



REAR BUMPER INSTALLATION INSTRUCTIONS 1992-2014 FORD VAN PN:210005.6 & 210005.7

Please read before beginning

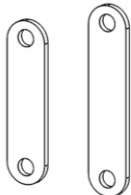
- *Stainless steel hardware may bind together when tightening— It is recommended that you apply an anti-seize assembly lubricant to the threads of each bolt before assembly*
- *This installation requires two people*
- *You may want to contact a body shop to perform certain steps of this installation if you are not comfortable with wiring or heavy tools*
- *Unless otherwise specified, refer to the general torque value at the end of the instructions for specified torque values.*



Required tools

- Standard wrench set
- Allen wrench set
- (Optional) Pneumatic air chisel
- Hammer
- Metal punch
- Leveling tool

Included Parts/Subassemblies



x2 (short; PN 350175)
x2 (long; PN 350175.1)
Ford Van Straps



x2
**Door Pin Bolt
(350177)**

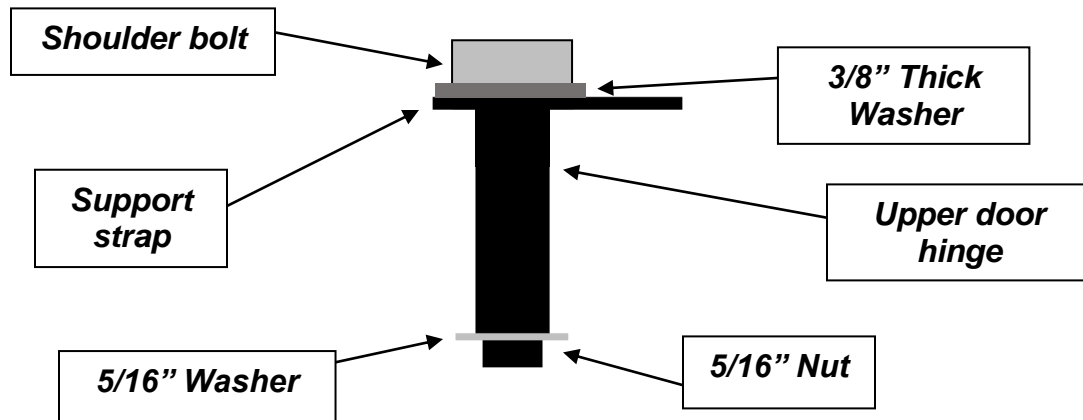


Included hardware **Quantity**

- Bumper mounting hardware
 - 70036 – 1/2"-13 x 1 1/2" Hex bolt, grade 8 6
 - 70033 – 1/2"-13 Nuts with nylon locking insert 6
 - 70035 – 1/2" Washer (.09 Thickness) 12
- Support strap
 - 70027 – 3/8" Thick Washer 2
 - 70028 – 3/8" Stainless Steel Washer 2
 - 70029 – 3/8"-16 x 1 1/2" Stainless steel bolt 2
 - 70118 – 5/16"-18 Thin Nuts with nylon locking insert 2
 - 70020 – 5/16" SS Washer 2
- License plate hardware
 - 70060 – Bolt, Button Head, Socket Cap, SS, 1/4-20 x 1" 2
 - 70008 – 1/4-20 Nuts with nylon locking insert 2
 - 70009 – 1/4 x 5/8 Washer SS (.03" Thick) 4
- Tire Rack Mounting Hardware
 - 70479 – 5/32", Tamper Resistant, Hex Bit, 1
 - 401132 – 1/4" Hex Bit Holder, Key Chain 1
- 400503.4 – Keys, Tool Box Lock Set 1 Set
- Antiseize Packet, 2g 1

