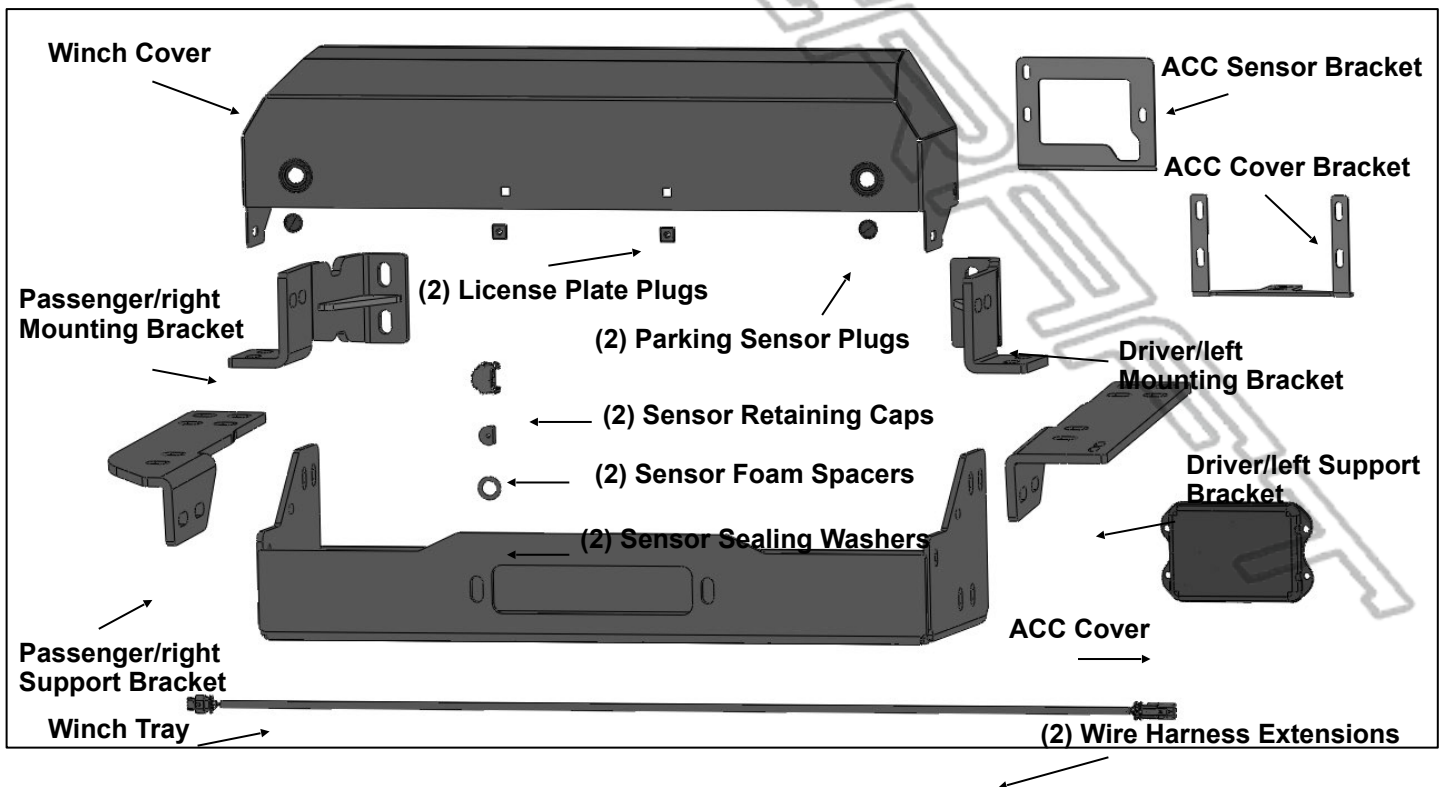


PARTS LIST:

