

FORD PERFORMANCE



February 5, 2025

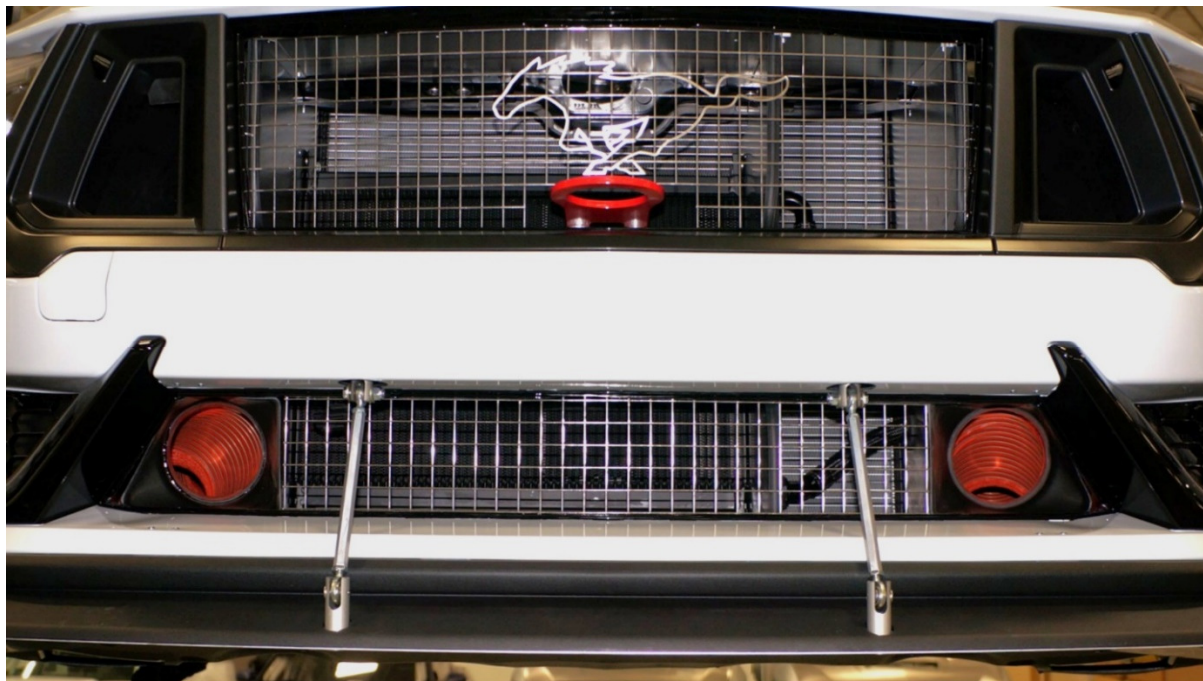
Technical Service Bulletin – 33

Splitter Support Kit

Purpose: To support splitter to a controlled height. Applies to vehicles 1-40.

New parts

Description	QTY	Part Number	Supplier
Splitter Bumper Brackets	2	LCR-DHR-BMPR-BRKT	Capaldi Racing
Splitter Support	1	LCR-DHR-SPLTR	Capaldi Racing
Splitter Pencil Rod	2	LCR-DH-PENCIL	Capaldi Racing
Rivet Nut, ¼"-20	4	95105A143	McMaster-Carr
Bolt, ¼"-20	4	90602A212	McMaster-Carr

