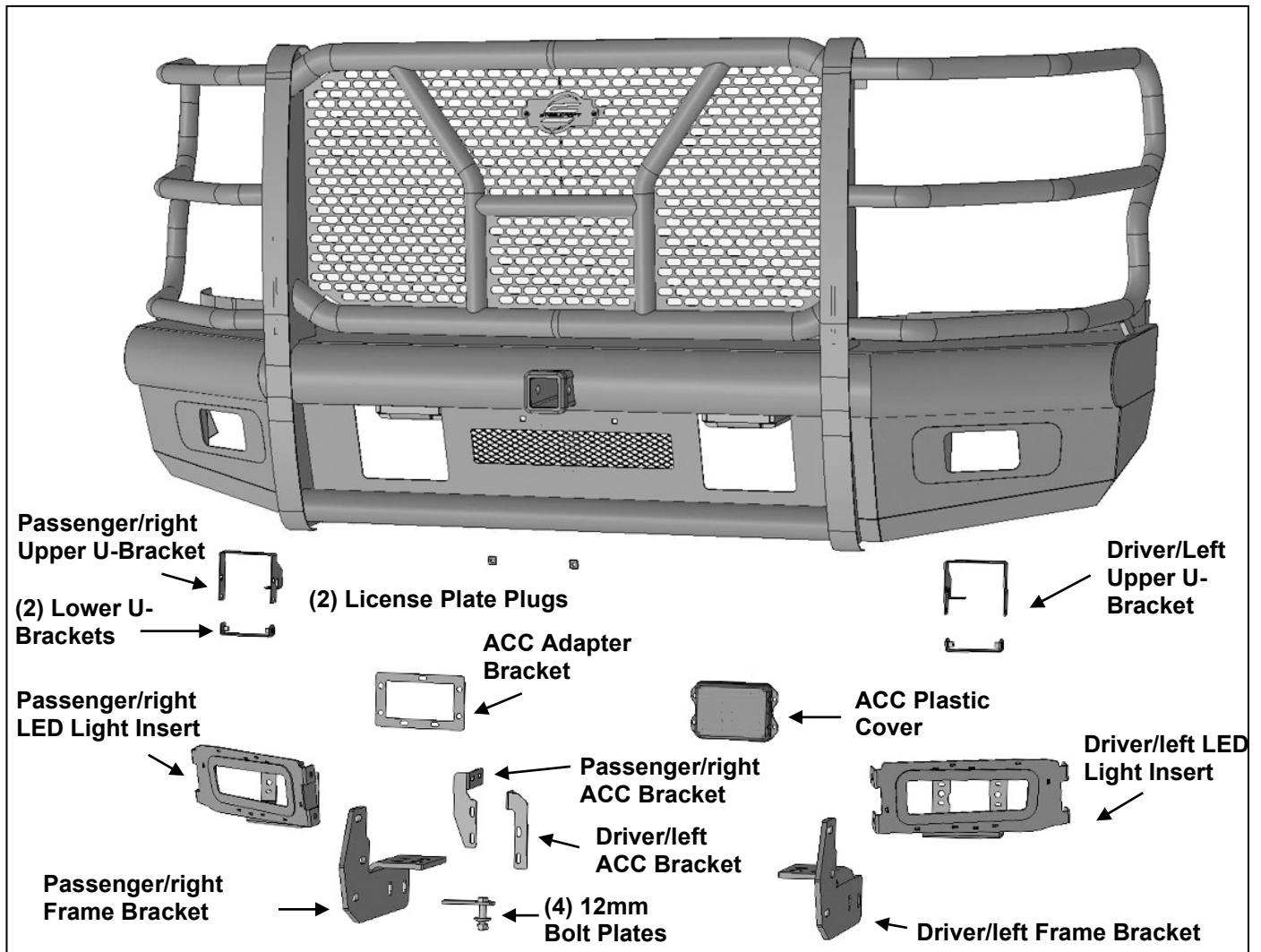


**HEAVY DUTY REPLACEMENT FRONT BUMPER
2017-20 FORD SUPER DUTY F250-350**

PARTS LIST:

1	HD Front Bumper Assembly	32	12mm x 32mm x 3mm Flat Washers
1	Driver/left Frame Bracket	18	12mm Lock Washers
1	Passenger/right Frame Bracket	18	12-1.75mm Hex Nuts
1	Driver/left Upper U-Bracket (OEM fog light)	2	8mm x 20mm Hex Bolts
1	Passenger/right Upper U-Bracket (OEM fog light)	4	8mm x 24mm x 2mm Flat Washers
2	Lower U-Brackets (OEM fog light only)	2	8mm Nylon Lock Nuts
1	Driver/left Light Mount (OEM LED)	3	6mm x 25mm Hex Bolts
1	Passenger/right Light Mount (OEM LED)	6	6mm x 25mm Button Head Bolts
1	Adaptive Cruise Control, (ACC) Plastic Cover	4	6mm x 16mm Hex Bolts
1	Driver/left side ACC Bracket	19	6mm x 18mm x 1.6mm Flat Washers
1	Passenger/right side ACC Bracket	13	6mm Lock Washers
1	ACC Adapter Plate	9	6mm Hex Nuts
2	Plastic Plugs for license plate mount	1	Allen Wrench S=4
4	12mm Bolt Plates	1	Allen Wrench S=2.5
14	12-1.75mm x 50mm Hex Bolts		