1	Winch Tray assembly	12	12mm Lock Washers
1	Winch Cover	24	12mm x 32mm x 3mm Flat Washers
1	Driver/left Mounting Bracket	12	12mm Hex Nuts
1	Passenger/right Mounting Bracket	12	12mm x 50mm Hex Bolts
1	Driver/left Support Bracket	6	8mm Hex Nuts
1	Passenger/right Support Bracket	12	8mm x 24mm x 2mm Flat Washers
2	Plastic Plugs for license plate mount	6	8mm Lock Washers
1	Adaptive Cruise Control (ACC) Plastic Cover	6	8mm x 35mm Hex Bolts
1	ACC Cover Bracket	4	6mm x 20mm Button Head Bolts
1	ACC Sensor Bracket	3	6mm x 25mm Hex Bolts
2	Parking Sensor Wire Extenders	7	6mm Lock Washers
2	Parking Sensor Hole Plastic Plugs	7	6mm Hex Nuts
2	Parking Sensor Retaining Caps	10	6mm x 18mm x 1.6mm Flat Washers
1	Parking Sensor Cover Kit	4	4mm Self-tapping Screws
2	20mm x 10mm Foam Spacers	1	4mm Allen Wrench
2	15.5mm x 25mm OD x 2mm Foam Washers		



PROCEDURE:

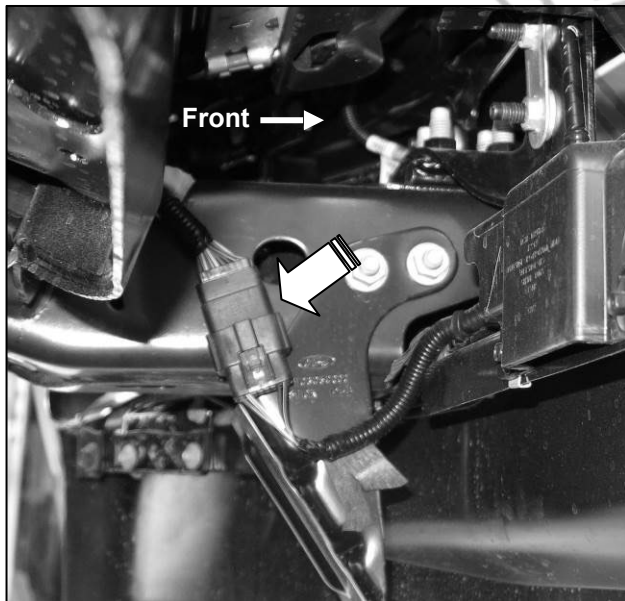
REMOVE CONTENTS FROM PACKAGING. VERIFY ALL PARTS ARE PRESENT. READ INSTRUCTIONS CAREFULLY BEFORE STARTING INSTALLATION. BUMPER MUST BE TEMPORARILY REMOVED, THEREFORE THIS WINCH TRAY MUST BE INSTALLED BEFORE ANY GRILLE GUARD. IF ALREADY INSTALLED, GRILLE GUARD MUST BE REMOVED. ASSISTANCE IS HIGHLY RECOMMENDED.

