

INSTALLATION INSTRUCTIONS

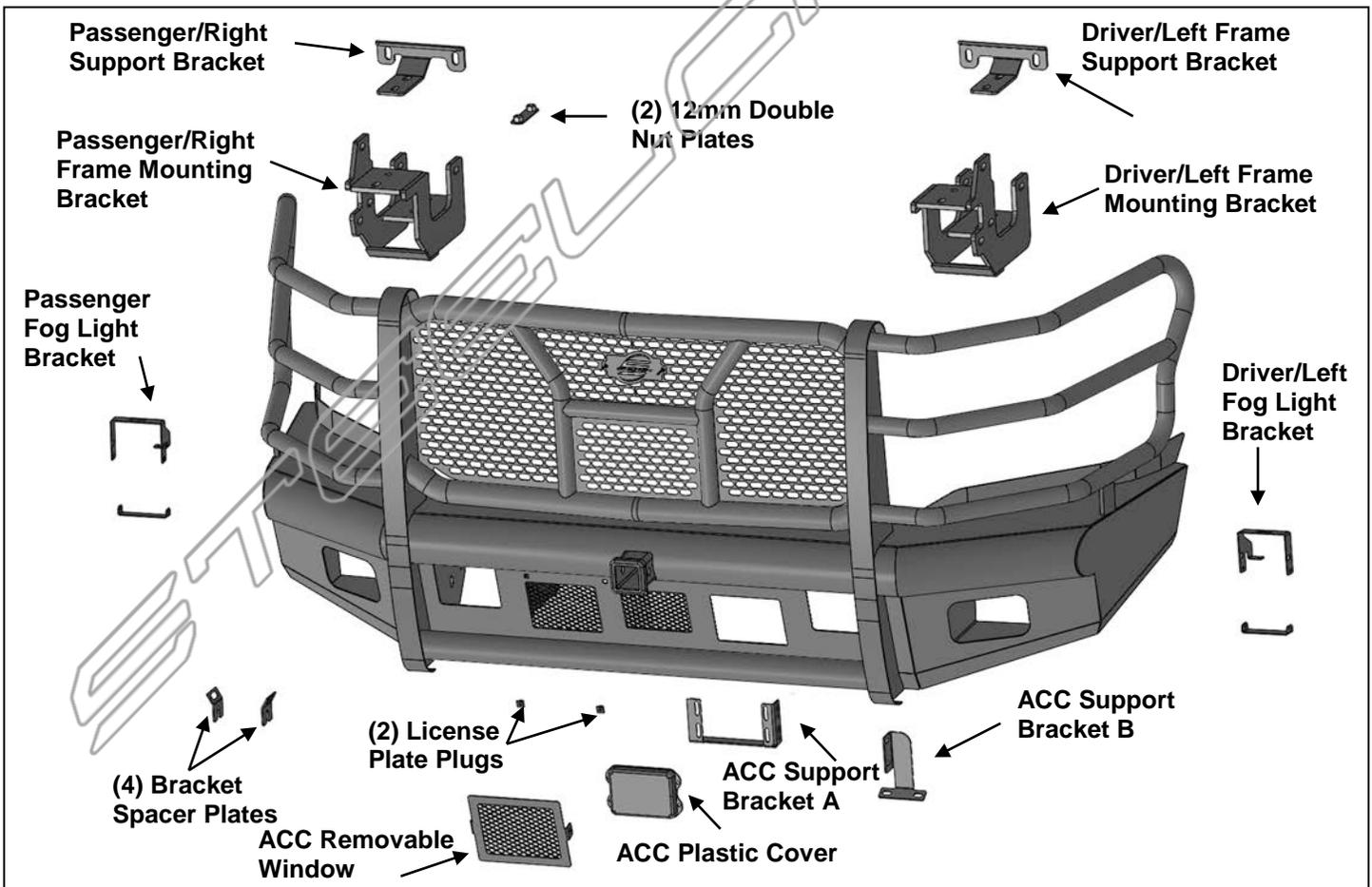
**HEAVY DUTY REPLACEMENT FRONT BUMPER
2018 FORD F150**

STEELCRAFT

**HEAVY DUTY REPLACEMENT FRONT BUMPER
2018 FORD F150**

PARTS LIST:

1	Heavy Duty Front Bumper Assembly	2	12-1.75mm x 170mm Hex Bolts
1	Driver/Left Frame Mounting Bracket	14	12-1.75mm x 45mm Hex Bolts
1	Passenger/Right Frame Mounting Bracket	28	12mm x 37mm x 3mm Flat Washers
1	Driver/Left Frame Support Bracket	12	12-1.75mm Nylon Lock Nuts
1	Passenger/Right Frame Support Bracket	4	12mm Lock Washers
4	Bracket Spacer Plates	4	8-1.25mm x 20mm Hex Bolts
1	Driver/Left Fog Light Upper U-Bracket	8	8mm x 24mm x 2mm Flat Washers
1	Passenger/Right Fog Light Upper U-Bracket	4	8mm Nylon Lock Nuts
2	Lower U-Brackets (Fog Lights)	2	6mm x 25mm Hex Bolts
1	Adapter Cruise Control (ACC) Removable Window	3	6mm x 25mm Button Head Bolts
1	ACC Support Bracket A	4	6mm x 16mm Hex Bolts
1	ACC Support Bracket B	11	6mm x 18mm x 1.6mm Flat Washers
1	ACC Plastic Cover	9	6mm Lock Washers
2	12mm Double Nut Plates	5	6mm Hex Nuts
2	Plastic Plugs for license plate mount	1	Allen Wrench S=4
		1	Allen Wrench S=2.5



