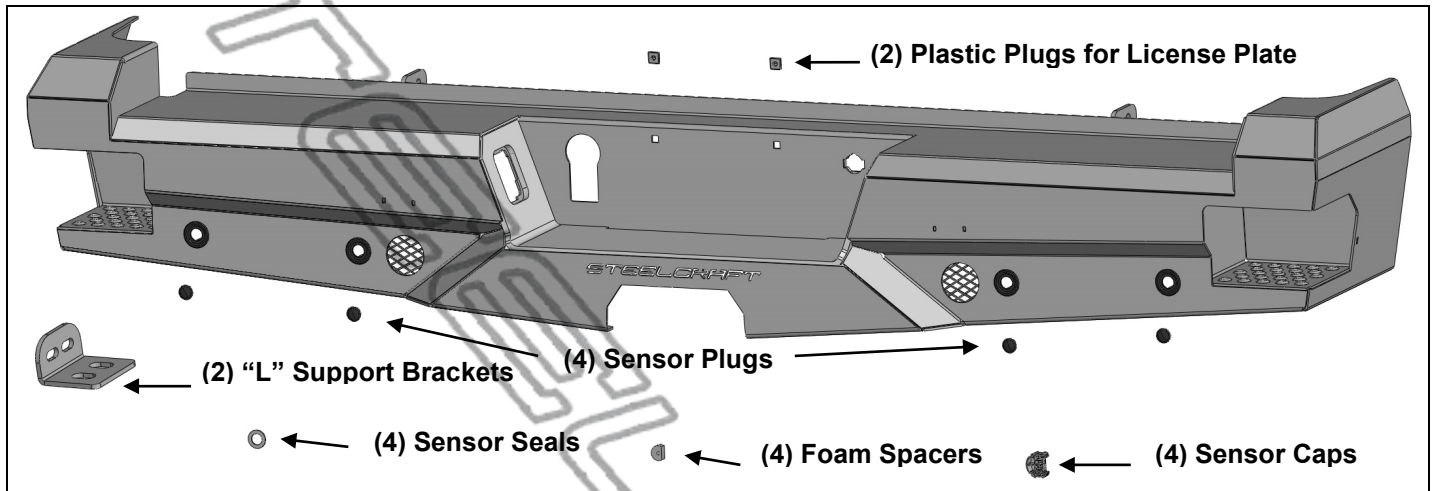


**ELEVATION REAR BUMPER  
2017-24 FORD F250-350**

**PARTS LIST:**

1	Elevation Rear Bumper Assembly	2	Plastic Plugs for license plate mount
4	Sensor Hole Plugs	8	4mm self-tapping screws
4	Sensor Retaining Caps	2	L Support Brackets
4	Foam Spacer 20mm x 10mm	8	M12 x 45mm hex bolt
4	Sensor Sealing Washer	16	12mm x 32mm x 3mm flat washer
1	Sensor Cover Kit	8	M12 nylon lock nut



**PROCEDURE:**

**REMOVE CONTENTS FROM BOX. VERIFY ALL PARTS ARE PRESENT. READ INSTRUCTIONS CAREFULLY BEFORE STARTING INSTALLATION. BUMPER IS HEAVY, ASSISTANCE IS RECOMMENDED TO AVOID POSSIBLE INJURY OR DAMAGE TO THE VEHICLE.**

1. Remove the license plate from the bumper. Unplug the wiring harness leading to the bumper and move harness away from bumper.
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 (2) factory bolts attaching the bottom of the bumper (step area) to the receiver hitch, **(Figure 1)**. Next, remove the factory hardware attaching the bumper to the bumper brackets and remove the bumper assembly, **(Figure 2)**. **WARNING!** Assistance is required to hold the bumper in place during hardware removal to prevent bumper from falling.
3. Next, remove both bumper brackets from the frame, **(Figure 3 & 4)**.
4. Remove sensors, (if equipped), from bumper. Release the clips securing the trailer plug and remove the plug. Remove the license plate lights and wiring harness from the bumper. Next, remove the spare tire plug lock if equipped, **(Figure 5)**.
5. Reinstall the spare tire hole plug lock, license plate lights and trailer plug into the Elevation Bumper, **(Figure 6)**. **NOTE:** Use a flat blade screwdriver to carefully pry out the metal clips on the trailer plug to grab the edge of the opening if necessary.
6. Determine if the vehicle is equipped with sensors. **NOTE:** It may be necessary or easier to install sensors, (if equipped), and harness before installing the Bumper.

**Models without bumper sensors:**

- a. Select the included (4) Sensor Hole Plugs, **(Figure 7)**. Insert the plugs into the sensor holes from the front of the bumper.

