

2019-26 SPRINTER FRONT BUMPER INSTALLATION INSTRUCTIONS

SKUS: 210769, 210769.1

IMPORTANT

- APPLY ANTI-SEIZE TO STAINLESS HARDWARE
 - Stainless steel hardware may bind together when tightening—**Anti-seize** lubricant must be applied to the threads of each bolt before assembly.

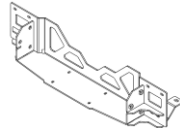
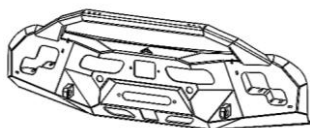
Required Tools

- Ratchet with extension, sockets, and wrenches. Sizes: 13 MM, 14 MM, 18 MM, 3/8", 7/16", 1/2", 3/4"
- Torx driver set. Sizes: T25, T30, T35, T45
- Torque wrench
- Phillips screwdriver



- Slotted screwdriver
- Hammer (optional)
- Small prybar (optional)
- Push-pin remover

<i>INCLUDED HARDWARE</i>		
PART NO.	QTY.	DESCRIPTION
70008	2	HEX LOCKNUT, 1/4-20, SS
70036	6	HHCS, 1/2-13 X 1 1/2, GR 8
70039	2	FW, 1/4 X 1, SS
70060	2	BHCS, 1/4-20 X 1, SS
70246	1	ANTI-SEIZE
70280	12	FW, .531 X 1.061 X .098, ST, ZINC, GR 8
70750	1	THREAD LOCKER
401018	4	ADHESIVE ZIP TIE MOUNT
90101	4	8" ZIP TIE

<i>INCLUDED COMPONENTS</i>			
PART NO.	DESCRIPTION	QTY.	PICTURE
301923	PARKING SENSOR RETAINER	3	
351871	STEEL WINCH CRADLE	1	
ONE OF THE FOLLOWING: 351872 (IN 210769) 351872.1 (IN 210769.1)	ALUMINESS FRONT BUMPER (BULL BAR SHOWN)	1	
351933	STEEL HITCH RECEIVER	1	

Bumper Removal Instructions

1. ☐ Open and secure the hood.
2. ☐ Remove the (3) screws located on the top of the grille using a T25 driver. **See Figure 1.**

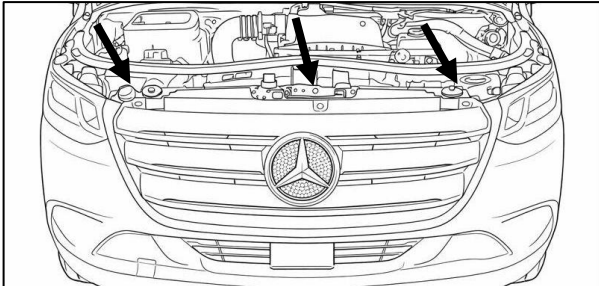


Figure 1: Grille Bolt Locations

3. ☐ Pull the grille away from the bumper, the grille has tabs in 6 locations that must be unclipped. Once the tabs have been released, the grille can be removed. **See Figure 2.**

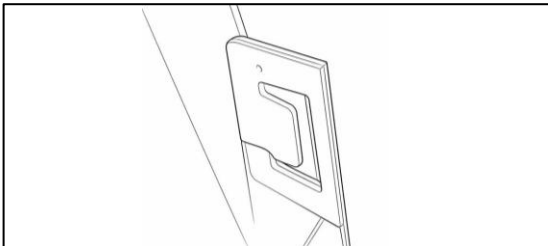


Figure 2: Grille Tab

4. ☐ Uninstall the front camera if applicable.
5. ☐ Remove the screws on both sides of the space left by the grill using a T30 driver. **See Figure 3.**

PRO TIP: Some bumpers may have an additional hex bolt to remove in the recessed hole next to the horn on the left side of the vehicle.

