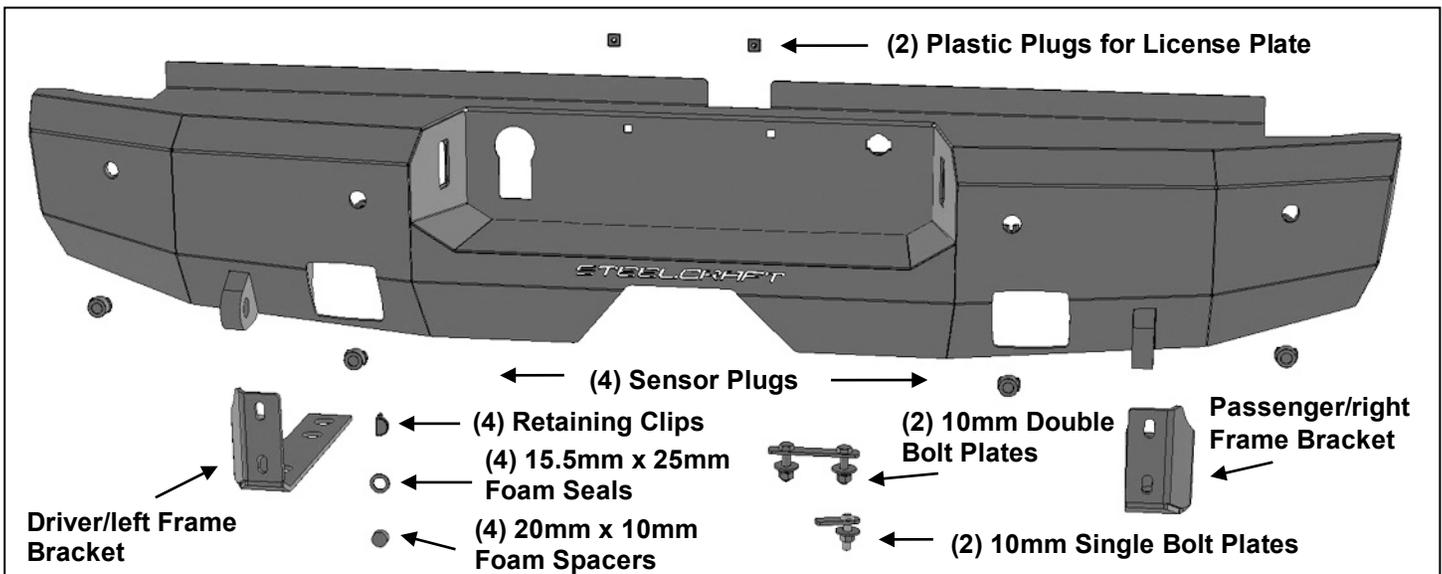


**PARTS LIST:**

|   |                                  |   |                                       |
|---|----------------------------------|---|---------------------------------------|
| 1 | Fortis Rear Bumper Assembly      | 2 | Plastic Plugs for license plate mount |
| 1 | Driver/left Mounting Bracket     | 2 | 10mm x 40mm Double Bolt Plates        |
| 1 | Passenger/right Mounting Bracket | 2 | 10mm x 40mm Single Bolt Plates        |
| 4 | Sensor Hole Plugs                | 6 | 10mm x 30mm x 2.5mm Flat Washers      |
| 4 | Sensor Retaining Clips           | 6 | 10mm Lock Washers                     |
| 4 | 20mm x 10mm Foam Spacers         | 6 | 10mm Hex Nuts                         |
| 4 | 15.5mm x 25mm x 2mm Foam Seals   | 8 | 4mm x 10mm Button Head Bolts          |
| 1 | Sensor Cover Kit                 | 1 | 2.5mm Wrench                          |



**PROCEDURE:**

**REMOVE CONTENTS FROM BOX. VERIFY ALL PARTS ARE PRESENT. READ INSTRUCTIONS CAREFULLY BEFORE STARTING INSTALLATION. ASSISTANCE IS RECOMMENDED TO AVOID POSSIBLE INJURY OR DAMAGE TO THE VEHICLE. RECEIVER HITCH REQUIRED FOR TOWING.**

