

## 2020 INV-FF-ELETRAY-ISUV-20 Installation instructions



Remove foam from rear of vehicle, It is not needed and not required by Ford. The spare tire however must remain for the rear crash rating.

Find the rear side bolts that attach the cross member to the vehicle floor.

To make installation easier you may cut out the plastics as shown.



Slide the side mount all the way to the outside of the vehicle as shown. Tighten factory bolts. Do this for both sides mounts are universal. You want to make sure that the mount is all the way outboard as this allows the frame to stay square when attached.



**Locate factory hole behind rear crossmember support it will be covered by black tape.**

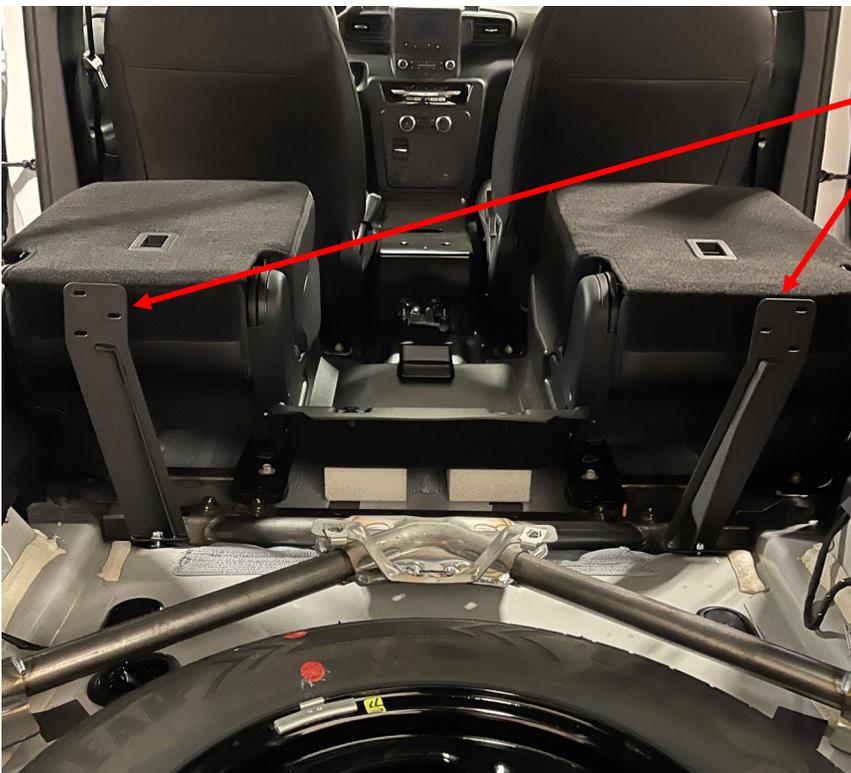


**Using an impact tool and the self tapping bolt (supplied) thread the factory hole.**

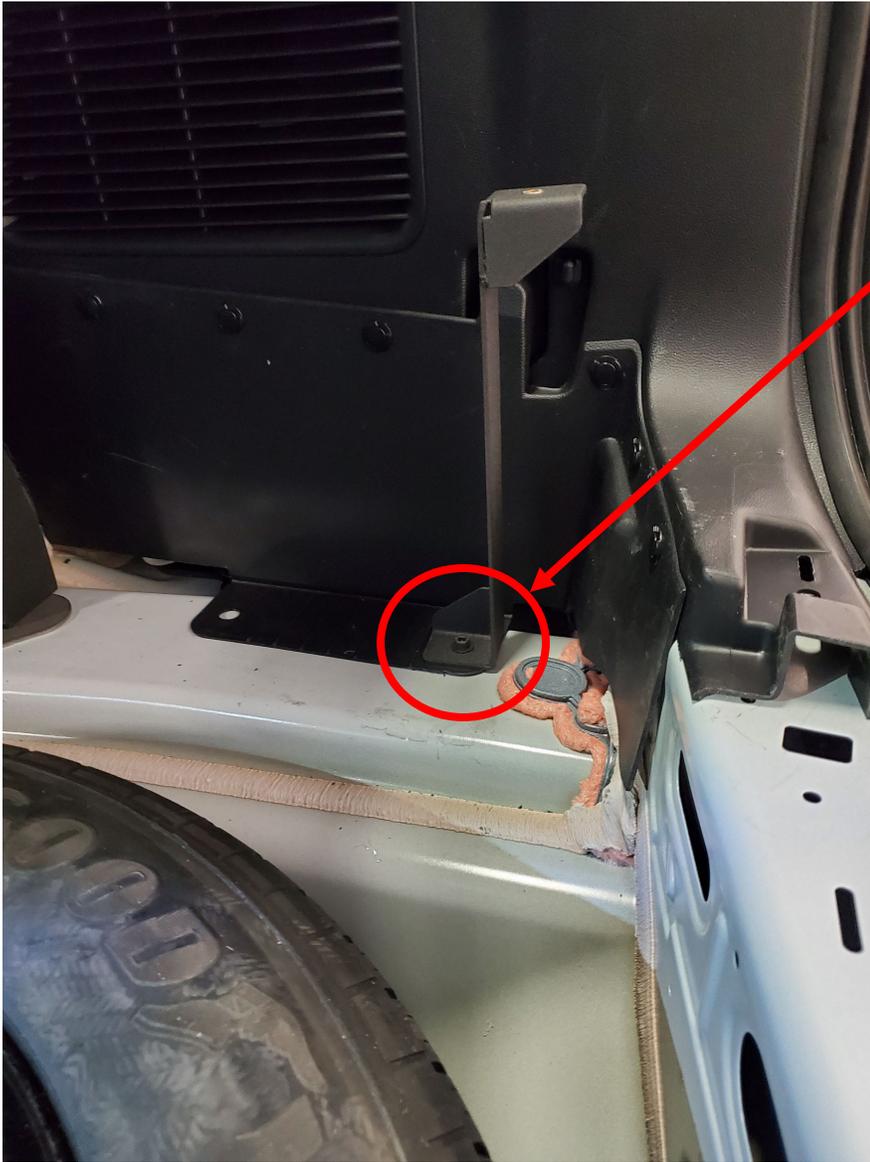




**Remove installed bolt, re-install through supplied bracket. Leave loose until installation of frame. Once frame is installed tighten these bolts.**

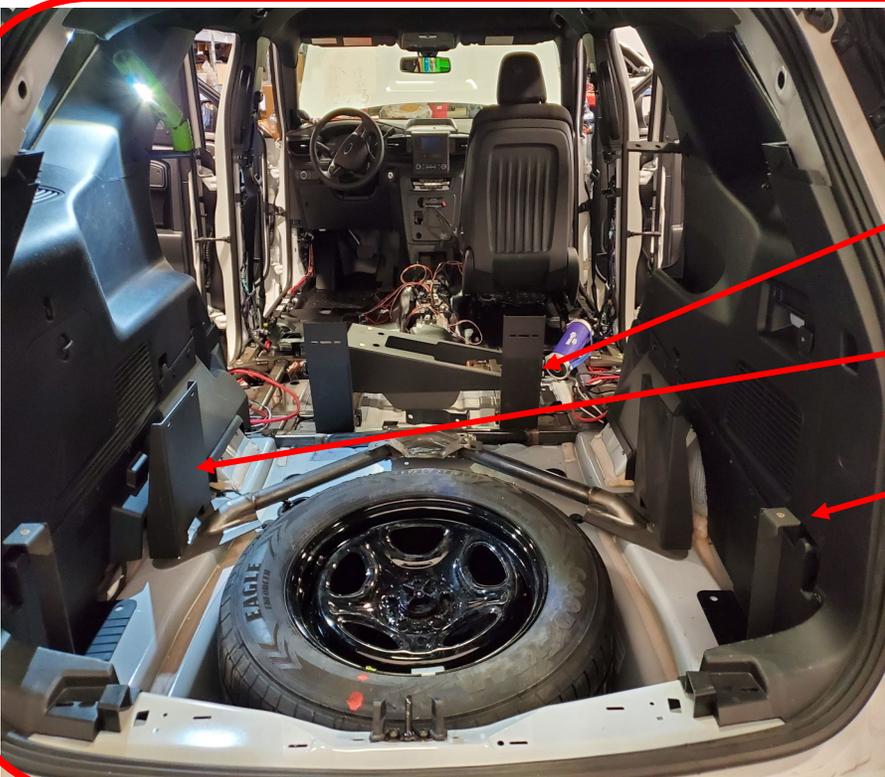


**Install both left and right front brackets as shown**



Locate threaded hole in the rear of the vehicle as shown.

