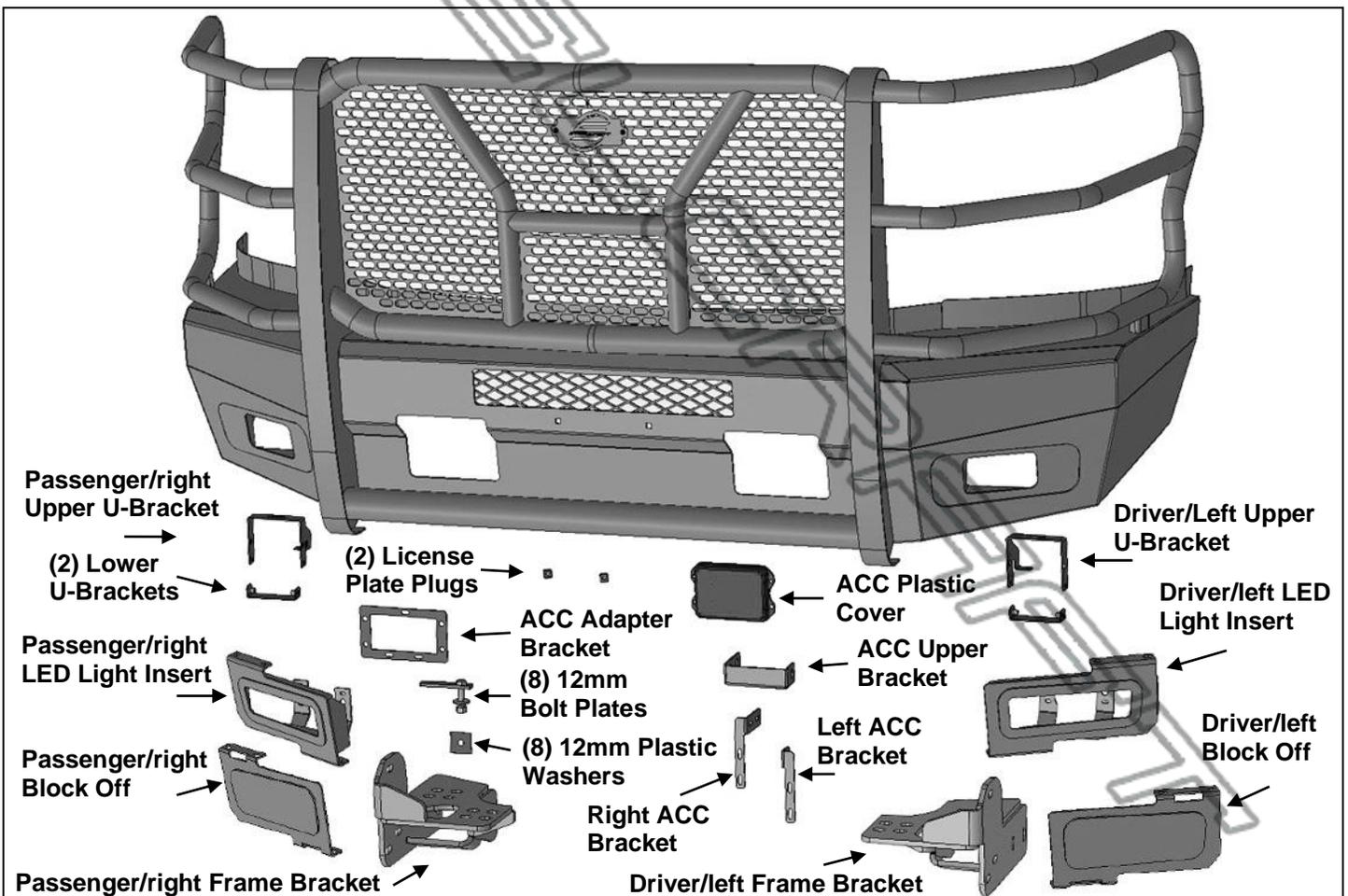


**ALUMINUM ELEVATION FRONT BUMPER
2017-22 FORD SUPER DUTY**

PARTS LIST:

1	Elevation Front Bumper Assembly	14	12-1.75mm x 50mm Hex Bolts
1	Driver/left Frame Bracket	22	12mm Lock Washers
1	Passenger/right Frame Bracket	22	12-1.75mm Hex Nuts
2	Plastic Plugs for license plate mount	2	8-1.25mm x 30mm Hex Bolts
1	Driver/left Light Mount (OEM LED)	2	8-1.25mm x 20mm Hex Bolts
1	Passenger/right Light Mount (OEM LED)	4	8mm x 28mm x 3mm Large Flat Washers
1	Driver/left Fog Light Block Off	4	8mm x 24mm x 2mm STD Flat Washers
1	Passenger/right Fog Light Block Off	4	8mm Nylon Lock Nuts
1	Driver/left Upper U-Bracket (OEM fog light)	3	6mm x 25mm Hex Bolts
1	Passenger/right Upper U-Bracket (OEM fog light)	6	6mm x 25mm Button Head Bolts
2	Lower U-Brackets (OEM fog light only)	4	6mm x 16mm Hex Bolts
1	ACC Adapter Bracket	19	6mm x 18mm x 1.6mm Flat Washers
1	Adaptive Cruise Control, (ACC) Driver/left Bracket	13	6mm Lock Washers
1	ACC Passenger/right side Bracket	9	6mm Hex Nuts
1	ACC Upper Bracket	1	4mm Wrench
1	ACC Plastic Cover	1	2.5mm Wrench
8	12mm x 50mm Bolt Plates		



RECOMMENDED TO REPLACE THE 12MM HEX BOLTS ON AN ANNUAL BASIS

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.

1. Remove the license plate and bracket. On models with factory fog lights, unplug both lights, **(Figure 1)**. Unplug and remove the adaptive cruise control, if equipped. Release the wiring harness from the clips attached to the back of the bumper, **(Figure 2)**. Move harness away from bumper.
2. Remove the bumper supports attaching the outer ends of the bumper to the outside of the frame, **(Figure 3)**. Remove the plastic covers surrounding the tow hooks, **(Figures 4 & 5)**.
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 (8) factory bumper bolts, **(Figure 5)**. Carefully slide the bumper off over the tow hooks. **WARNING!** Assistance is required to hold the bumper in place during bolt removal to prevent the bumper from falling.
4. Remove the tow hooks from the ends of the frame, **(Figure 6)**. Next, remove the factory hex nuts, lower frame extensions and double bolt plates from the end of the frame, **(Figures 2 & 6)**.
5. Select the driver/left Frame Bracket, **(Figure 7)**. Slide the Bracket over the end of the frame. Line up the slots in the sides of the Bracket with the holes in the frame. Select (4) 12mm Bolt Plates. Insert the Bolt Plates into the open end of the frame and out through the Bracket. Attach the Bracket to the Bolt Plates with (4) 12mm Flat Washers, (4) 12mm Lock Washers and (4) 12mm Hex Nuts, **(Figures 7 & 8)**. Leave hardware loose.
6. Attach the top of the Bracket to the top of the frame with the included (4) 12mm x 50mm Hex Bolts, (8) 12mm Flat Washers, (4) 12mm Lock Washers and (4) 12mm Hex Nuts, **(Figures 9 & 10)**. Do not fully tighten hardware at this time.
7. Reuse the factory hardware to attach the driver/left tow hook to the bottom of the mounting tab on the Frame Bracket, **(Figure 10)**. **NOTE:** On models with ACC, driver side tow hook cannot be reinstalled.
8. Repeat **Steps 5—7** to install the passenger/right Frame Bracket and tow hook.
9. Models with fog lights and/or sensor, disassemble factory bumper to remove fog light assemblies, sensor and wiring harness.
10. Determine if vehicle is equipped with an adaptive cruise control, (ACC), and note the design of the sensor. **NOTE:** The ACC assembly can also be installed after Bumper installation.

Vehicles without Adaptive Cruise Control, skip to Step 11.

All Models with Adaptive Cruise Control.

- a. Select the Left ACC Bracket, Right ACC Bracket and ACC Upper Bracket, **(Figure 11)**. Attach the Left and Right ACC Brackets to the ACC Upper Bracket with (3) 6mm x 25mm Hex Bolts, (6) 6mm Flat Washers, (3) 6mm Lock Washers and (3) 6mm Hex Nuts. Do not tighten hardware

Vehicles with "late" style ACC with tabs on top and bottom.

- a. Select the Mounting Bracket Adapter Plate, **(Figure 12)**.
- b. Attach the ACC sensor to the back of the Adapter with the included (3) 6mm x 25mm Button Head Bolts, (6) 6mm Flat Washers, (3) 6mm Lock Washers and (3) 6mm Hex Nuts, **(Figure 12)**.
- c. Insert (3) 6mm x 25mm Button Head Bolts through the (3) holes on the ACC Plastic Cover, the ACC Bracket and out through the adaptive cruise control Adapter Plate. Secure with (3) 6mm Flat Washers, (3) 6mm Lock Washers and (3) 6mm Hex Nuts, **(Figure 13)**.