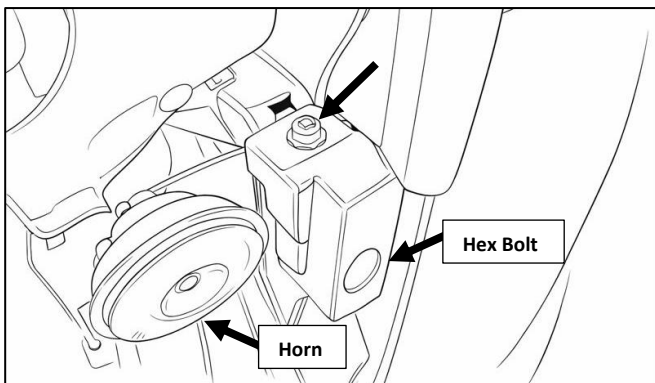


Figure 3: Bumper Inner Bolt Location, Left Side

6. ☐ Use a push-pin remover and a slotted screwdriver to remove the (12) plastic push-pins that are located on the outer edges of the bumper. **See Figures 4 and 5.**

NOTE: 2 push-pins on the underside of the bumper on each side and 4 located in each wheel well.

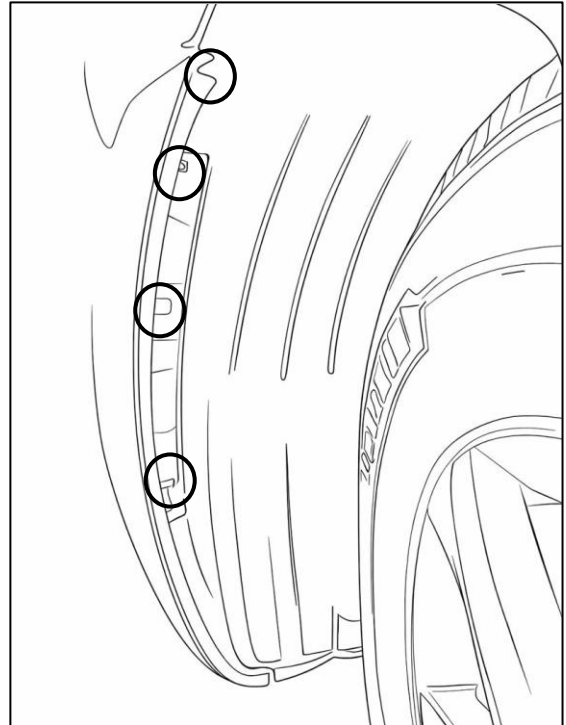


Figure 4: Wheel Well Push-Pins

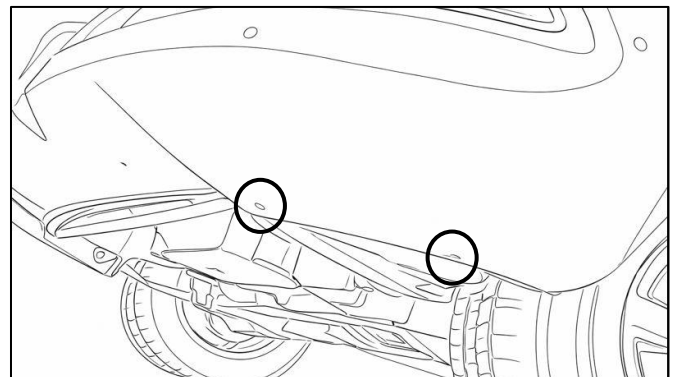


Figure 5: Underside Push-Pins

7. ☐ Using a T45 driver, remove the (2) bolts located at the center of the bumper. **See Figure 6.**