1. Remove the license plate from the bumper. Unplug any wiring harnesses leading to the bumper, **(Figure 1)**. Move wiring harnesses away from bumper. **NOTE:** Steelcraft Bumper is designed to be compatible with larger 7-wire universal trailer harness plug. Receiver hitch required for towing.
2. Place blocks or jack stands under the bumper to support it during mounting bolt removal. Once the bumper has been safely supported, remove the factory hex bolts attaching the bumper to the bottom of the frame and remove the bumper assembly, **(Figures 1 & 2)**. **WARNING!** Assistance is required to hold the bumper in place during hardware removal to prevent bumper from falling.
3. Disassemble the bumper and remove the bumper bracket reinforcement, (or receiver hitch, if equipped with tow package). Remove the wiring harness, license plate lights, trailer plug and spare tire access lock from the factory bumper. Remove sensors, (if equipped), from bumper, **(Figures 3 & 4)**. **NOTE:** Bumper reinforcement will not be reinstalled, **(Figure 4)**.
4. Select (1) 10mm Single Bolt Plate. Insert the Bolt Plate into the end of the frame and through the hole in the outer side of the frame, **(Figures 5 & 6)**. Select the driver/left Frame Mounting Bracket, **(Figure 7)**. Attach the Bracket to the Bolt Plate with (1) 10mm Flat Washer, (1) 10mm Lock Washer and (1) 10mm Hex Nut, **(Figures 7 & 8)**. Repeat this Step to attach the passenger/right Frame Mounting Bracket to the Single Bolt Plate. Leave hardware loose at this time.
5. Determine if Bumper will be installed with or without receiver hitch.

**Models with receiver hitch, (towing package).**

- a. With assistance, hold the receiver hitch up to the bottom of the frame.
- b. Reuse the (4) factory hex bolts to attach the receiver hitch to the bottom of both Brackets and the frame, **(Figure 9)**. Do not fully tighten hardware at this time.

**Models without receiver hitch.**

- a. Reuse the (4) factory hex bolts to attach the Brackets to the bottom of the frame, **(Figure 9)**. Do not fully tighten hardware at this time.
6. Determine if the vehicle is equipped with sensors. **NOTE:** If equipped with tow package, it may be necessary or easier to install sensors, (if equipped), before installing the Bumper, **(Figure 13)**.

**Models without bumper sensors:**

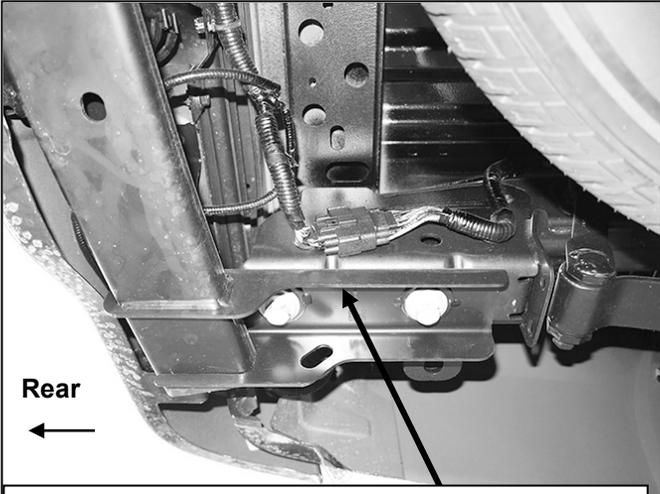
- a. Select the included (4) Rubber Plugs.
- b. From behind bumper, push plugs into sensor mounting holes, **(Figure 10)**. Screws have been provided to lock the plugs in the sleeve. Use is optional.
- c. Install wiring harness for license plate lights.

