

# Rear Bumper Installation Instructions

P/N 210042: Ford, Super Duty, F-250/F-350, Rear Bumper

## Before you begin:

- Read all instructions carefully before beginning installation/assembly.
- Stainless steel hardware may bind together when tightening. Apply the supplied anti-seize assembly lubricant to bolt threads.
- *This installation requires two people.*

## Required Tools:

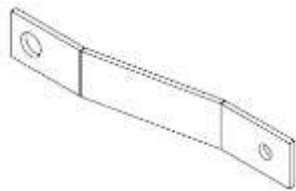
- Standard wrench set
- Leveling tool



## Included Hardware:

<b>P/N</b>	<b>Description</b>	<b>Quantity</b>
70036	Bolt, ½"-13 x 1-1/2", Hex Head, Grade 8, Zinc	4
70033	Nut, ½"-13, Nylock, Grade 8	4
70035	Washer, ½" ID, Flat, Steel	8
70019	Nut, 5/16"-18, Nylock, SS	5
70020	Washer, 5/16" ID x ¾" OD, Flat, SS	6
70022	Bolt, 5/16"-18 x 1", Hex Head, SS	5
70011	Bolt, ¼"-20 x ¾", Hex Head, SS	2
70008	Nut, ¼"-20, Nylock, SS	2
70009	Washer, ¼" ID x 5/8" OD, Flat, SS	4
400503.4	Keys, Tool Box Lock Set	1
70246	Loctite Anti-Seize Packet, 2g	1

## Included Items:



**x2**  
Tailgate Strap



**x1**  
**70718**  
9/16" Grommet



**x1**  
Spare Tire Strap

### **Rear Bumper Installation Instructions:**

1. Remove the factory rear bumper.
2. If you are keeping a spare tire under your truck, follow steps 3-6. If not, skip to step 7.

### **Spare Tire Info:**

3. If you are keeping a spare tire under your truck, you will need to purchase a spare tire rod extension to access it from your Aluminess rear bumper. You can purchase a new tool kit from Amazon or other retailers.
  - a. When purchasing a new tool kit for your spare tire, make sure to verify that the tool kit is designed for your year-range truck. Depending on the year of your truck, the new tool kit will come with a different length socket extension.
  - b. Dorman Products supplies a variety of spare tire tools, you can purchase their parts from an Autozone, Pep Boys or other parts stores and use the below part numbers that correspond to your truck's year range:
    - i. Ford Super Duty '00-'07                      Dorman PN 926-806
    - ii. Ford Super Duty '08-'16                     Dorman PN 926-779
  - c. Once purchased, you will also need a ¼" drive ratchet and wrench to lower the tire.
4. Remove your spare tire locking lug from the plastic pouch (in glove box) and attach the spare tire socket extension to it by sliding the flat end into the socket followed by installing the 8-32 set screw. Use Loctite on these threads.
5. Install the factory spare tire socket extension into the plastic hole with the key attached at the rear of the vehicle. The end of the factory extension shaft will protrude through a hole in the back of the bumper.
6. A 3<sup>rd</sup> stainless steel strap with 1 large hole with a grommet and 1 smaller hole will be provided for mounting the spare tire extension shaft. The shaft will slide through the larger hole, while the smaller hole will be used as a drill guide to keep your shaft in a specific spot. Find a spot where the spare tire shaft is straight and locks into the key hole. Then drill a hole through the bumper using the stainless-steel strap as a guide, fasten with a nut and bolt. This will keep the spare tire shaft located in the correct spot.
  - a. To lower the spare tire, get a 13mm socket and slide it over the end of the spare tire shaft. You can now use a ratchet to lower and raise your spare tire.

### **Rear Bumper Installation Instructions, cont.**

7. Set the Aluminess bumper on the tow hitch for balance and guide it over the spare tire removal extension shaft.
8. With one person holding the bumper, install the 4 ½"-13 x 1 ½" bolts with large flat washers and nuts; it is easiest to install the bolts into the holes furthest from the center first
9. Tighten all 4 bolts so the bumper will be held in place but can still be moved, but do not fully tighten down the bolts yet
10. Visually inspect and adjust the bumper so it is centered side to side and level on top
11. Re-check the bumper to make sure it is level and tighten down the 4 ½"-13 x 1 ½" mounting bolts to a maximum torque of 100 ft-lbs.

12. If your bumper is equipped with swing arms, you will need to attach the stainless-steel support straps. This must be done one side at a time.
  - a. Open tail gate and detach tail gate cable.
  - b. Remove tailgate cable bolt. Make sure you do only one side at a time so that the tailgate does not fall
  - c. Install support strap with using the tailgate lanyard bolt
  - d. Clamp the protruding support straps to the bumper brush guard vertical blades on each side with the strap's outer edges parallel with the outer edges of the bumper brush guard vertical blades (see Fig 3 below). Verify that the bumper brush guard uprights are not leaning out or in and adjust as necessary to achieve a clean fit. Drill two 5/16-inch holes thru each vertical brush guard upright. *NOTE: Drilling stainless steel requires slow rpm. Drilling fast will heat up and ruin the drill bit. Use wax to lubricate drill and take your time...* Install flat head screw with washer and nut on backside and tighten.
  - e. Repeat steps on other side.
  - f. Carefully open tailgate and check gap between straps and tailgate on both sides. If necessary, you may need to loosen the bumper mounting bolts and adjust bumper to achieve even gaps on both sides.



### **Mounting Your Tire on Swing Arms**

13. If you are installing a spare tire to your swing arm, be sure to place the tire so that it rests on the two support arms before tightening anything down (see **Figure 1**)



**Figure 1.** Rest tire on both support arms (before tightening the lugs or U-bolts down).

*\*NOTE\** Your bumper may look different than the one seen in the above picture.



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