set Collar** using an Allen Key.



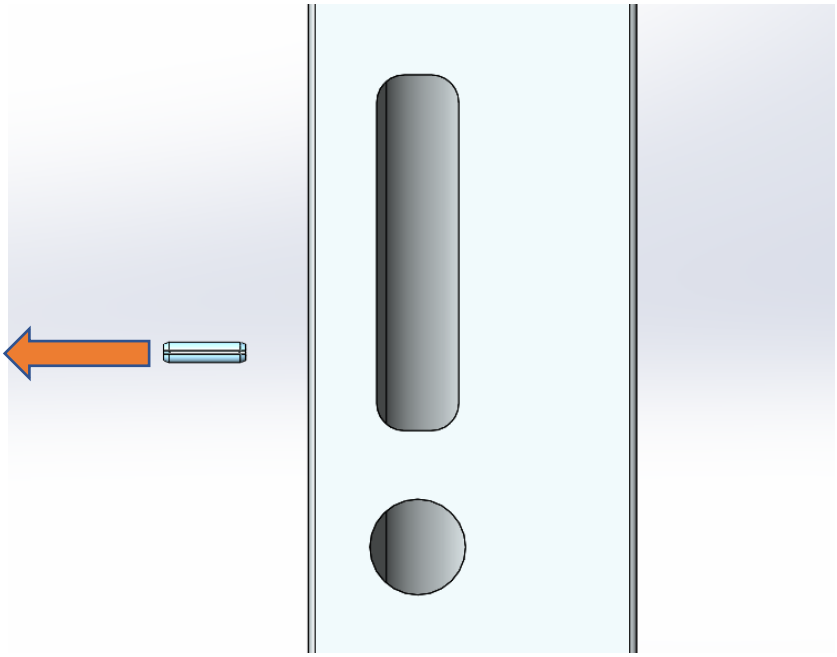
2. Remove the old **Cam Locking Assembly** by pulling the cam handle away from vertical beam.



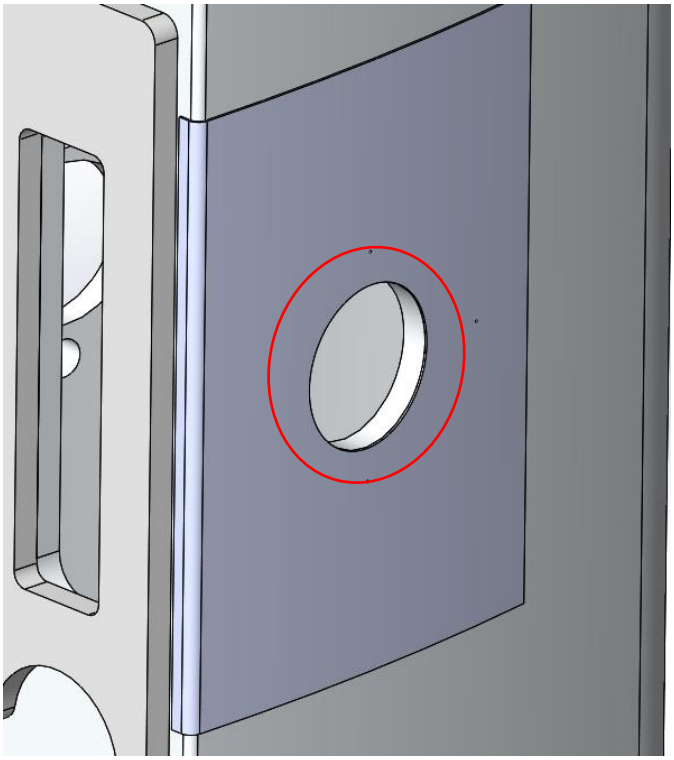
3. Remove both **Cam Bushings** on either side of vertical beam by pinching the ends and pulling them away from the vertical beam. **NOTE:** If your bumper includes double sided tape underneath these bushings remove it and clean the affected area.