1. Remove the license plate. Unplug all wiring harnesses connecting bumper to vehicle (**Figure 1**).
2. Remove the outer bumper supports attaching the outer ends of the bumper to the side of the frame, (**Figure 2**). Remove the plastic covers from the tow hooks to uncover the bumper bolts, (**Figures 3 & 5**) **Note:** the plastic covers will not be re-installed. Unplug and remove the ACC (adaptive cruise control) sensor, if equipped, and gently place on a safe surface. Remove nuts and ACC housing (**FIGURE 4**).
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**). **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. There will be 2 plastic pins that attach the rubber bumper trim to the grille that need to be pried off (**Figure 6**).
4. Remove the 3 bolts from the left/driver side tow hook at the end of the frame, (**Figure 7**). Slide the Driver/left Support Bracket inside the frame channel and re-insert the OE tow hook bolts to prop-up the Bracket, (**Figure 8**). Do not tighten hardware at this time. Repeat this Step to install the Passenger/right Support Bracket. Temporarily position the Winch Tray between the Support Brackets to verify clearance and then fully tighten tow hook bolts. **Note:** One tow hook bolt was left tight to keep original position.
5. Next, remove the ACC bracket from the back of the bumper (if equipped, **Figure 9**). Remove the middle two parking sensors by spreading the plastic tabs apart on the sensor sleeve (if equipped). Detach wiring clips to allow ACC sensor harnesses to reach the potential front of the winch tray (**Figure 9**). Plug-in the provided (2) Parking Sensor Wire Extensions to the factory sensor harness and route through the original sensor holes on the bumper.
6. With assistance, slide the factory bumper over the newly installed brackets and re-attach to the factory outer bumper supports at the side of the frame.
7. Using the factory hardware, attach the Driver/left Mounting Bracket to the bumper mount inside the tow hook. Then attach the Mounting Bracket to the Support Bracket with the provided (2) 12mm x 50mm Hex Bolts, (4) 12mm Flat Washers, (2) 12mm Lock Washers and (2) 12mm Hex Nuts (**Figure 10**). Do not tighten hardware at this time. Repeat this Step to attach the Passenger/right Mounting Bracket. **Note:** Depending on your vehicle, minor bumper tab trimming may be required for proper clearance.
8. Next, select the Winch Tray assembly, (**Figure 11**). Slide the Winch Tray between the Brackets. Attach the Winch Tray to the Brackets with (6) 12mm x 50mm Hex Bolts, (12) 12mm Flat Washers, (6) 12mm Lock Washers and (6) 12mm Hex Nuts. Fully tighten all hardware. Install winch and fairlead (not included).
9. Prepare Winch Cover:
 - For vehicles not equipped with front parking sensors.**
 - a. Select the included (2) Plastic Parking Sensor Plugs. From the front of the Winch Cover, push plugs into sensor holes until they snap into place, (**Figure 14**).
 - For vehicles equipped with front parking sensors.**
 - a. Select a previously removed parking sensor and peel off the OE silicone seal from the end of the sensor. Remove the adhesive backing from the supplied (1) 15.5mm x 25mm x 2mm Foam Washer Seal. Slide the Foam Seal over the front of the sensor (**Figure 12**).
 - b. Insert sensor with Foam Seal into sensor sleeve from back of Cover, (**Figure 13**).
 - c. Select the included (1) Foam Spacer and peel off the adhesive backing. Place Foam Spacer into (1) Sensor Retainer Cap. Push Sensor Retaining Cap and Foam Spacer onto sensor mount and lock into mounting holes, (**Figure 13**).
 - d. Repeat previous Steps to install the remaining parking sensor.
 - e. Plug-in Parking Sensor Wiring Harness Extensions previously routed through the bumper.
10. Carefully attach Winch Cover to the Winch Tray with the included (2) 8mm x 35mm Hex Bolts, (4) 8mm Flat Washers and (2) 8mm Nylon Lock Nuts, (**Figure 14**).
11. **Vehicles equipped with ACC sensor,**

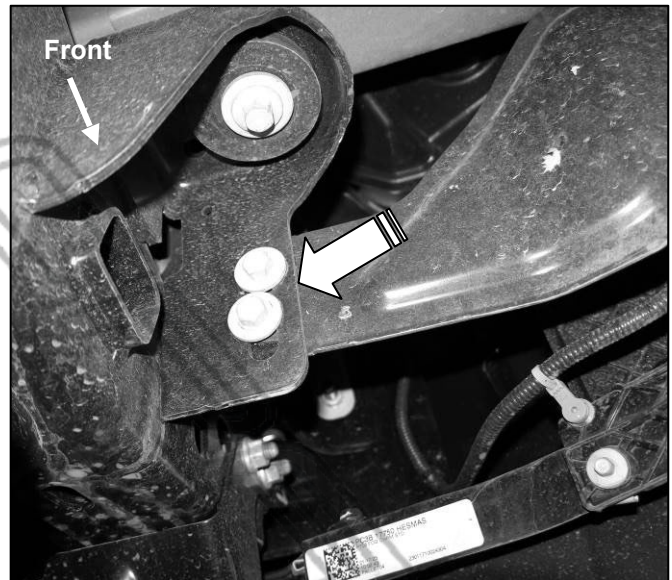
**STEELCRAFT WINCH TRAY
2017-24 FORD SUPERDUTY**