Assembly instructions

1. Remove the existing bumper
2. Before installing the new bumper, you will need to remove the **upper door hinge pins** on each side:
 - Tape a piece of cardboard below the hinge to protect the paint on the van
 - Drill the bottom of the hinge pin with a 3/8" drill bit 1/4" up into the hinge
 - Use a hammer and punch or air chisel to drive the pin out of the hinge
 - The pin is splined at the top and requires hard blows to remove
3. Use the provided shoulder bolt in place of the removed hinge bolts to attach the support straps to the top of upper door hinge with washers and bolts as shown in picture below



4. 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
5. Set the Aluminess bumper on the tow hitch for balance
6. With one person holding the bumper, install the six 1/2"-13 x 1 1/2" bolts with large flat washers and nuts; it is easiest to install the bolts into the holes furthest from the center first



7. Tighten all six bolts so the bumper will be held in place but can still be moved, but do not fully tighten down the bolts yet
8. Visually inspect and adjust the bumper so it is centered side to side and level on top
9. Bend the support strap so it is flat against the top of the brush guard pole
10. Use the 3/8"-16 x 1 1/2" bolts and 3/8" washers on both sides of the strap to bolt the strap into the threaded hole on top of the brush guard pole
11. The installed support strap should resemble the picture below



12. Re-check the bumper to make sure it is level and tighten down the six 1/2"-13 x 1 1/2" mounting bolts to a maximum torque of 100 ft-lbs
13. Install the tow light receptacle if you have one
14. Move the license plate from back of the van to the bumper using the supplied 1/4"-20 x 3/4" bolts, 1/4" Washers, and 1/4"-20 Nylock Nuts

Tire Rack Installation Instructions

1. Loosely fasten the Tire Mount Bracket to the slotted channel, going through the bracket first, using the 3/8" carriage head bolts, washer, and nuts to mount. Reference Figure 1.

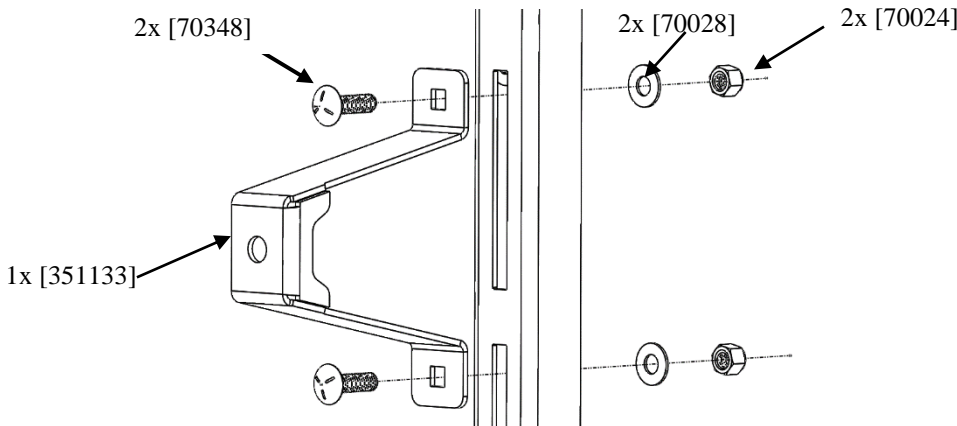


Figure 1: Mounting Tire Bracket

2. Place the mounting bracket in the correct location by placing your tire on the tire supports and then adjusting the bracket vertically until the center hub aligns with the center of the bracket.
3. Once the bracket is in place remove the tire and tighten the hardware holding the bracket in place.



4. Place the tire on the support stands and mount the wheel wedge, using the 5" hex head bolt, washer and star washer. Reference Figure 4 and 5.

NOTE: Tighten down bolt until snug with wedge (it should be very hard/near impossible to rotate the wedge by hand. Once at this point tighten 2 more full rotations.