PROCEDURE:

REMOVE CONTENTS FROM BOX. VERIFY ALL PARTS ARE PRESENT. READ INSTRUCTIONS CAREFULLY BEFORE STARTING INSTALLATION. BUMPER IS HEAVY, ASSISTANCE IS HIGHLY RECOMMENDED TO AVOID POSSIBLE INJURY OR DAMAGE TO THE VEHICLE. BUMPER INSTALLATION WILL INTERFERE WITH GRILLE MOUNTED CAMERA.

HEAVY DUTY REPLACEMENT FRONT BUMPER 2018 FORD F150

1. Remove the license plate and bracket. Release the wiring harness from the clips attached to the back of the bumper. Move all wiring harnesses away from bumper.
2. Next, remove the plastic bumper pad assembly, **(Figure 1)**. **NOTE:** Release metal clips from back of bumper to remove bumper pad assembly. It may be easier to access bumper hardware with plastic air dam removed from bottom of bumper.
3. Place blocks or jack stands under the front bumper to support it during mounting bolt removal. Once the bumper has been safely supported, remove the large hex nut from the back of each bumper bracket, **(Figure 2)**. Next, from the front of the bumper, remove the (2) factory hex nuts attaching the bumper to each bumper bracket, **(Figure 3)**. **WARNING!** Assistance is required to hold the bumper in place during bolt removal to prevent the bumper from falling. Carefully slide the bumper off over the tow hooks.
4. Remove the passenger side tow hook and plastic cover, (if equipped), from the bottom of the frame, **(Figure 4)**. Repeat to remove the driver side tow hook if equipped.
5. Next, select the passenger side Frame Mounting Bracket. Slide the Bracket over the end of the frame. Insert (1) 12mm x 175mm Long Hex Bolt with (1) 12mm Flat Washer through the outside of the mounting tab on the Frame Bracket, through the frame and inside tab. Secure with (1) 12mm Flat Washer and (1) 12mm Nylon Lock Nut. Insert (1) Spacer Plate down between each mounting tab and the side of the frame, **(Figures 5—7)**. Do not fully tighten hardware.
6. Insert (1) 12mm Double Nut Plate into the open end of the frame. Attach the Frame Bracket to the bottom of the frame and the Double Nut Plate with (2) 12mm x 45mm Hex Bolts, (2) 12mm Lock Washers and (2) 12mm Flat Washers, **(Figures 5 & 8)**. **NOTE:** On models with tow hooks, reuse the factory nut plate and hardware to install the Frame Bracket. Leave hardware loose at this time.
7. Select the passenger side Frame Support Bracket, **(Figure 9)**. On models without tow hooks, attach the Support Bracket directly to the top of the Frame Bracket with (2) 12mm x 45mm Hex Bolts, (4) 12mm Flat Washers and (2) 12mm Nylon Lock Nuts, **(Figure 10)**. Do not tighten hardware at this time. **NOTE:** On models with tow hooks, attach the tow hook to the inside of the frame bracket and repeat step to attach the tow hook to the frame bracket and the Support Bracket, **(Figure 11)**.
8. Reuse the factory hardware to attach the Support Bracket to the front of the frame. Do not fully tighten.
9. Repeat **Steps 5—8** to install the driver side Frame Bracket assembly.
10. If equipped with factory fog lights, unplug both lights and remove the complete light assemblies from back of bumper, **(Figure 12)**. Unplug and remove the adaptive cruise control, if equipped.
11. **Models with factory fog lights:**
 - a. Use a flat blade screwdriver to carefully pop out the tabs on the side of the fog light bracket attaching the light to the bracket, **(Figure 12)**. Pop the light out of the plastic bracket housing.
 - b. Remove the adjustment screw and spring from the light assembly.
 - c. Select the passenger top U Bracket, **(Figure 13)**. Attach the Bracket to the slot in the light opening with (1) 8mm x 20mm Hex Bolt, (2) 8mm Flat Washers and (1) 8mm Nylon Lock Nut, **(Figure 13)**.
 - d. Carefully spread the sides of the Bracket enough to slide the OE plastic fog light between and into the Bracket, **(Figure 14)**. Attach (1) Lower U Bracket to the Upper Bracket with (2) 6mm x 16mm Hex Bolts, (2) 6mm Lock Washers and (2) 6mm Flat Washers, **(Figure 15)**.
 - e. Insert the factory spring between the tab on the Bracket and the light. Insert the screw through the tab, spring and into the fog light, **(Figure 15)**.
 - f. Repeat to install the driver/left fog light.
12. Determine if vehicle is equipped with an adaptive cruise control, (ACC). **NOTE:** Install the ACC assembly onto Bumper before mounting Bumper to end of frame.

Vehicles without ACC:

 - a. Attach the ACC Removable Window to the back of the bumper using (2) 6mm x 25mm Hex Bolts, (4) 6mm Flat Washers, (2) 6mm Lock Washers and (2) 6mm Hex Nuts, **(Figure 16)**.
 - b. Continue to **Step 13**.