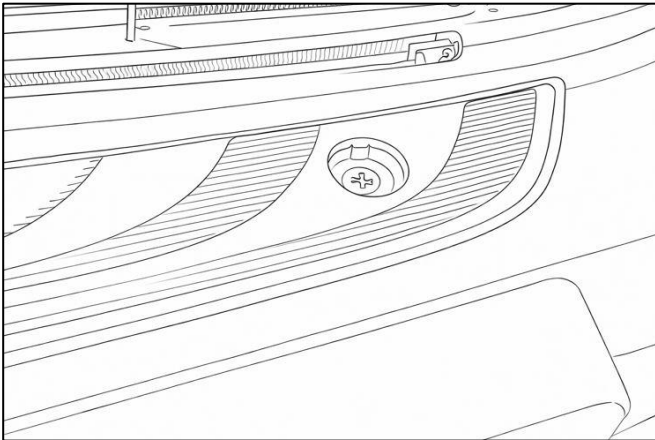


Figure 6: Center Step Bolts

8. ☐ Pull the bumper away from the vehicle to unclip it, starting at each wheel well and working towards the center. **See Figure 7.**

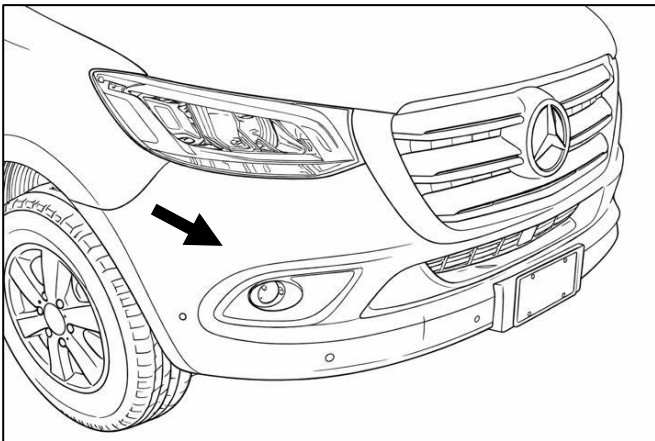


Figure 7: Direction to Remove Stock Bumper

9. ☐ Disconnect the parking sensors, side guard assist, and fog light wiring as applicable.

10. ☐ Using a T25 driver, remove the (2) screws that are holding the front radar sensor enclosure to the top of the radiator and the (1) screw holding it to the housing. Disconnect the wiring and remove the sensor from the enclosure. **See Figure 8.**

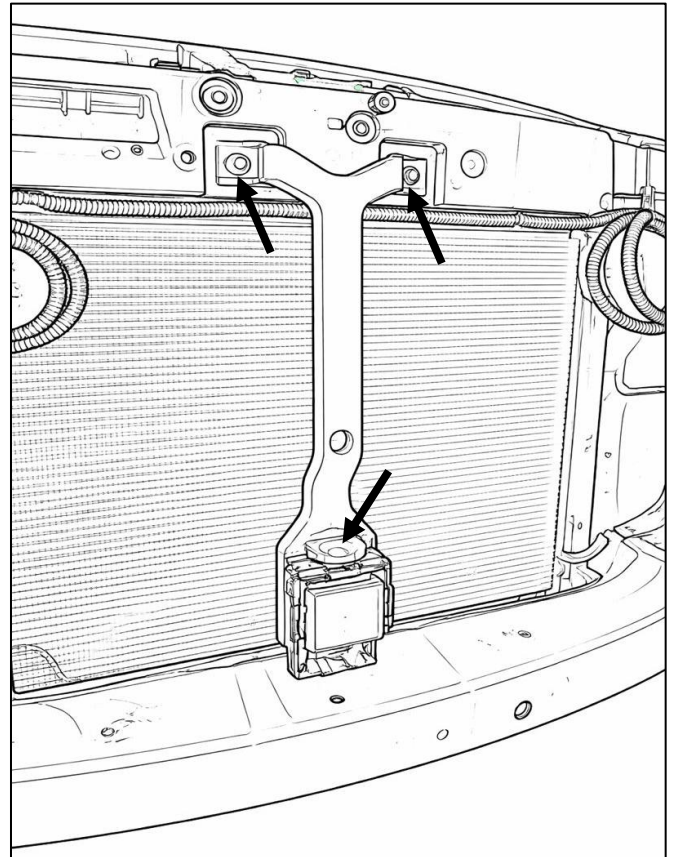


Figure 8: Radar Sensor, Bolts

11. ☐ Using a 13 MM socket, remove the (8) bolts holding the stock crossmember to the frame rail. See Figure 9.