Install rear wing support mounts with supplied M6x14 screws (2), noting locations of the gussets. (bottom towards the outside top towards the inside)



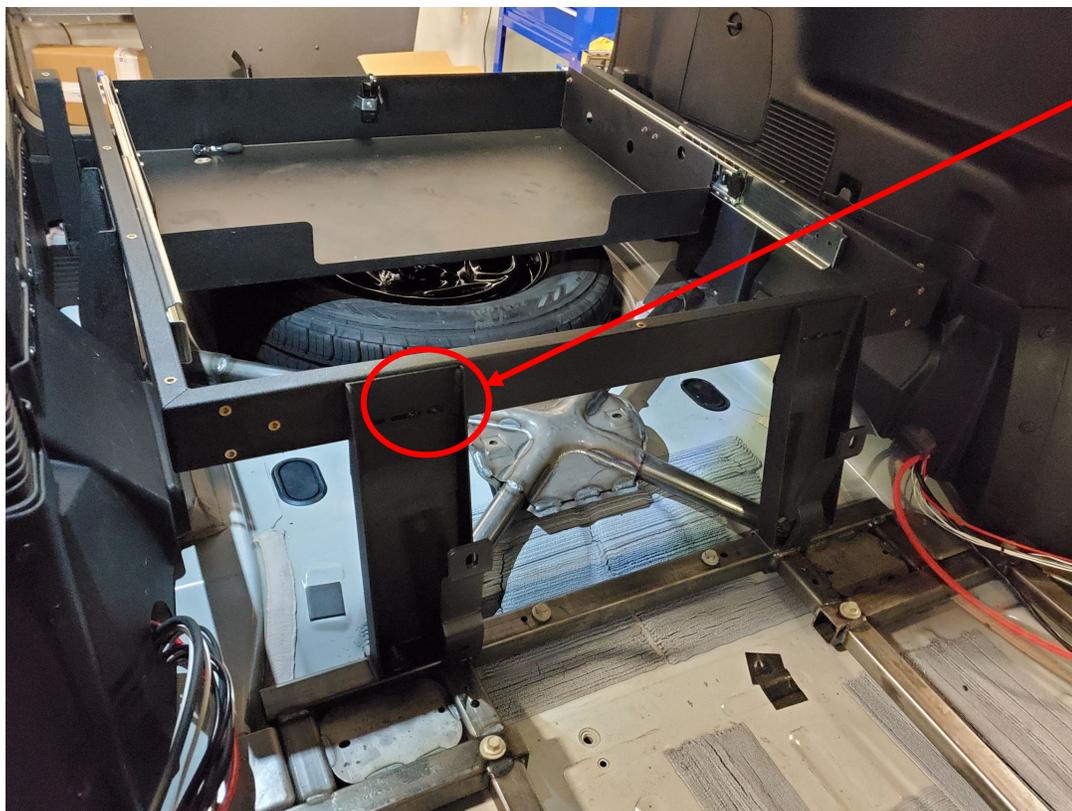
Rear of vehicle should now look like this.

