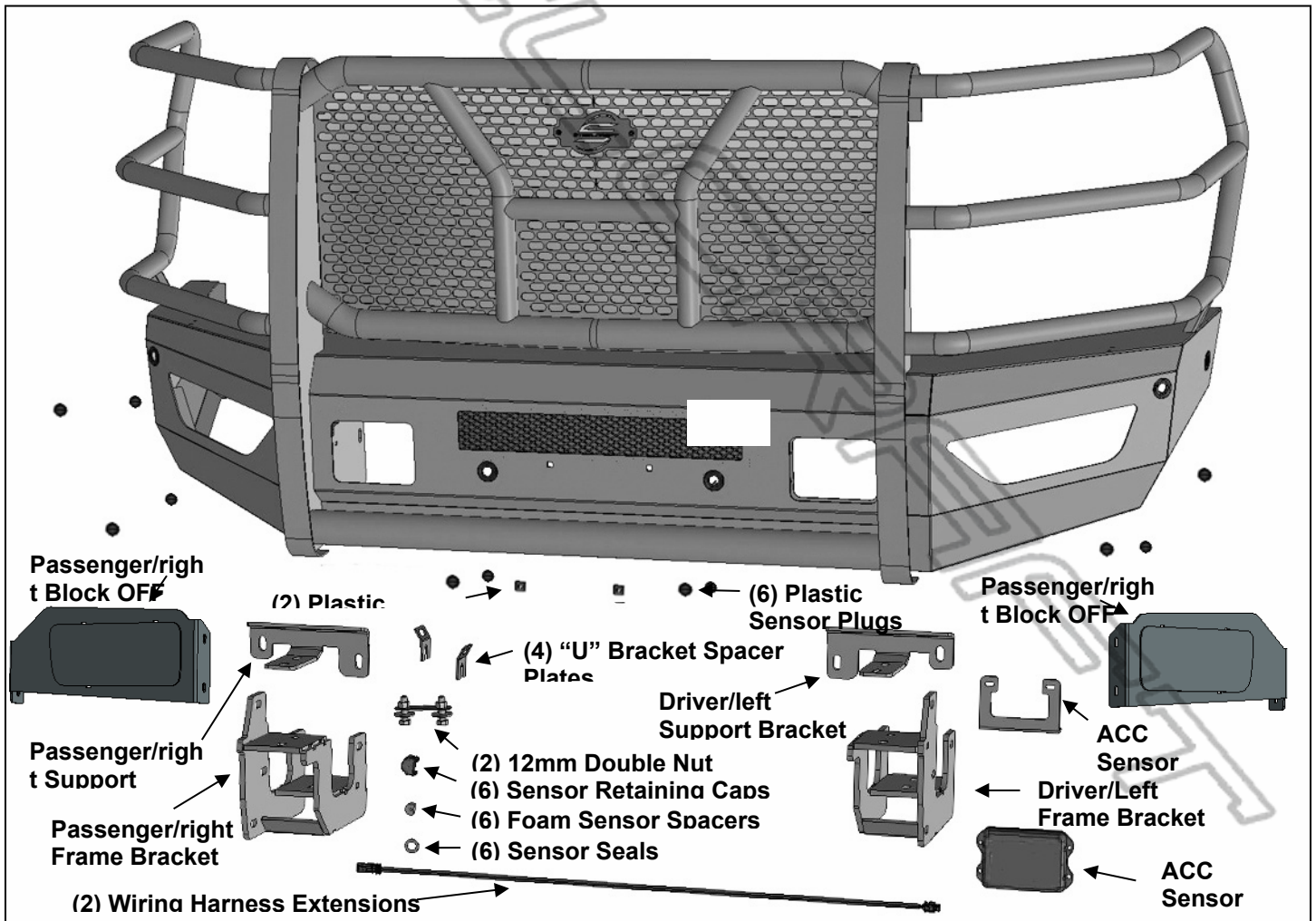


**ELEVATION FRONT BUMPER
2024+ FORD F150**

PARTS LIST:

1	Elevation Front Bumper	2	M12 double nut plates
1	Driver/left Side Frame Bracket	36	12mm x 37mm x 3mm Flat Washers
1	Passenger/right Side Frame Bracket	2	M12 x 170 hex bolts
1	Driver/left Side Support Bracket	18	12mm x 45mm Hex Bolts
1	Passenger/right Side Support Bracket	4	M12 lock washer
2	Block Off Plates	16	M12 nylon lock nuts
1	ACC Sensor Bracket	4	5mm x 10mm x 1mm flat washers
1	ACC Sensor Cover	4	5mm Lock Washers
2	Plastic Plugs for license plate mount	4	5mm x 12mm Hex Bolts
4	"U" Bracket Spacer Plates	10	M6 lock washer
2	Parking wires	6	6mm x 12mm x 1.6mm Flat Washers
6	Sensor Retaining Caps	8	6mm Hex Nuts
6	15.5mm x 25mm Foam Sensor Seals	10	6mm x 25mm Hex Bolts
6	20mm x 10mm Foam Sensor Spacers	18	6mm x 18mm x 1.6mm Flat Washers
1	Sensor Cover Kit	2	M6 flange nuts
6	Plastic Sensor Hole Plugs	1	Allen Wrench
12	4mm Self-Tapping Screws		