- a. Select the included plastic ACC Cover and insert (4) 6mm x 25mm Button Head Bolts through the (4) holes on the ACC Plastic Cover to each side of the ACC Cover Bracket. Secure with (4) 6mm x 18mm Flat Washers, (4) 6mm Lock Washers and (4) 6mm Hex Nuts, **(Figure 15)**.
 - b. Select the provided ACC Sensor Bracket and ACC Sensor. Attach the sensor to the brackets with (3) 6mm x 25mm Hex Bolts, (6) 6mm x 18mm Flat Washers, (3) 6mm Lock Washers and (3) 6mm Hex Nuts, **(Figure 16)**. Do not tighten hardware. Make sure the sensor is in the same orientation as removed from the OE bumper.
 - c. Select the ACC Cover Bracket assembly and place it on the Driver/left Support Bracket. Then place ACC sensor + Bracket assembly on top of the ACC Cover Bracket and fasten with the included (2) 8mm x 35mm Hex Bolts, (4) 8mm Flat Washers, (2) 8mm Lock Washers, and (2) 8mm Hex Nuts **(Figure 17)**.
 - d. Level and adjust the sensor, then tighten all hardware. Plug-in OE wiring harness to sensor.
Note: additional clips, zip ties, or tape may need to be cut to gain the stretch required for the new position.
- 12.** Insert (2) Plastic Plugs into the square holes in the front of the Winch Cover if front license plate is required. Reuse the factory screws to attach the license plate to the plastic plugs.
- 13.** Plug-in main bumper wiring harness. Perform periodic inspections to make sure bolts remain 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 Winch Tray Assembly.



(Fig 1) Unplug all wiring harnesses. (Inside of driver side frame shown)



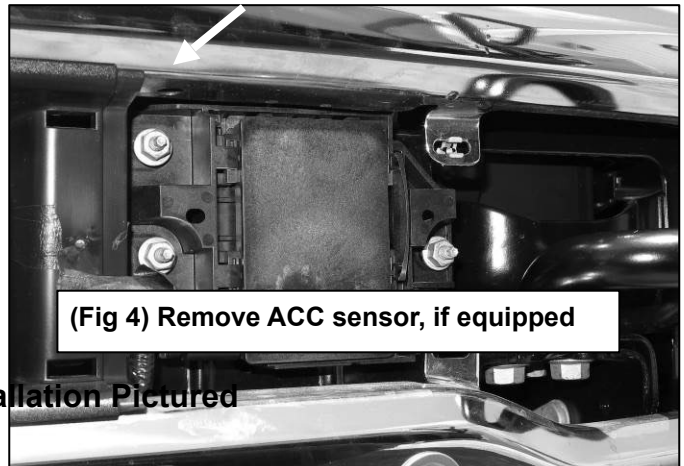
(Fig 2) Remove outer bumper support brackets between frame and bumper (arrow) [Passenger side shown]

Remove nuts and pull ACC bracket



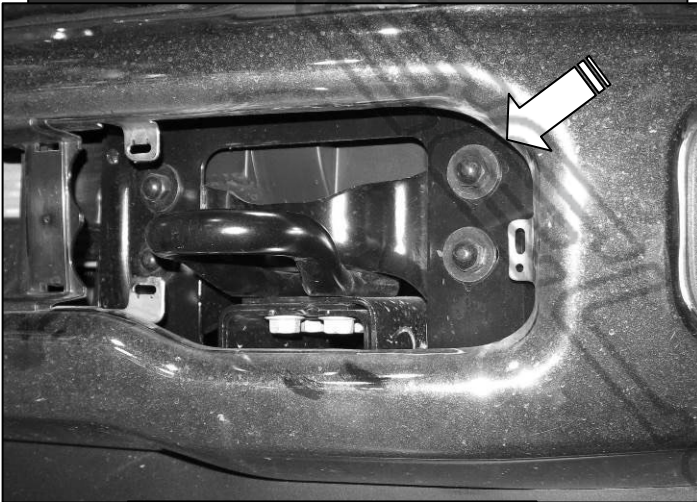
(Fig 3) Remove plastic covers around tow hooks