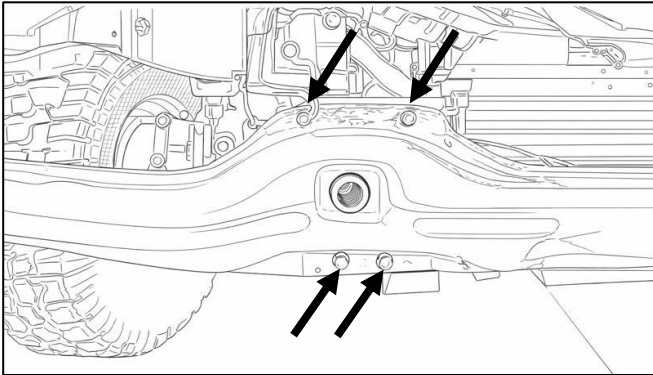


Figure 9: Stock Crossmember Bolting Location, Right Side

12. ☐ Remove the airflow skirt by carefully unclipping it from each side of the radiator and the (3) clips located on the bottom. See Figure 10.

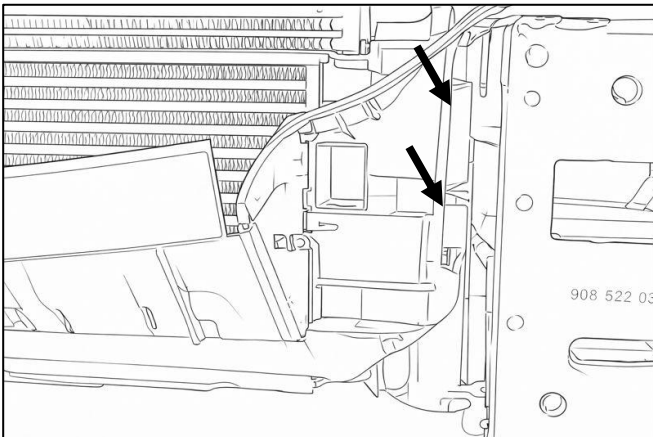


Figure 10: Airflow Skirt Clip Location

13. ☐ Remove the bottom screw that attaches the black crossbar to the underside of the frame rail. See Figure 11.

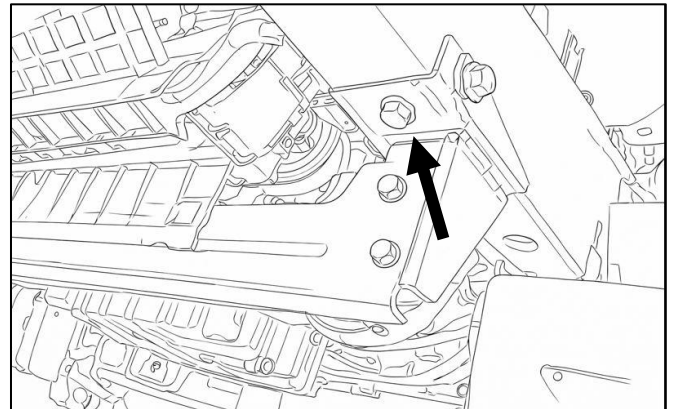


Figure 11: Black Crossbar Bolt to Remove

Bumper Install Instructions

14. ☐ Remove your ALUMINESS FRONT BUMPER from the pallet and unbolt the STEEL WINCH CRADLE and HITCH RECEIVER.
15. ☐ Attach the STEEL WINCH RECEIVER to the underside of the WINCH CRADLE using the 3/8 hardware already used to attach the receiver. See Figure 12.