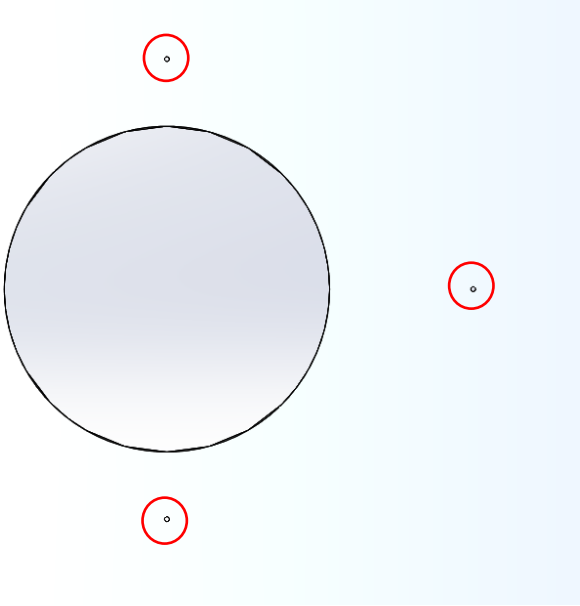
4. Remove the **Roll Pin** with a pair of pliers



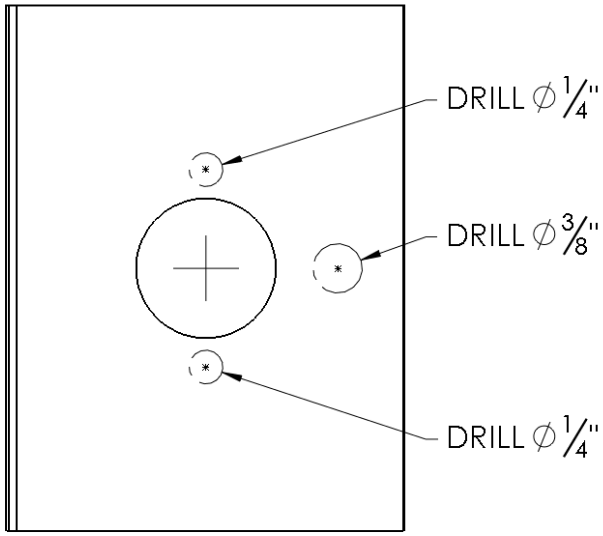
5. Place the **Drawing Template** on the vertical beam so that lip of template rests against the back side of the beam. Align the hole in the template with the hole in the beam.
   NOTE: The template will need to be bent in order to create the lip found in the image below.



6. Mark out the locations for drilling by taking a center punch and placing it on the points outlined by the template. Hammer the center punch through the template to make an indentation in the aluminum. Additionally, a felt pen can be used to mark the locations of the holes and then by removing the template you can proceed to center punch the marked locations.

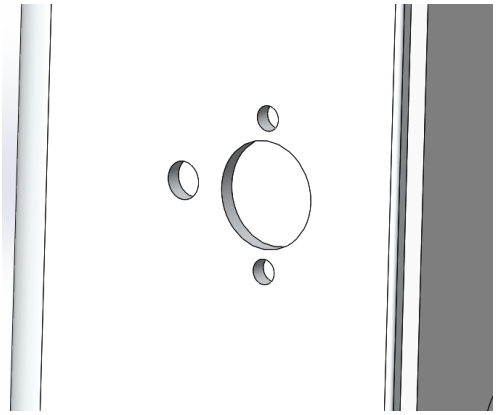


7. Remove the template and proceed to drill out the holes using the appropriate drill bit as shown in the figure below. **NOTE:** Keep in mind that the original hole left from the roll pin will still be present on one of the two sides of the vertical beam.