Vehicles with ACC:

 - a. Select the ACC Plastic Cover and the ACC Support Bracket A, **(Figure 17)**. Insert (3) 6mm x 25mm Button Head Bolts through the ACC Plastic Cover, the adaptive cruise control and out through the ACC Support Bracket A. Secure with (3) 6mm Flat Washers, (3) 6mm Lock Washers and (3) 6mm Hex Nuts, **(Figure 17)**.

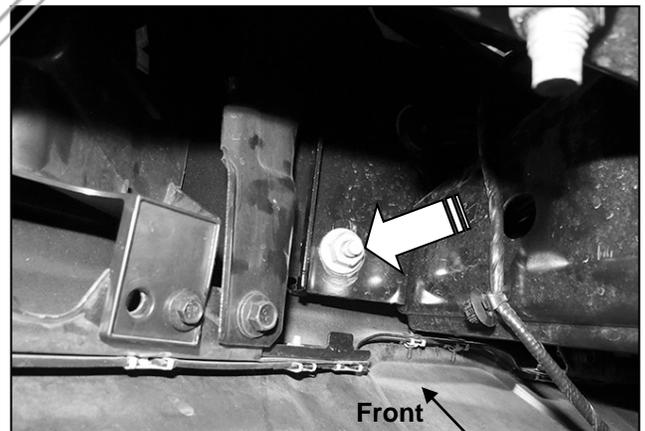
HEAVY DUTY REPLACEMENT FRONT BUMPER 2018 FORD F150

- b. Next, attach the ACC Support Bracket B to Bracket A using (2) 6mm x 25mm Hex Bolts, (4) 6mm Flat Washers, (2) 6mm Lock Washers and (2) 6mm Hex Nuts, **(Figure 18)**.
- c. Attach the ACC assembly to the back of the bumper using (2) 8mm x 20mm Hex Bolts, (4) 8mm Flat Washers and (2) 8mm Nylon Lock Nuts, **(Figure 19)**.
13. On models with grille mounted factory camera, remove the center screen, **(Figure 20)**.
14. With assistance, position the Bumper Assembly onto the outsides of the Frame Brackets. Temporarily support the weight of the Bumper. **WARNING:** To avoid possible injury or damage to the vehicle, do not proceed until the bumper is fully and safely supported.
15. Attach the Bumper to the Brackets with the included (6) 12mm x 45mm Hex Bolts, (12) 12mm Flat Washers and (6) 12mm Nylon Lock Nuts, **(Figures 21 & 22)**. Snug but do not tighten hardware.
16. Level and adjust the bumper and fully tighten all hardware to 65-70ft-lbs. **NOTE:** If additional in-out adjustment is required, loosen Frame Bracket Hardware, slide the Bracket in or out as necessary and fully tighten all hardware.
17. Reattach the wiring harness. Adjust lights as necessary and tighten all fog light bracket hardware.
18. Use the included (2) push-in plastic nuts to attach the front license plate, (if required), to the (2) holes in the front bumper, **(Figure 23)**.
19. Do periodic inspections to the installation to make sure that all hardware is secure and tight.

To protect your investment, wax this product after installing. Regular waxing is recommended to add a protective layer over the finish. Do not use any type of polish or wax that may contain abrasives that could damage the finish. Mild soap may be used to clean the HD Front Bumper assembly.

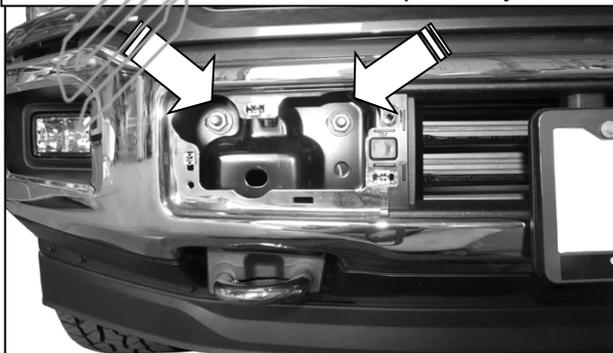


(Fig 1) From behind bumper, release metal clips attaching plastic bumper pad to the bumper

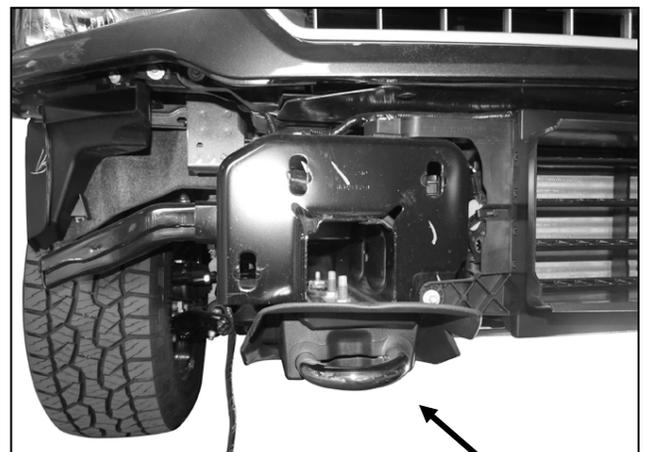


(Fig 2) Remove factory hex nut (arrow) from back of bumper bracket (Driver side pictured)

WARNING! Do not remove bumper bolts unless the bumper is properly supported on blocks or stands or the bumper may fall.