PROCEDURE:

REMOVE CONTENTS FROM PACKAGING. SOME PARTS ARE SMALL AND WILL BE HIDDEN IN WRAPPINGS. VERIFY ALL PARTS ARE PRESENT AND DO NOT DISCARD PACKAGING UNTIL INSTALLATION IS COMPLETE. 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 if equipped.
2. From behind the front bumper, unplug and remove the active air dam from the bottom of the frame, **(Figures 1 & 2)**. It is not necessary to remove the lift motors, only remove the (6) bolts to remove the air dam. **NOTE:** Active air dam lift motor will not be installed or used on Steelcraft bumper. It will remain on OE bumper.
3. With the air dam out of the way, locate and unplug the main harness plug on the top of the passenger/right frame rail behind the bumper bracket, **(Figure 3)**. Unplug any remaining harnesses leading to the bumper. On hybrid models, temporarily remove the speaker assembly for the pedestrian audible alert system from the driver/left frame channel, **(Figure 4)**. Note speaker is located on the inner side of the frame, behind the driver/left bumper bracket. From below, remove the hex bolt and drop the speaker down, unplug and remove, **(Figure 5)**.
4. Place blocks or jack stands under the front bumper to support it during mounting hardware removal. Once the bumper has been safely supported, remove the large hex nuts from the back of each bumper bracket attaching the bumper to the bumper brackets, **(Figure 6)**. **WARNING!** Assistance is required to hold the bumper in place during hardware removal to prevent the bumper from falling. Carefully slide the bumper off over the tow hooks if equipped.
5. Remove both tow hooks if equipped, **(Figure 6)**.
6. On models with bolt-on frame extensions, remove the extensions from outside of frame, **(Figure 6)**. **NOTE:** It may be necessary to cut the bolts to remove frame extensions, (removal is optional).
7. Models without tow hooks, insert (1) 12mm Double Nut Plate into the end of the driver/left side of the frame and over the two holes in the bottom of the frame, **(Figures 6 & 7)**.
8. Select the driver/left Frame Mounting Bracket. Attach the Bracket to the bottom of the frame and inner double nut plate with the included (2) 12mm x 45mm Hex Bolts, (2) 12mm Lock Washers and (2) 12mm Flat Washers, **(Figures 7 & 8)**. Do not fully tighten hardware at this time.
9. Next, insert (1) 12mm x 170mm Long Hex Bolt with (1) 12mm Flat Washer **through the inner side** of the Frame Bracket, and frame, **(Figure 9)**. **NOTE:** On models with ecoboost, it may be necessary to temporarily remove the hardware attaching the intercooler shutter assembly to insert the long Hex Bolt. Secure the Bracket to the frame with (1) 12mm Flat Washer and (1) 12mm Nylon Lock Nut.
10. Slide (2) "U" Bracket Spacers, (1 on inner, 1 on outer side of frame), down between the side of the frame and the inside of the Frame Bracket, **(Figure 9)**. Reattach assembly once Hex Bolt has been installed. Do not fully tighten hardware.
11. Select the driver/left Frame Support Bracket. Attach the Bracket to the end of the frame with the included (2) 12mm x 45mm Hex Bolts, (4) 12mm Flat Washers and (2) 12mm Nylon Lock Nuts, **(Figures 10 & 12)**. Attach the Support Bracket to the top of the Frame Bracket with the included (2) 12mm x 45mm Hex Bolts, (4) 12mm Flat Washers and (2) 12mm Nylon Lock Nuts, **(Figures 11 & 12)**. **Models with tow hooks**, attach the tow hook to the inside of the Frame Bracket, **(Figure 12)**. **IMPORTANT:** Models with Adaptive Cruise Control (ACC) sensor, do not reinstall the driver/left side tow hook, **(Figure 13)**. Do not fully tighten hardware.
12. Repeat **Steps 8—11** to install the passenger/right Frame Bracket and Support Brackets, **(Figure 12)**.
13. Disassemble front bumper to unplug and remove fog lights, sensors and wiring harness from bumper. Pay attention to mounting location of all sensors for proper reinstallation.

14. On models with fog lights, determine the style of fog light.

Models equipped with small halogen fog lights:

- a. Attach the driver/left fog light assembly to the preinstalled fog light mount tabs on the back of the Bumper with (3) 6mm x 25mm Hex Bolts, (3) 6mm x 12mm Flat Washers, and (3) 6mm Lock Washers (**Figure 14**). Repeat this step to the passenger/right fog light.
- b. Plug in the fog light harness to the lights and secure it to the Bumper.

Models equipped with large LED fog lights:

- a. Remove driver/left preinstalled small halogen fog light mounting bracket from behind the bumper, (**Figure 14**).
- b. Attach fog light to large LED mounting bracket with (3) 6mm x 25mm Hex Bolts, (6) 6mm x 18mm Flat Washers, (3) 6mm Lock Washers, and (3) 6mm Hex Nuts, (**Figure 15**). Repeat this Step to attach the passenger/right fog light assembly.
- c. Plug in the fog light harness to the lights and secure it to the Bumper.