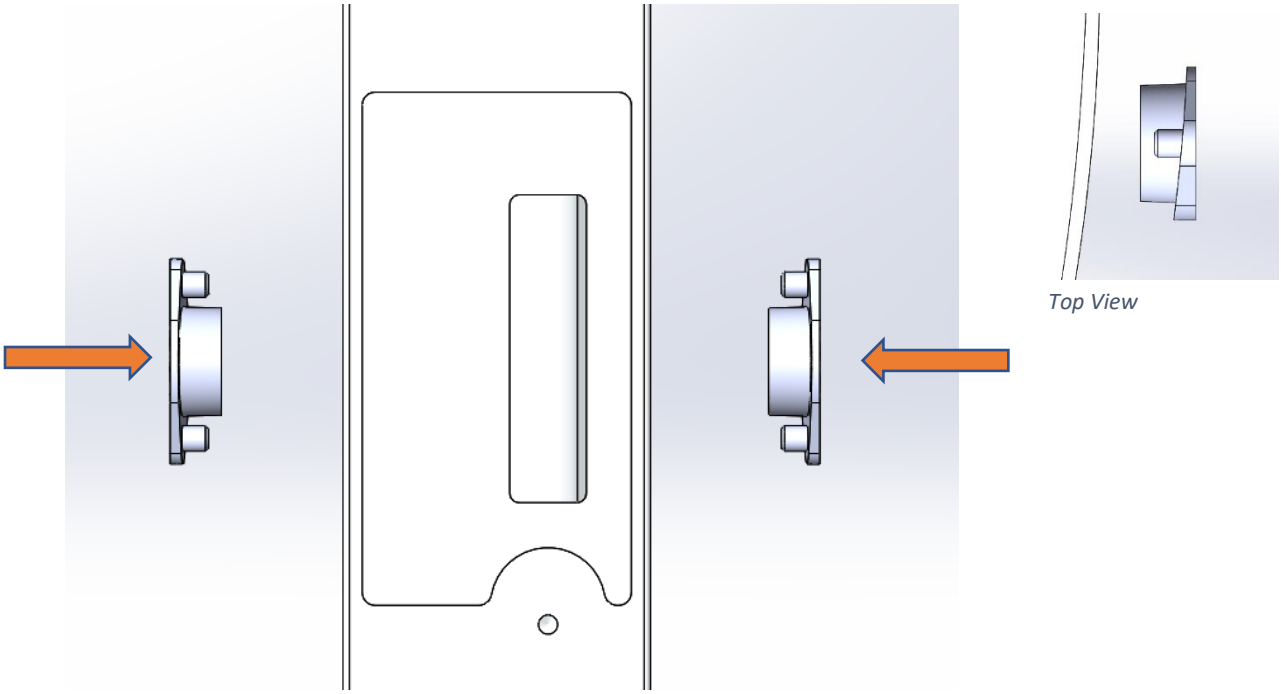


Repeat Steps 5-7 with the opposite side of the vertical beam.

After drilling your beam should look like the figures below.

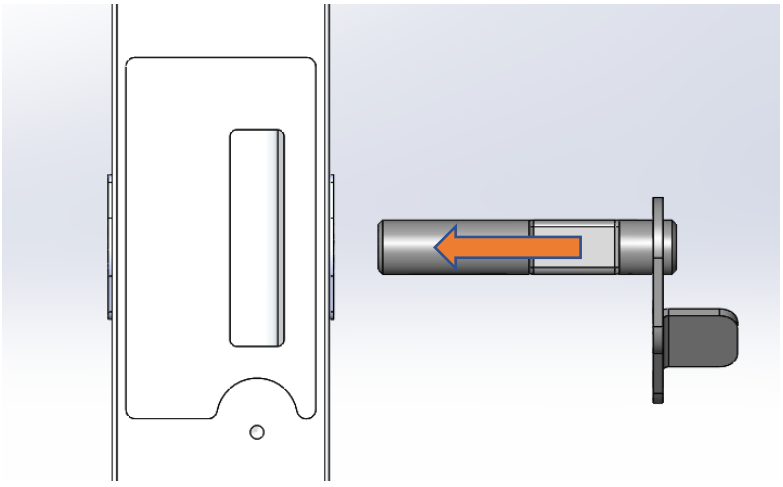


8. Insert new **Cam Bushings** into the vertical beam so that the contour of the bushing is flush with the contour of the beam. The pins on the bushings fit into the two ¼" holes that where drilled. **NOTE: Remove any burrs and clean the surface before inserting the bushings.**

