

# 2017-20XX, FORD RAPTOR

## FRONT BUMPER INSTALLATION INSTRUCTIONS



## SAFETY

**Know safety, no injury. Know injury, no safety. ~Author Unknown**

If there are any questions, call 1-855-HHTOUGH

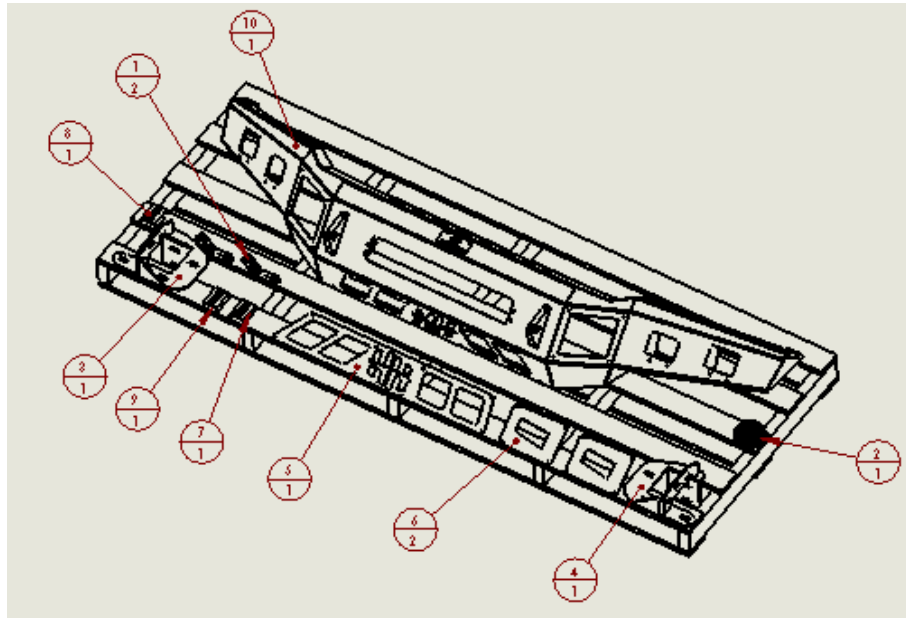
- **READ ALL SAFETY INSTRUCTIONS BEFORE INSTALLATION**
  - FOLLOW ALL INSTRUCTIONS FOR PROPER ASSEMBLY
  - WEAR APPROPRIATE EYE PROTECTION
  - EXERCISE CARE WHEN LIFTING COMPONENTS
  - USE APPROPRIATE TORQUE FOR BOLTS

SUGGESTED TORQUE VALUES FOR STEEL GRADE SAE 5 BOLTS

BOLT DIAMETER (INCH)	TREADS PER INCH	TORQUE (POUND-FEET)
1/4	20	7
5/16	18	14
3/8	16	25
7/16	14	40
1/2	13	60
9/16	12	88
5/8	11	120
3/4	10	200
7/8	9	302
1	8	466



## I. PARTS LIST



ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	2	601-56-2868	WELDNUT TAB 3
2	1	601-56-3744	3048MM LENGTH FOAM ROLL
3	1	601-56-5324	RIGHT FRAME MOUNT WELDMENT
4	1	601-56-5325	LEFT FRAME MOUNT WELDMENT
5	1	601-56-5341	MIDDLE ACCENT
6	2	601-56-5342	OUTSIDE ACCENT
7	1	60K-56-0052	HARDWARE KIT #52
8	1	60K-56-0058	HARDWARE KIT #58
9	1	60K-56-0202	HARDWARE KIT #202
10	1	60P-56-0948	600-56-0948 POLISHED

## I. TOOL LIST

1. Basic tool set
2. Blue masking tape
3. Trim tool
4. Paint marker
5. Heavy duty shears or 4" grinder with cutoff wheel
6. 8mm socket
7. 13mm socket
8. 15mm socket
9. 11mm socket
10. 21mm socket
11. ¾ inch socket
12. ½" extension 12" long

## II. REMOVAL OF BUMPER

1. Disconnect battery.
2. Using blue masking tape, mask along the profile of your truck above the bumper between fender wells. This will help protect your truck from accidental scratches.
3. Using 13mm socket, remove four bolts attaching front of skid plate to truck.