**Models with bumper mounted sensors:**

- a. Remove sensors from factory bumper, **(Figure 3)**.
- b. Remove the silicone seal from the end of the sensor. Slide the included larger Sensor Seal over front of sensor, **(Figure 11)**.
- c. Insert sensor with Seal into sensor mount on back of Bumper, **(Figure 12)**.
- d. Place Foam Spacer over end of sensor. Push Sensor Retaining Clip into sensor mount and lock into mounting holes, **(Figure 12)**.
- e. Repeat previous Steps to install remaining sensors.
- f. Install wiring harness, **(Figure 13)**.
- g. **Optional:** Secure each sensor to the socket with (2) 4mm x 10mm Button Head Screws, **(Figure 10)**. **IMPORTANT:** Sensors fit snug in sockets. The 4mm Screws are used to apply slight pressure to lock the sensors in place. Tighten both screws evenly until they touch the sensor body only. Do not overtighten screws or damage to sensors will result.
7. Remove the license plate lights from the plastic housings. Install the license plate lights and spare tire access lock into the Fortis Bumper, **(Figure 14)**.
8. Plug the bumper wiring harness into the lights and sensors if equipped, **(Figure 13)**.
9. Select (1) 10mm Double Bolt Plate, **(Figure 15)**. With assistance, hold the Bumper up against the 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.
10. Insert the Double Bolt Plate into and through the back of the mounting tab on the Bumper, **(Figure 15)**. Attach the Bumper with Double Bolt Plate to the driver/left Bracket with (2) 10mm Flat Washers, (2) 10mm Lock Washers and (2) 10mm Hex Nuts, **(Figure 15)**. Snug but do not fully tighten hardware at this time. Repeat to attach the passenger/right side of the Bumper.
11. Slowly open the tailgate and check for clearance. Level and adjust the Bumper and fully tighten all hardware including all Bracket to frame hardware.
12. Push the included (2) Plastic Plugs into the square holes in the Bumper for the license plate, **(Figure 16)**. Push trailer plug, (if equipped), into Bumper and plug into wiring harness.
13. Plug the Bumper wiring harness into the main harness. Secure the wiring harness to the Bumper and frame as necessary.
14. Do periodic inspections to the installation to make sure that all hardware is secure and tight.

**To protect your investment,** 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 Bumper assembly.

Driver/left Side Installation Pictured

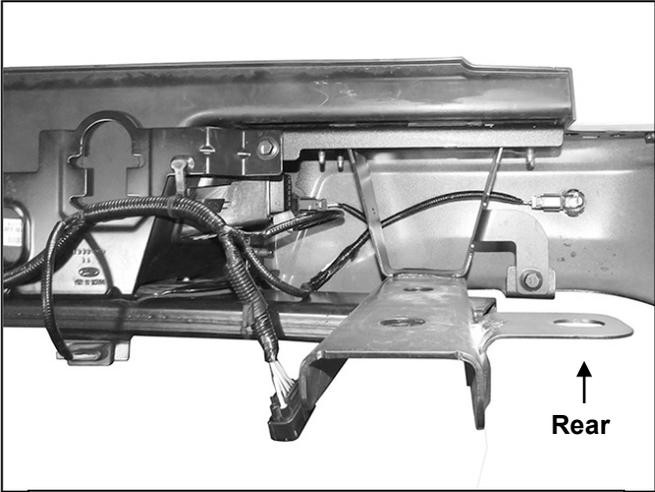


(Fig 1) Unplug all harnesses. Remove hex bolts from bottom of bumper reinforcement (pictured) or receiver hitch to remove bumper assembly

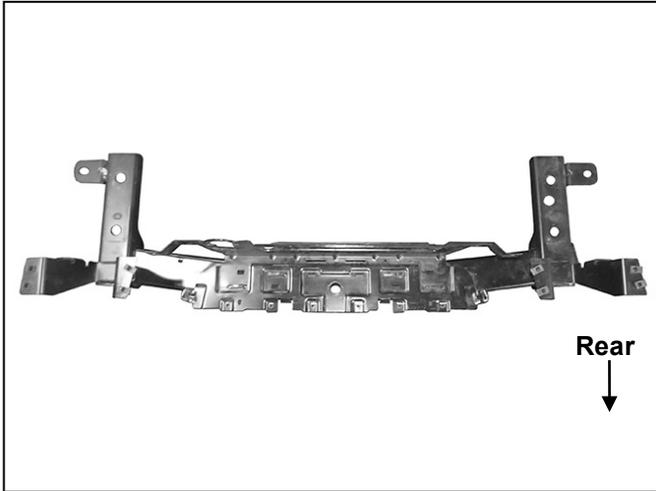
**WARNING!** Do not crawl under bumper unless the bumper is properly supported on blocks or stands or the bumper may fall.