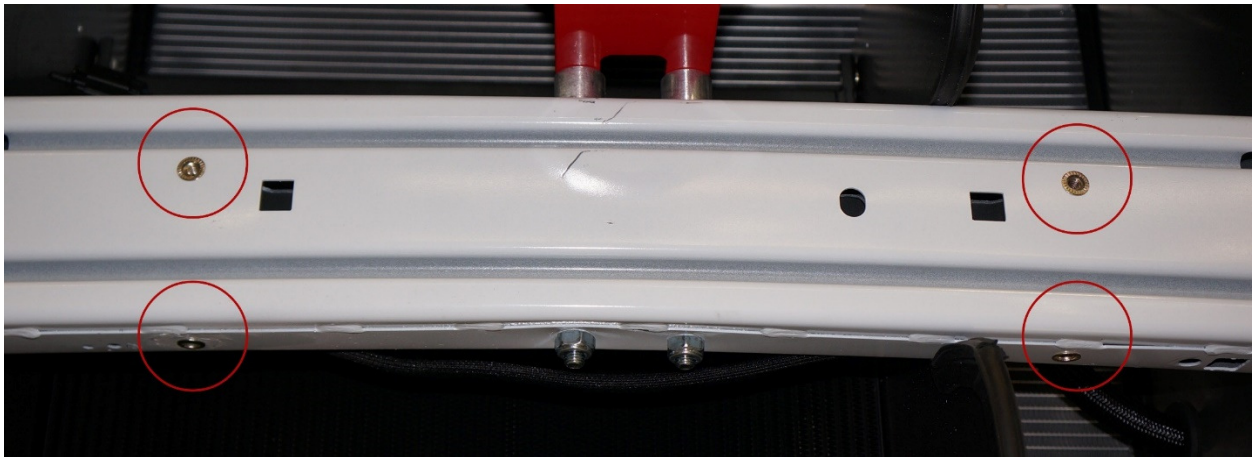


Installation Overview

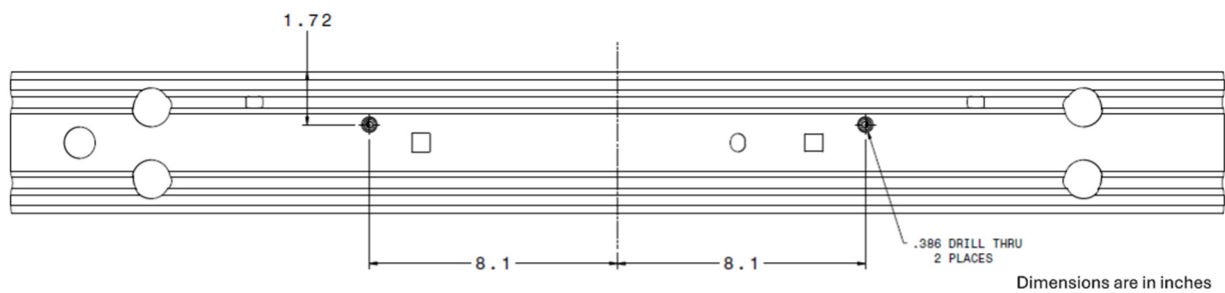
- Remove bumper cover
- Install rivet nuts in bumper beam
- Install splitter support brackets on bumper beam
- Install splitter support on the factory splitter, drill for lower pencil rod mounting location
- Clearance bumper beam cover
- Drill pass through bores for pencil rod mounts in bumper cover
- Reinstall bumper cover
- Install pencil rods
- Adjust height to current specification found in the homologation document

Remove bumper cover to expose the bumper beam.