**Models with bumper mounted sensors:**

- a. Remove the OE silicone seal from the end of the sensor, **(Figure 8)**. Remove the adhesive backing from the included larger foam Sensor Seal and slide over the front of the sensor.
- b. Insert the sensor with Seal into sensor mount, **(Figure 9)**.
- c. Place the thick Foam Spacer over end of the sensor. Push Sensor Retaining Clip into sensor mount and lock into mounting holes, **(Figure 9)**.

**ELEVATION REAR BUMPER  
2017-24 FORD F250-350**

- d. Repeat previous Steps to install remaining sensors.
- e. Install wiring harness for sensors.
- 7. Attach the wiring harness to the sensors and license plate lights as equipped.
- 8. Determine year of vehicle.

**2017-22 models:**

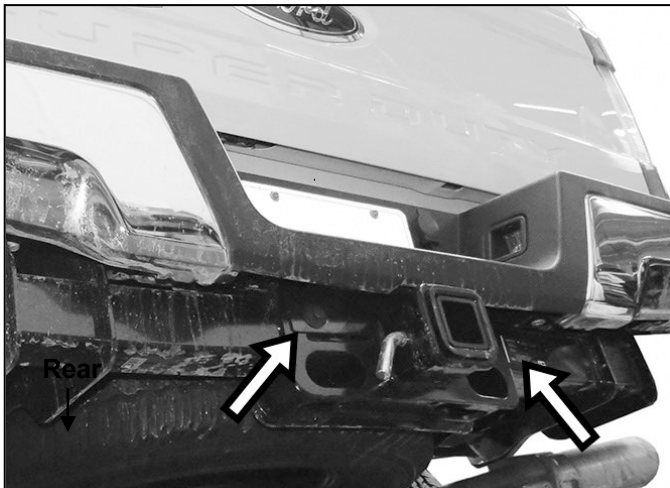
- a. With assistance, hold the Bumper assembly up to the frame. Temporarily support the weight of the Bumper. **WARNING:** To avoid possible injury or damage to the vehicle, do not proceed until the bumper is fully and safely supported. Re-use the factory bumper hardware to attach the Bumper Mounting Bracket to the outside of the frame, **(Figure 10)**.
- b. Repeat this **Step** to install the driver/left Bracket. Snug but do not fully tighten hardware at this time.

**2023-on models:**

- a. Select (1) L Support Bracket. Attach the Bracket to the top of the hitch with the included (2) 12mm x 45mm Hex Bolts, (4) 12mm Flat Washers and (2) 12mm Nylon Lock Nuts, **(Figures 11 & 12)**.
- b. With assistance, hold the Bumper assembly up to the frame. 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. Re-use the factory hardware to attach the Bumper Mounting Bracket to the side of the frame. Attach the Bumper Mounting Bracket to the side of the new "L" support Bracket with the included (2) 12mm x 45mm Hex Bolts, (4) 12mm Flat Washers and (2) 12mm Nylon Lock Nuts, **(Figures 11 & 12)**. Snug but do not fully tighten hardware at this time.
- c. Repeat the previous **Steps** to install the driver/left "L" Support Bracket and Mounting Bracket.
- 9. Level and adjust the bumper and slowly lower the tailgate and check for clearance. Adjust the bumper as required and fully tighten all hardware to 65-70ft-lbs.
- 10. Use the included (2) push-in plugs to attach the license plate to the Bumper, **(Figure 13)**.
- 11. Plug in the wiring harness on the bumper to the main harness on the vehicle.
- 12. 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.

**Passenger Side Installation Pictured**



**(Fig 1) Remove the (2) bolts attaching the bottom of the step to the receiver hitch if equipped**



**(Fig 2) Remove the factory hex nuts attaching the bumper to the brackets (arrow)**

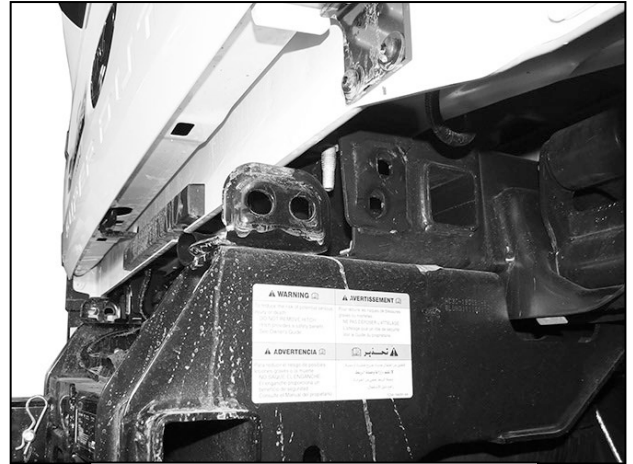
**WARNING!** Do not crawl under bumper unless the bumper is properly supported on blocks or stands or the bumper may fall.