Front mounts

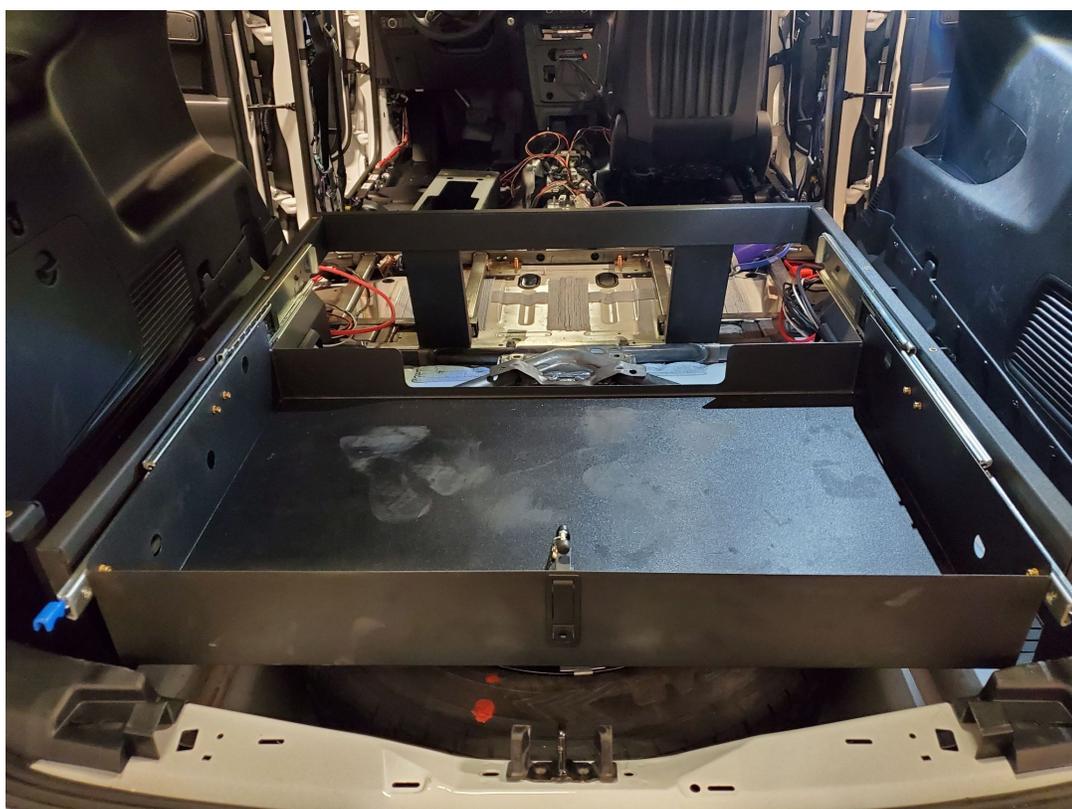
Side mounts

Rear wing supports

Please note the following can be done with the drawer and frame assembled, or you may remove the slides and drawer from the frame by removing the four 10-32 screws that hold the slide to the frame. And then re-installing the drawer system in the reverse order.



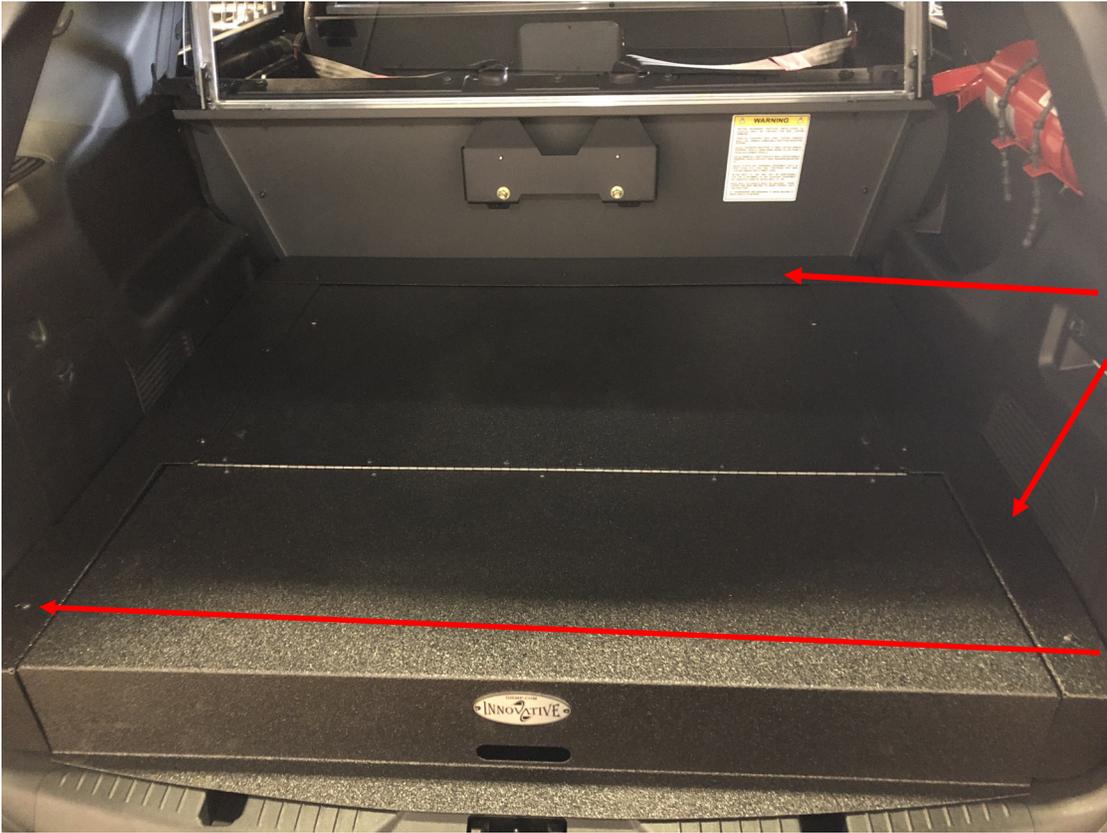
Insert frame between mounts with supplied 10-32 button head cap screws to rear mount as shown to inside slots on front mounts



