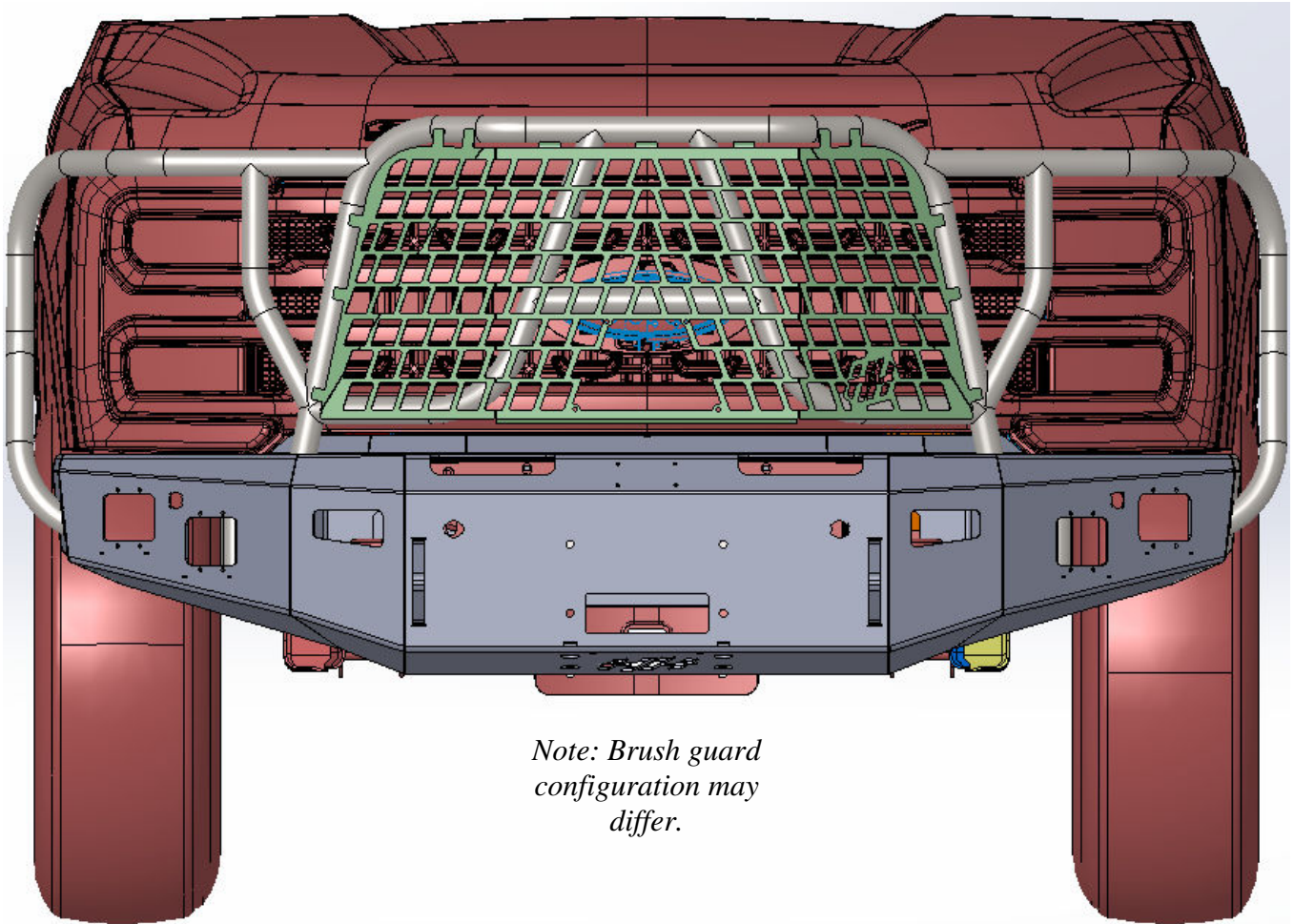




# 2023-20XX FORD F250-F550 X SERIES WINCH BUMPER INSTALLATION INSTRUCTIONS



*Note: Brush guard  
configuration may  
differ.*

# 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
- RE-TORQUE HARDWARE AT EVERY OIL CHANGE.

<b>Suggested Torque Values For Steel Grade 5 Standard Bolts</b>		
BOLT DIAMETER (INCH)	THREADS 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

<b>Suggested Torque Values For Steel Grade 8.8 Metric Bolts</b>		
BOLT DIAMETER (mm)	THREAD PITCH (mm)	TORQUE (POUND- FEET)
6	1.0	7
8	1.25	16
10	1.5	32
12	1.75	55
14	2.0	88
16	2.0	140
18	2.5	195
20	2.5	275
22	2.5	375
24	3.0	475