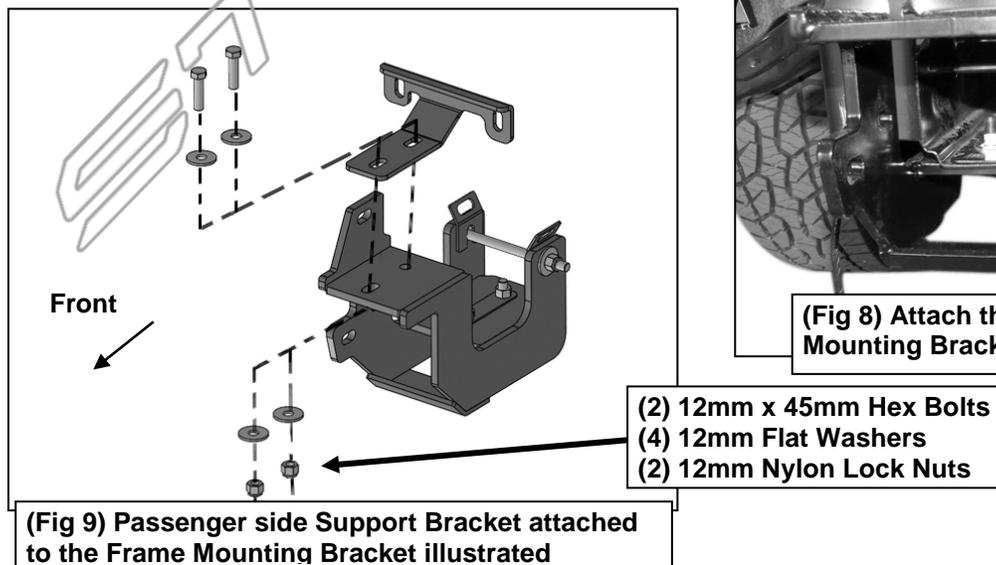
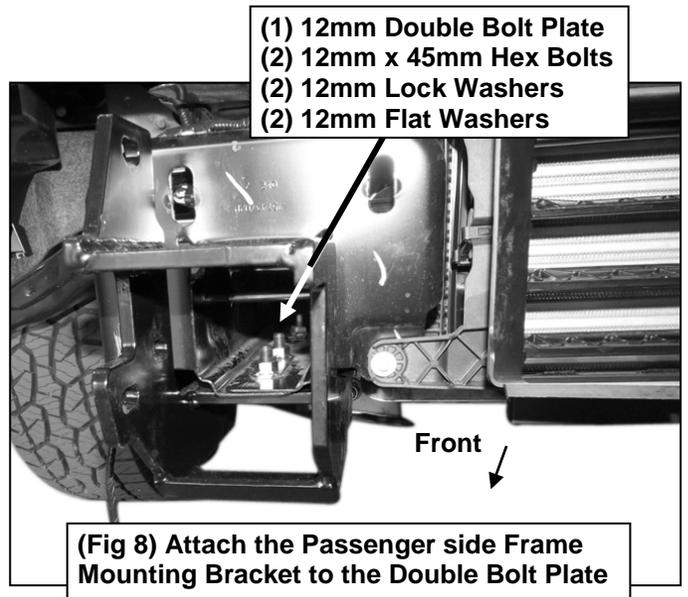
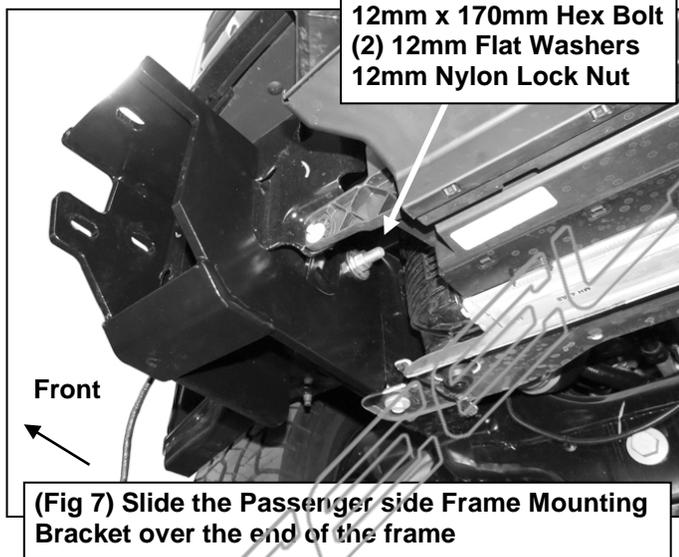