Models without fog lights:

- a. Remove driver/left preinstalled small halogen fog light bracket from behind the bumper and set hardware off to the side, (**Figure 14**).
- b. Select the driver/left Block Off.
- c. Reuse hardware removed from small halogen fog light mounting panel to attach Block Off to the same mounting tabs where the small halogen fog light panel was, (**Figure 16**)
- d. Repeat previous Steps to install the passenger/right Block Off.

15. Determine if the vehicle is equipped front sensors:

Models without bumper sensors:

- a. Select the included (6) Plastic Plugs.
- b. From the front, push the plugs into the sensor mounting holes, (**Figure 17**).

Models with bumper mounted parking sensors:

- a. Select the driver/left outer sensor. Remove the silicone seal from the end of the sensor. Slide the included larger Foam Sensor Seal over front of sensor, (**Figure 18**).
- b. Insert sensor with Seal into driver/left outer sensor mount, (**Figure 19**).
- c. Place Foam Spacer over end of sensor. Push Sensor Retaining Cap onto sensor mount and lock into mounting holes, (**Figure 19**).
- d. Repeat previous Steps to install remaining sensors.
- e. Install wiring harness for sensors. **NOTE:** Use the included (2) Wire Harness Extensions to extend the length of the factory harness to reach all sensors.

Models with Adaptive Cruise Control (ACC).

- a. Attach the Plastic Sensor Cover to the inside of the Bumper with the included (4) 5mm x 12mm Hex Bolts, (4) 5mm Lock Washers and (4) 5mm Flat Washers, (**Figure 20**).
- b. Remove sensor from outer steel bracket, (**Figure 21**).
- c. Attach the sensor to the back of the Relocation Bracket with (2) 6mm x 25mm Hex Bolts, (2) 6mm Lock Washers, (2) 6mm Flat Washers and (2) 6mm Flange Nuts, (**Figure 22**).
- d. Next, attach the sensor and Bracket to the tab on the back of the Bumper with the included (2) 6mm x 25mm Hex Bolts, (4) 6mm Flat Washers (2) 6mm Lock Washers and (2) 6mm Hex Nuts, (**Figure 23**). Fully tighten sensor mounting hardware.

16. Center LED light installation (not included).

- a. Attach the LED light assembly to the tabs on the back of the Bumper.
- b. Follow light manufacturer's instructions to properly wire the light.

17. With assistance, position the Bumper Assembly up to the outside of the Mounting Brackets, (**Figure 24**). Temporarily support the weight of the Bumper. **NOTE:** On models with ecoboost, trim plastic shroud to fit Bumper profile as needed. **WARNING:** To avoid possible injury or damage to the vehicle, do not proceed until the bumper is fully and safely supported.

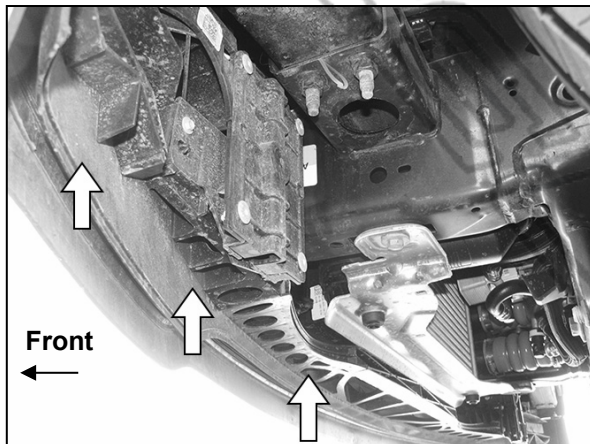
18. Attach the driver/left mounting plate on the back of the Bumper to the outside of the Mounting Bracket with the included (3) 12mm x 45mm Hex Bolts, (6) 12mm Flat Washers and (3) 12mm Nylon Lock Nuts,

(Figures 24 & 25). Repeat this **Step** to attach the passenger/right side of the Bumper to the Bracket.
Do not fully tighten hardware at this time.

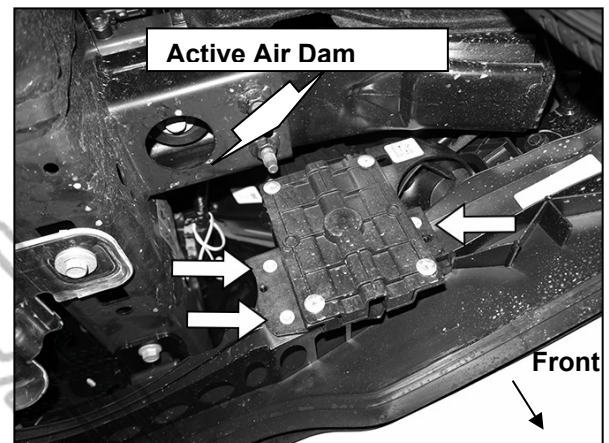
19. Level and adjust the bumper and fully tighten all hardware.
20. If front license plate is required, insert (2) Plastic Plugs into the square holes in the Bumper. Reuse the factory screws to attach the license plate to the Plastic Plugs, (Figure 26).
21. Models with grille mounted camera, lower center remove screen from Bumper, (Figure 26).
22. Do periodic inspections to the installation to make sure that all hardware is secure and tight.
23. **NOTE:** The air dam motor is not a sensor. It will not get reinstalled on Steelcraft Bumper and remains on OE bumper, (Figure 27).