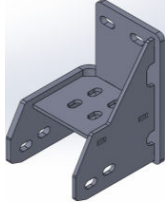
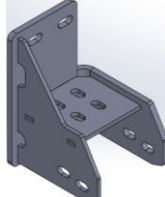
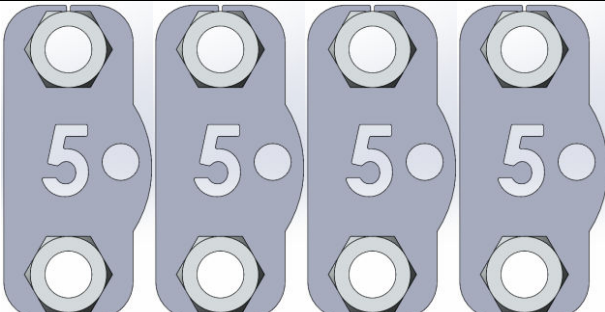
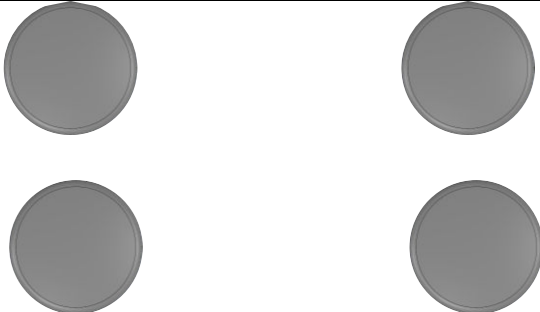


**WARNING: Cancer  
and Reproductive Harm**

[www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov)

**I. PARTS LIST**

*Note: Brush guard configuration may differ.*

<b>Item 1</b>	<b>X SERIES WINCH BUMPER</b>	<b>QTY. 1</b>	<b>ITEM 2</b>	<b>RIGHT FRAME MOUNT WELDMENT</b>	<b>QTY. 1</b>		
							
<b>ITEM 3</b>	<b>LEFT FRAME MOUNT WELDMENT</b>	<b>QTY. 1</b>	<b>ITEM 4</b>	<b>HARDWARE KITS</b>			
			<ul style="list-style-type: none"> <li>✓ <b>HARDWARE KIT #97</b> (60K-56-0097)</li> <li>✓ <b>(2) HARDWARE KIT #98</b> (60K-56-0098)</li> <li>✓ <b>(2) HARDWARE KIT #219</b> (60K-56-0219)</li> <li>✓ <b>LICENSE PLATE MOUNT KIT</b></li> </ul>				
<b>ITEM 5</b>	<b>WELDNUT TAB 5</b>		<b>QTY. 4</b>	<b>ITEM 6</b>	<b>SENSOR CUTOUT PLUGS</b>		<b>QTY. 4</b>
							

**REMOVE CONTENTS FROM BOX AND VERIFY ALL PARTS ARE PRESENT.**

**If there are any questions, call 1-855 HHTOUGH or email HHORDERS@hammerheadarmor.com**

**II. TOOL LIST**

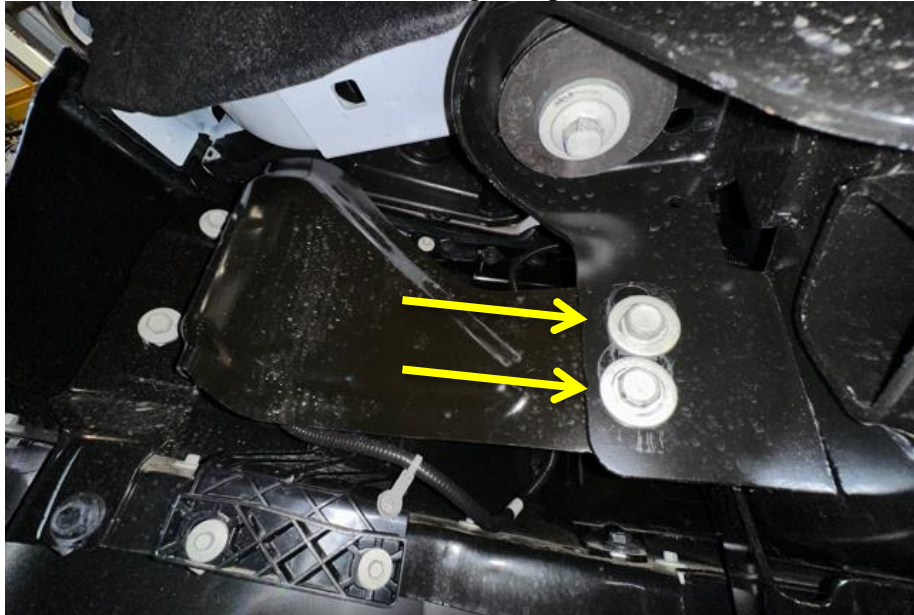
- ✓ A good friend
- ✓ Basic tool set
- ✓ Blue masking tape
- ✓ 13mm socket
- ✓ 15mm socket
- ✓ 21mm socket
- ✓ 3/4" socket
- ✓ Trim tool
- ✓ Ratchet extension

### III. VEHICLE PREPARATION

1. Park vehicle on level surface.
2. Engage parking brake and disconnect battery.
3. Using blue masking tape, mask along the profile of your truck above the bumper. This will help protect your truck from any accidental scratches.