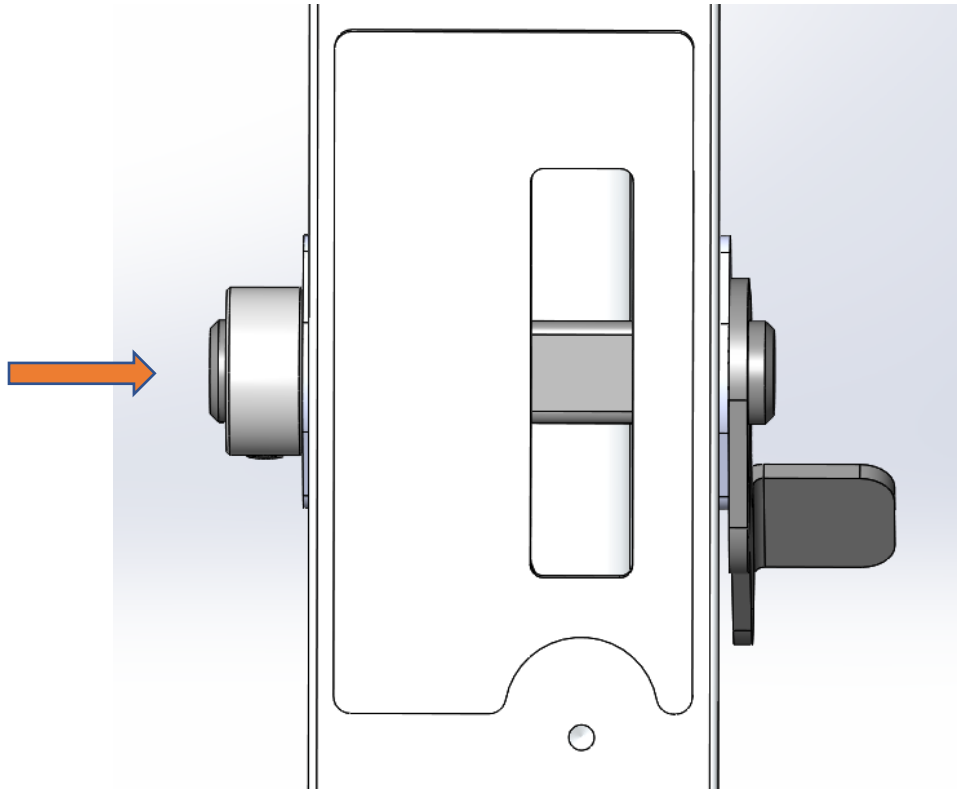


Top View

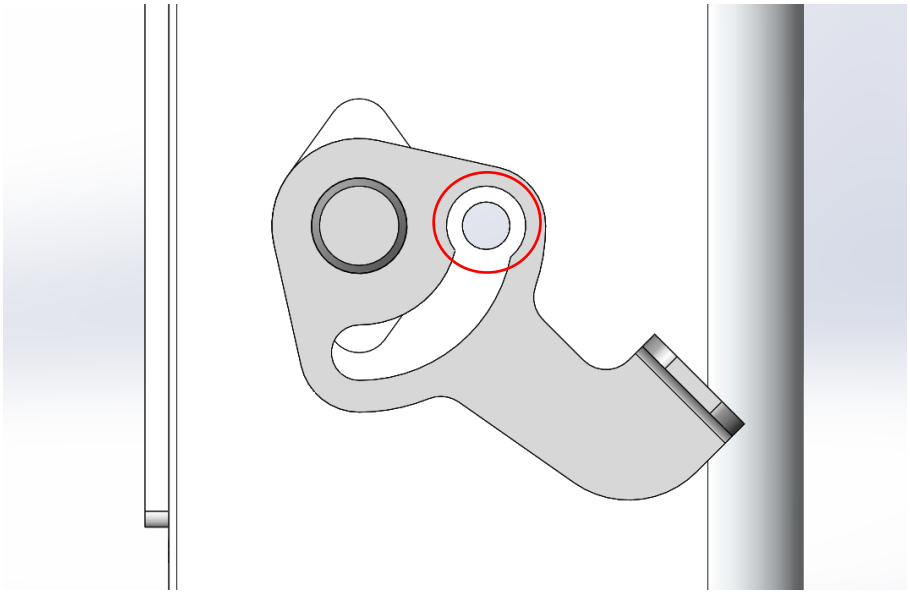
9. Insert the **Cam Lock Assembly** on the inside of the beam by pushing it through the bushing. Push until it is flush with the inside bushing.