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.

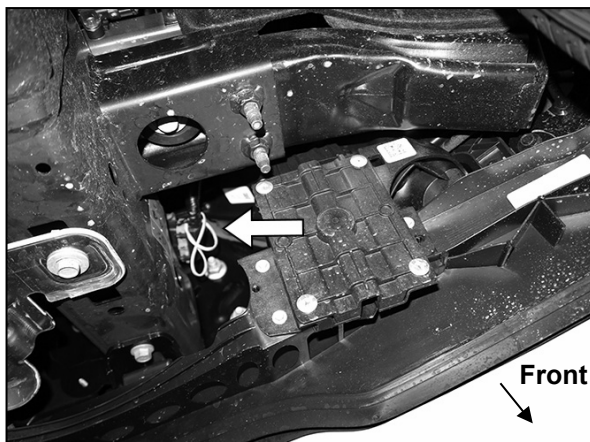
Driver/left Side Installation Pictured



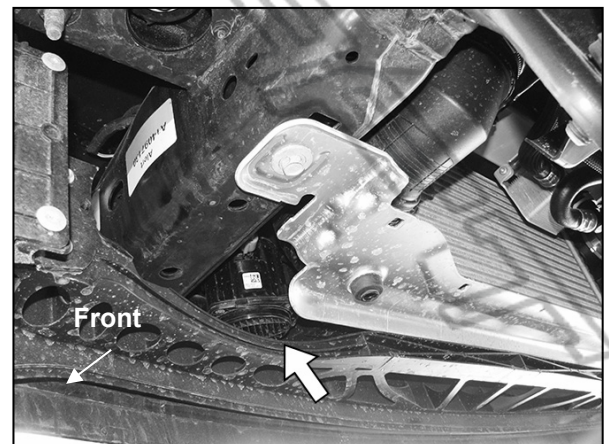
(Fig 1) Active air dam behind



(Fig 2) Remove bolts (arrows) to remove active air dam from motors (passenger/right side pictured) **NOTE:** Air dam motor will **NOT** be installed on Steelcraft Bumper. Remains on OE



(Fig 3) Locate and unplug main harness plug on passenger/right side of bumper



(Fig 4) Hybrid Models Only, locate alert speaker behind driver/left side of

Driver/left Side Installation Pictured

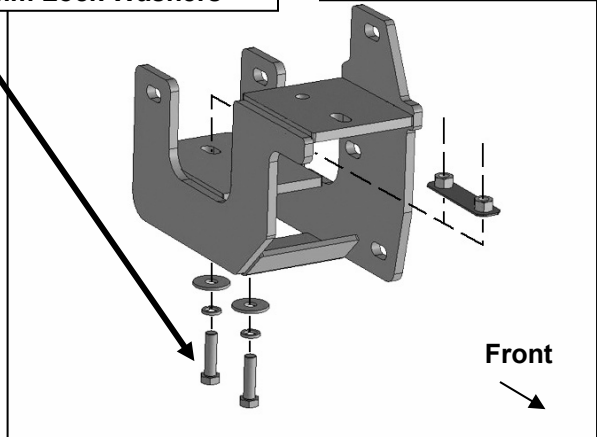


(Fig 5) Remove bolt (arrow) to temporarily remove audible alert speaker located behind driver/left side of bumper (hybrid models only-pictured from below)

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

(2) 12mm x 45mm Hex Bolts
(2) 12mm Lock Washers

Use either factory double nut plate or the included 12mm Double



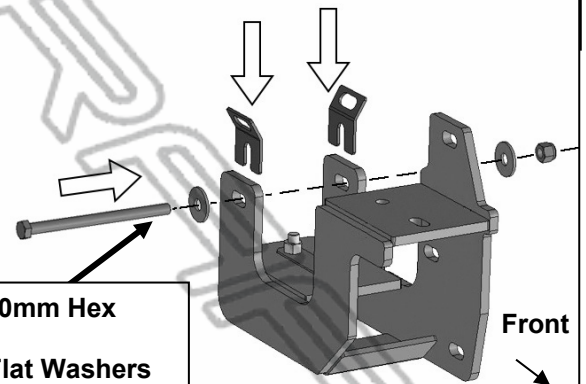
(Fig 7) Attach driver/left Frame Mounting Bracket to end of



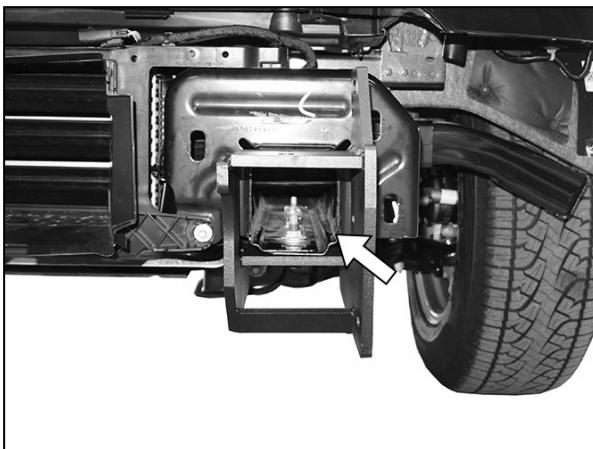
(Fig 6) Remove bumper. Also remove the factory frame extension (arrow-