Passenger Side Installation Pictured



(Fig 3) Remove bumper bracket from frame. [2023-on model year pictured]

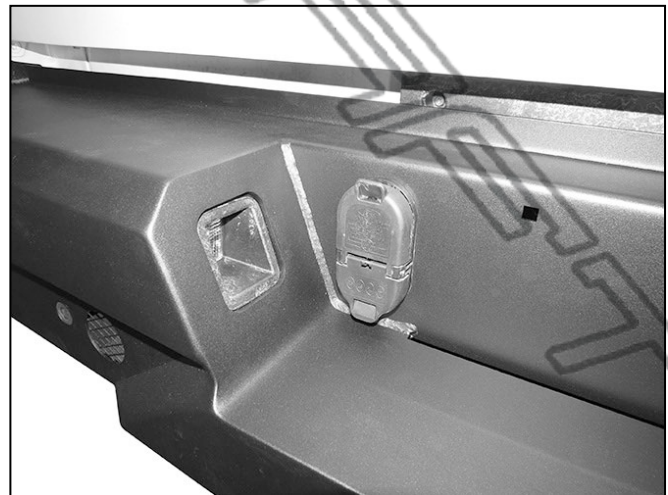
**WARNING!** Do not remove bumper bolts unless the bumper is properly supported on blocks or stands or the bumper may fall.



(Fig 4) Bumper bracket removed. [2017-22 model year pictured  
OE "L" bracket remains attached]

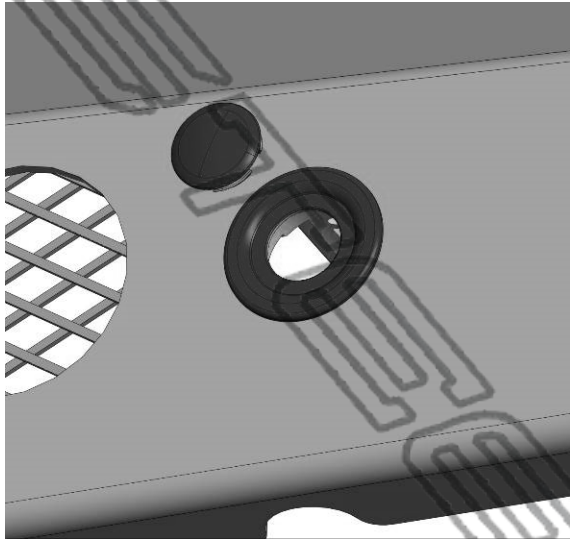


(Fig 5) Remove sensors, wire harness, license plate lights, trailer plug and spare tire access lock (pictured) if equipped