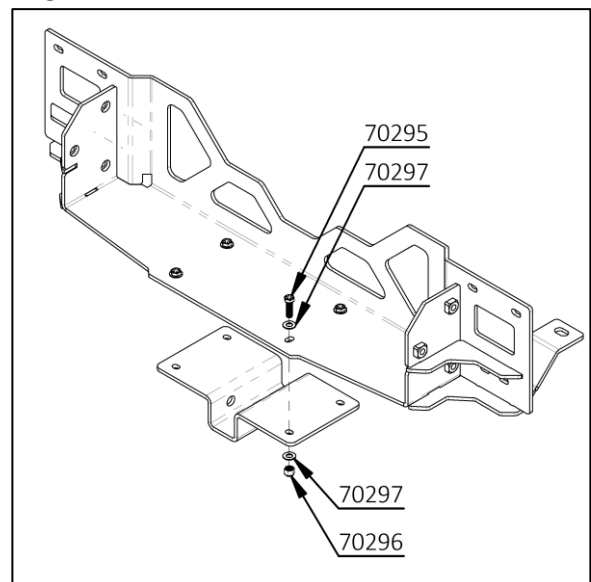


Figure 12: Hitch Receiver Install (3/8" Hardware)

16. ☐ Fasten the WINCH CRADLE to the frame rail using the (8) factory bolts removed in Step 11. Apply thread locker to the threads but do not torque at this time.

Pro Tip: Use the recovery point on the frame located on the right side of the frame rail to help support the WINCH CRADLE.

17. ☐ Reinstall the factory bolt to the underside of the WINCH CRADLE, apply thread locker but do not torque at this time. **See Figure 13.**

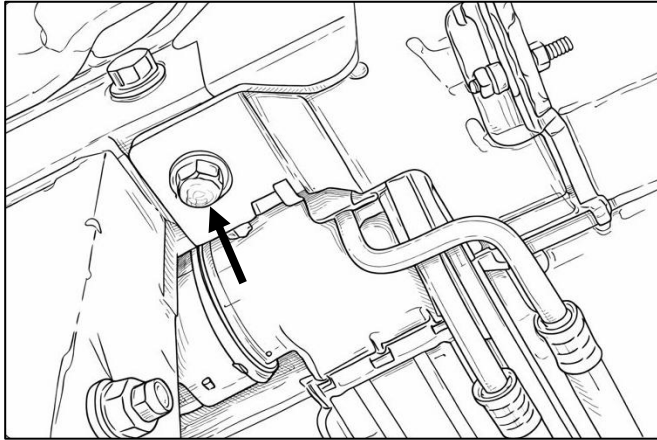


Figure 13: Underside Mounting of Winch Tray

18. ☐ Center the WINCH CRADLE between the frame rails and torque the bolts to OEM specifications.
19. ☐ For 2019-2024, install the front radar sensor into the sensor carriage by locating the protrusions on each side (**Figure 14, A**) and rotating the sensor into the top of the carriage at the 0 degree notch (**Figure 14, B and Figure 15**).

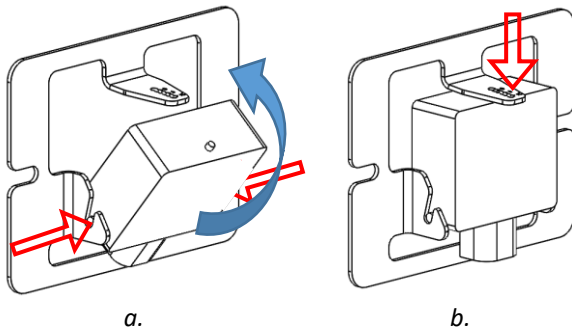


Figure 14: Sensor Installation

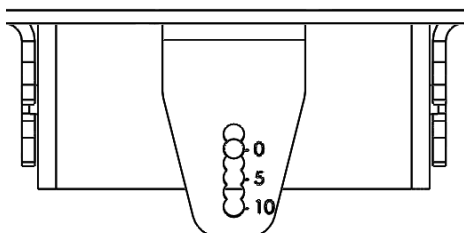


Figure 15: Sensor Alignment from -2.5 degrees to +10 degrees

20. ☐ Install the (2) PARKING SENSOR RETAINERS [301923] by orienting the tab to fit in the relief cutout on the bumper. Ensure the tabs on the retainer are fully extended. **See Figure 16.**

PRO TIP: Three retainers are included, an extra retainer is provided in case of damage during installation.