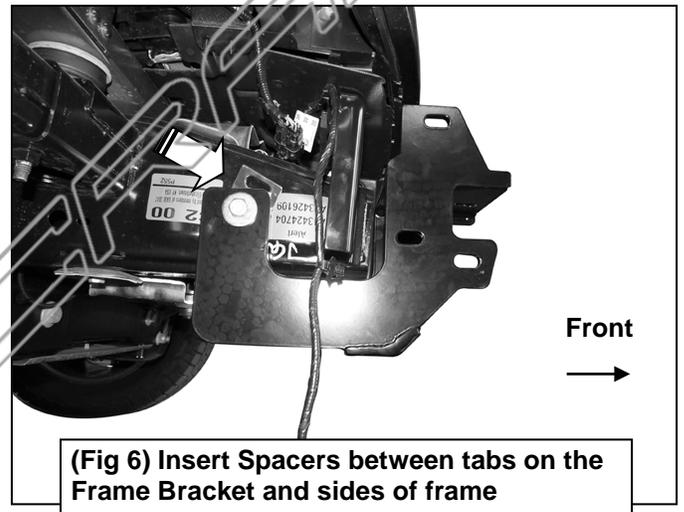
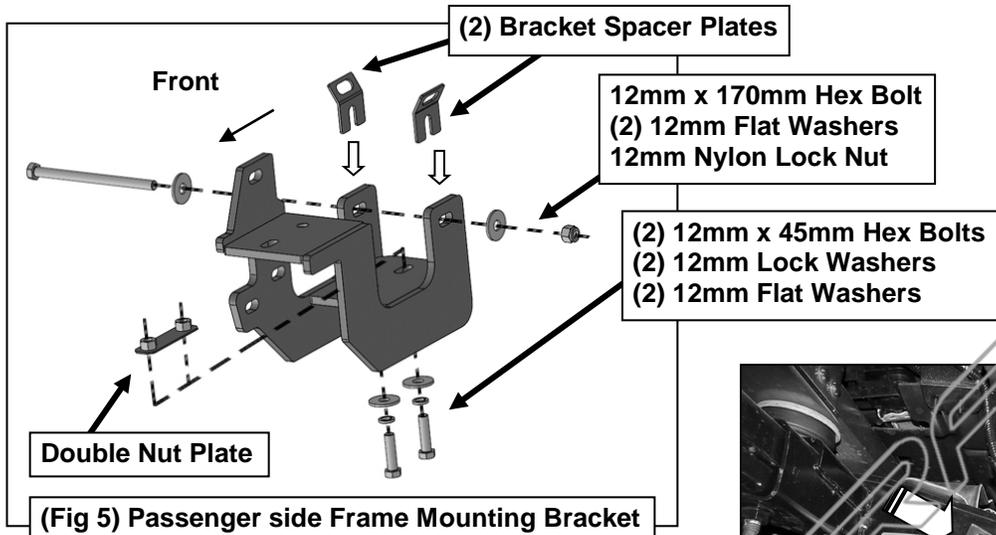