Driver Side Installation Pictured

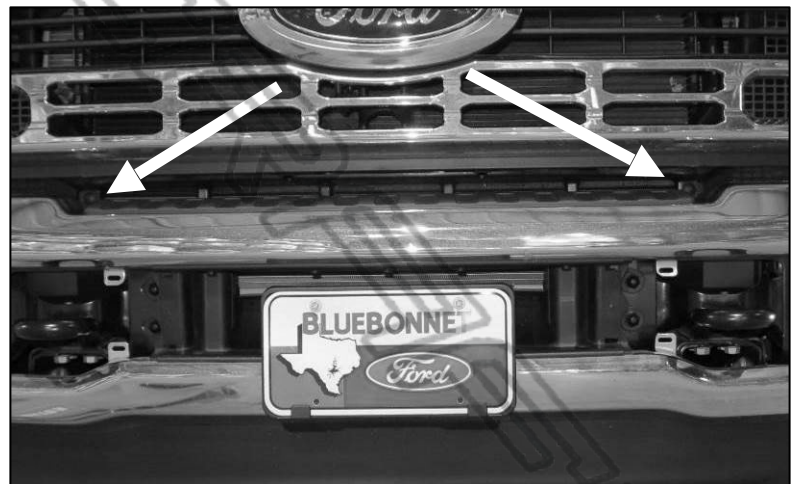


(Fig 4) Remove ACC sensor, if equipped

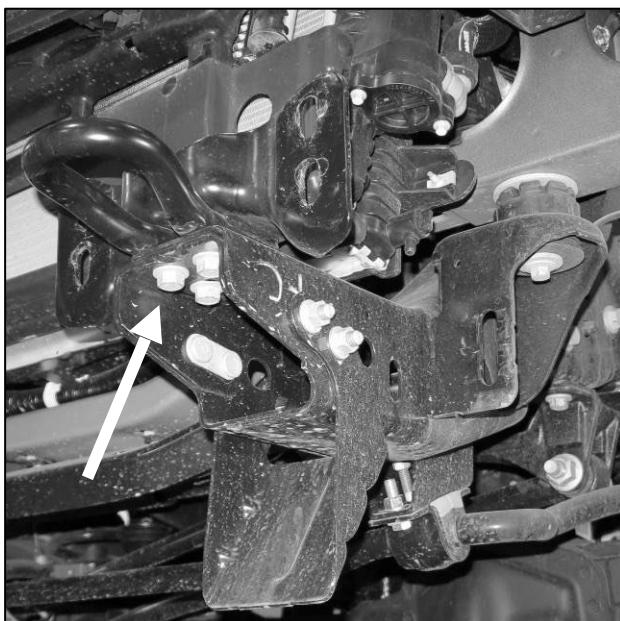
WARNING! Do not remove bumper bolts unless the bumper is properly supported on blocks or stands or the bumper may fall.



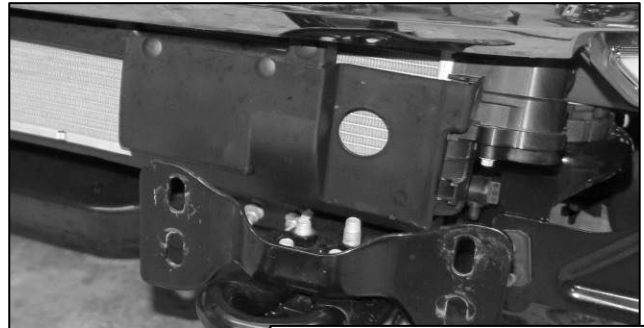
(Fig 5) Remove bumper bolts



(Fig 6) Remove the clips attaching rubber bumper trim to grille.