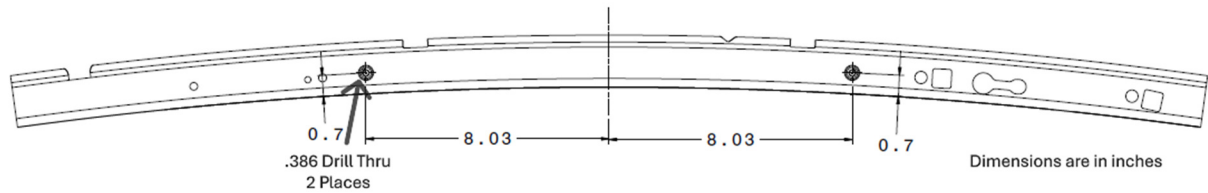
Bumper Beam Rivet Nut Installation



Front of Bumper Beam

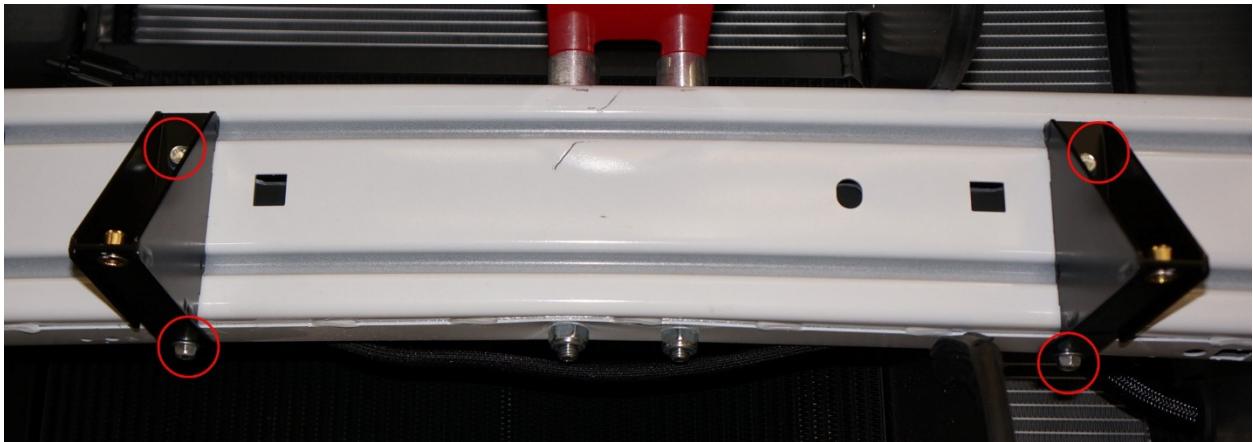


Bottom of Bumper Beam

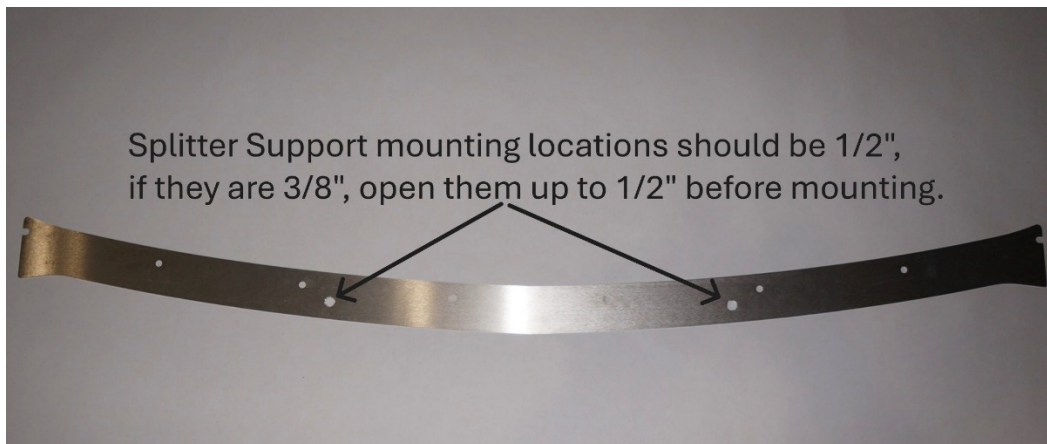


Splitter Support Installation

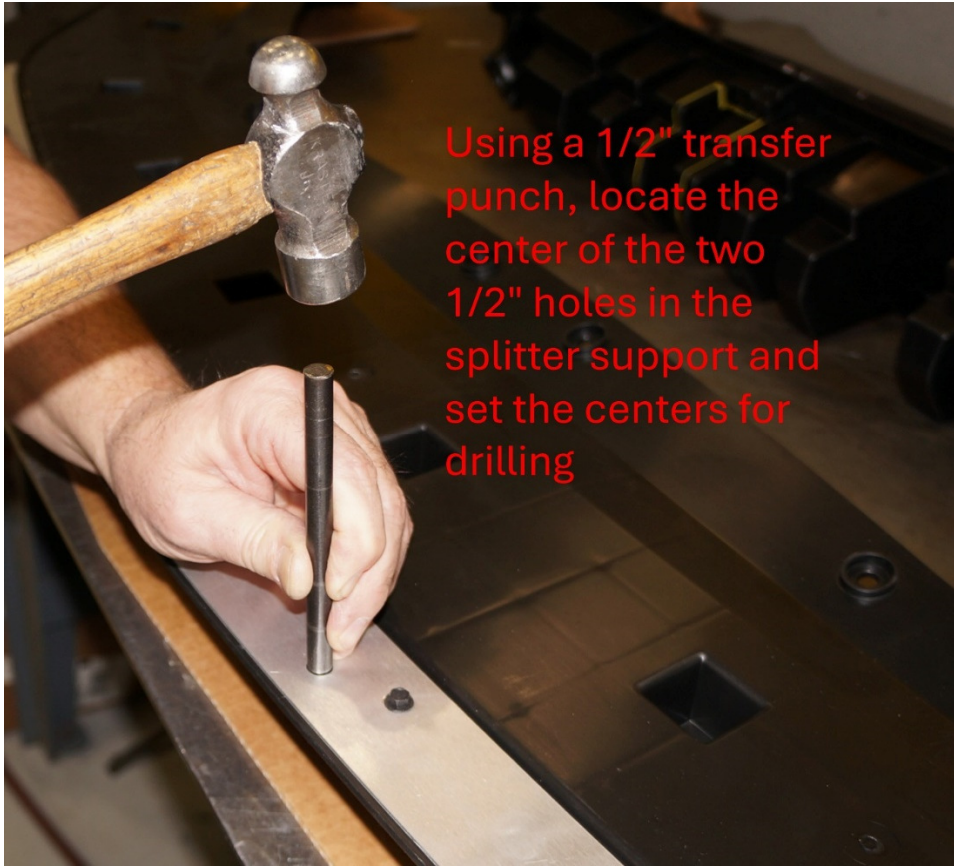
Install bumper beam on vehicle, make sure to center it while doing so. Using the $\frac{1}{4}$ "-20 bolts, install the bumper beam brackets to the bumper beam. Keeping them as vertical as possible while tightening the bolts to 8 ft-lbs.