Vehicles with early style ACC with mounting tabs on ends.

- a. Insert (3) 6mm x 25mm Button Head Bolts through the (3) holes on the ACC Plastic Cover, the ACC Bracket and out through the adaptive cruise control. Secure with (3) 6mm Flat Washers, (3) 6mm Lock Washers and (3) 6mm Hex Nuts, **(Figure 14)**.

Attach the ACC Bracket and sensor assembly to the mounting tab for the tow hook on the driver/left Frame Bracket with (2) 8mm x 30mm Hex Bolts, (4) 8mm x 28mm Large Flat Washers and (2) 8mm Nylon Lock Nuts, **(Figure 15)**. Tighten all ACC Bracket hardware.

11. Determine if vehicle is equipped with fog lights and type of light.

Models with rectangular 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 1)**. Pop the light out of the plastic bracket housing.
- b. Remove the adjustment screw and spring from the light assembly.

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- c. Select the driver/left top U-Bracket, **(Figure 16)**. Attach the Bracket to the slot in the light opening with the included (1) 8mm x 20mm Hex Bolt, (2) 8mm x 24mm STD Flat Washers and (1) 8mm Nylon Lock Nut, **(Figure 16)**.
- d. Spread the sides of the Bracket enough to slide the OE plastic fog light between and into the Bracket, **(Figure 17)**. Select (1) Lower U-Bracket. Attach the Lower Bracket to the Upper Bracket with (2) 6mm x 16mm Hex Bolts, (2) 6mm Lock Washers and (2) 6mm Flat Washers, **(Figure 18)**.
- 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 18)**.
- f. Repeat to install the passenger/right fog light.

Models with optional narrow factory LED Fog Light (2020-on models)

- a. Remove the screws attaching the light to the plastic mount, **(Figure 19)**.
- b. Remove the preinstalled driver/left rectangular fog light mount insert from the back of the Elevation Bumper, **(Figure 20)**.
- c. Select the driver/left LED light mount. Reuse the hardware to attach the Mount to the tabs on the back of the Bumper, **(Figure 21)**.
- d. Reuse the factory screws to attach the LED fog light to the LED light mount, **(Figure 21)**.
- e. Repeat previous Steps to install the passenger/right LED Light Mount and light.

Models without fog lights.

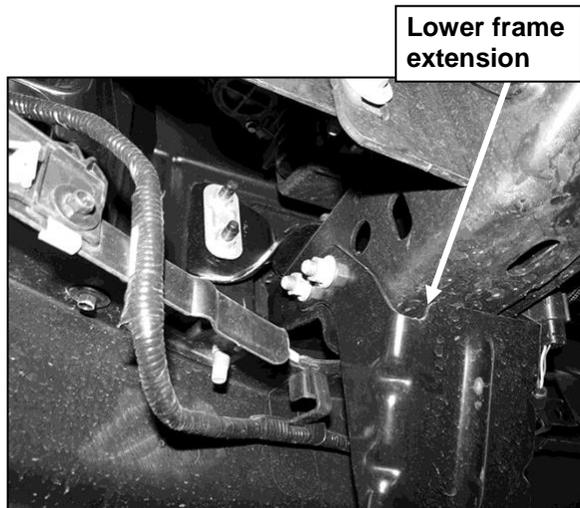
- a. Remove the preinstalled driver/left rectangular fog light mount insert from the back of the HD Bumper, **(Figure 21)**.
 - b. Select the driver/left Block Off. Reuse the hardware to attach the Block Off to the tabs on the back of the Bumper, **(Figure 21)**.
 - c. Repeat previous Steps to install the passenger/right Block Off.
12. Models with fog lights and/or ACC sensor, reinstall and plug in wiring harness.
 13. With assistance, carefully position the Bumper Assembly up to 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.
 14. Line up the (3) holes in the driver/left side of the Bumper with the Frame Bracket. Attach the Bumper to the Bracket with the included (3) 12mm x 50mm Hex Bolts, (3) 12mm Flat Washers, (3) 12mm Plastic Washers, (3) 12mm Flat Washers, (3) 12mm Lock Washers and (3) 12mm Hex Nuts, **(Figures 22 & 23)**. **NOTE:** Insert the Plastic Washers between the outer 12mm Flat Washers and the mounting plate on the back of the Bumper to minimize corrosion. Do not fully tighten hardware at this time. Repeat to attach the passenger/right side of the Bumper to the Bracket.
 15. Level and adjust the bumper and fully tighten all hardware.
 16. 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 24)**.
 17. On models with grille mounted factory camera, remove the center screen, **(Figure 24)**.
 18. Reattach the factory harness. Adjust lights and tighten all fog light bracket hardware.
 19. 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 Elevation Front Bumper assembly. Regular washing is required in extreme environments to help prevent deposits of corrosive salts.