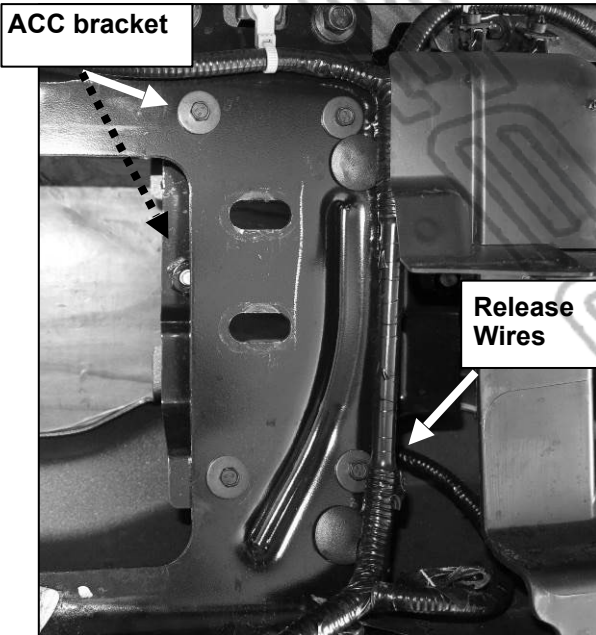


(Fig 7) Remove 3 tow hook bolts



(Fig 8) Attach Support Bracket using the OE tow hook bolts

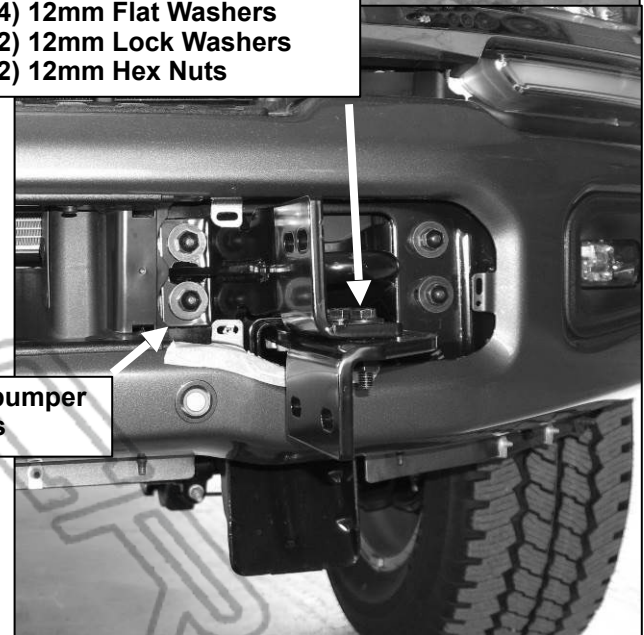
Driver Side Installation Pictured



ACC bracket

Release Wires

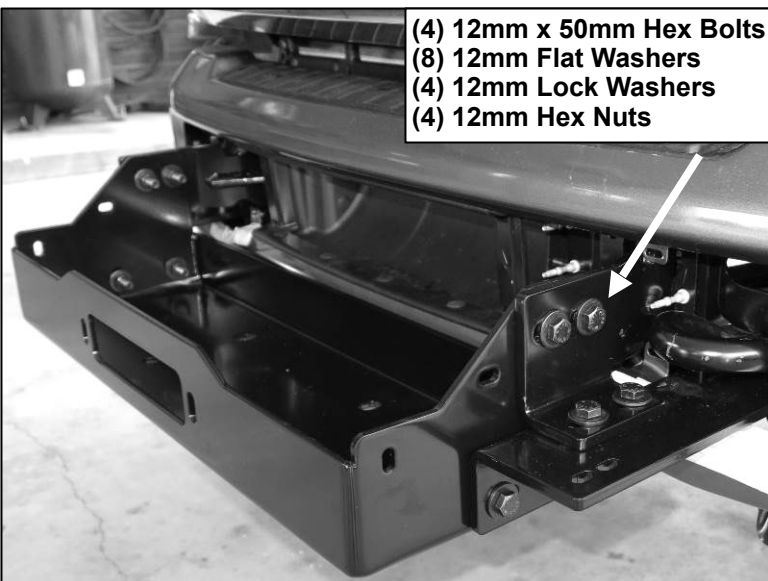
- (2) 12mm x 50mm Hex Bolts
- (4) 12mm Flat Washers
- (2) 12mm Lock Washers
- (2) 12mm Hex Nuts



