

# RACEWERX ARCTIC CAT PROCROSS/PROCLIMB SKID PLATE-FRONT BUMPER ASSY INSTRUCTIONS

## PART # 100-301-SPFB 100-301-MSPFB

### KIT CONTENTS;

REAR SKID PLATE, CENTER SKID PLATE, FRONT ARM, FRONT GRAB HANDLE, SIDE MOUNTING BRACES, LOWER MOUNT, HARDWARE KIT. YOU WILL NEED A HEAVY DUTY RIVETER OR AIR RIVETER AND A DRILL WITH A 3/16" BIT FOR THIS INSTALL.

\*REMOVE THE STOCK BUMPER. YOU WILL NEED A T30 TORX TO DO THIS. RETAIN ALL HARDWARE FOR FUTURE USE.

\*REMOVE THE FACTORY PLASTIC SKID PLATE AND ALUMINUM REAR SKID PLATE. YOU WILL USE A T20 TORX. 2012 MODELS USE 4 SCREWS ON THE PLASTIC SKID PLATE. 2013 MODELS USE 6 SCREWS. ON 2013 MODELS THE FRONT 2 SCREWS SHOULD BE REINSTALLED WITHOUT THE SKID PLATE.

\*REMOVE THE 2 LOWER BOLTS HIDDEN UNDER THE STOCK PLASTIC SKID PLATE. NEXT REMOVE THE 2 UPPER BOLTS ABOVE THE STOCK PLASTIC SKID PLATE. NOTE; IF THESE BOLTS ARE TORX HEAD USE THE METRIC HARDWARE SUPPLIED IN THE KIT. IF THE BOLTS ARE HEX HEAD BOLTS USE THE STANDARD HARDWARE SUPPLIED IN THE KIT. WE RECOMMEND RUNNING A TAP THROUGH THESE HOLES AND BLOWING THEM OUT WITH COMPRESSED AIR. THE METRIC TAP SIZE IS 6MMX1.0 AND THE STANDARD TAP SIZE IS 1/4"X 20.

\*WHILE LOOKING UNDER THE SLED YOU WILL SEE A SMALL HOLE IN THE CENTER OF WHERE THE 2 FRAME TUBES COME TOGETHER. INSTALL THE SPRING CLIP NUT OVER THIS HOLE.

\*DRILL OUT THE RIVET ON THE FRONT OF THE STEERING BOOT USING A 3/16" DRILL BIT. REPEAT ON THE OTHER SIDE.

\*SET THE SIDE MOUNT BRACES UP TO THE SIDE OF THE SLED AND NOTE THE POSITION OF THE STOCK RIVETS THAT YOU WILL HAVE TO DRILL OUT. THERE WILL BE 4 ON THE RIGHT SIDE AND 2 ON THE LEFT SIDE. THEY WILL BE LOCATED IN THE NOTCH OF THE STEERING BOOT. REMOVE THESE 6 STOCK RIVETS WITH A 3/16" DRILL BIT. SEE FIG. 2. BE CAREFUL NOT TO DRILL TO DEEP AS DAMAGE MAY OCCUR.

\*INSTALL THE LOWER MOUNT USING THE HARDWARE FOR YOUR MACHINE. REMEMBER IF YOU REMOVED TORX BOLTS YOU WILL USE METRIC HARDWARE. IF YOU USED A 3/8 SOCKET TO REMOVE THEM, USE THE STANDARD HARDWARE. REFER TO THE BOLT DIAGRAM AND INSTALL THE 2 LONGER BOLTS (25MM) IN THE FRONT SLOTTED HOLES AND INSTALL THE 2 SHORTER BOLTS (20MM) IN THE REAR HOLES. DO NOT TIGHTEN AT THIS TIME. NOTE; WE RECOMMEND USING BLUE LOCTITE ON ALL FASTENERS.

\*LOOSELY INSTALL THE SIDE BRACES TO THE FRONT ARM USING A 6X20 BOLT IN THE FRONT HOLE ON EACH SIDE.

\*USE THE BUTTON HEAD BOLTS TO LOOSELY ATTACH THE CENTER SKID. MAKE SURE IT REMAINS LOOSE BEFORE YOU CONTINUE.

\*CAREFULLY INSTALL THE REAR SKID PLATE AND REAR CENTER SKID BOLT TO THE SPRING CLIP NUT INSTALLED EARLIER. BE SURE TO USE THE LONGER SCREWS PROVIDED IN THE FRONT 2 HOLES. IT MAY BE NECESSARY TO ENLARGE THE EXISTING FRONT 2 HOLES WITH A 5/32 DRILL BIT. USE THE STOCK SCREWS FOR THE REAR 3 HOLES. USE A 6MM X 25 BUTTON HEAD BOLT SUPPLIED FOR THE REAR OF THE CENTER SKID PLATE. DO NOT TIGHTEN AT THIS TIME.

\*INSTALL THE FRONT ARM TO THE CENTER SKID PLATE WITH THE REMAINING 6MM X 25 BOLTS. DO NOT TIGHTEN AT THIS TIME.

\*INSTALL THE 2 RIVETS ON THE LEFT SIDE AND THE 4 RIVETS ON THE RIGHT SIDE. ONCE ALL THE RIVETS ARE IN THEIR RESPECTIVE HOLES THEY MAY BE POPPED. THESE ARE HEAVY DUTY HUCK RIVETS AND A AIR RIVETER IS RECOMMENDED.

\*ONCE THE 2 LEFT SIDE RIVETS ARE INSTALLED YOU WILL NEED TO DRILL THE 2 REMAINING HOLES WITH A 3/16" DRILL BIT.

\*INSTALL THE 2 REMAINING RIVETS.

\*TIGHTEN THE 3 CENTER SKID PLATE BOLTS TO THE LOWER MOUNT FIRST. TORQUE TO 84IN/LBS

\*TIGHTEN THE REAR BUTTON HEAD BOLT TO 84IN/LBS.

\*TIGHTEN THE 4 LOWER MOUNT BOLTS TO 84IN/LBS

\*TIGHTEN THE 6 FRONT ARM BOLTS EVENLY TO 84IN/LBS

\*INSTALL THE FRONT GRAB HANDLE. YOU WILL NEED TO SPREAD THE FRONT ARM SLIGHTLY TO INSTALL THIS. USE THE 8MM BOLTS AND TORQUE TO 10-12FT/LBS.

\*INSTALL THE 2 NEW BLACK RIVETS IN THE STEERING BOOT.

\*TIGHTEN THE REAR SKID PLATE SCREWS. DOUBLE CHECK ALL HARDWARE FOR TIGHTNESS. REMEMBER WE RECOMMEND BLUE LOCTITE ON ALL FASTENERS.

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\*FOR MORE DETAILED INSTRUCTIONS WITH PHOTOS PLEASE VISIT [WWW.FACEBOOK.COM/RACEWERX](http://WWW.FACEBOOK.COM/RACEWERX)

**AC Front Bumper Installation Guide**

- Use Blue Loctite on all Fasteners
- Late Model Units will Use the 1/4" Standard Thread Bolts Provided for the Frame Mount
- Remove Lower Steering Boot Rivets to ease in Installation of the Lower Frame Mount Bolts