(Fig 2) Bumper assembly removed. Remove clip attaching harness to frame (arrow)



(Fig 3) Disassemble bumper to remove bumper reinforcement (pictured) or receiver hitch, wiring harness, sensors, license plate lights and trailer plug as equipped



(Fig 4) Remove bumper reinforcement (pictured) or receiver hitch from bumper. NOTE: Only receiver hitch will be reinstalled

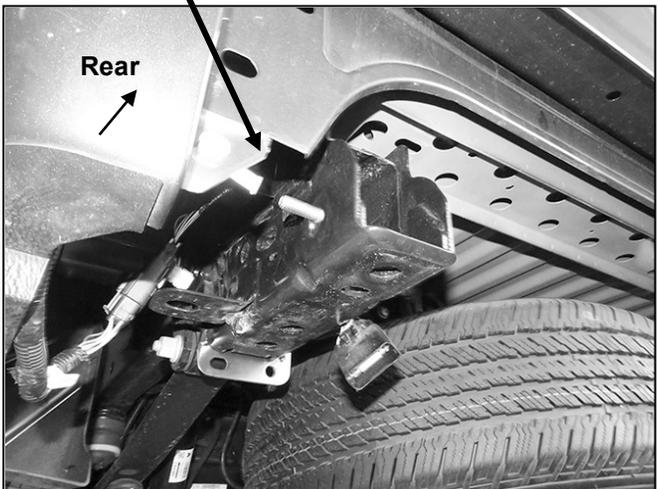
Driver/left Side Installation Pictured



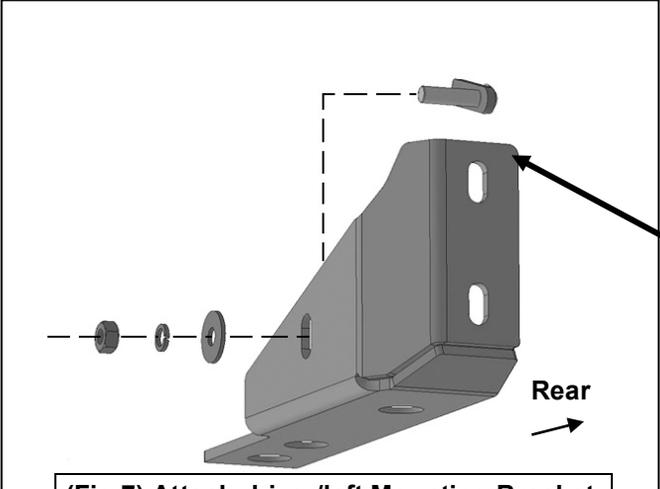
(Fig 5) Insert 10mm Single Bolt Plate into open end of frame and out hole in side of frame

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

10mm Single Bolt Plate

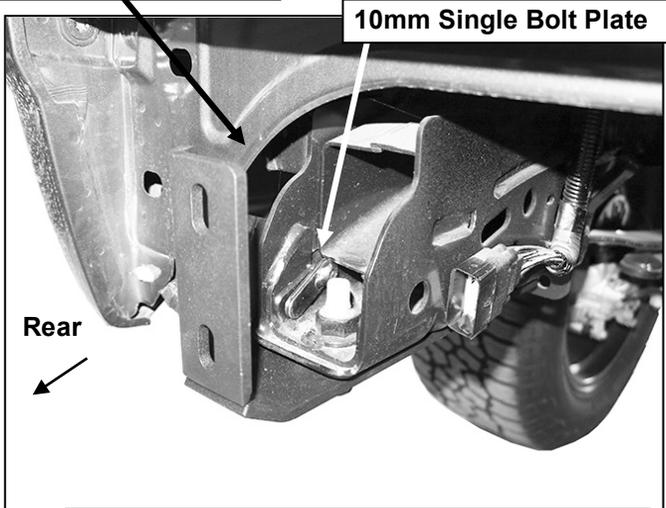


(Fig 6) Attach driver/left Frame Bracket to Bolt Plate



(Fig 7) Attach driver/left Mounting Bracket to Bolt Plate in side of frame

10mm Single Bolt Plate  
10mm Flat Washer  
10mm Lock Washer  
10mm Hex Nut



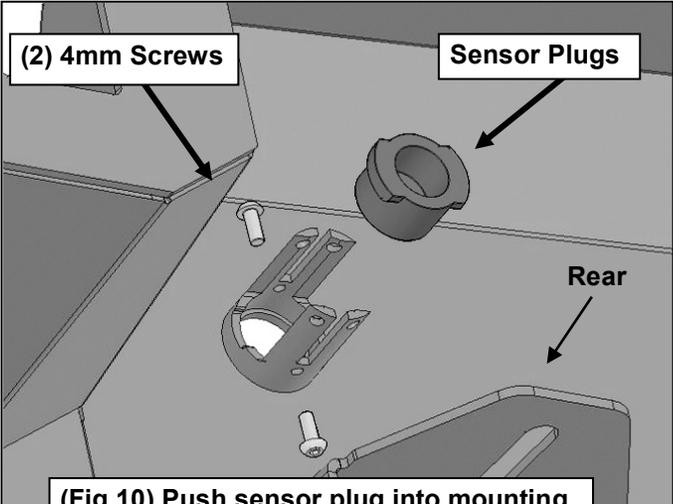
(Fig 8) Driver/left Mounting Bracket installed (model without receiver hitch)