OE bumper bolts

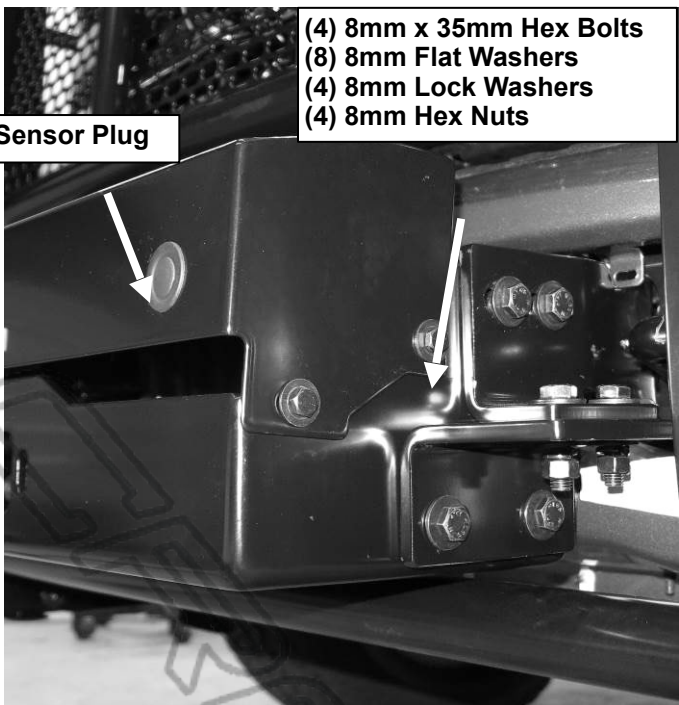
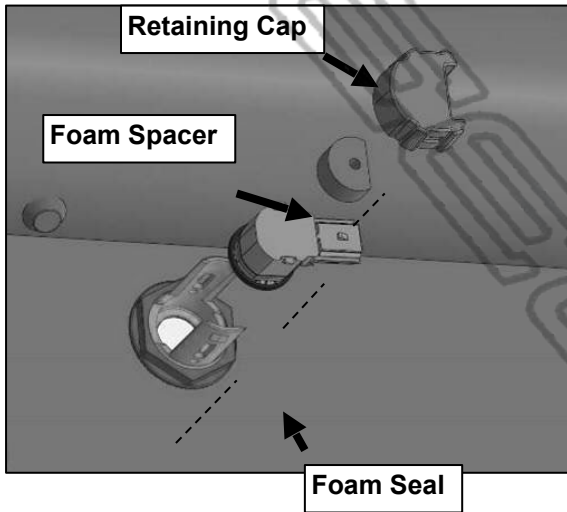
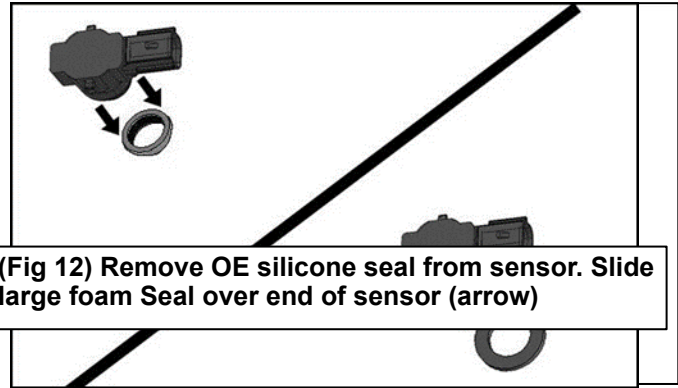
(Fig 9) Remove ACC bracket from the OE bumper. Remove middle parking sensors. Detach wire clips to allow extension to new location.

