



FORD SUPERDUTY REAR BUMPER INSTALLATION NOTES

Please read before beginning

- *Stainless steel hardware may bind together when tightening—It is recommended that you apply an anti-seize assembly lubricant to the threads of each bolt before assembly*
- *This installation requires two people*

Required tools

- Standard wrench set
- Leveling tool



Included hardware

Quantity

- | | |
|---|-------|
| • Bumper mounting hardware | |
| ○ 70036 – ½”-13 x 1 1/2” Hex bolt, grade 8 | 4 |
| ○ 70034 – ½”-13 Nuts with nylon locking insert | 4 |
| ○ 70035 – ½” Washer (.09 Thickness) | 8 |
| • Support strap | |
| ○ 70008 – Nut, Nylock, SS, 1/4-20 | 4 |
| ○ 70009 – Washer, Flat, SS, 1/4 ID | 4 |
| ○ 70013 – Bolt, Flat Head Soc Cap, SS, 1/4-20 x 1” | 4 |
| ○ Support strap, stainless steel | 2 |
| • License plate hardware | |
| ○ 70011 – 1/4-20 x 3/4” Stainless steel hex head bolt | 2 |
| ○ 70008 – 1/4-20 Nuts with nylon locking insert | 2 |
| ○ 70009 – 1/4 x 5/8 Washer SS (.03” Thick) | 4 |
| • 400503.4 – Keys, Tool Box Lock Set | 1 Set |
| • Ford Spare tire removal extension shaft | 1 |

Assembly instructions

1. Remove the existing bumper
2. Remove your spare tire locking lug from the plastic pouch (in glove box) and attach the spare tire removal extension bar to it by sliding the flat end into the socket followed by installing the 8-32 set screw. Use loctite on these threads.
3. Install the spare tire removal extension shaft into the plastic hole at the rear of the vehicle. The female 3/8” socket drive will extend outward and will be positioned to protrude inside the bumper tool box.
4. Set the Aluminess bumper on the tow hitch for balance and guide it over the spare tire removal extension shaft.
5. 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
6. 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
7. Visually inspect and adjust the bumper so it is centered side to side and level on top

8. 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
9. 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 straps 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 1/4 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.