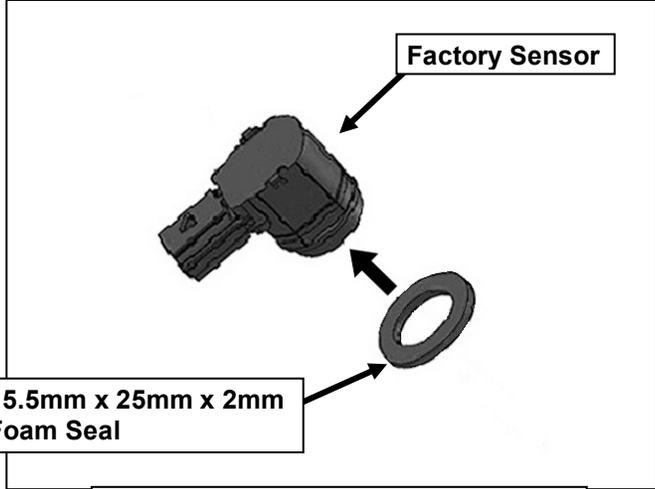
(Fig 9) Reuse factory hex bolts to attach Brackets to bottom of frame

**NOTE:** Models without receiver hitch, reuse factory hex bolts to attach Brackets to bottom of frame. Models with receiver hitch, reuse factory hex bolts to attach hitch to bottom of Brackets and frame