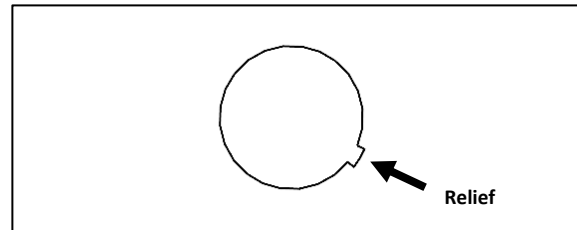


Figure 16: Cutout with Relief

21. ☐ Route the sensor wiring harness through the cutouts in the bumper and install into the retainers with the OEM gasket. Secure the wiring with the zip tie mounts and the zip ties.
22. ☐ The Light Grille's on either side can be adjusted or removed by loosening or removing the ¼-20 hardware.

NOTE: If installing lights, the Light Grilles must be uninstalled, they cannot be installed together.

23. ☐ Using a Dremel or cutoff wheel, cut the mesh from the air flow relief. Cut a large enough relief on the top center section to provide clearance for a winch solenoid controller. **See Figure 17.**

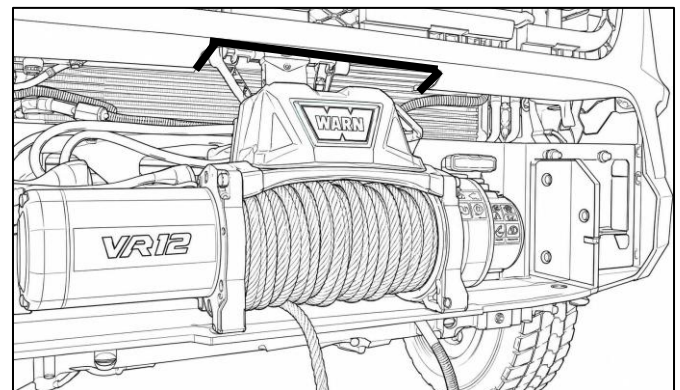


Figure 17: Winch Controller Relief Example

24. ☐ Mark out the location to be cut on the factory plastic front bumper using painter's tape. The width of the cutout should be ~51 wide" (25-1/2" from centerline). Start at the bottom of the license

plate and mark up to the air flow relief. See Figure 18 to Figure 20.