Insert (2) 10-32 button head cap screws to side mounts into frame and tighten, then install drawer utilizing supplied hardware.



There should be a minimum of 38-1/8 between the frame rails at the rear of the vehicle after tightening the mounts.



Lay flat front cover over frame then lay over

rear filler plate, side wings

Then install utilizing supplied hardware as well as installing last socket head cap screws to wing supports.



Install hinged lid to cover utilizing supplied 10-32 BHCS's and #10 Washers Supplied (nutcerted tube shown attached to front flat lid)



#10 washers (10)



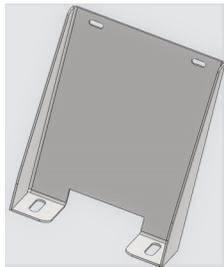
10-32 x 1/2 BHCS (10)



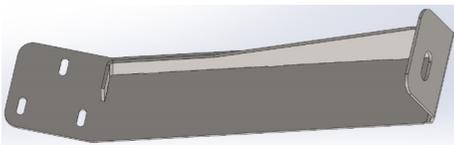
M6 x 14 Screw (2)



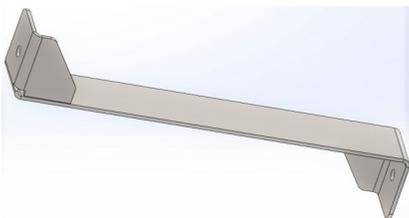
Self Tapping front bracket bolt



Rear bracket, Universal (2)