**HEAVY DUTY REPLACEMENT FRONT BUMPER
2017-20 FORD SUPER DUTY F250-350**

PROCEDURE:

REMOVE CONTENTS FROM BOX. VERIFY ALL PARTS ARE PRESENT. READ INSTRUCTIONS CAREFULLY BEFORE STARTING INSTALLATION. BUMPER IS HEAVY, ASSISTANCE IS HIGHLY RECOMMENDED TO AVOID POSSIBLE INJURY OR DAMAGE TO THE VEHICLE.

1. Remove the license plate and bracket. On models with factory fog lights, unplug both lights. Unplug and remove the adaptive cruise control, if equipped. Release the wiring harness from the clips attached to the back of the bumper, **(Figures 1 & 2)**. Move harness away from bumper.
2. Next, remove the plastic lower air dam from the bottom of the bumper, **(Figure 3)**. Remove the outer bumper supports attaching the outer ends of the bumper to the side of the frame, **(Figure 4)**. Remove the plastic covers from the tow hooks to uncover the bumper bolts, **(Figures 5 & 6)**.
3. Place blocks or jack stands under the front bumper to support it during mounting bolt removal. Once the bumper has been safely supported, remove the (8) factory bumper bolts, **(Figures 6 & 7)**.
WARNING! Assistance is required to hold the bumper in place during bolt removal to prevent the bumper from falling. Carefully slide the bumper off over the tow hooks.
4. Remove the passenger/right side tow hook from the end of the frame, **(Figure 7)**. Next, remove the (4) factory hex nuts, lower frame extension and double bolt plates from the end of the frame, **(Figures 2 & 7)**. Repeat this Step to remove the driver/left side tow hook and lower frame extension.
5. Reuse the factory hardware to attach the passenger side tow hook to the bracket on the back of the HD Bumper, **(Figure 8)**.
6. Next, select the passenger/right Frame Bracket. Slide the Bracket over the end of the frame. Line up the slots in the side of the Bracket with the holes in the outside of the frame. Select (2) 12mm Bolt Plates. Insert the Bolt Plates into the open end of the frame and out through the Bracket. Attach the Bracket to the Bolt Plates with (2) 12mm Flat Washers, (2) 12mm Lock Washers and (2) 12mm Hex Nuts, **(Figure 9)**. Leave loose at this time.
7. Attach the mounting tab on the top of the Bracket to the top of the frame with the included (4) 12mm x 50mm Hex Bolts, (8) 12mm Flat Washers, (4) 12mm Lock Washers and (4) 12mm Hex Nuts, **(Figure 10)**. Do not fully tighten hardware at this time.
8. Repeat **Steps 6 & 7** to attach the driver/left Frame Bracket to the end of the frame.
9. With assistance, carefully position the Bumper Assembly to the outside of the Frame Brackets. Temporarily support the weight of the Bumper. **WARNING:** To avoid possible injury or damage to the vehicle, do not proceed until the bumper is fully and safely supported.
10. Attach the Bumper to the outside of the Frame Brackets with the included (6) 12mm x 50mm Hex Bolts, (12) 12mm Flat Washers, (6) 12mm Lock Washers and (6) 12mm Hex Nuts, **(Figure 11)**. Do not fully tighten hardware at this time.
11. Level and adjust the bumper and fully tighten all 12mm hardware to 65-70ft-lbs.
12. Determine if vehicle is equipped with adaptive cruise control, (ACC), and note the design of the sensor.

Vehicles without Adaptive Cruise Control, skip to Step 13.

All Models with Adaptive Cruise Control.

- a. Select the Left ACC Bracket, Right ACC Bracket and ACC Upper Bracket. Attach the Left and Right ACC Brackets to the ACC Upper Bracket with (3) 6mm x 25mm Hex Bolts, (6) 6mm Flat Washers, (3) 6mm Lock Washers and (3) 6mm Hex Nuts, **(Figure 12)**. Do not tighten hardware

Vehicles with "late" style ACC with tabs on top and bottom.