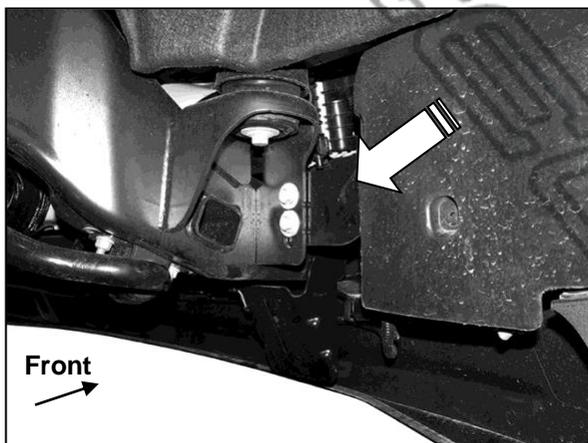
Driver/left Side Installation Pictured



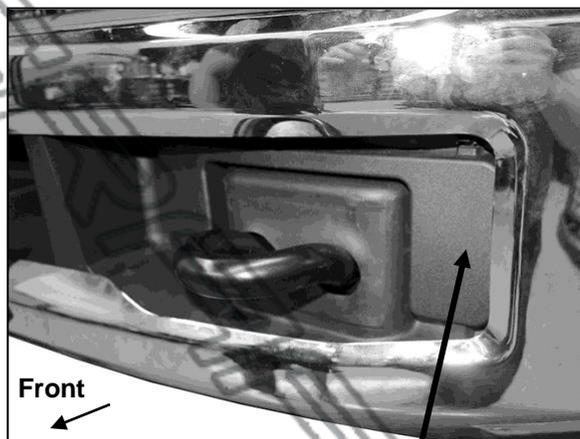
(Fig 1) On models with fog lights, unplug wire harness from back of light



(Fig 2) Release clips attaching the wire harness for fog lights if equipped (driver side)



(Fig 3) Remove outer bumper support brackets between frame and bumper (arrow)



(Fig 4) Remove plastic cover around tow hook

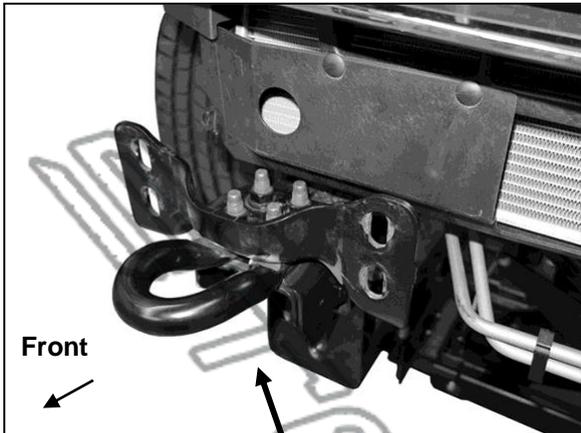


(Fig 5) Remove bumper bolts (driver side pictured)

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

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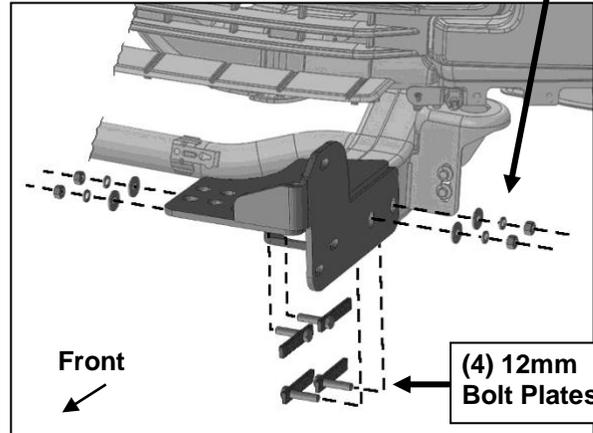
Driver/left Side Installation Pictured