Note: Preferred torque spec is 45 inch pounds

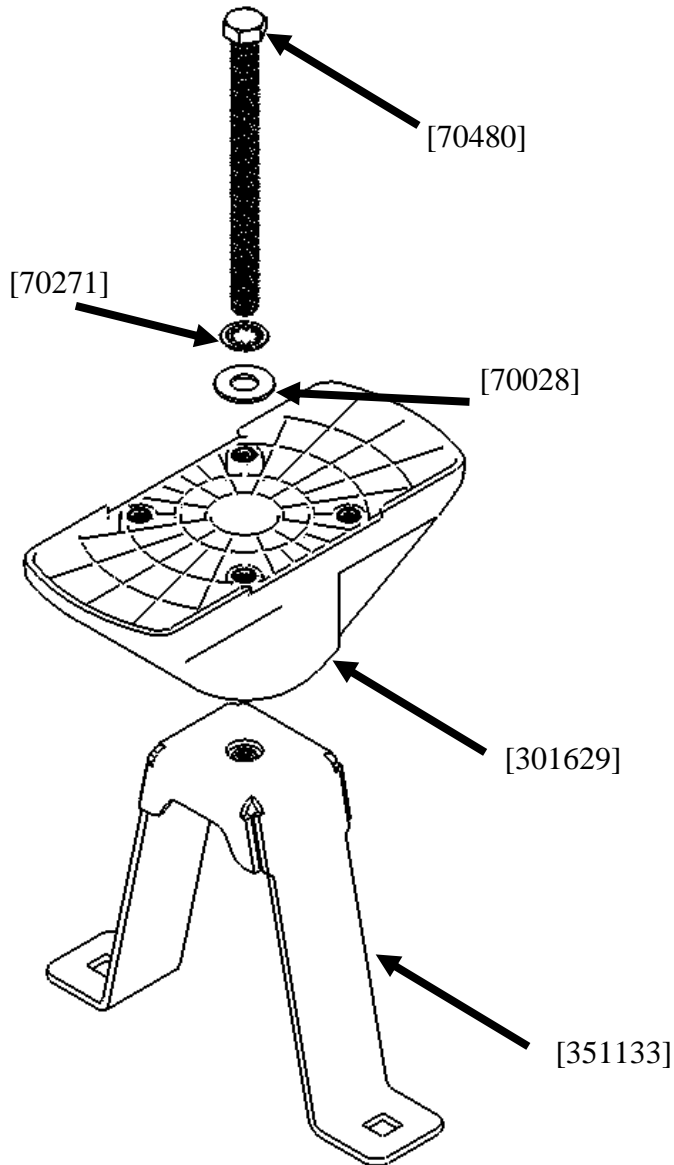


Figure 4: Wheel Wedge Assembly



Figure 5: Tire Mount Assembled

5. [Optional] If desired, you can mount a Rotopax to the wheel wedge. After installing the cover [Step 6], bolt the rotopax mount through the wheel wedge cover to the wheel wedge using the security bolts [70478], as shown below in figure 6. Then simply install the rotopax onto the mount.



Figure 6: Rotopax Mount



- Once everything is securely fastened, bolt the cover to the wheel wedge using the included special bit [70479], and bolts [70478] . Reference Figure 7.

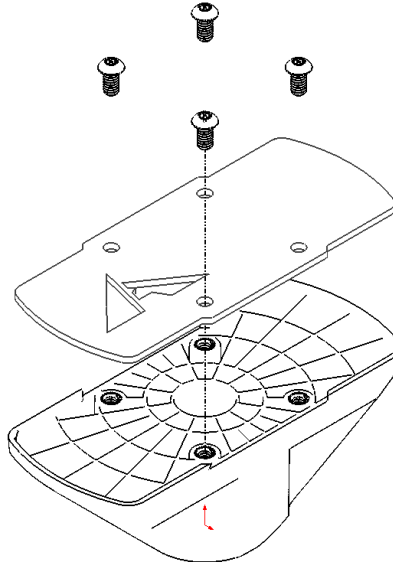


Figure 7: Wheel Wedge, Cover Mounting

General Torque Values			
Size	Stainless Steel	Zinc	Grade 8
#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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