(Fig 3) Remove (2) factory hex nuts from each side

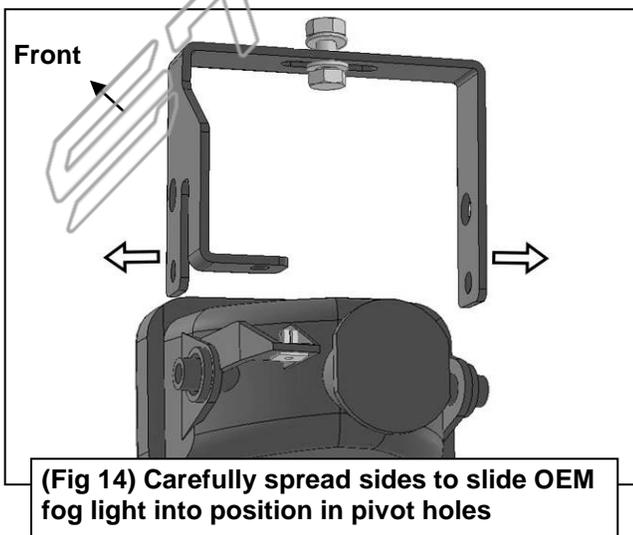
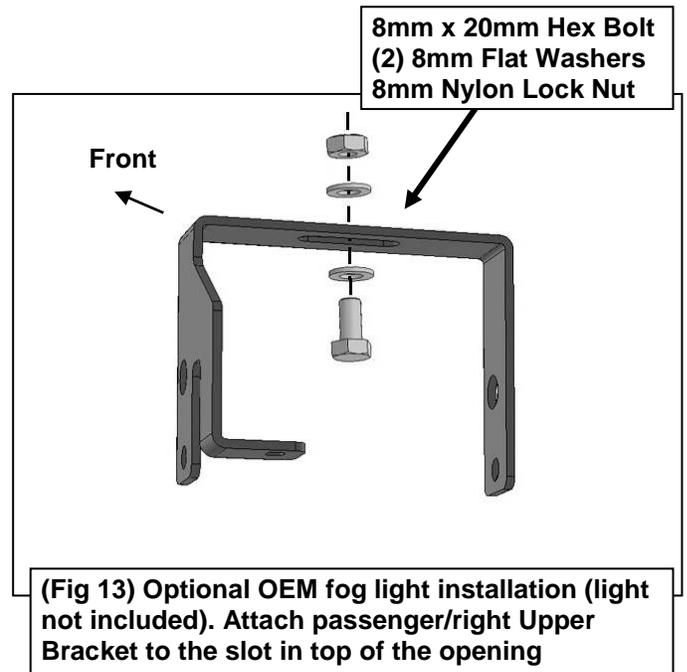
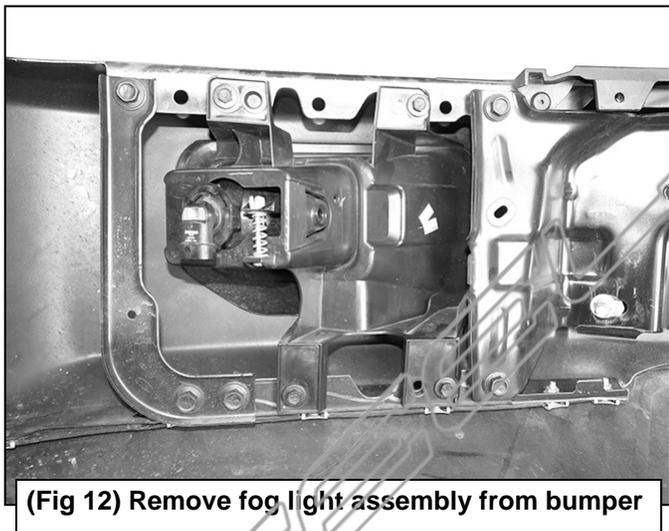
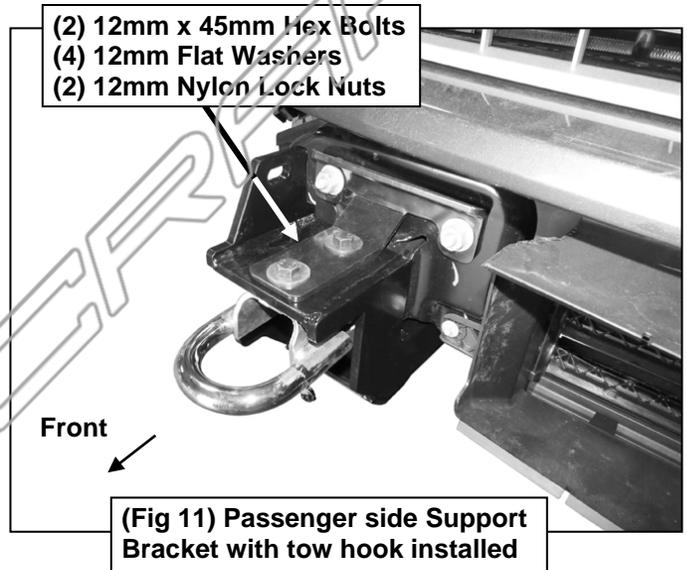
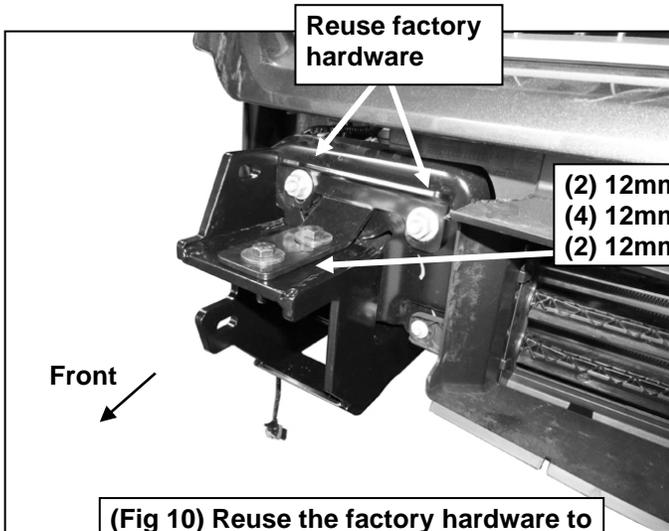


(Fig 4) Remove the passenger side tow hook and plastic cover, (if equipped)

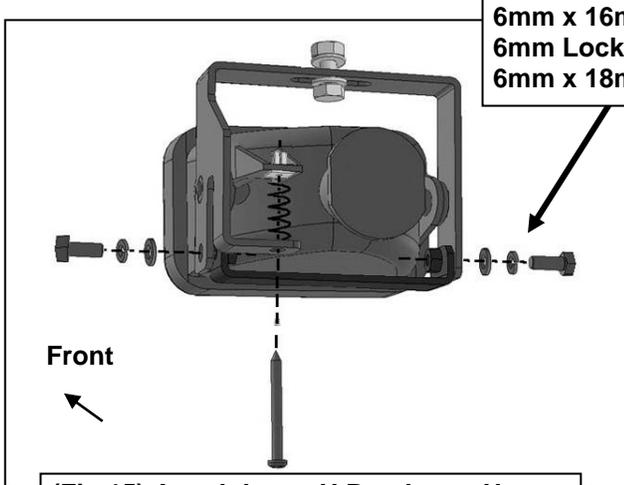
Passenger/right Side Installation Pictured