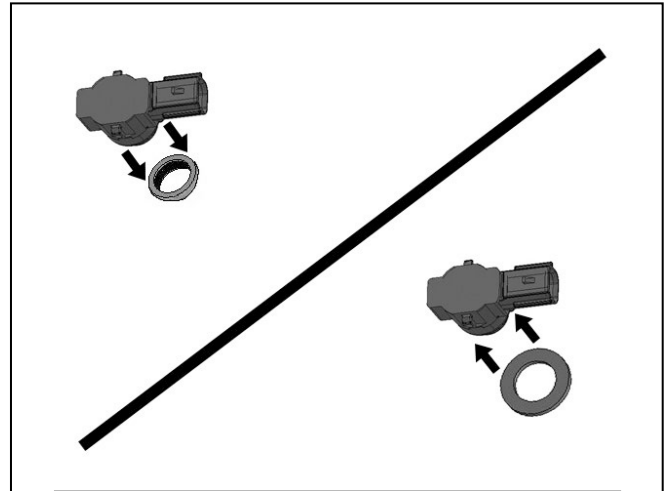


(Fig 6) Reinstall trailer plug, license plate lights and spare tire access lock

Passenger Side Installation Pictured

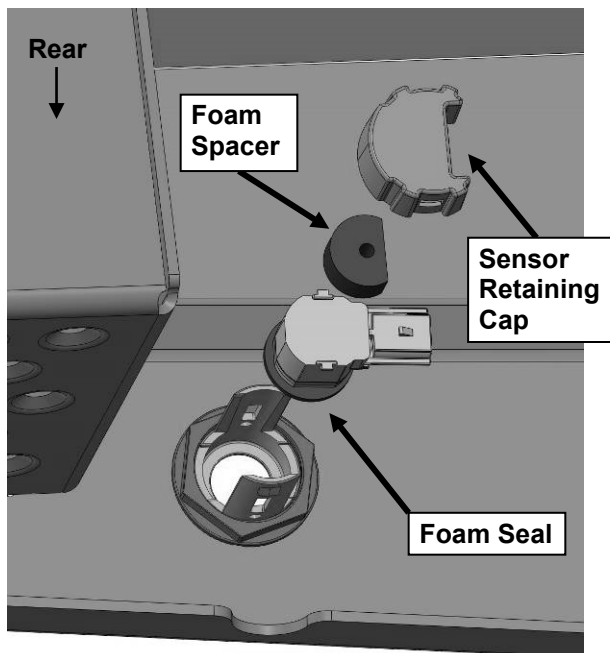


(Fig 7) Push sensor hole plug into holes on outside of bumper.



(Fig 8) Remove silicone seal from sensor. Slide large Seal over end of sensor (arrow)

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



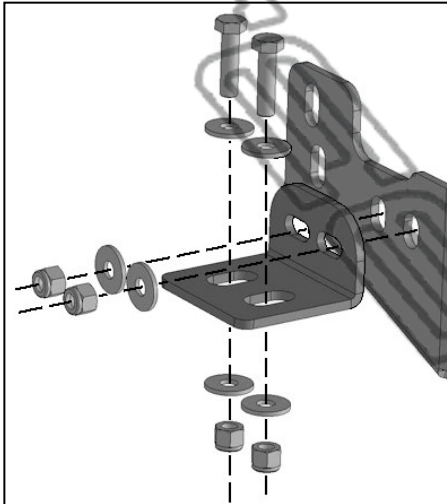
(Fig 9) Slide sensor with foam seal into sleeve. Insert Foam Spacer and Clip onto back of sensor to lock sensor in sleeve.



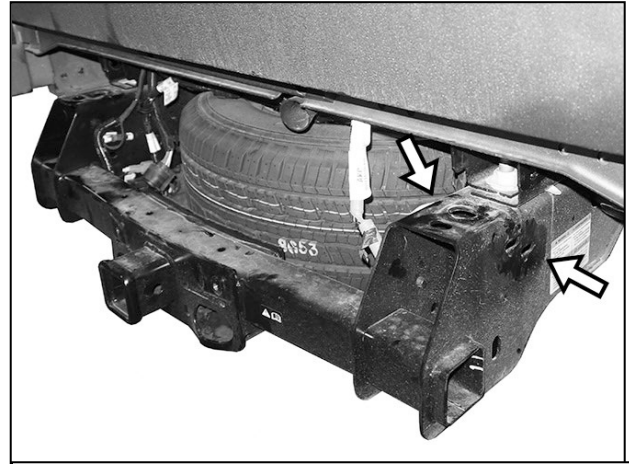
(Fig 10) Reuse factory hardware to attach passenger/right Bumper to side of frame

Passenger Side Installation Pictured

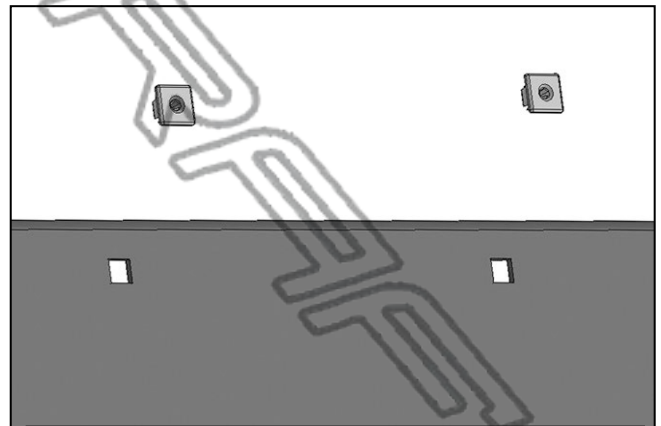
**WARNING!** Do not crawl under bumper unless the bumper is properly supported on blocks or stands or the bumper may fall.



(Fig 12) 2023-on models with OE receiver hitch, attach the Support Bracket to the top of the hitch. Reuse the factory hardware to attach the Mounting Bracket to the side of the frame. Use the included 12mm hardware to attach the Mounting Bracket to the Support Bracket



(Fig 11) 2023-on models with OE receiver hitch, attach the "L" Support Bracket to the top of the hitch using the supplied 12mm hardware.



(Fig 13) Push plugs into holes for license plate



Complete Installation