Splitter Support Installation







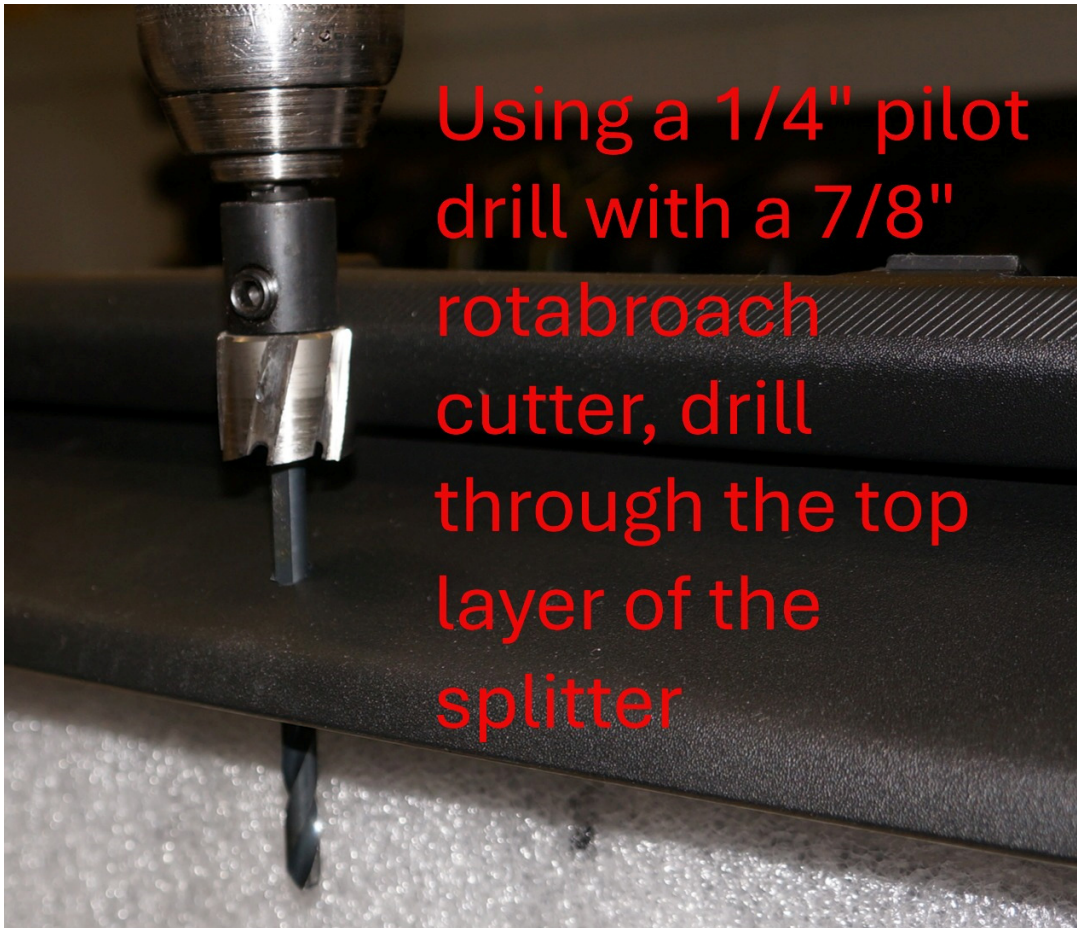
Using a 1/2" transfer punch, locate the center of the two 1/2" holes in the splitter support and set the centers for drilling