Passenger/right Side Installation Pictured

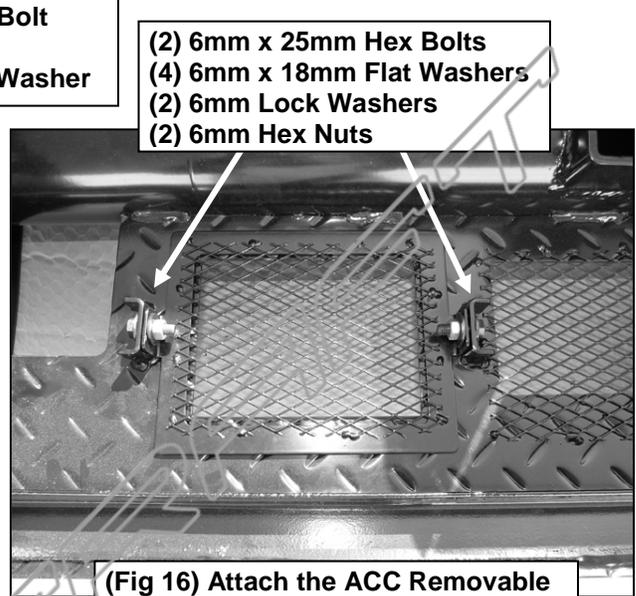


Passenger/right Side Installation Pictured



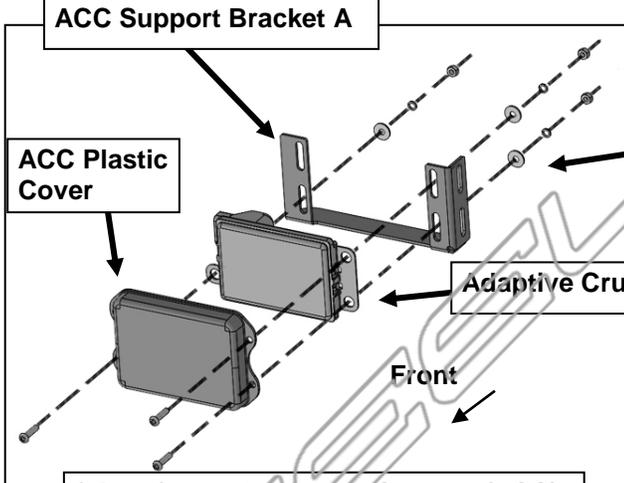
- 6mm x 16mm Hex Bolt
- 6mm Lock Washer
- 6mm x 18mm Flat Washer

(Fig 15) Attach lower U Bracket to Upper Bracket. Reuse factory adjustment hardware (screw, spring and plastic nut)



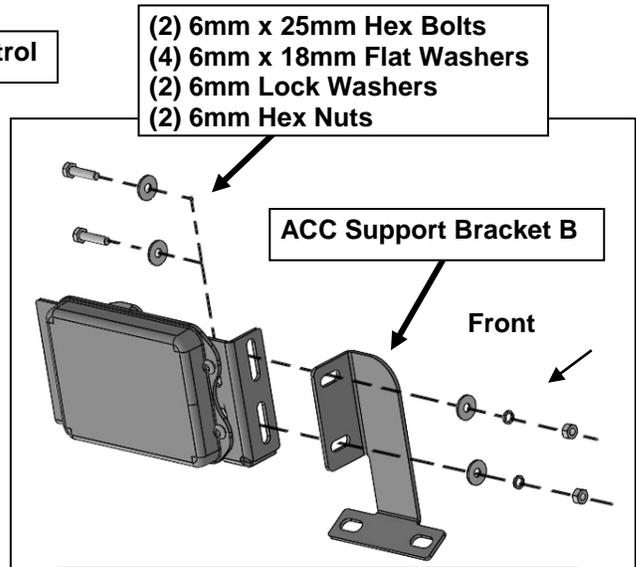
- (2) 6mm x 25mm Hex Bolts
- (4) 6mm x 18mm Flat Washers
- (2) 6mm Lock Washers
- (2) 6mm Hex Nuts

(Fig 16) Attach the ACC Removable Window to the back of the Bumper



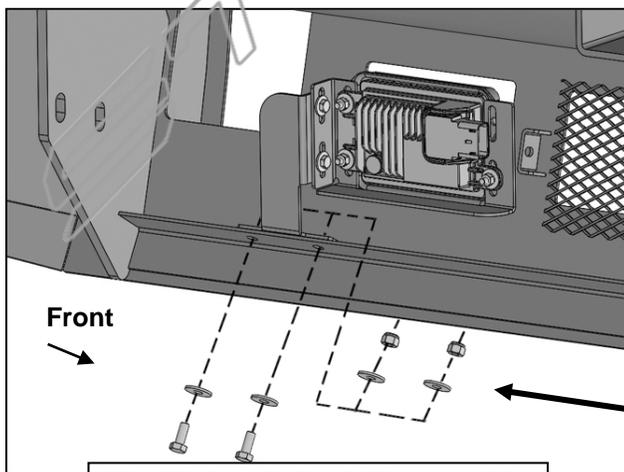
- (3) 6mm x 25mm Button Head Bolts
- (3) 6mm x 18mm Flat Washers
- (3) 6mm Lock Washers
- (3) 6mm Hex Nuts

(Fig 17) Adaptor Cruise Control, (ACC) assembly illustrated



- (2) 6mm x 25mm Hex Bolts
- (4) 6mm x 18mm Flat Washers
- (2) 6mm Lock Washers
- (2) 6mm Hex Nuts