WARNING! Do not remove bumper

12mm x 170mm Hex Bolt
(2) 12mm Flat Washers



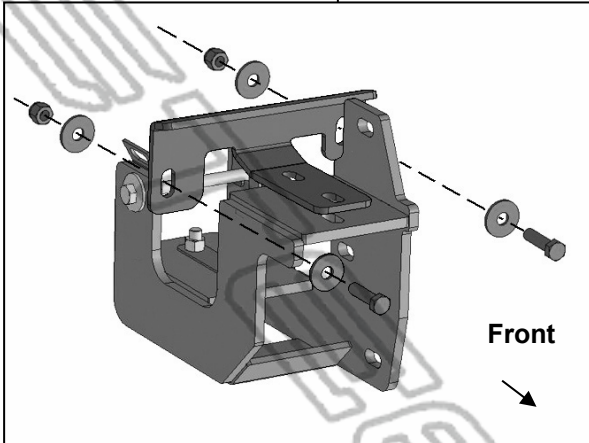
(Fig 9) Insert "U" Bracket Spacers between side of frame and inside of Frame Bracket (driver/left side Bracket illustrated)



(Fig 8) Driver/left Frame Mounting Bracket attached to inner Double Nut

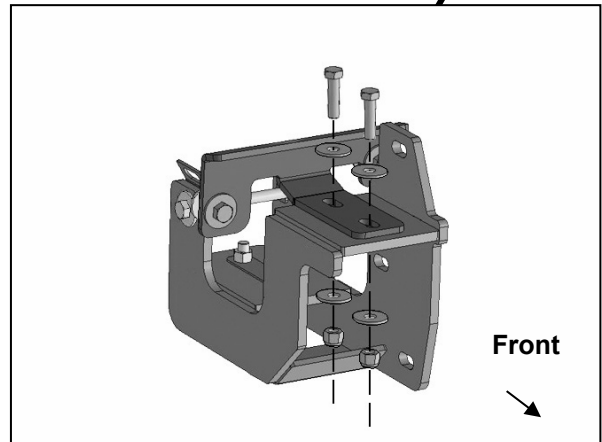
Driver/left Side Installation Pictured

(2) 12mm x 45mm Hex



(Fig 10) Attach driver/left Support Bracket to top mounting holes in end of

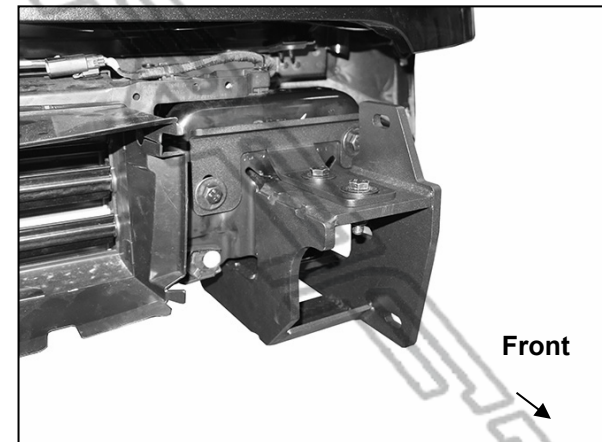
(2) 12mm x 45mm Hex Bolts
(4) 12mm Flat Washers



(Fig 11) Attach driver/left Support Bracket to top Frame Bracket. Models equipped with tow hooks without ACC sensor, reinstall tow hook to inside of Frame

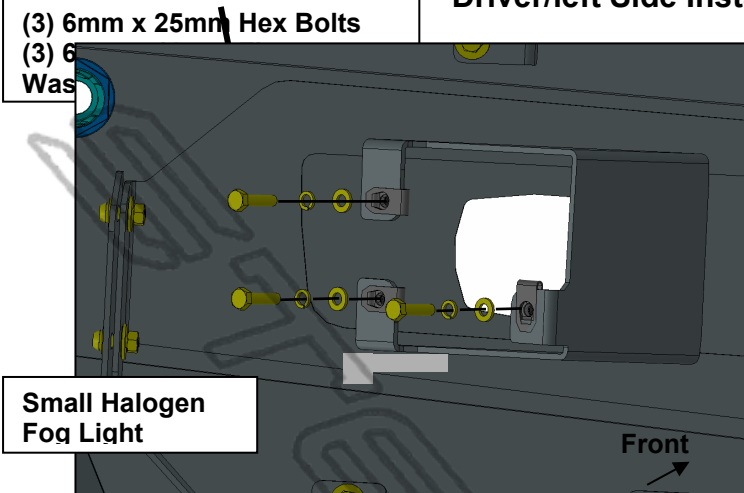


(Fig 12) Passenger/right Frame Bracket and Support Bracket installed with tow hook