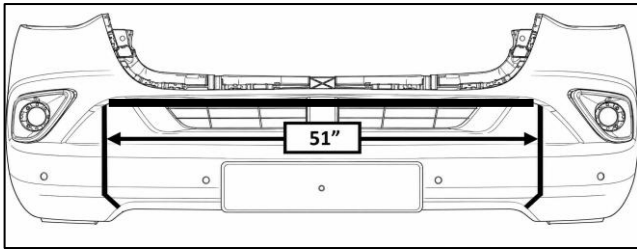


Figure 18: Marking Front Bumper Cutout

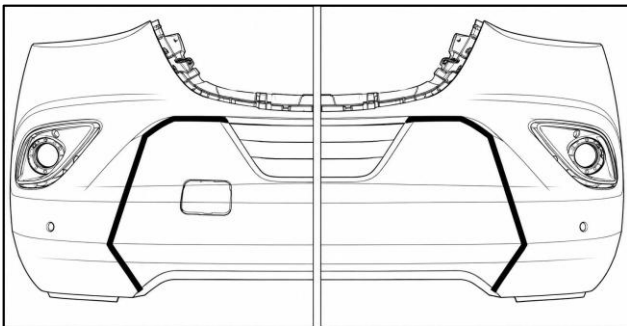


Figure 19: Cutout Close Up – Front

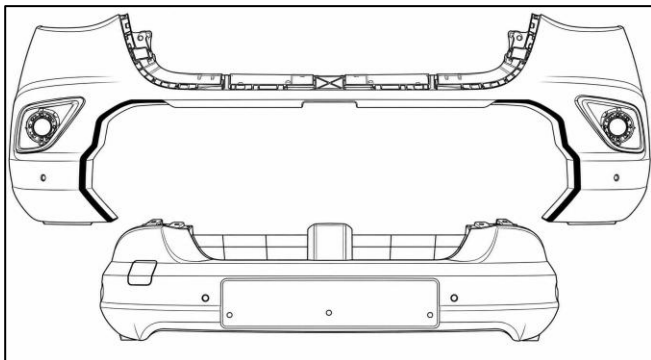


Figure 20: Completed Front Bumper Cutout

PRO TIP: A razor blade or metal deburr tool can be used to clean up the rough plastic edges left from using the cutoff wheel.

NOTE: Do **NOT** cut out air temperature sensor mount on driver's side of bumper. This is necessary for reinstallation. See Figure 21.

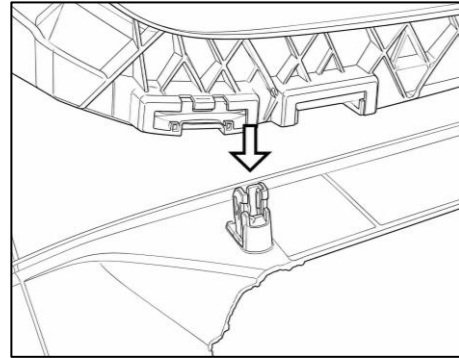


Figure 21: Air Temperature Sensor Mounting Location

NOTE: Do **NOT** cut off the bottom mounting hole in the factory plastic – this hole will be re-used to secure the factory plastic once re-installed. Cut to the inside of this hole. See Figure 22.

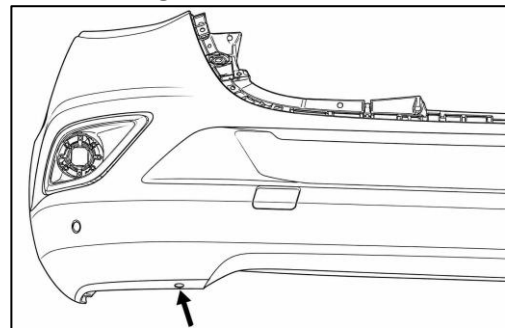


Figure 22: Bottom Mounting Location

25. ☐ Reinstall only the two driver's side parking sensors into the plastic factory bumper if applicable. Leave the remaining parking sensors uninstalled for the time being.
26. ☐ Reinstall the factory plastic bumper back onto the vehicle using only the top two torx bolts. Leave the outer portions of the OEM plastic bumper loose for the time being. See Figure 23.

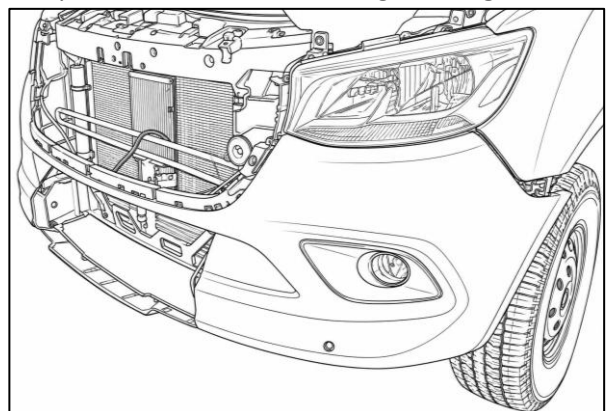


Figure 23: Loosely Installed Factory Front Bumper

27. ☐ Partially install the ALUMINESS FRONT BUMPER onto the steel winch tray. Route the parking sensor wiring harness from behind the factory plastic bumper on the passenger side, through the two relief cuts in the ALUMINESS FRONT BUMPER, and back behind the other side of the factory plastic front bumper on the driver side.
28. ☐ Ensuring no wiring gets pinched and that the wheel liner is inside your ALUMINESS FRONT BUMPER, lift your ALUMINESS FRONT BUMPER onto the WINCH CRADLE. Use the 1/2-13 X 1 1/2 HHCS and washers. Apply thread locker to the threads and fasten the bumper to the WINCH CRADLE. Do not tighten at this time. **See Figure 24.**