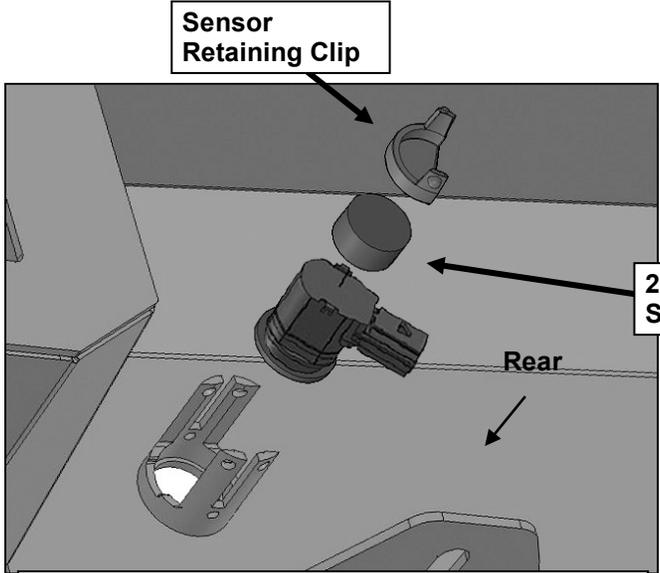
Driver/left Side Installation Pictured



(Fig 10) Push sensor plug into mounting sleeve. Use of 4mm Screws is optional

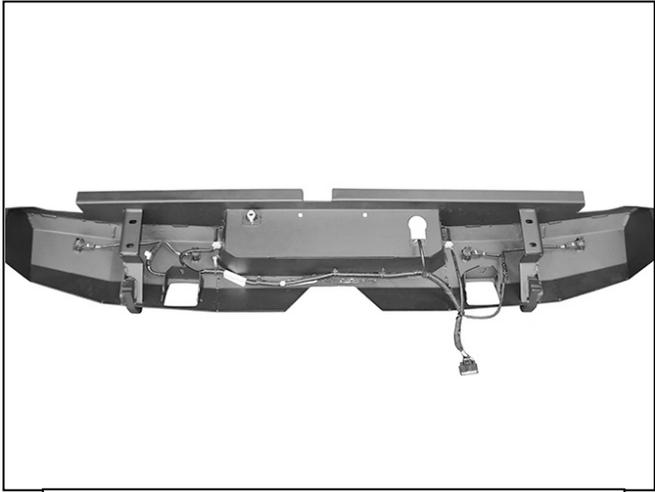


(Fig 11) Remove factory seal and push Foam Washer onto end of



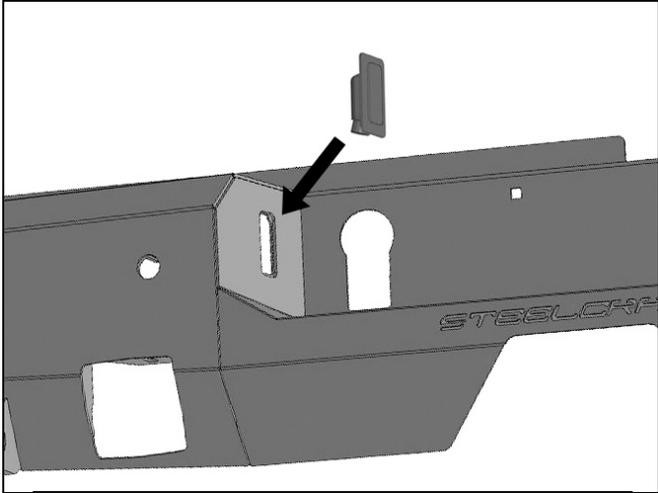
(Fig 12) Insert the sensor into the sensor sleeve

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



(Fig 13) Models with sensors, remove wiring harness from factory bumper, (Fig 3). Attach harness to sensors in Bumper

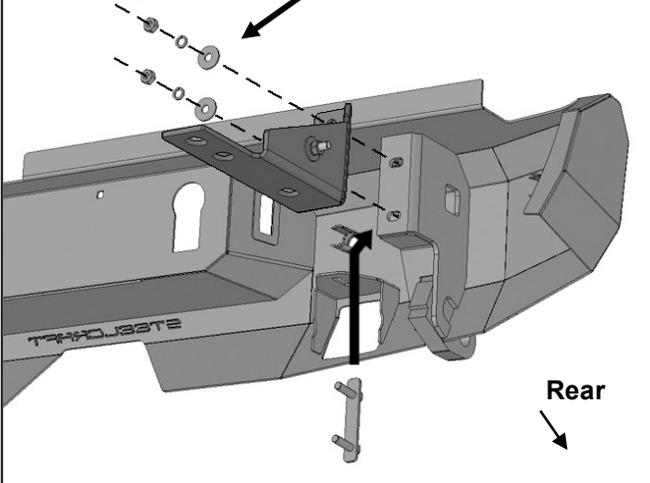
**Driver/left Side Installation Pictured**



**(Fig 14) Remove light from plastic mount. Push license plate lights into slots in Bumper**

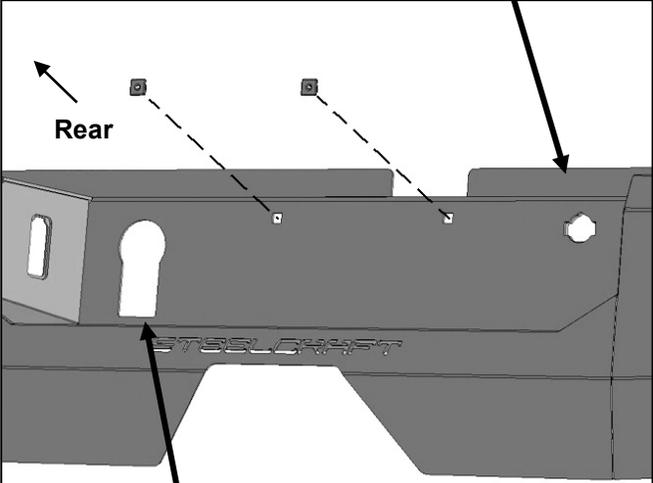
**WARNING!** Do not crawl under bumper unless the bumper is properly supported on blocks or stands or the bumper may fall.

- (2) 10mm Flat Washers
- (2) 10mm Lock Washers
- (2) 10mm Hex Nuts



**(Fig 15) Insert 10mm Double Bolt Plate into and through back of mounting tab on back of Bumper. With assistance, attach Bumper and Double Bolt Plates to Mounting Brackets**

**Attach spare tire access lock**



**(Fig 16) Push plastic plugs into holes for license plate. Models with receiver hitch, attach 7-pin connector to opening in Bumper**

