



REAR BUMPER INSTALLATION INSTRUCTIONS **Ford Transit**

Please read before beginning

- *Stainless steel hardware may bind together when tightening—It is recommended that you apply an anti-seize assembly lubricant to the threads of each bolt before assembly*
- *This installation requires three people*
- *Unless otherwise specified, refer to the general torque value at the end of the instructions for specified torque values*



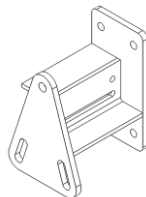
Required tools

- Standard and metric wrench set
- Allen wrench set
- Torx Driver Set
- Flat-head screwdriver (used to remove stock plastic fasteners)
- Loctite

Included Hardware/Parts

Quantity

- | | |
|---|---|
| • 70090 – 7/16-14 x 4 1/2" Hex Head Bolt, Grade 8 | 4 |
| • 70056 – 7/16-14 Nylock Nuts, Grade 8 | 4 |
| • 70057 – 7/16" Flat Washers, Zinc Plated | 8 |
| • 70257 – M10-1.5 Left Hand Nuts | 2 |
| • Antiseize Packet, 2g | 1 |



x1
Tire Plate Assembly

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Installation Instructions

1. Remove the rear plastic bumper cover by removing the torx head screws bolting it to the vehicle, there should be 6 of these (**Figure 1**).
2. Next, remove the plastic popper fasteners bolting the middle plastic bumper cover to the two corner plastic pieces. You can use a flat head screwdriver to help pry them loose.

Note: you will only need to remove the *middle* plastic bumper cover. The corner plastic pieces must remain on the vehicle.



Figure 1. Removal of torx head fasteners on plastic bumper cover.

3. Remove the stock rear bumper by first removing the 8 hex flange head bolts going up underneath the vehicle (**Figure 2**). There are 4 on each side. Keep all 8 of these bolts, you will reuse them for installation of your Aluminess bumper.

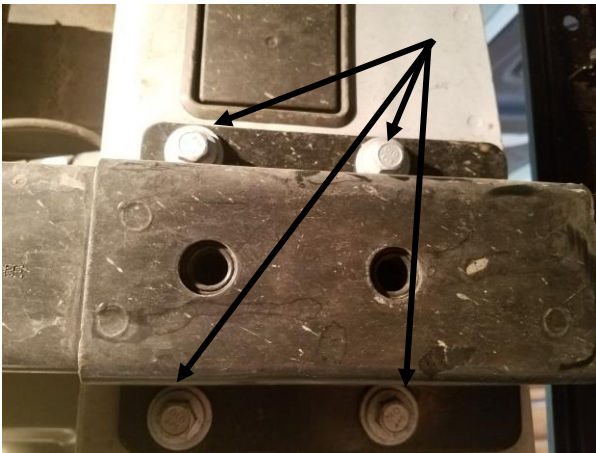


Figure 2. Removal of 8 bolts to the frame (only one side shown).

4. Next remove the 4 cross bolts (2 on each side) going through the blades and the vehicle frame (**Figure 3**). These are the last fasteners holding the bumper in place, so be careful when sliding the cross bolts out of the frame so as not to let the bumper fall on top of you.



Note: You may have a backup beeper speaker held in place by these bolts. You can discard the bolts, but hold onto the speaker as you will hold it in place using the replacement bolts provided in this hardware kit.



Figure 4. Picture of your vehicle after stock bumper removal.

Notes for Aluminess bumper installation:

5. Before installing your Aluminess bumper, liberally apply tape to the corner stock plastic pieces on the rear of the vehicle. This will prevent the Aluminess bumper from scraping the plastic upon installation (see **Figure 5**).
6. It is also good practice to fix the swing arms in their locked-open position – this will help avoid interference and possibly scratching your vehicle body.
7. Be sure to install the Aluminess bumper with your rear van doors closed shut. If your van doors are locked all the way open, it will be impossible to close them after you've installed your bumper.

Bumper Installation

8. With the help of two other people, lift the bumper into place to install on the vehicle. The



mounting structure of your Aluminess bumper shares the same bolt locations from which you removed your stock bumper.

9. Bolt the 7/16" hardware cross-bolting through the frame tightening to 63 ft-lb torque, and reattaching your backup speaker if needed.
10. Use the 8 factory flange-head bolts to bolt up through the bottom of the frame, tightening these bolts to 81 ft-lb torque.
11. Tighten down all mounting bolts.



Figure 3. Tape applied to plastic corner pieces to prevent scratching. The swing arm has been removed and door is open to clearly show the location of the tape, although **THIS IS NOT THE CONFIGURATION IN WHICH YOU SHOULD INSTALL YOUR ALUMINESS BUMPER.**

12. The bumper is now installed—check the mounting hardware after 100 miles of driving to ensure that nothing has come loose due to vibration.



Figure 5. Rest tire on both support arms (before tightening the lugs or U-bolts down). If your tire is "floating" above these support arms, you may damage your swing arm while driving.



General Torque Values			
Size	Stainless Steel	Zinc	Grade 8
#6-32	10 lb-ft	--	--
#8-32	18.4 lb-ft	--	--
#10-32	26.6 lb-ft	--	--
1/4"-20	5.3 lb-ft	7.8 lb-ft	9 lb-ft
5/16"-18	10.9 lb-ft	16 lb-ft	18 lb-ft
3/8"-16	19.4 lb-ft	28.3 lb-ft	33 lb-ft
7/16"-14	31 lb-ft	45 lb-ft	52 lb-ft
1/2"-13	47 lb-ft	69 lb-ft	80 lb-ft
M6	4.7 lb-ft	5.8 lb-ft	--
M8	11.3 lb-ft	14.1 lb-ft	--
M10	22.3 lb-ft	27.9 lb-ft	--
M12	38.9 lb-ft	48.7 lb-ft	--



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