### IV. REMOVAL OF OE BUMPER

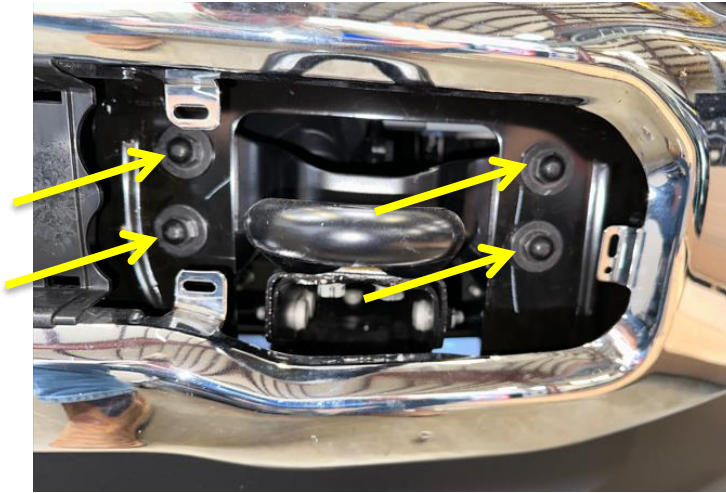
1. Unplug the fog lights, engine block heater, and adaptive cruise control (if applicable).
2. Using 15mm socket, remove two bolts attaching bumper side brace to frame. (both sides)



3. Using a trim tool or flathead screwdriver, remove trim piece from around tow hooks.



- Using an 18mm socket, remove eight bolts attaching the bumper to the frame. Remove bumper and set aside. It will not be reused.



- Using an 18mm socket, remove four bolts attaching tow hook to frame. Set aside; it will not be reused. (both sides)



- Using 18mm socket, remove two nuts attaching underrun bracket to frame. Set aside; it will not be reused. (both sides) Bolt strips and nuts will be reused.



7. **FOR TRUCKS EQUIPPED WITH FRONT SENSORS:** Lay OE bumper face down on a carpeted surface or a piece of cardboard. Carefully remove sensors, sensor retainers, and wiring harness from OE bumper. Be sure to keep sensors and sensor retainers in same order as OE bumper. It is recommended to immediately place sensors and sensor retainers in HammerHead bumper as they are removed from OE bumper.

#### V. INSTALLATION OF HAMMERHEAD BUMPER

1. Lay bumper face down on a carpeted surface or a piece of cardboard. Install all lights in bumper with brackets and hardware provided by light manufacturer. Install winch into bumper at this time using hardware supplied by winch manufacturer.
2. Layout frame mounts and hardware from kit #98.



3. Install frame mounts on frame with hardware from kit #98. Insert bolts from the top. Use bolt strips removed in step 6 to attach HH mount on both sides of frame. Do not fully tighten.

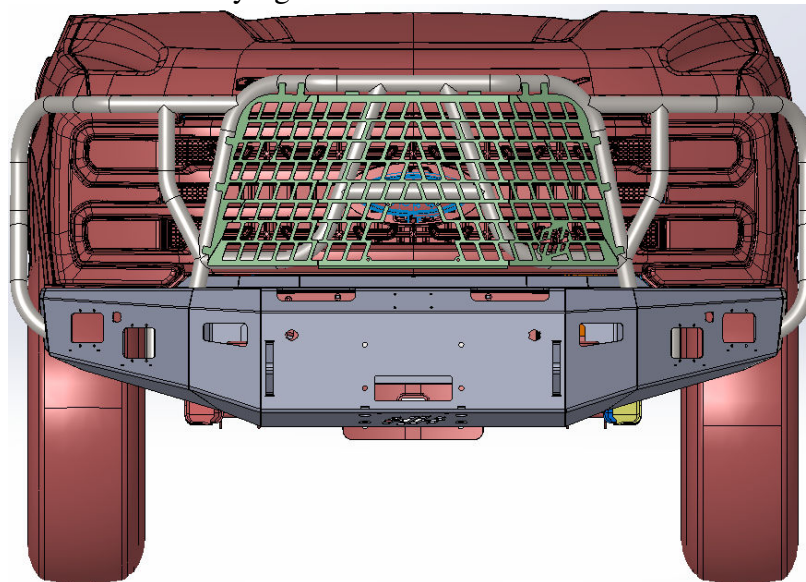


4. Layout weldnut tab 5 and hardware from kit #97 as shown below.



5. Using a hoist or a few friends, attach bumper to frame mounts using hardware kit #53 and weld nut tabs as shown below. Start all bolts before aligning bumper. Align bumper a minimum of  $\frac{1}{4}$ " below plastic fascia. When truck flexes off-road, this distance allows your bumper and body to have clearance. Fully tighten bolts with  $\frac{3}{4}$ " socket. Fully tighten frame mount bolts as well at this time.

*Note: Brush guard configuration may differ.*



**Congratulations! Your product installation is now complete.  
Thank you for your purchase!**