(Fig 10) Attach Mounting Bracket to Support Bracket



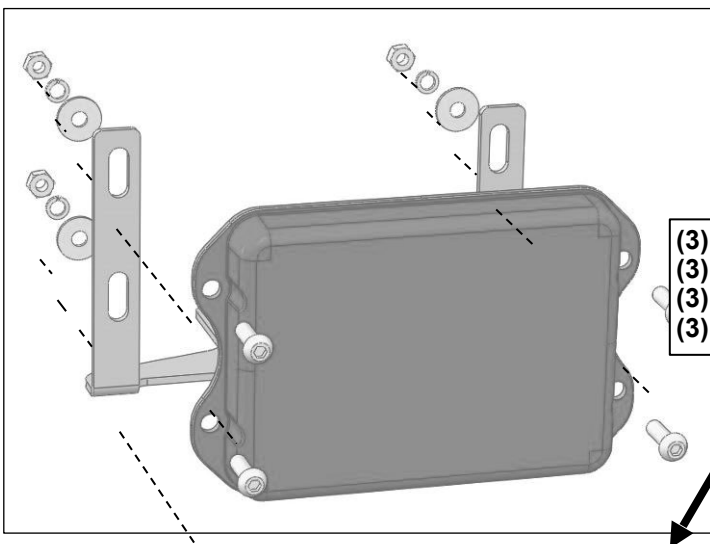
- (4) 12mm x 50mm Hex Bolts
- (8) 12mm Flat Washers
- (4) 12mm Lock Washers
- (4) 12mm Hex Nuts

(Fig 11) Attach Winch Tray to Mounting and Support Brackets



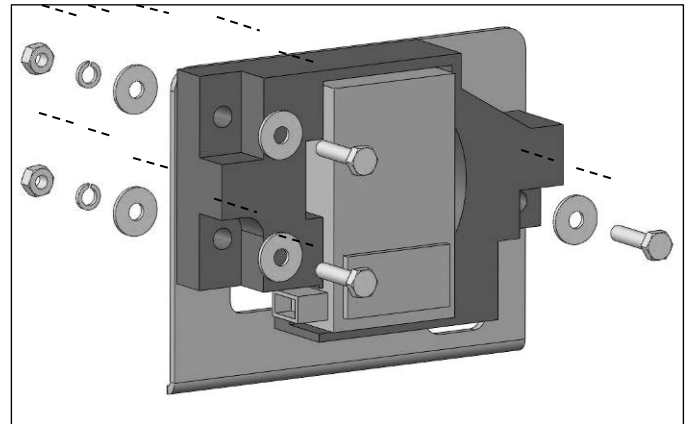
(Fig 13) Insert the sensor with seal into the sensor sleeve, followed by the foam spacer and retaining cap

(Fig 14) Attach Winch Cover to the Winch Tray

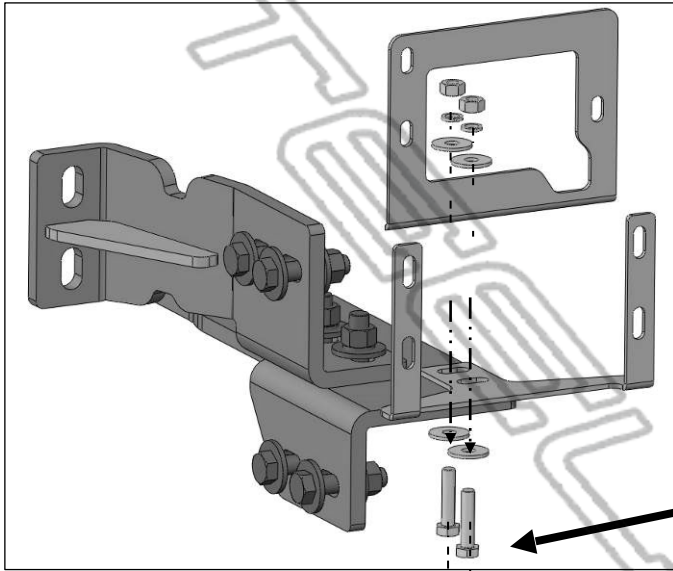


- (3) 6mm x 25mm Hex Bolts**
- (6) 6mm Flat Washers**
- (3) 6mm Lock Washers**
- (3) 6mm Hex Nuts**

(Fig 15) Attach plastic ACC Cover to ACC Cover Bracket, if equipped



(Fig 16) Attach adaptive cruise control sensor to ACC Sensor Bracket, if equipped



- (2) 8mm x 35mm Hex Bolts**
- (4) 8mm Flat Washers**
- (2) 8mm Lock Washers**
- (4) 8mm Hex Nuts**

(Fig 17) Place ACC Cover Bracket on driverside Support Bracket, then place ACC Sensor Bracket on top last. Fasten with 8mm hardware.