Using a 1/8" drill bit and a V block, drill straight through the splitter

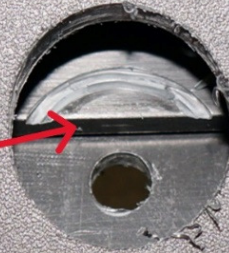


Drill 1/4"
pilot holes
through the
previously
drilled 1/8"
holes



Using a 1/4" pilot
drill with a 7/8"
rotabroach
cutter, drill
through the top
layer of the
splitter

After removing
the top of the
splitter, use the
same cutting tool
and remove the
half moon layer



Half moon
removed

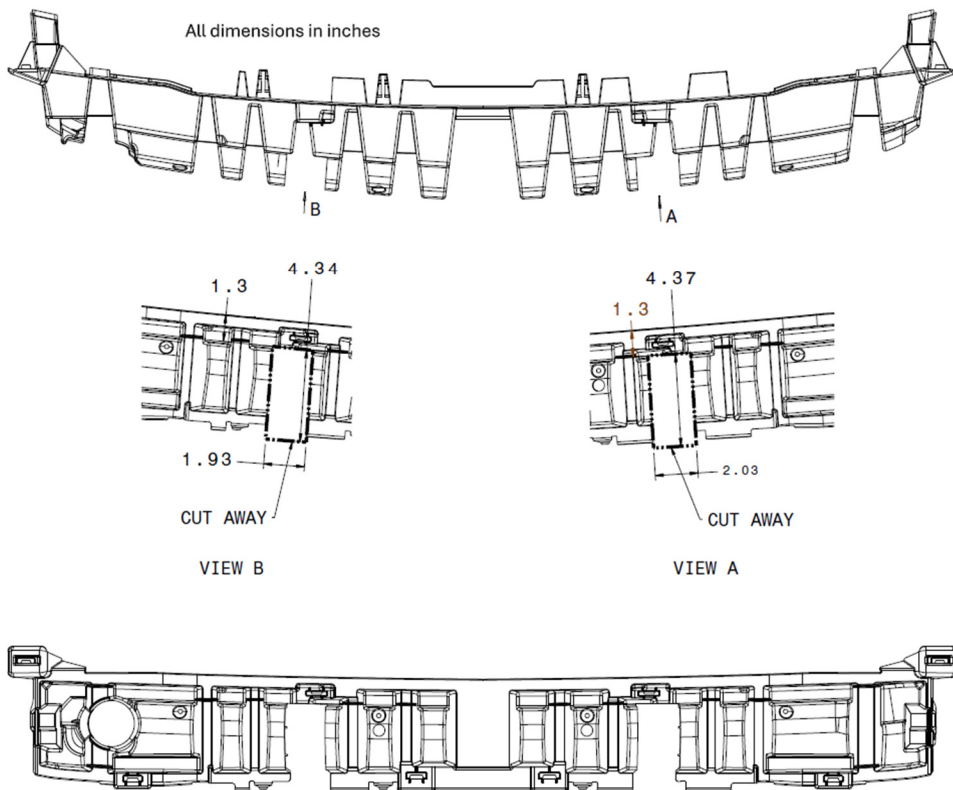




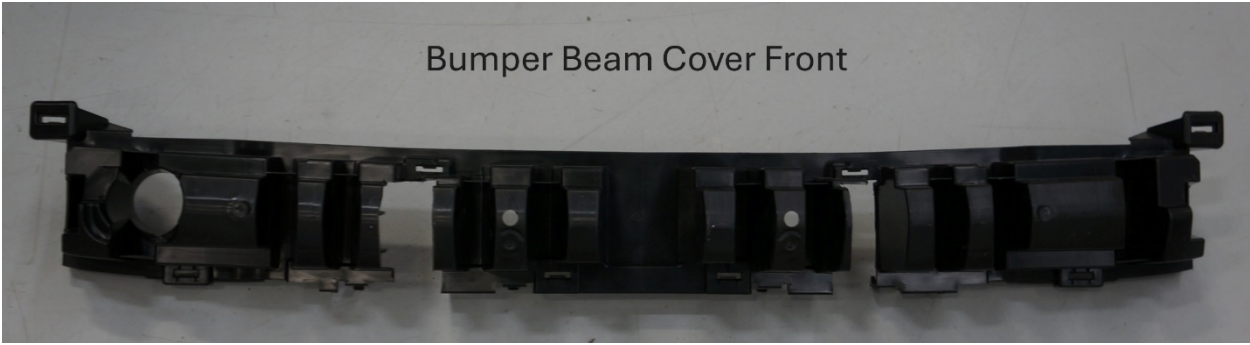
From the bottom, drill through the splitter with a 3/8" drill bit

