

## **BUMPER INSTALLATION INSTRUCTIONS**

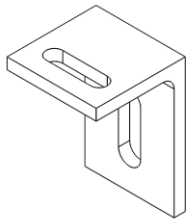
### **Ford Super Duty Rear Bumper, 2017+**

**Please read before beginning**

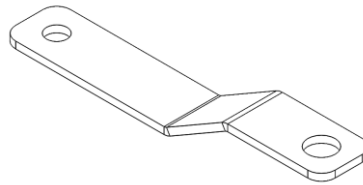
- *Stainless Steel nuts and bolts may bind permanently together if installed incorrectly; to avoid this it is recommended to apply a small amount of lubricant to bolt threads before installing (wax, never cease, etc.)*



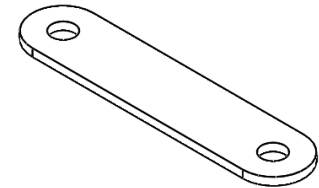
**Included Parts/Subassemblies**



x2  
**Lower Support  
 "L" Bracket**



x2  
**Rear Bumper  
 Straps**



X1  
**Regular Body  
 Strap**

**Included Hardware**

**Quantity**

- |                                                                 |   |
|-----------------------------------------------------------------|---|
| • 70080 – ½"-13 x 2" Grade 8 Hex Head Bolt .....                | 4 |
| • 70035 – ½" Zinc Washer .....                                  | 8 |
| • 70033 – ½"-13 Grade 8 Nylock Nut .....                        | 4 |
| • 70023 – 5/16"-16 x 1-1/2" Stainless Steel Hex Head Bolt ..... | 2 |
| • 70022 – 5/16" -16 x 1" Stainless Steel Hex Head Bolt .....    | 2 |
| • 70020 – 5/16" Washer Stainless Steel (.03" Thick) .....       | 8 |
| • 300095 – Regular Body Strap.....                              | 1 |
| • 70019 – 5/16" Nylock Nut .....                                | 4 |
| • 70246 – Antiseize Packet, 2g                                  | 1 |

## **Installation Instructions**

### **Disassembly:**

1. Unclip/disassembly any wiring for towing, back up sensors, or license plate lights. It's helpful to completely remove the wiring harness from the bumper to ease installation later, but not necessary.
2. Unbolt the factory rear bumper from underneath the vehicle. There are four (4) bolts holding on the bumper through vehicle mounted brackets (2 per side). Reference Figure 1.

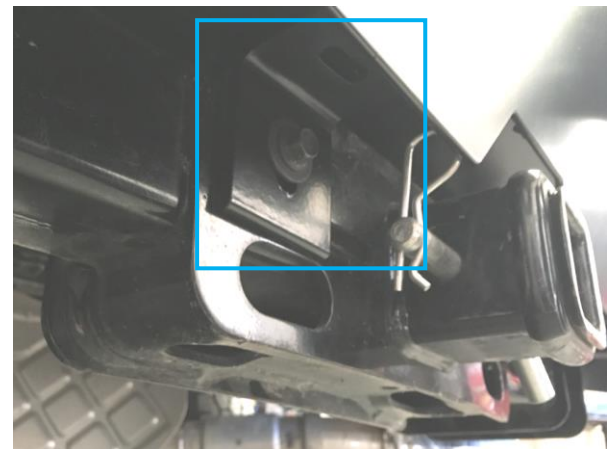


**Figure 1: Factory Bumper Brackets**



**Figure 2: Hitch Bracket**

3. Remove the bracket mounted the factory hitch. Keep the hardware, as this will be reused for re-installation, but you may discard the bracket. Reference Figure 2.



**Figure 3: "L" Brackets Pre-Installed**

5. If you plan on keeping your spare tire underneath the vehicle, continue onto the next steps. Otherwise, remove tire and lift the tire-keeper until it is tight. Then skip to Step 7.
6. Install the spare tire extension through the hole inside the toolbox of the bumper as shown in Figure 4. Keep the 3/8" drive inside the bumper toolbox and use the rubber gromet (PN 70718) around the extension to secure into the bumper.

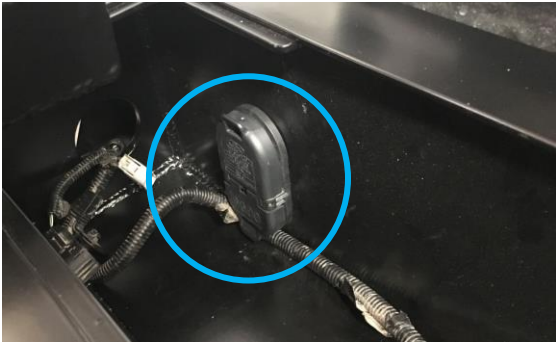


**Figure 4: Spare Tire Release Hole**

7. Press-fit the towing electrical connection into the pre-cut hole on the backplate. Reference Figure 5.

### **Rear Bumper Installation:**

4. Install the lower "L" brackets onto the hitch from where the factory bracket hitch was removed in Step 3. Reusing the factory hardware, snug the bracket vertically so it can still move. These brackets will be tightened later. Reference Figure 3.



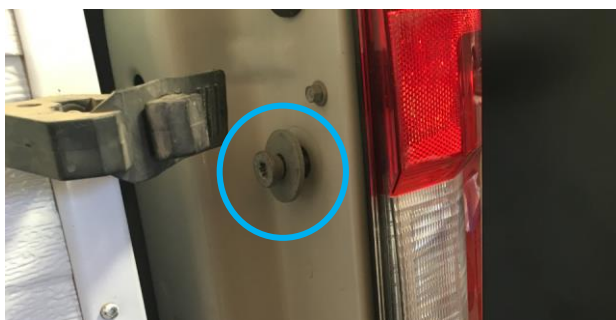
**Figure 5: Towing Electrical Connection**

8. Route the wiring harness through the new bumper being sure to reconnect any sensors or towing connection. Reference Figure 4 and 5.
9. Install new bumper onto vehicle using the provided 1/2" hardware mounting through the same brackets utilized by the factory bumper (brackets shown in Figure 1).
10. Adjust bumper to desired fitment on vehicle in left/right and up/down directions. Once in the desired location, tighten the four (4) 1/2" bolts.
11. With the bumper tight on the brackets, move the lower "L" brackets up to meet the bottom of the new bumper.
12. Using the 5/16" x 1-1/2" hardware, bolt the bumper to the hitch through the brackets. Tighten all bolts on these brackets. Reference Figure 3 & 6.



**Figure 6: Lower "L" Brackets Tightened onto Bumper**

13. Remove the tailgate cable connections and corresponding bolts on the inside of the bed. Reference Figure 7.
14. Install the rear bumper strap re-using the tailgate bolt as shown in Figure 7.



**Figure 7: Rear Strap Installation**

15. Using the strap as a template, drill a hole through the upright of the bumper. Install the remaining 5/16" x 1" hardware through the strap and bumper. Reference Figure 7.
16. Install your tire onto the tire rack swing arm (if applicable), be sure to place the tire so that it rests on the two support arms before tightening anything down (reference Figure 8).



17. Check all fasteners for fitment after 50 miles of driving, and every 1000 miles afterwards. Enjoy!

**Figure 8: Tire Resting on Both Supports**