(Fig 18) ACC assembly attached to the ACC Support Bracket B

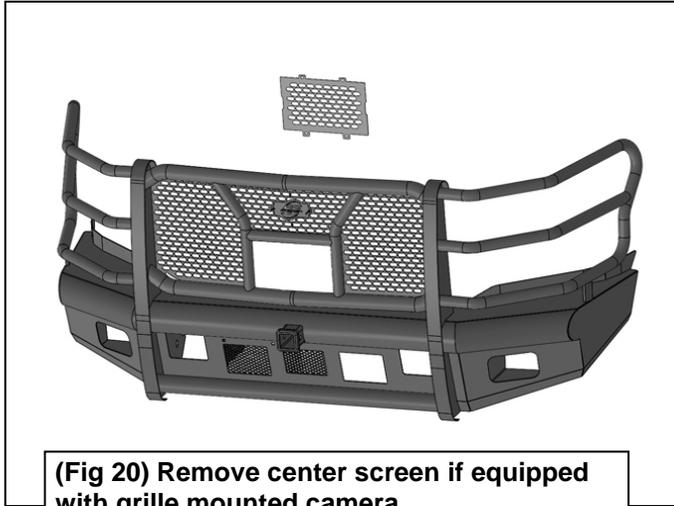


- (2) 8mm x 20mm Hex Bolts
- (4) 8mm x 24mm Flat Washers
- (2) 8mm Nylon Lock Nuts

(Fig 19) Attach the ACC assembly to the back of the Bumper

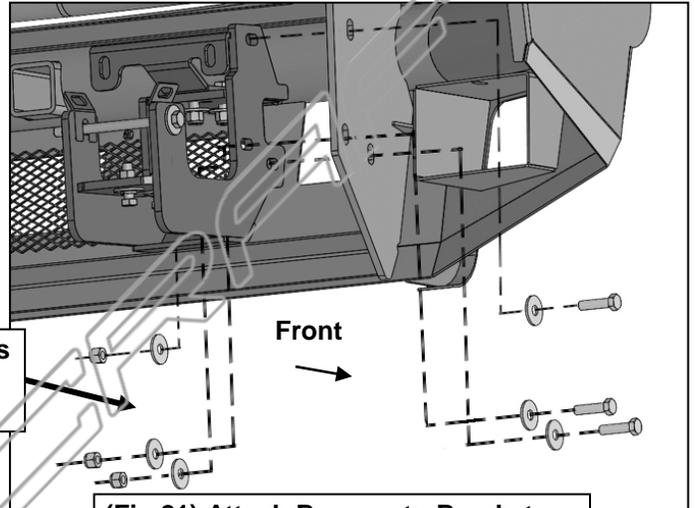
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Passenger/right Side Installation Pictured

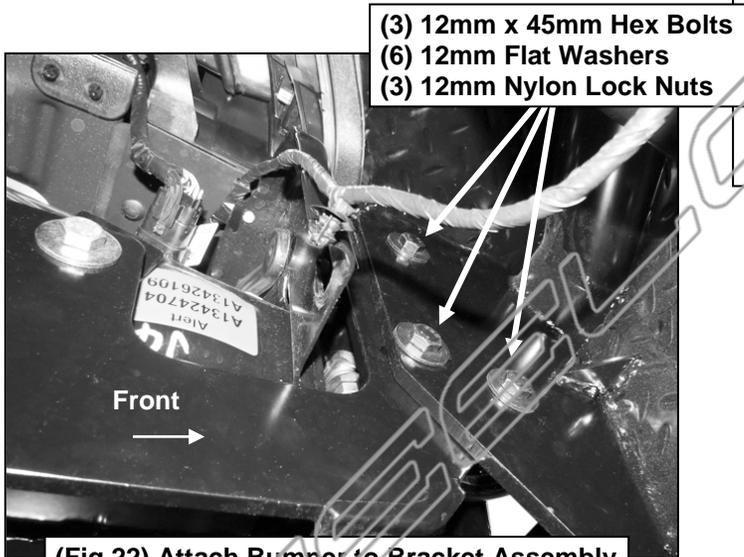


(Fig 20) Remove center screen if equipped with grille mounted camera

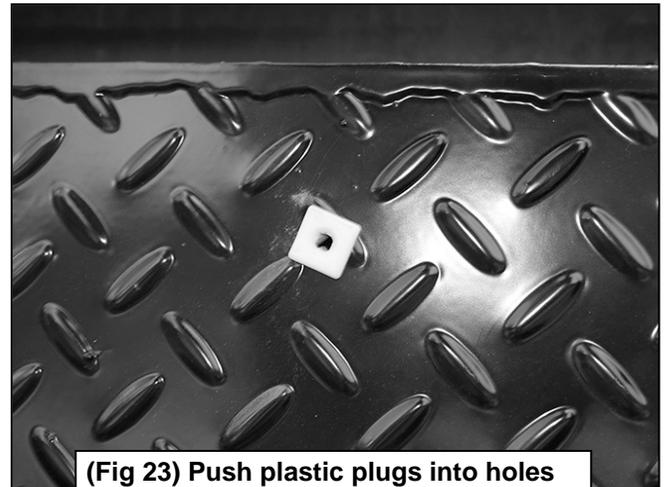
WARNING! Do not crawl under bumper unless the bumper is properly supported on blocks or stands or the bumper may fall.



(Fig 21) Attach Bumper to Brackets



(Fig 22) Attach Bumper to Bracket Assembly



(Fig 23) Push plastic plugs into holes in Bumper for license plate if required



Complete Installation