Clearance

Bumper Beam Cover



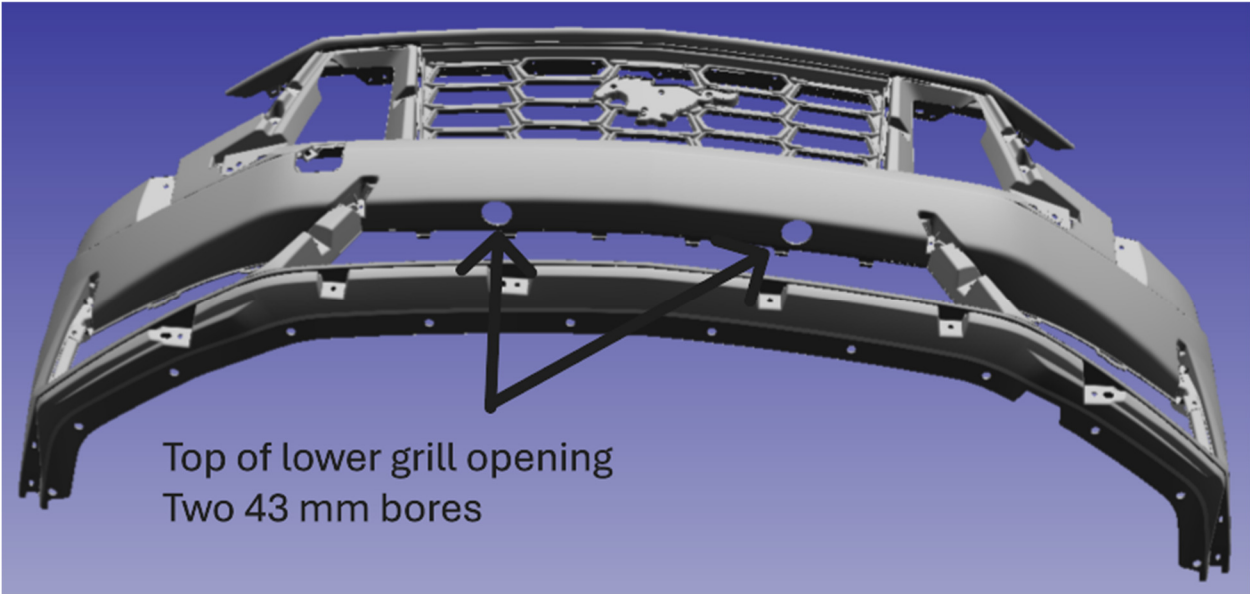
Bumper Beam Cover Front



Bumper Beam Cover Back



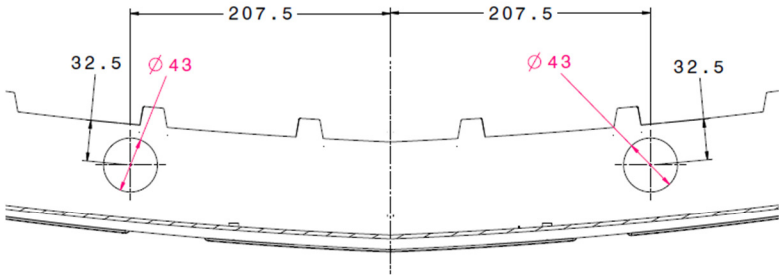
Pencil Rod Mount Clearance Bore



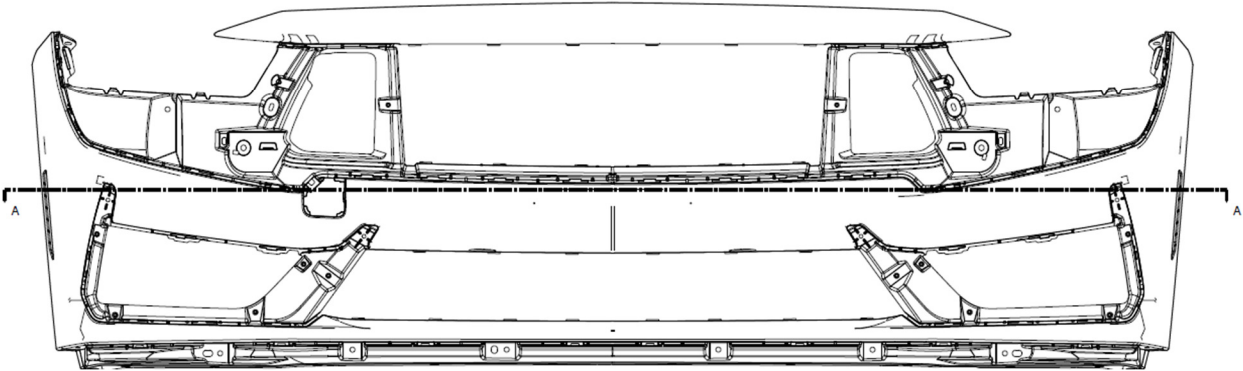
Top of lower grill opening
Two 43 mm bores

Bore Location Layout

All dimensions are metric