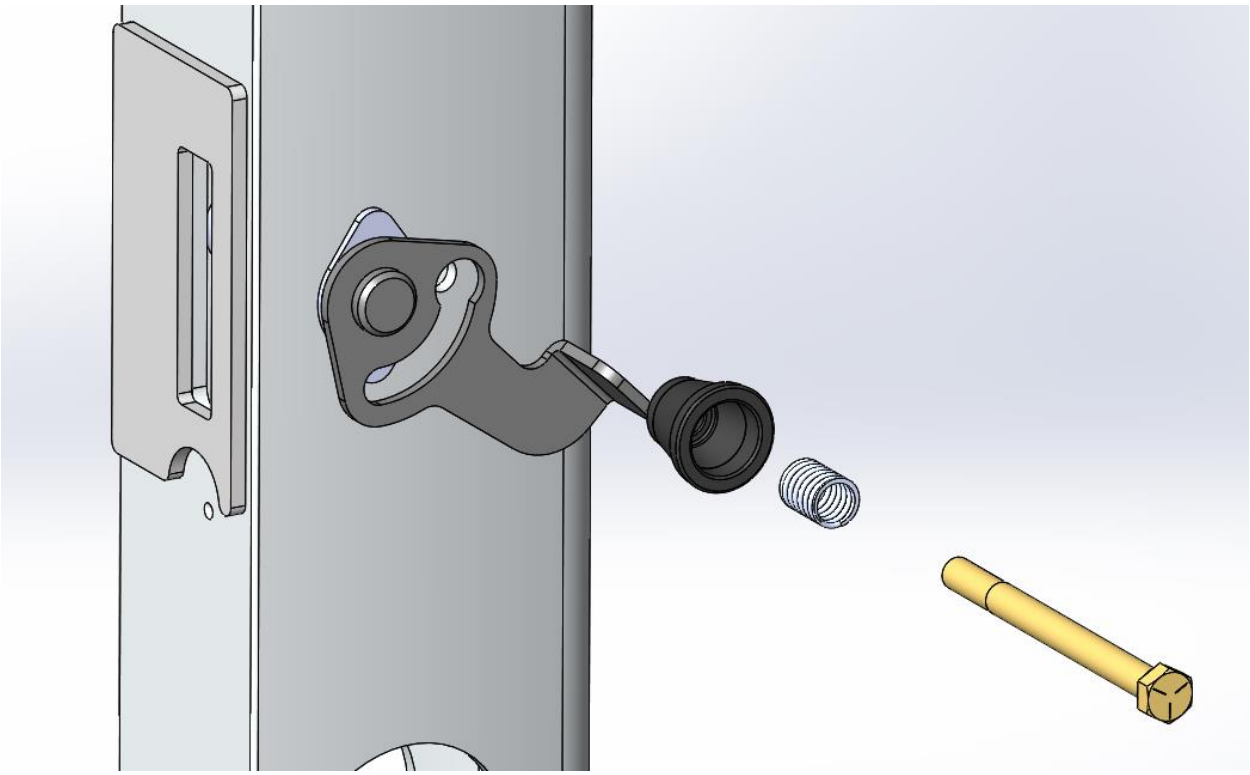
10. Place the **Set Collar** on the opposite side of the beam overtop the bottom of the **Cam Lock Assembly**. Tighten the set screw with an Allen key so that the **Cam Lock Assembly** can not be pulled out of the beam.



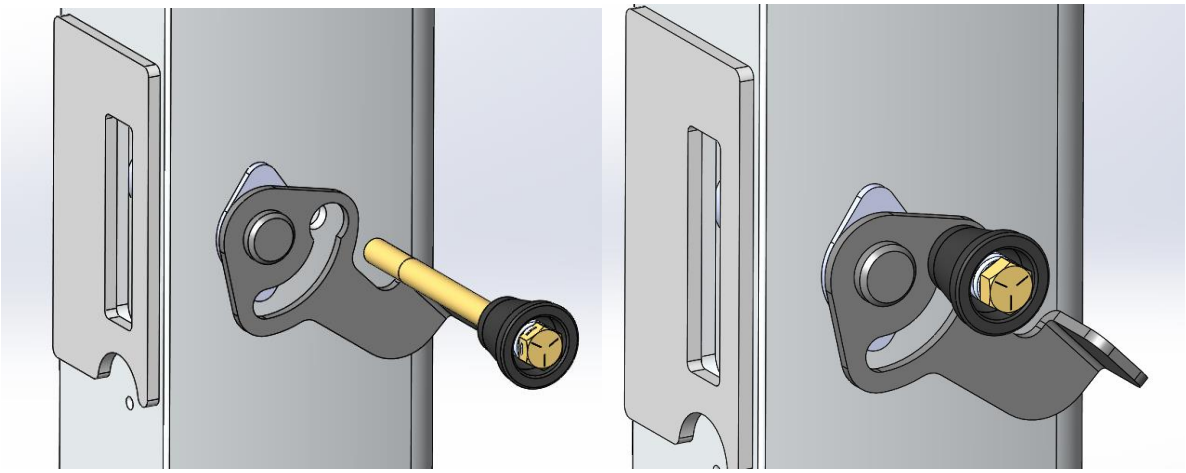
11. Align the 3/8” hole with the cut out in the handle of the **Cam Lock Assembly** as seen in the figure below.