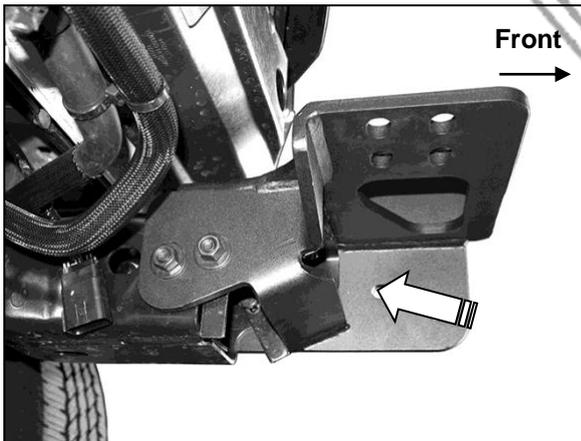
(Fig 6) Remove tow hook assembly and lower frame extension (not pictured-see Fig 2)

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

- (4) 12mm Flat Washers
- (4) 12mm Lock Washers
- (4) 12mm Hex Nuts

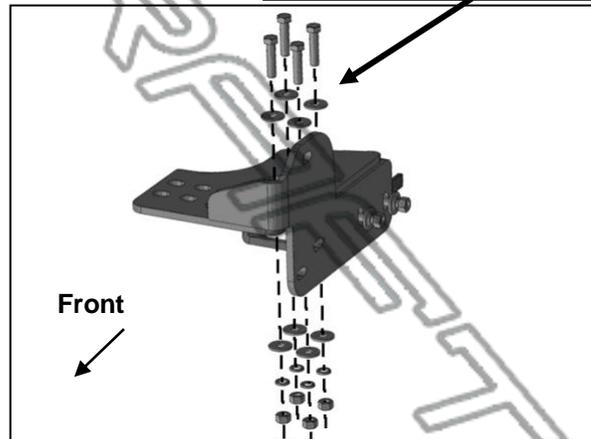


(Fig 7) Insert Bolt Plates into open end of frame. Attach Bracket to sides of frame



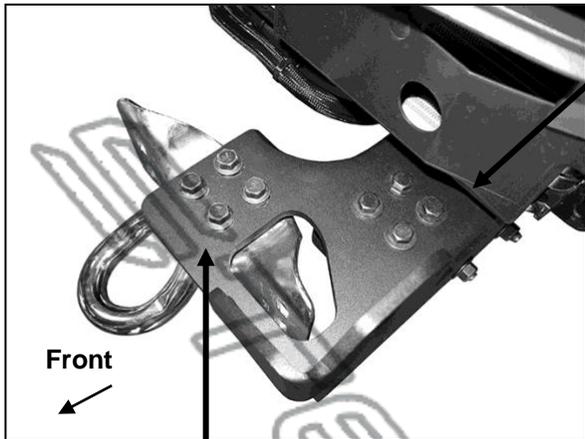
(Fig 8) Insert Bolt Plates into open end of frame (driver/left frame Bracket pictured)

- (4) 12mm x 50mm Hex Bolts
- (8) 12mm Flat Washers
- (4) 12mm Lock Washers
- (4) 12mm Hex Nuts



(Fig 9) Attach top of Bracket to top of frame

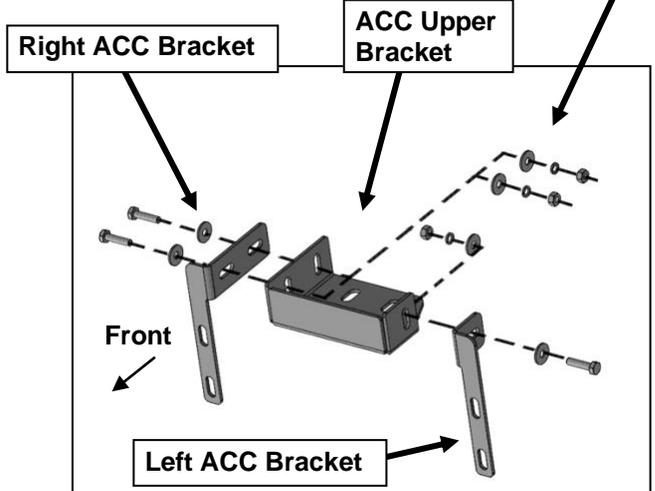
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Attach top of Bracket to top of frame