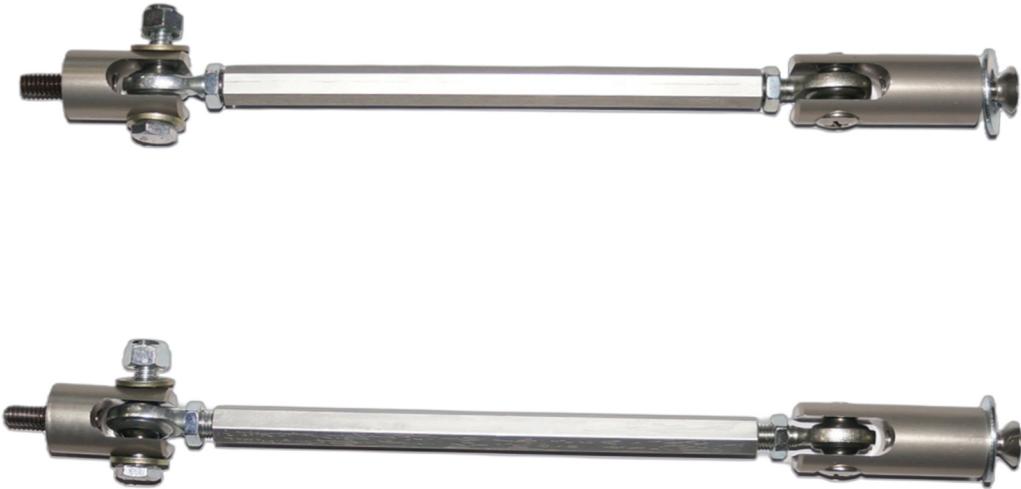


SECTION A-A

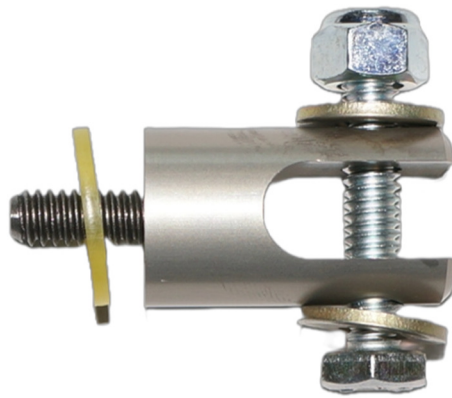


Reinstall bumper cover at this point.

Install Pencil Rods



Upper Pencil Rod Mount



Install with soft washer and a small amount of blue locking compound, align as shown.



Lower Pencil Rod Mount



Install as shown



Pencil Rod