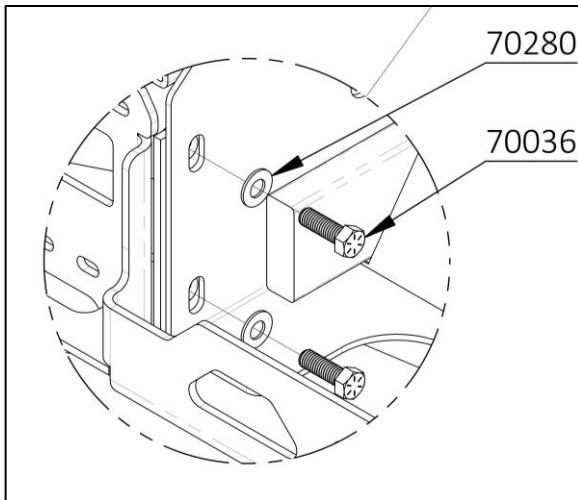


Figure 24: Inner Winch Cradle Install (1/2" Fasteners)

29. ☐ Adjust the bumper into the desired position by evenly tightening all 1/2" hardware. Then torque all hardware to 75 ft-lbs.
- Pro Tip:** Use caution near the headlights when installing the bumper.
30. ☐ Reinstall the grille, locate into the grille tabs on the bumper and reinstall the (3) OEM screws along the top of the grille using a T25 driver.
31. ☐ Using four 1/4" fender washers (70039), two 1/4-20 x 1" bolts (70060), and two 1/4-20 SS nuts (70008), bolt the lower tray of the bumper to the factory plastic bumper. **See Figure 25.**

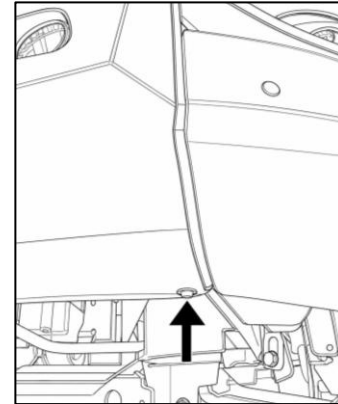


Figure 25: Lower Tray Mounting Bolt Location

32. ☐ Connect all sensors (parking, radar, and temperature) to the vehicle.
33. ☐ Finish installing the OEM bumper using the OEM plastic rivets.
34. ☐ Verify that all sensors are working by driving for 15 to 30 minutes.
35. ☐ Verify tightness of bolts after 100 miles, periodically afterwards, and after any off-road use.

TORQUE SPECIFICATIONS			
SIZE (SAE)	18-8 SS	GRADE 5 ZINC PLATED	GRADE 8 ZINC PLATED
6-32 (IN-LBS)	9.6	15.3	21.5
8-32 (IN-LBS)	19.8	29.5	41.7
10-24 (IN-LBS)	22.8	47.0	62.9
10-32 (IN-LBS)	31.7	48.0	68.0
1/4-20 (IN-LBS)	75.2	91	129
5/16-18 (IN-LBS)	132	188	265
3/8-16 (FT-LBS)	20	28	39
7/16-14 (FT-LBS)	31	44	63
1/2-13 (FT-LBS)	43	68	96
9/16-12 (FT-LBS)	57	109	226
SIZE (Metric)	18-8 SS	CLASS 8.8 ZINC PLATED	CLASS 10.9 ZINC PLATED
M5 X 0.8 (IN-LBS)	38.4	46.8	66.0
M6 X 1.0 (IN-LBS)	57.6	79.2	112.8
M8 X 1.25 (IN-LBS)	99.6	192.0	274.8
M10 X 1.5 (FT-LBS)	13.8	31.6	45.2
M12 X 1.75 (FT-LBS)	21.0	55.1	78.9
M14 X 2.0 (FT-LBS)	29.4	88.1	126.1



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