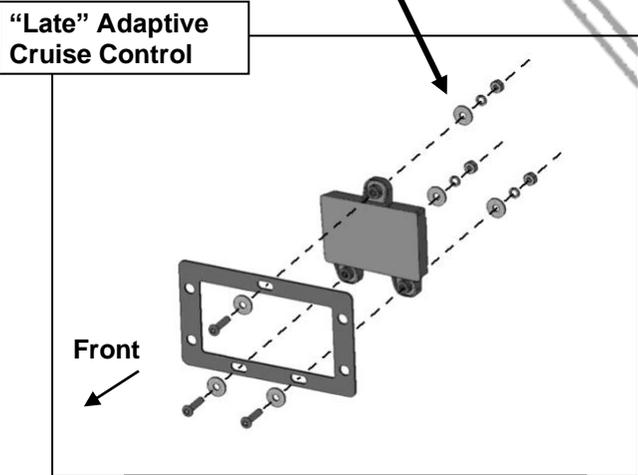
- (3) 6mm x 25mm Hex Bolts
- (6) 6mm Flat Washers
- (3) 6mm Lock Washers
- (3) 6mm Hex Nuts

(Fig 10) Reuse factory hardware to attach tow hook to Bracket (do not reinstall tow hook on driver/left side on models with ACC sensor)



(Fig 11) Vehicles equipped with adaptive cruise control, ACC, Bracket assembly illustrated

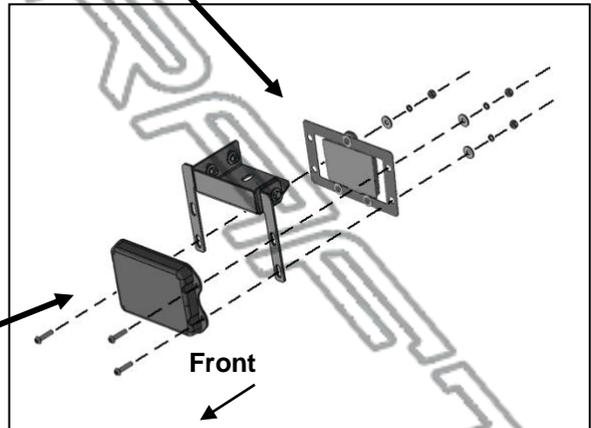
- (3) 6mm Button Head Bolts
- (3) 6mm Flat Washers
- (3) 6mm Lock Washers
- (3) 6mm Hex Nuts



"Late" Adaptive Cruise Control

(Fig 12) Attach "Late" ACC sensor to back of Adapter Bracket

Adapter Bracket with "Late" Adaptive Cruise Control sensor



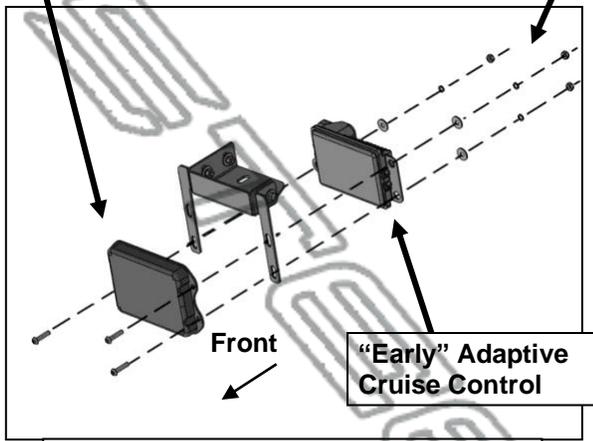
Plastic Cover

(Fig 13) Attach Adapter Bracket with "Late" ACC sensor to back of Mounting Brackets, (Fig 16) and attach Plastic Cover to front

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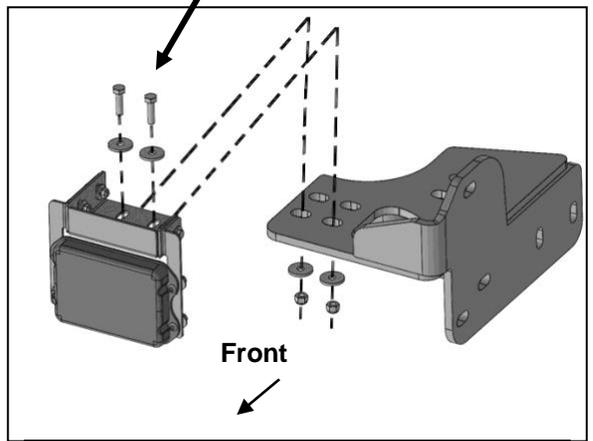
Plastic Cover