- a. Select the Mounting Bracket Adapter Plate, **(Figure 13)**.
- b. Attach the ACC sensor to the back of the Adapter with the included (3) 6mm x 25mm Button Head Bolts, (6) 6mm Flat Washers, (3) 6mm Lock Washers and (3) 6mm Hex Nuts, **(Figure 13)**.
- c. Insert (3) 6mm x 25mm Button Head Bolts through the (3) holes on the ACC Plastic Cover, the ACC Bracket and out through the adaptive cruise control Adapter Plate. Secure with (3) 6mm Flat Washers, (3) 6mm Lock Washers and (3) 6mm Hex Nuts, **(Figure 14)**.

Vehicles with early style ACC with mounting tabs on ends.

- a. Insert (3) 6mm x 25mm Button Head Bolts through the (3) holes on the ACC Plastic Cover, the ACC Bracket and out through the adaptive cruise control, (or adapter and late style ACC). Secure with (3) 6mm Flat Washers, (3) 6mm Lock Washers and (3) 6mm Hex Nuts, **(Figure 15)**.

13. Models with fog lights, determine style of fog light. Models without factory fog lights, skip to **Step 14**.

Models with rectangular factory fog lights:

HEAVY DUTY REPLACEMENT FRONT BUMPER 2017-20 FORD SUPER DUTY F250-350

- a. Use a flat blade screwdriver to carefully pop out the tabs on the side of the fog light bracket attaching the light to the bracket, **(Figure 1)**. Pop the light out of the plastic bracket housing.
- b. Remove the adjustment screw and spring from the light assembly.
- c. Move to the passenger/right fog light opening, **(Figure 16)**. Select the passenger/right top U-Bracket, **(Figure 17)**. Attach the Bracket to the slot in the light opening with the included (1) 8mm x 20mm Hex Bolt, (2) 8mm x 24mm STD Flat Washers and (1) 8mm Nylon Lock Nut, **(Figure 17)**.
- d. Spread the sides of the Bracket enough to slide the OE plastic fog light between and into the Bracket, **(Figure 18)**. Select (1) Lower U-Bracket. Attach the Lower Bracket to the Upper Bracket with (2) 6mm x 16mm Hex Bolts, (2) 6mm Lock Washers and (2) 6mm Flat Washers, **(Figure 19)**.
- e. Insert the factory spring between the tab on the Bracket and the light. Insert the screw through the tab, spring and into the fog light, **(Figure 19)**.
- f. Repeat to install the driver/left fog light.

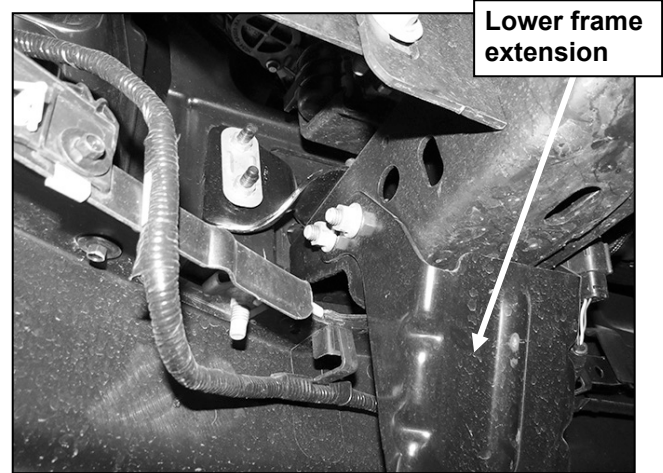
Models with optional narrow factory LED Fog Light (2020 models)

- a. Remove the light mount from the bumper, **(Figure 20)**. Remove the screws attaching the light to the plastic mount, **(Figure 21)**.
 - b. Remove the preinstalled passenger/right rectangular fog light mount insert from the back of the HD Bumper, **(Figure 22)**.
 - c. Select the passenger/right LED light mount insert. Reuse the hardware to attach the Mount to the tabs on the back of the Bumper, **(Figure 23)**.
 - d. Reuse the factory screws to attach the LED fog light to the LED light mount, **(Figure 23)**.
 - e. Repeat previous Steps to install the passenger/right LED Light Mount and light.
14. Insert (2) Plastic Plugs into the Bumper. Reuse factory hardware to attach license plate to Plugs. On models with grille mounted factory camera, remove the center screen, **(Figure 24)**.
15. Reattach the factory wiring harness. Adjust lights as necessary and tighten fog light bracket hardware.
16. Do periodic inspections to the installation to make sure that all hardware is secure and tight.

To protect your investment, Do not use any type of polish or wax that may contain abrasives that could damage the finish. Mild soap may be used to clean the HD Front Bumper assembly.