Front bracket, Left & Right



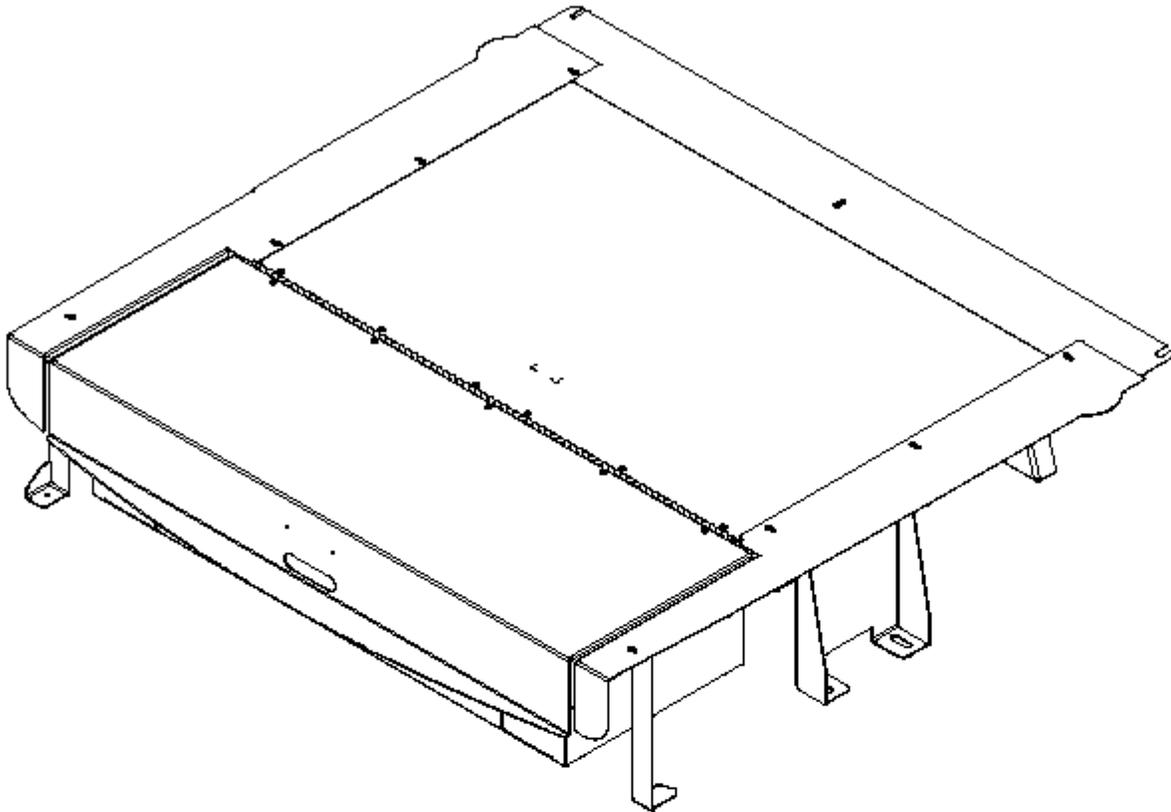
Wing Support Bracket Universal (2)



Wing filler, Driver (1)



Wing filler, Passenger (1)



17	2	N/A	FOUR-ARM KNOB	10-32 X 1.000 FOUR ARM KNOB	
16	36	N/A	BUTTON HEAD CAP SCREW	10-32 X .500 BHCS	
15	36	N/A	10-32 NUTSERT	10-32 BULB-TYPE NUTSERT	
14	1	N/A	I-DS-3600-18	18" 3600 SERIES SLIDE	
13	1	N/A	SOUTHCO-C2-33-25	SOUTHCO LOCKING COMPRESSION	
12	2	12	INV-FF-ELETRAY-ISUV-20-202-MOUNT-WING	FILLER PANEL MOUNT	1.3
11	2	12	INV-FF-ELETRAY-ISUV-20-201-MOUNT-F	MOUNTING BRACKET, FRONT	1.1
10	2	12	INV-FF-ELETRAY-ISUV-20-200-MOUNT-R	MOUNTING BRACKET, REAR	2.2
9	1	STD	INV-FF-ELETRAY-ISUV-20-125-HINGE	CUSTOM HINGE w/HOLES	37
8	1	16	INV-FF-ELETRAY-ISUV-20-800-WING-F	FILLER PANEL, FRONT	.1
7	1	16	INV-FF-ELETRAY-ISUV-20-802-WING-P	FILLER PANEL, PASSENGER	6.6
6	1	16	INV-FF-ELETRAY-ISUV-20-801-WING-D	FILLER PANEL, DRIVER	6.6
5	1	16	INV-FF-ELETRAY-ISUV-20-402-DRAWER	ELECTRONICS DRAWER	5.5
4	1	16	INV-FF-ELETRAY-ISUV-20-101-TUBE-LATCH	REINFORCING TUBE	.1
3	1	STD	INV-FF-ELETRAY-ISUV-20-100-FRAME	FABRICATION BENT TUBE	1.0
2	1	16	INV-FF-ELETRAY-ISUV-20-200-LID	BENT LID	5.1
1	1	16GA	INV-FF-ELETRAY-ISUV-20-201-TOP	TOP SKIN	.8
ITEM	QTY.	GAUGE	IDSMP PART NO.	DESCRIPTION	

UNLESS OTHERWISE SPECIFIED

DIMENSIONS ARE IN INCHES  
DIMENSIONS APPLY AFTER FINISHING

INCH	METRIC
XXXX ± .005	XXXX ± .005

DESIGN JMK DATE 4/1/2020

CHECKED

LAST UPDATE JMK DATE 4/1/2020



PART TH