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



(Fig 14) Attach "Early" ACC sensor to back of Mounting Brackets, (Fig 16) and Plastic Cover to front

- (2) 8mm x 30mm Hex Bolts
- (4) 8mm x 28mm Flat Washers
- (2) 8mm Nylon Lock Nuts

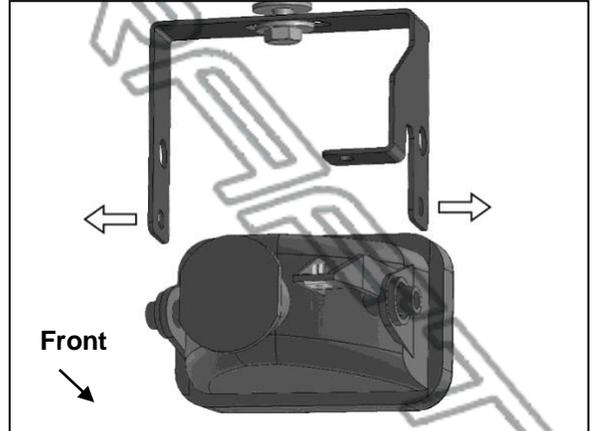


(Fig 15) ACC assembly attached to the Driver/left side Frame Bracket illustrated

- 8mm x 20mm Hex Bolt
- (2) 8mm x 24mm Flat Washers
- 8mm Nylon Lock Nut



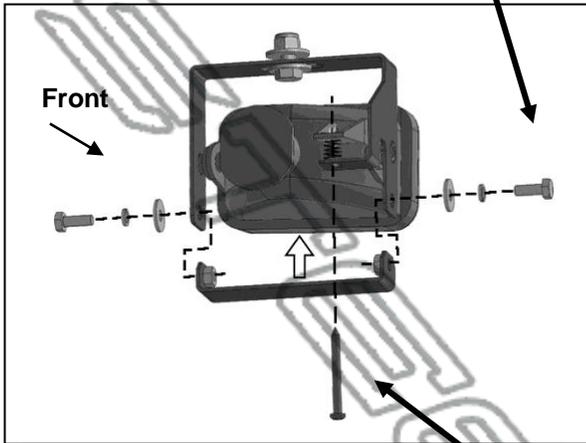
(Fig 16) Rectangular fog light installation (light not included). Attach driver/left Upper Bracket to the slot in top of the opening



(Fig 17) Carefully spread sides to slide OEM fog light into position in pivot holes

Driver/left Side Installation Pictured

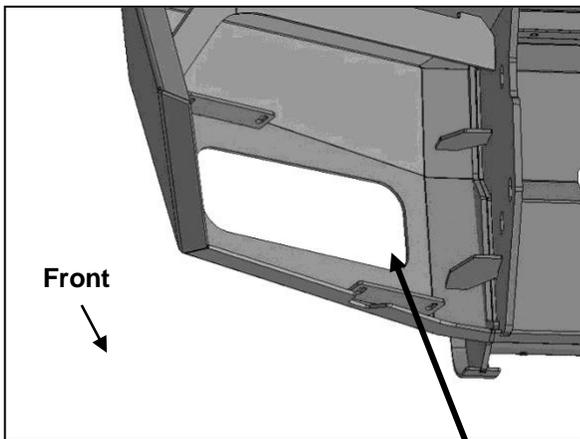
6mm x 16mm Hex Bolt
6mm Lock Washer
6mm Flat Washer



(Fig 18) Attach lower U Bracket to Upper Bracket. Reuse factory adjustment hardware (screw, spring and plastic nut)

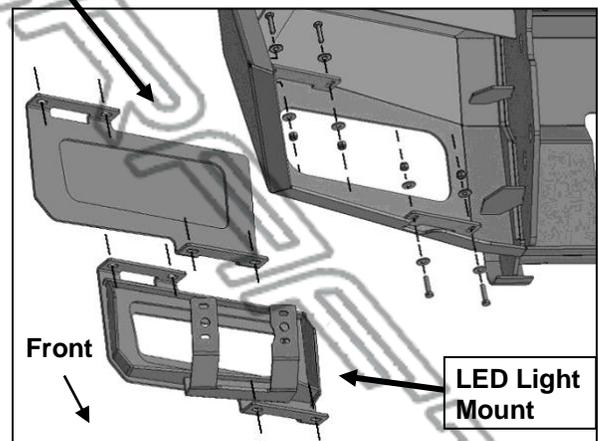


(Fig 19) Remove screws to remove narrow LED fog light from plastic mount



(Fig 20) Remove fog light mount from back of Bumper (driver/left side illustrated)