(Fig 1) On models with fog lights, unplug wire harness from back of light

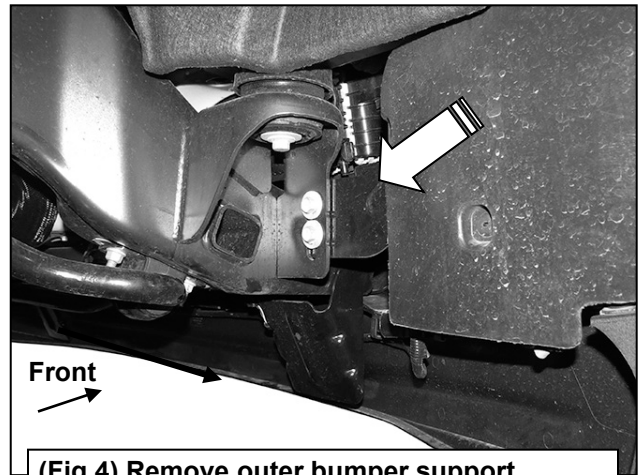


(Fig 2) Release clips attaching the wire harness for fog lights if equipped (driver side)

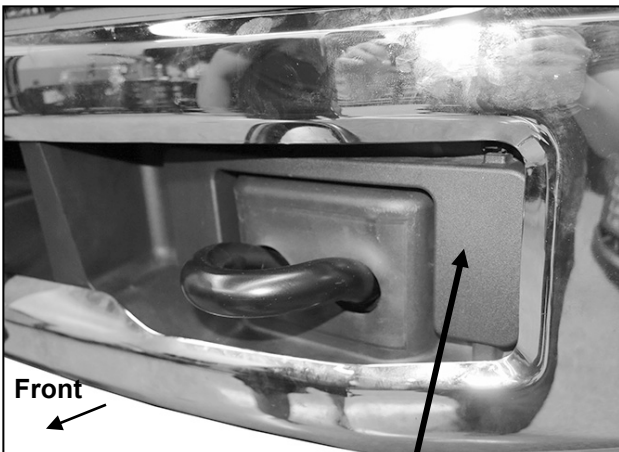
**HEAVY DUTY REPLACEMENT FRONT BUMPER
2017-20 FORD SUPER DUTY F250-350**



(Fig 3) Remove plastic air dam from bumper



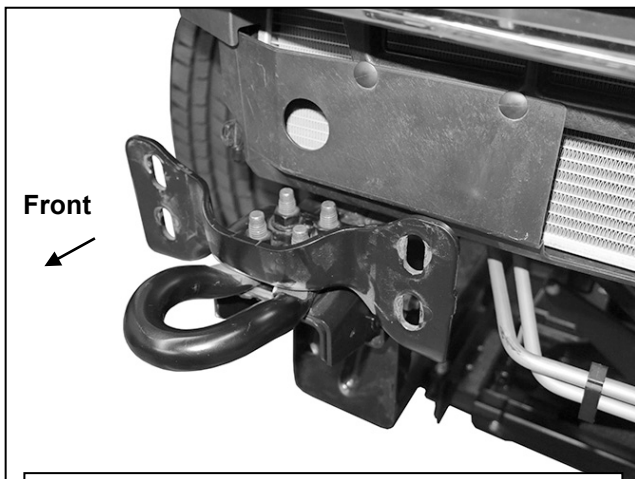
(Fig 4) Remove outer bumper support brackets between frame and bumper (arrow)



(Fig 5) Remove plastic cover around tow hook



(Fig 6) Remove bumper bolts (driver side pictured)

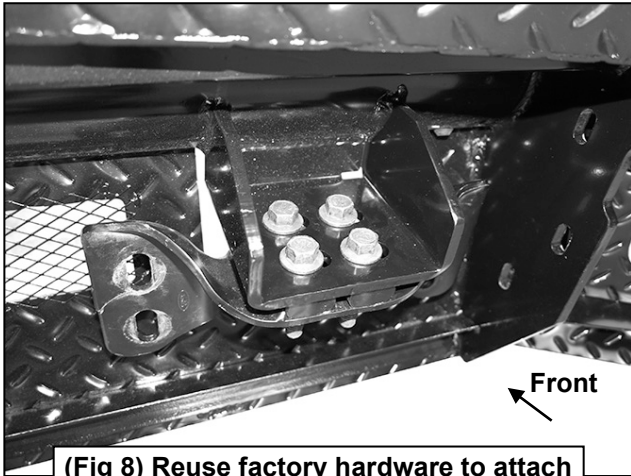


(Fig 7) Remove tow hook assembly and lower frame extension (not pictured-see Fig 2)

WARNING! Do not remove bumper bolts unless the bumper is properly supported on blocks or stands or the bumper may fall.

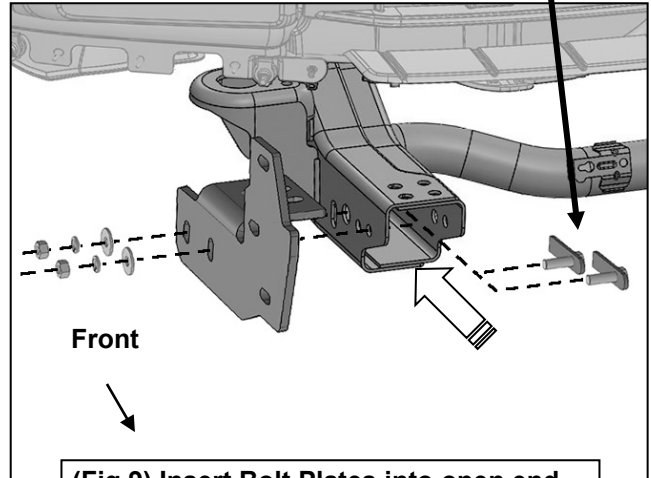
**HEAVY DUTY REPLACEMENT FRONT BUMPER
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Passenger/right Side Installation Pictured

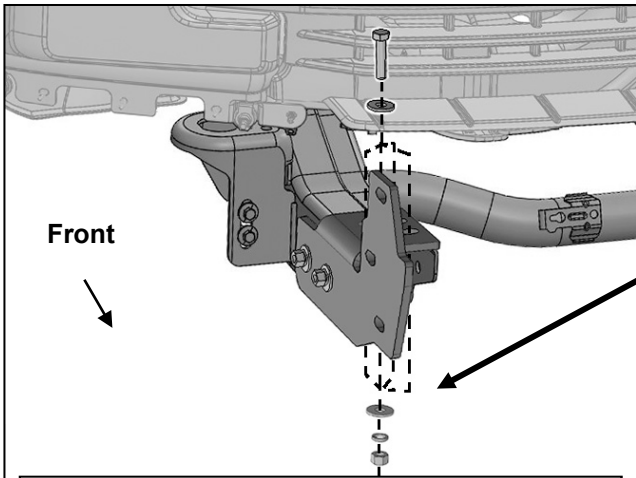


(Fig 8) Reuse factory hardware to attach tow hook to mount on back of bumper

- (2) 12mm Bolt Plates
- (2) 12mm Flat Washers
- (2) 12mm Lock Washers
- (2) 12mm Hex Nuts



(Fig 9) Insert Bolt Plates into open end of frame. Attach Bracket to side of frame

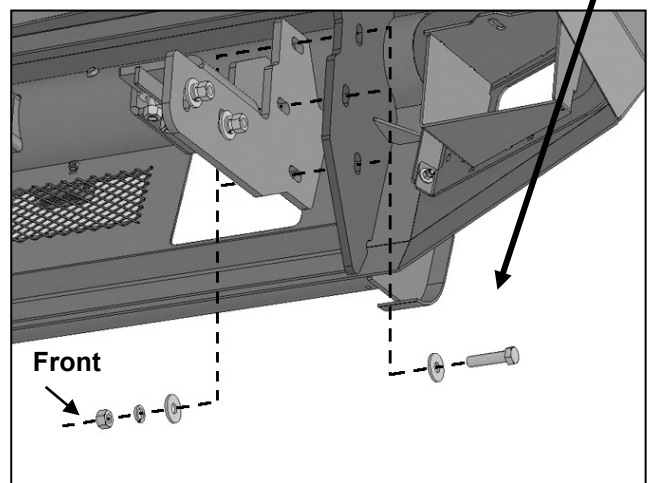


(Fig 10) Attach tab on Bracket to top of frame

- (4) 12mm x 50mm Hex Bolts
- (8) 12mm Flat Washers
- (4) 12mm Lock Washers
- (4) 12mm Hex Nuts

- (3) 12mm x 50mm Hex Bolts
- (6) 12mm Flat Washers
- (3) 12mm Lock Washers
- (3) 12mm Hex Nuts

WARNING! Do not crawl under bumper unless the bumper is properly supported on blocks or stands or the bumper may fall.



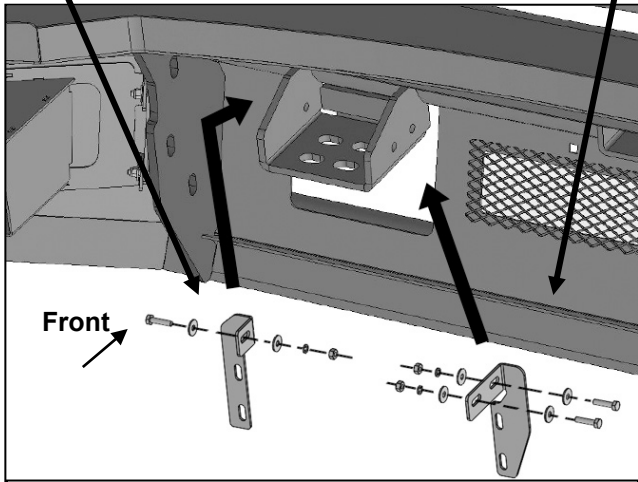
(Fig 11) Attach Bumper to side of Bracket

**HEAVY DUTY REPLACEMENT FRONT BUMPER
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Passenger/right Side Installation Pictured

- (3) 6mm x 25mm Hex Bolts
- (6) 6mm Flat Washers
- (3) 6mm Lock Washers
- (3) 6mm Hex Nuts

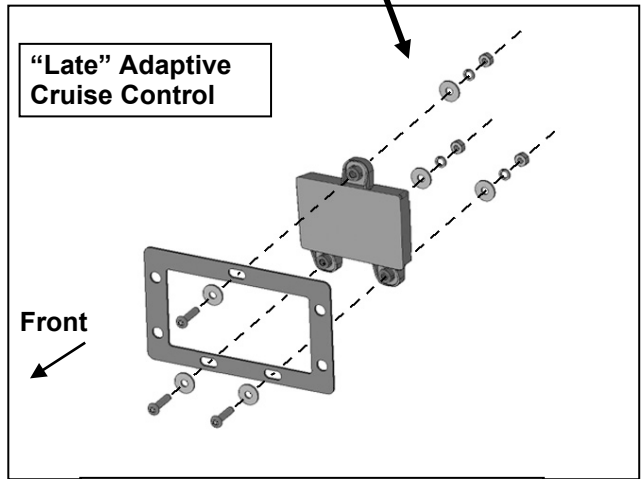
Passenger/right side
ACC Bracket



(Fig 12) Vehicles equipped with adaptive cruise control, attach ACC Brackets to the tow hook mount on back of bumper (Driver side pictured)

- (3) 6mm Button Head Bolts
- (3) 6mm Flat Washers
- (3) 6mm Lock Washers
- (3) 6mm Hex Nuts

"Late" Adaptive
Cruise Control

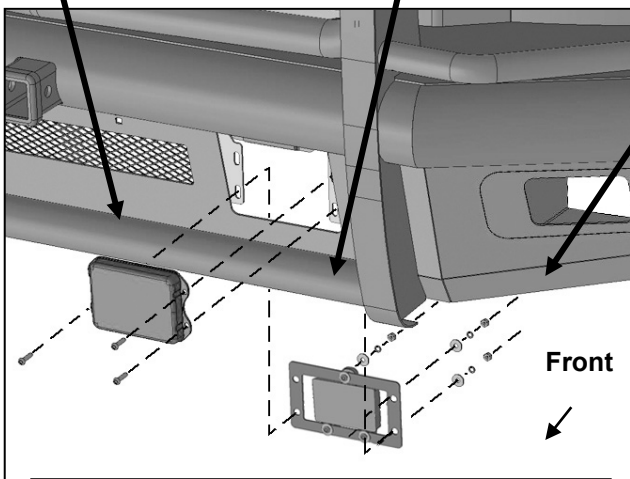


(Fig 13) Attach "Late" ACC sensor to back of Adapter Bracket

ACC Plastic
Cover

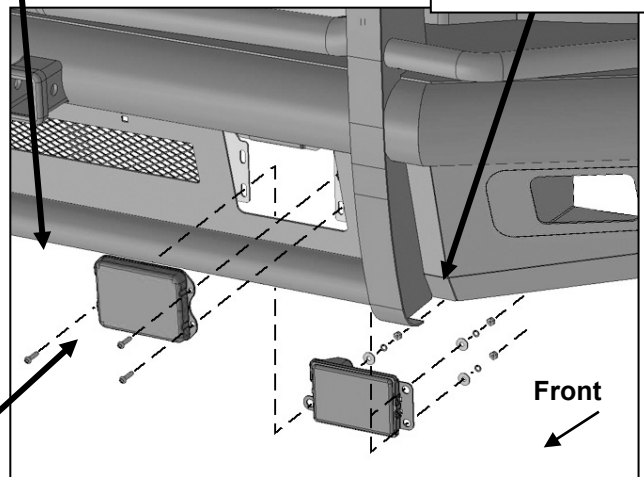
Adaptive cruise
control and Adapter

- (3) 6mm x 25mm Button Head Bolts
- (3) 6mm Flat Washers
- (3) 6mm Lock Washers
- (3) 6mm Hex Nuts



(Fig 14) Attach Adapter Plate with "Late" ACC and plastic cover to the ACC Brackets

"Early" Adaptive
cruise control

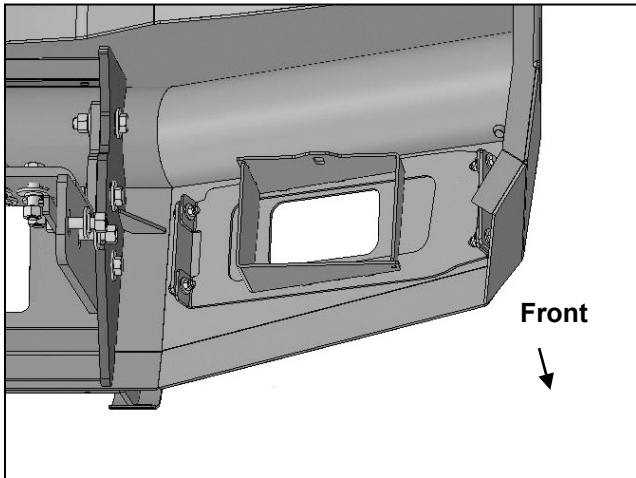


(Fig 15) Attach "Early" ACC and plastic cover to the ACC Brackets

ACC Plastic
Cover

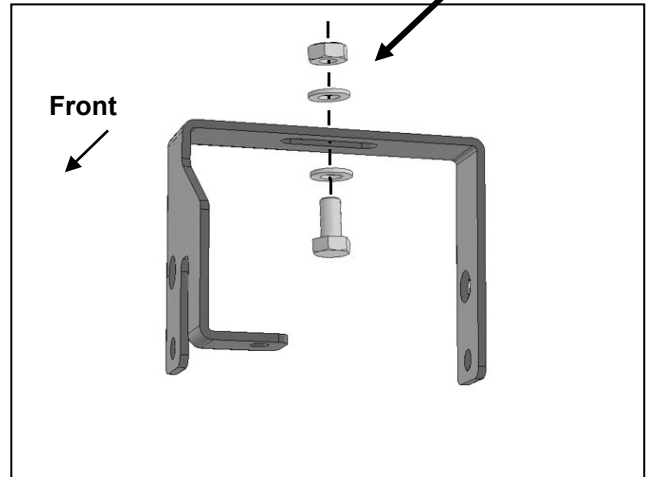
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Passenger/right Side Installation Pictured

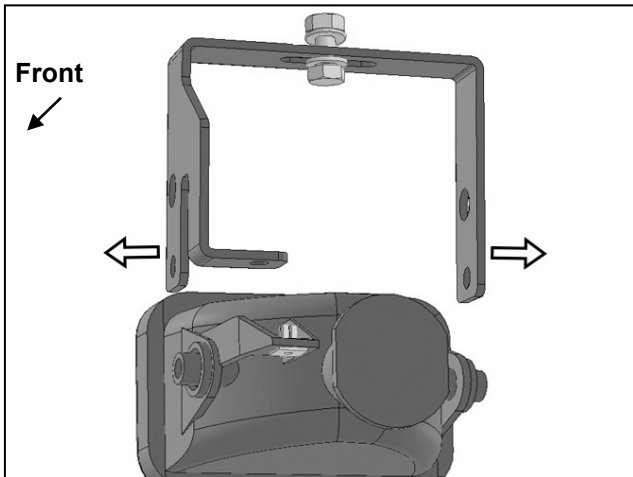


(Fig 16) Passenger/right OE rectangular fog light mounting location

**8mm x 25mm Hex Bolt
(2) 8mm Flat Washers
8mm Nylon Lock Nut**

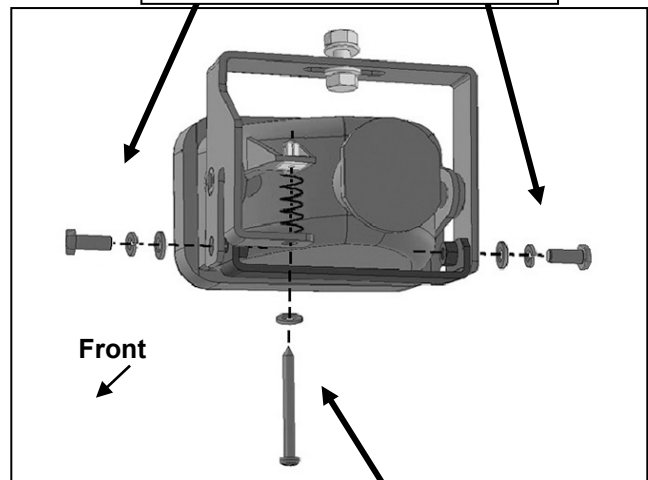


(Fig 17) Optional OEM fog light installation (light not included). Attach passenger/right Upper Bracket to the slot in top of the opening



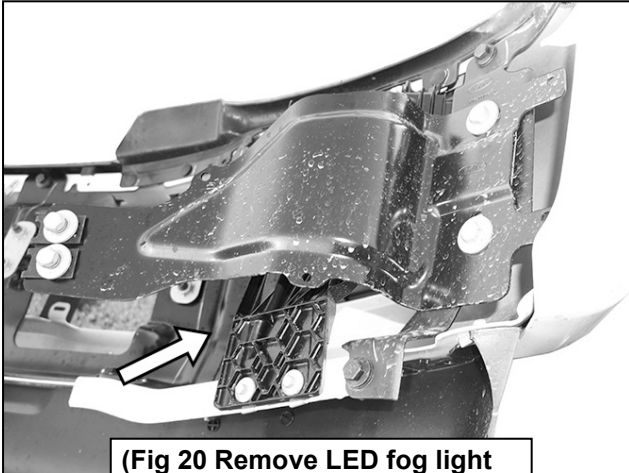
(Fig 18) Carefully spread sides to slide OEM fog light into position in pivot holes

**(2) 6mm x 16mm Hex Bolts
(2) 6mm Lock Washers
(2) 6mm x 12mm Flat Washers**



(Fig 19) Attach lower U Bracket to Upper Bracket. Reuse factory adjustment hardware (screw, spring and plastic nut)

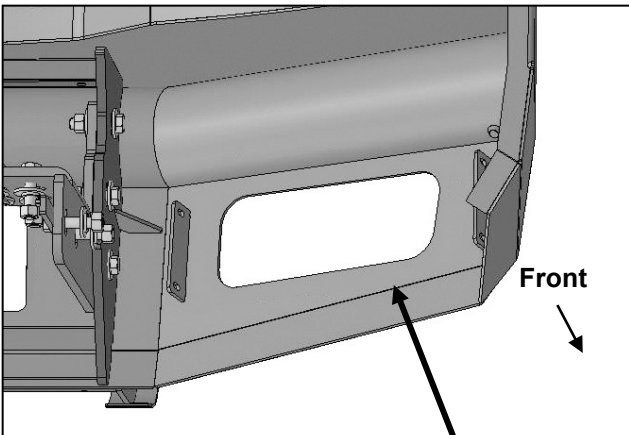
**HEAVY DUTY REPLACEMENT FRONT BUMPER
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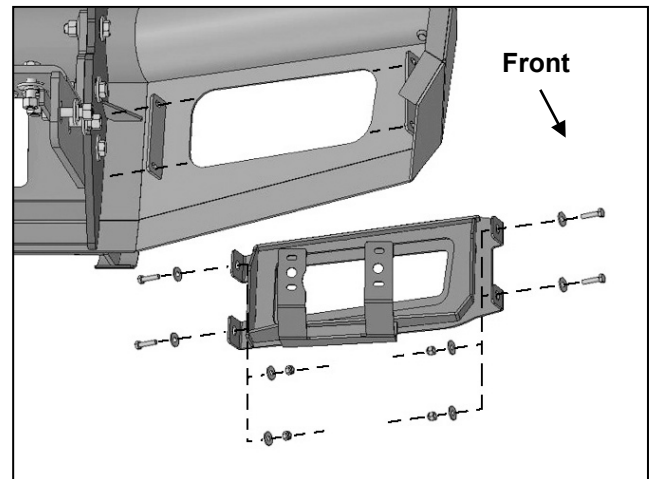
(Fig 20) Remove LED fog light assembly from factory bumper



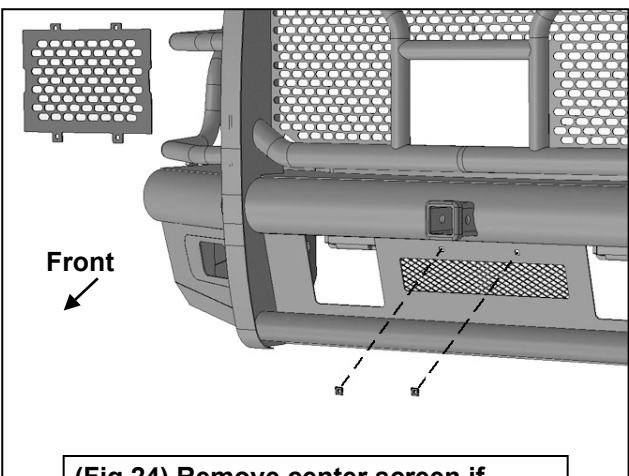
(Fig 21) Remove screws to remove narrow LED fog light from plastic mount



(Fig 22) Remove fog light mount from back of Bumper (passenger/right side illustrated)



(Fig 23) Reuse screws to attach LED fog light to Light Mount. Reuse hardware to attach LED Fog Light assembly to tabs on back of Bumper



(Fig 24) Remove center screen if equipped with grille mounted camera. Install Plastic Plugs for license plate