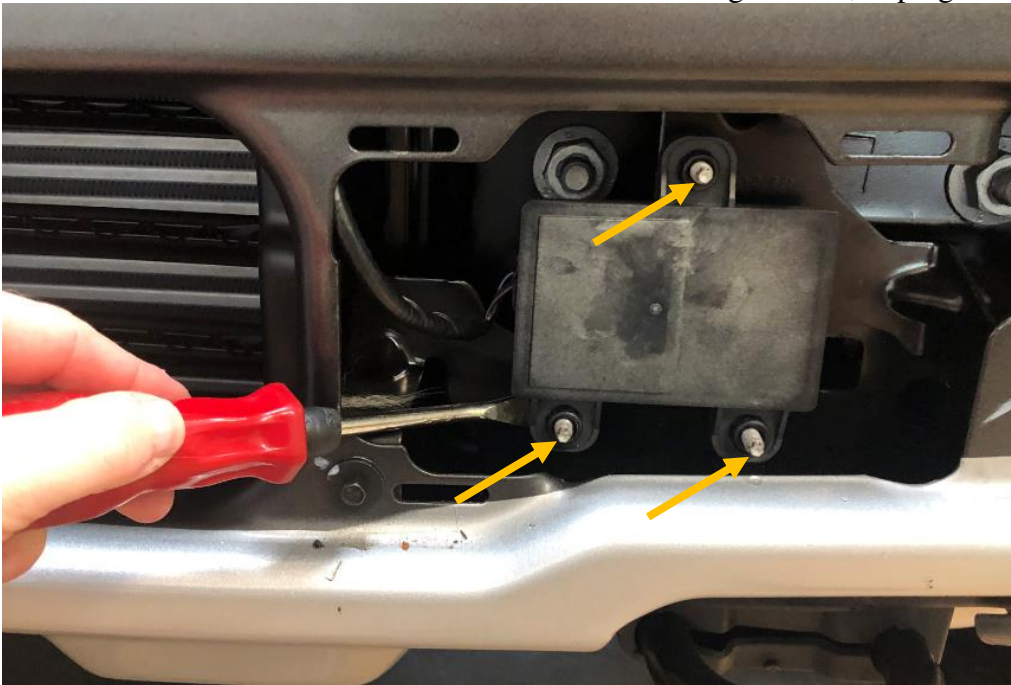
4. Using 15mm socket, remove two bolts attaching back of skidplate to truck. Note: Hold skidplate while removing bolts. It will be ready to remove after bolts are out. Set skidplate and black metal spacer aside. They will be reused.



5. Using trim tool, gently remove center plastic cover on bumper. Set cover aside.



6. Using an 11mm socket, remove three nuts attaching ACC unit to bumper. Use trim tool to gently pry out on ACC unit to remove it from the studs it is mounted on. After removing the unit, unplug it and set it aside.



7. Using 8mm socket, remove bolts attaching side bumper support to frame and bumper. Set bracket aside. (both sides)



8. Using 21mm socket, remove three nuts attaching bumper to frame. Two nuts are accessible from the front and one is accessible from behind the bumper. (both sides)



9. Carefully pull bumper out about 2" and use trim tool to remove three Christmas trees attaching plastic shroud to bumper. Remove bumper and set aside. NOTE: Have someone hold the bumper while you remove the Christmas trees.
10. Using 13mm socket, loosen bolt attaching skidplate bracket to frame. (both sides) Bracket will rotate down to allow access to rearmost tow hook bolt.



11. Use 15mm socket to remove front bolt attaching tow hook to frame. After removal, loosen rearmost bolt. Remove tow hook and set aside. Remove rearmost bolts and set aside. (both sides)





#### IV. TRUCK PREPARATION

1. In this step you will trim the rubber shroud that covers the intercooler. Feel the shroud near the base; there is an area about  $\frac{3}{4}$ " away from the base where the softer material meets the harder base material. This is where you will trim the shroud. Using a marker, draw a line  $\frac{3}{4}$ " from the base of the shroud. Using the tool of your choice, trim shroud. Heavy duty shears or a cutoff wheel on a grinder works well. Wear all required PPE when using tools.