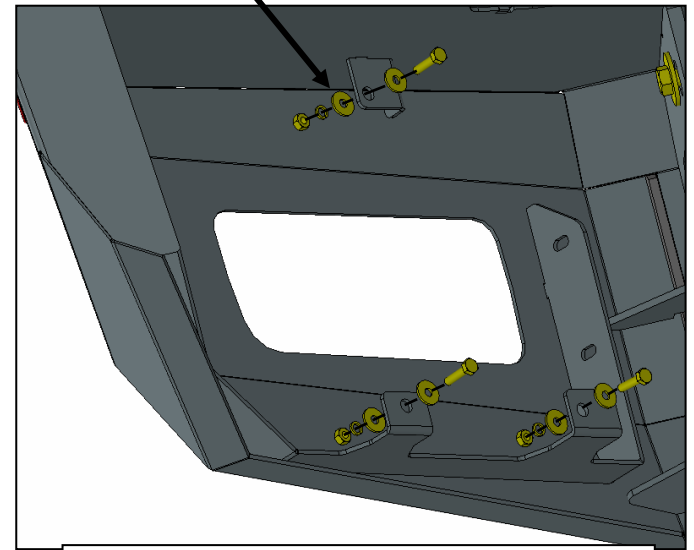
(Fig 13) Driver/left Frame Bracket and Support Bracket installed. Models with ACC sensor, do not install driver/left side tow

Driver/left Side Installation Pictured

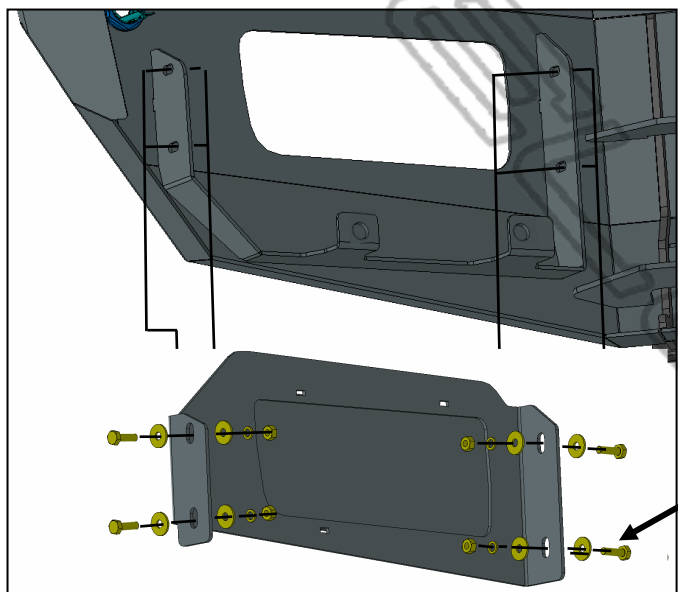


(Fig 14) Attach driver/left Halogen Fog Light assembly to tabs on Bumper.

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

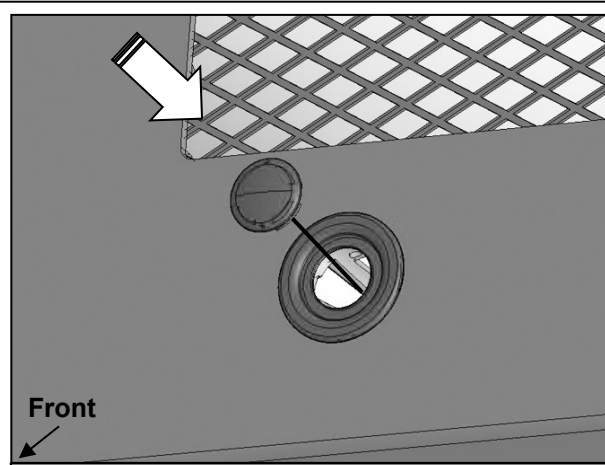


(Fig 15) Remove driver/left Small Halogen Fog Light Bracket and Attach driver/left LED Fog Light assembly to tabs on

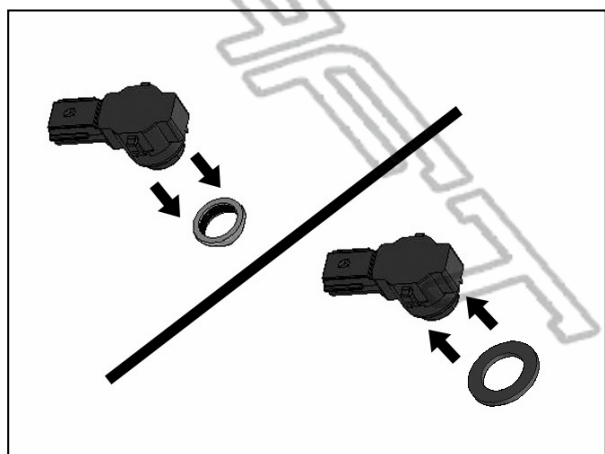


(Fig 16) Remove driver/left Small Halogen Fog Light Bracket and re-use hardware to attach driver/left Block Off Panel.