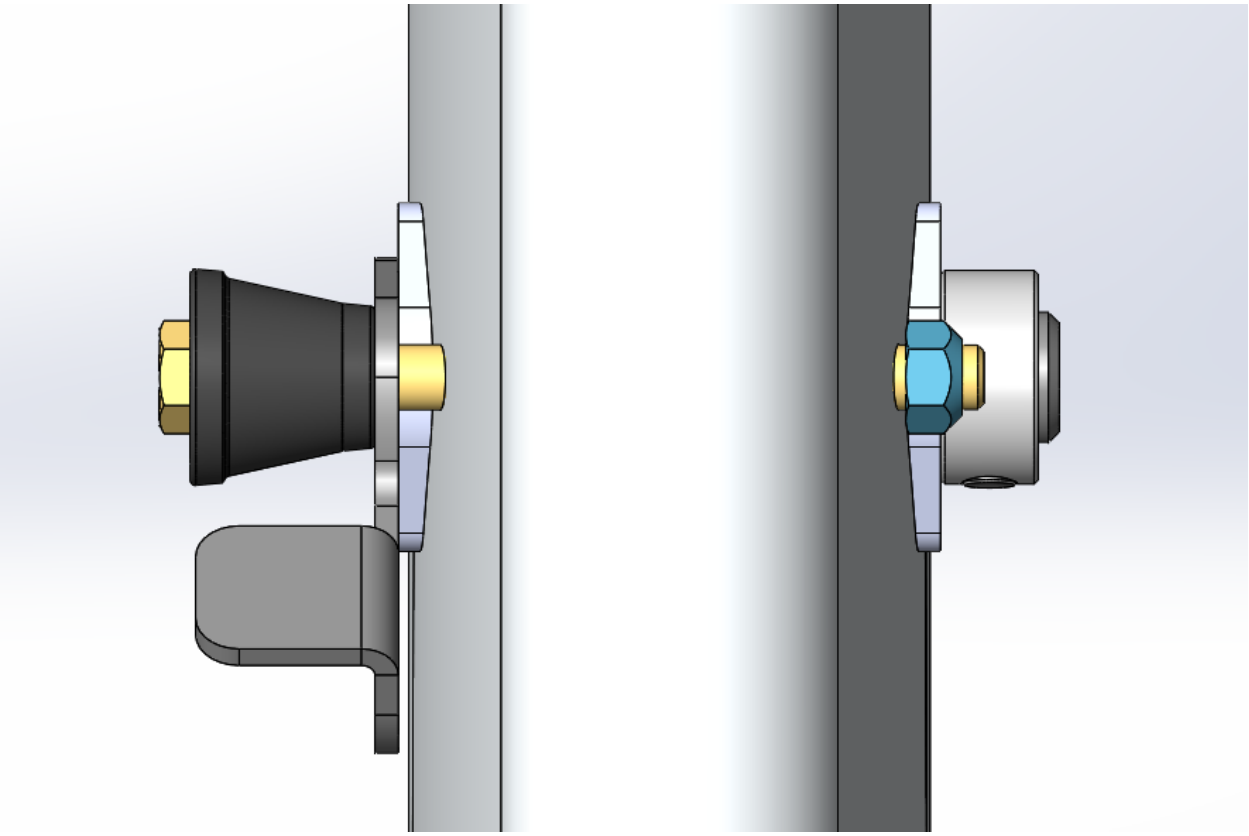
12. Next take a **Knob**, **Spring** and **Bolt** and arrange them in the order shown in the figure below. Place the spring on the bolt and push both through the knob until the spring rests on the inside of the knob.



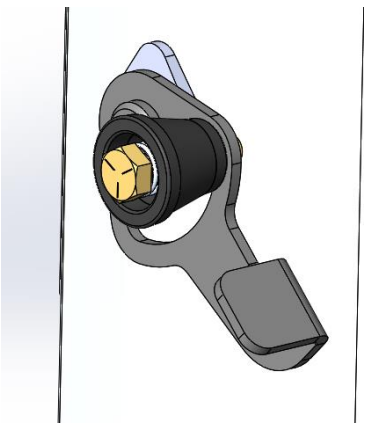
13. Insert the assembled components through the handle and the 3/8” hole until the knob sits in the cut out of the handle.

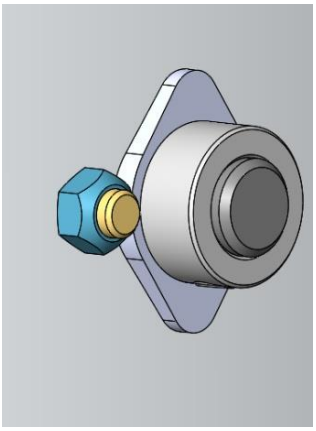


14. Screw a **Stover Nut** onto the bolt using a 9/16" wrench. To properly tighten the nut, use an additional 9/16" wrench and place it on the hex head of the bolt. Hold the bolt fixed and continue to tighten the nut until adequately tightened.



The finished assembly should look like the picture below.





Repeat steps 1 – 14 for the passenger side latch with the use of the Mirror Cam Locking Assembly. All other parts are identical to the driver's side.