#### V. INSTALLATION OF HAMMERHEAD BUMPER

1. Layout Hammerhead frame mounts as shown.



2. In this step you will use hardware kit #52, a  $\frac{3}{4}$ " socket, and a 15mm socket. Install frame mounts using six  $\frac{1}{2}$ "-13x1.5" carriage head bolts, six  $\frac{1}{2}$ " flat washers, six  $\frac{1}{2}$ " lock washers, and six  $\frac{1}{2}$ "-13 nuts. Install carriage head bolts with the threads pointing to the truck. Use OE tow hook hardware in bottom of Hammerhead frame mount. Install them with the bolts facing up and the nut strips in the frame. Do not fully tighten.



F-150 mounts shown. Your mounts will differ slightly.

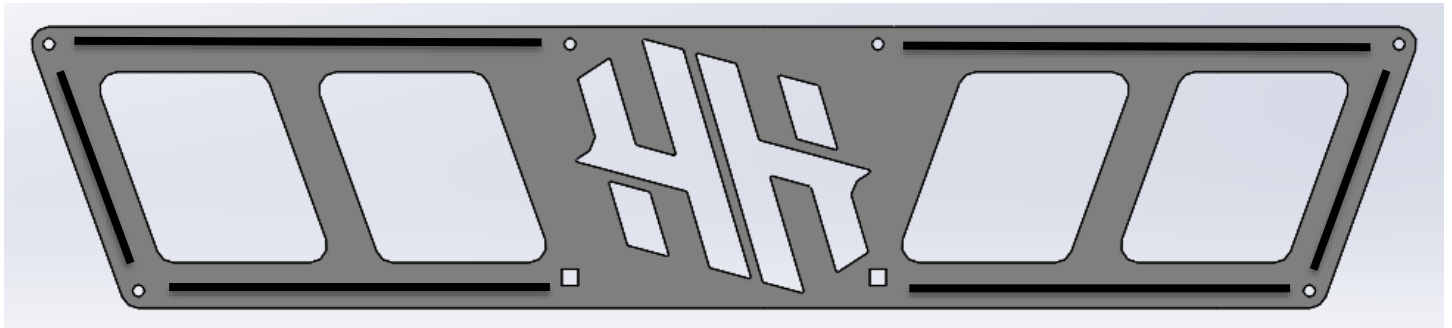
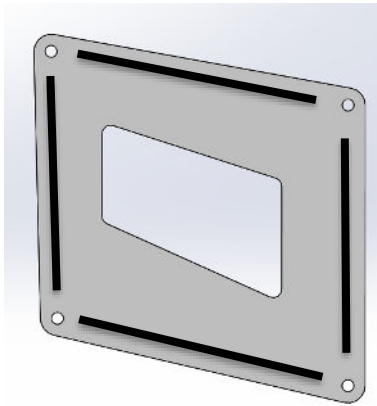
3. Layout hardware kit #58 and weldnut tab #3 as shown.



4. Using a hoist or a few friends, attach bumper to frame mounts using hardware kit #58 and weldnut tab #3. Start all bolts before aligning bumper. Align bumper a minimum of  $\frac{1}{4}$ " below headlights. When truck flexes off-road, this distance allows your bumper and body to have clearance. Tighten bolts with  $\frac{3}{4}$ " socket and extension. Tighten frame mount bolts at this time.



5. Accent plate installation. Apply foam in line with bolt holes in strips to eliminate vibration on the accent plates. See lines below for reference. Before you apply the foam, make sure you have it in the correct locations. It is very hard to remove.



6. Use hardware kit # 202 to install accent plates. Use T30 bit and 7/16" socket to tighten hardware.  
Congratulations! Your product installation is now complete.  
Thank you for your purchase.