- Re-used Hardware
- (4) 6mm x 25mm Hex Bolts
- (8) 6mm Flat Washers
- (4) 6mm Lock Washers

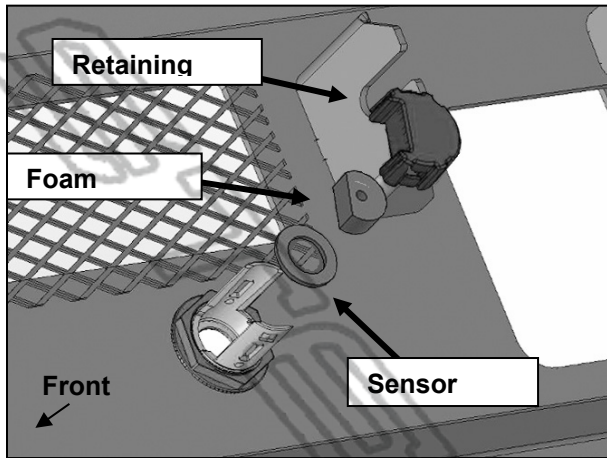


(Fig 17) Push Plastic Plug into sensor



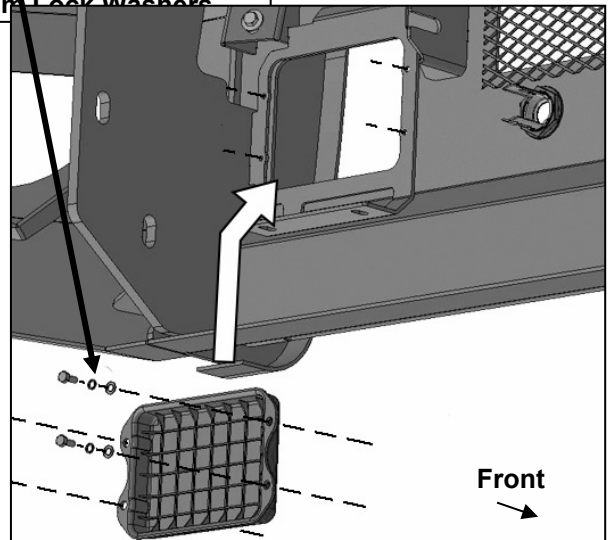
(Fig 18) Remove silicone seal from sensor. Slide large Seal over end of

Driver/left Side Installation Pictured

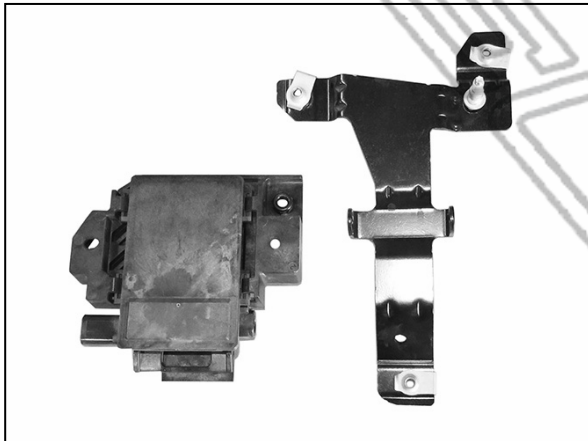


(Fig 19) Insert sensor assembly into the sensor mount on back of Bumper

- (4) 5mm x 12mm Hex Bolts
- (4) 5mm Lock Washers

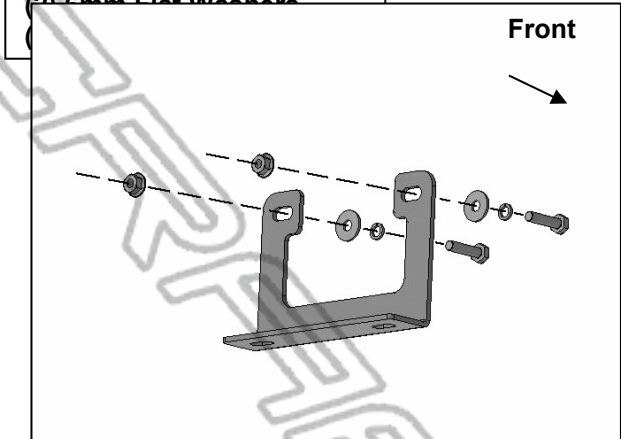


(Fig 20) Models equipped with adaptive cruise control (ACC), attach Plastic Sensor Cover to back of Bumper

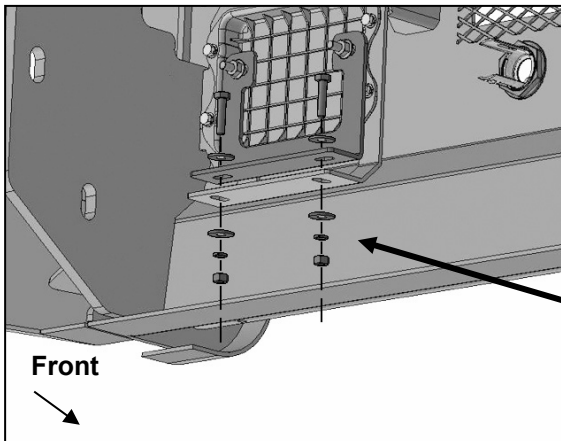


(Fig 21) Models equipped with ACC, remove sensor from mounting bracket

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



(Fig 22) Models equipped with ACC, attach sensor to back of Relocation Bracket



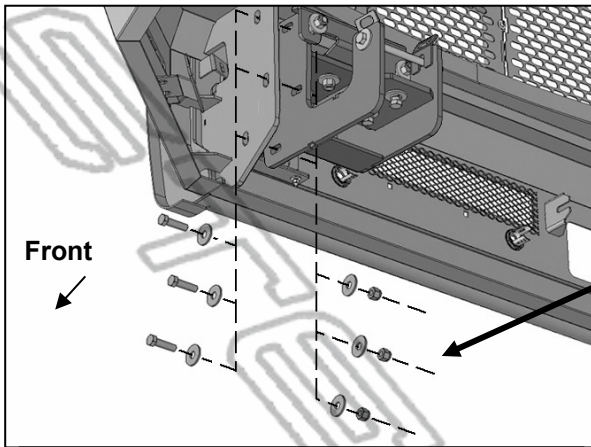
(Fig 23) Models with ACC, attach Bracket with ACC sensor to tab on back of Bumper

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

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

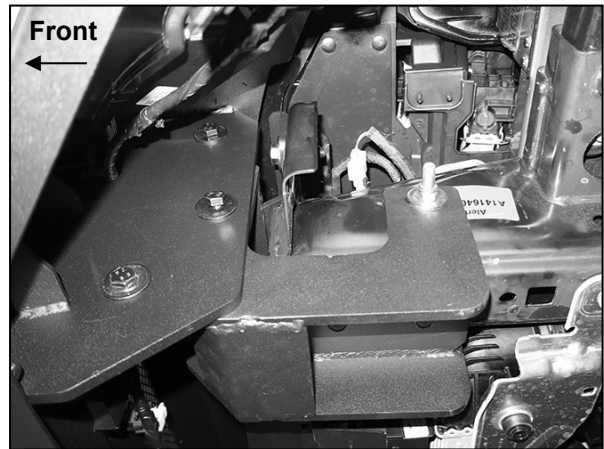
Driver/left Side Installation Pictured

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

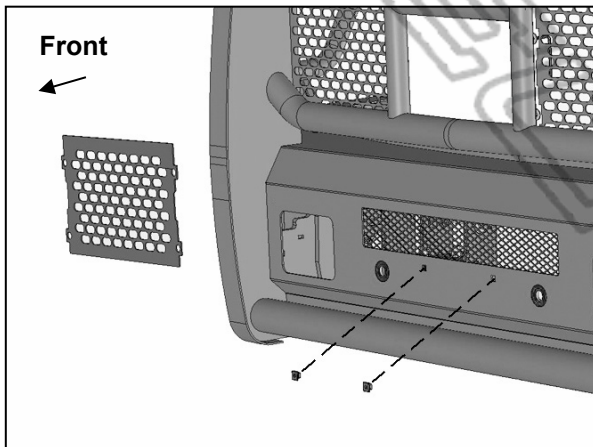


- (3) 12mm x 45mm Hex Bolts
- (6) 12mm Flat Washers
- (3) 12mm Nylon Lock Nuts

(Fig 24) Attach Bumper to Frame Mounting Bracket (driver/left side)

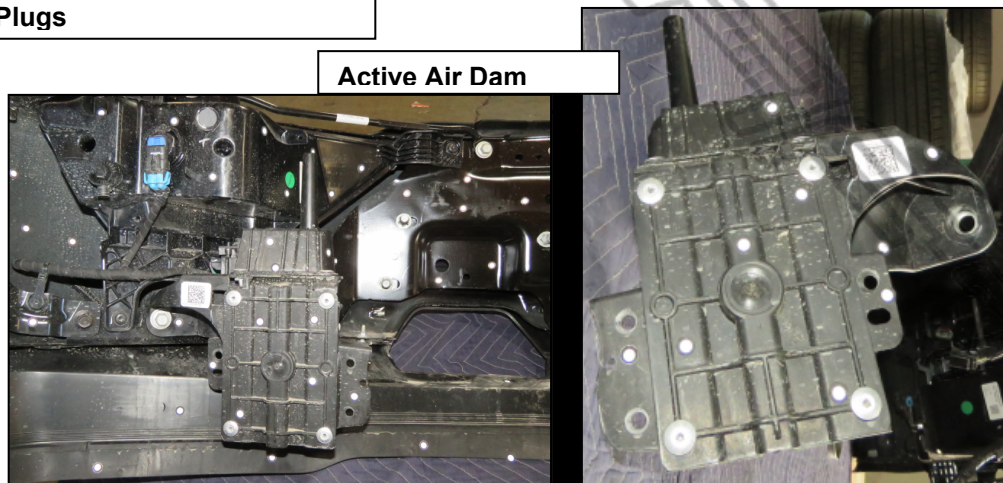


(Fig 25) Driver/left side of Bumper attached to Bracket (pictured from



(Fig 26) Models equipped with grille mounted camera, remove center screen. Reuse factory screws to attach license plate to Plastic Plugs

Active Air Dam



(Fig 27) This is not a sensor. This air dam motor does not get re-installed.