



## **FORD REAR BUMPER NO BRUSH GUARDS** **INSTALLATION INSTRUCTIONS**

### **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 2 people*
- *Unless otherwise specified, refer to the general torque value at the end of the instructions for specified torque values.*



### **Included Hardware:**

- BUMPER MOUNTING
  - 1. 70033- 1/2-13 Nylock Nuts SS 6
  - 2. 70035- 1/2 Washer F/W STL Zinc (.09 Thickness) 12
  - 3. 70036- 1/2-13 x 1 1/2" Hex Bolt Grade 8 6
- 400503.4- KEYS 1 set
- Antiseize Packet, 2g 1

### **Installation Procedure:**

1. Remove the existing bumper.
2. Installation of the Aluminess Bumper:
  - a. Set the Aluminess bumper on the tow hitch for balance.
  - b. Install the six 1/2"-13 x 1 1/2" bolts with large flat washers and nylock nuts.
    - i. It is easiest to have on person hold the bumper while another installs one bolt on each side first
      1. The hole furthest from the center on each side is the easiest to do first.
  - c. Tighten all six bolts so the bumper will be held in place but can still be moved.
    - i. Do not fully tighten the bolts until the straps are secured.
  - d. Adjust the bumper so it is centered side to side and level.
  - e. Tighten the six 1/2"-13 x 1 1/2" mounting bolts.



3. The tow light receptacle can be mounted to the bottom of the bumper or to the side of the lock box. It is less likely to get damaged if it is mounted out of sight to the side of the lock box. You will need to reroute the wire harness before installing the bumper.
  - a. Install the tow light receptacle.

<b>General Torque Values</b>			
<b>Size</b>	<b>Stainless Steel</b>	<b>Zinc</b>	<b>Grade 8</b>
#6-32	10 lb-ft	--	--
#8-32	18.4 lb-ft	--	--
#10-32	26.6 lb-ft	--	--
1/4"-20	5.3 lb-ft	7.8 lb-ft	9 lb-ft
5/16"-18	10.9 lb-ft	16 lb-ft	18 lb-ft
3/8"-16	19.4 lb-ft	28.3 lb-ft	33 lb-ft
7/16"-14	31 lb-ft	45 lb-ft	52 lb-ft
1/2"-13	47 lb-ft	69 lb-ft	80 lb-ft
M6	4.7 lb-ft	5.8 lb-ft	--
M8	11.3 lb-ft	14.1 lb-ft	--
M10	22.3 lb-ft	27.9 lb-ft	--
M12	38.9 lb-ft	48.7 lb-ft	--



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