Block Off



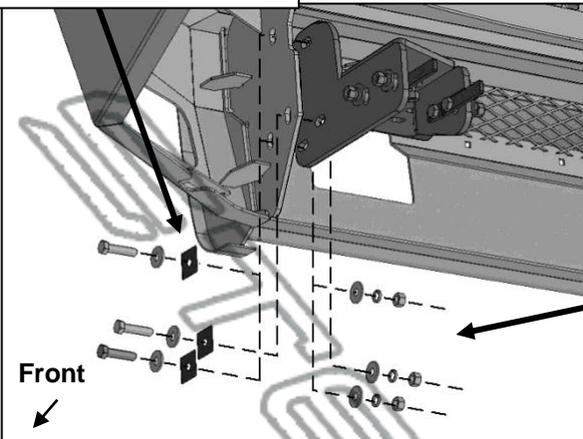
(Fig 21) Models with LED fog lights only, reuse screws to attach LED fog light to Light Mount. Reuse hardware to attach LED Fog Light assembly or Block Offs to tabs on back of Bumper

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

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Driver/left Side Installation Pictured

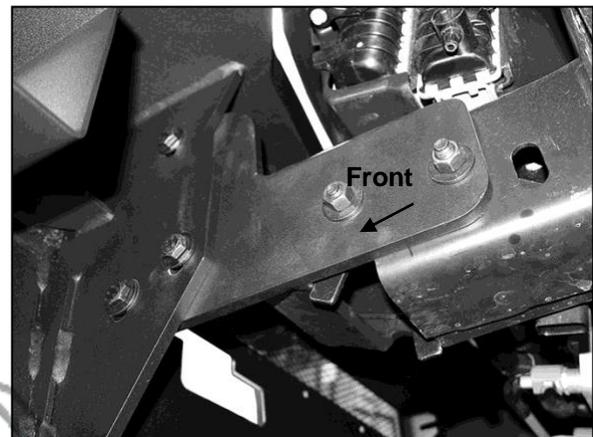
(3) 12mm Plastic Washers



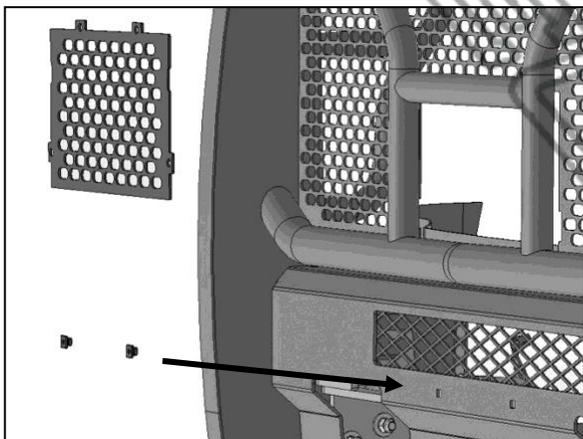
WARNING! Do not crawl under bumper unless it is properly supported on blocks or stands or the bumper may fall.

**(3) 12mm x 50mm Hex Bolts
(6) 12mm Flat Washers
(3) 12mm Lock Washers
(3) 12mm Hex Nuts**

**(Fig 22) Attach Bumper to side of Bracket.
NOTE: Insert Plastic Washers between Flat Washer and mounting plate on Bumper to minimize corrosion**



**(Fig 23) Attach Bumper to side of Bracket
(driver/left side pictured from behind bumper)**



(Fig 24) Remove center screen if equipped with grille mounted camera. Push plastic plugs into holes in Bumper for license plate

Special Note: While Aluminum does not rust, there is potential for galvanic corrosion if the coating is scratched between your bumper and the steel frame brackets + hardware (especially in extreme environments such as the coastlines or where road salt is used during winter). A visual inspection should be performed by the user at least on an annual basis to determine if excessive corrosion is present on or surrounding the hardware.

Complete Installation



**ALUMINUM ELEVATION FRONT BUMPER
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Supplemental Installation Steps: Some 2022 F-350's will have an extra cooler between frame.

- Trim tabs off OE cooler brackets so they rest flat against the bumper brackets:



- Install cooler onto forward bolt plate:

