



INSTALLATION INSTRUCTIONS

ELITE REAR BUMPER KIT

Part Number: 111117

Application: 2021 Ford Bronco

GENERAL SAFETY PRECAUTIONS

Your safety, and the safety of others, is very important. To help you make informed decisions about safety, we have provided installation and operating instructions and other information on labels and in this guide. This information alerts you to potential hazards that could hurt you or others. It is not possible to warn you about all potential hazards associated with this product, you must use your own good judgment.

CARELESS INSTALLATION AND OPERATION CAN RESULT IN SERIOUS INJURY OR EQUIPMENT DAMAGE. READ AND UNDERSTAND ALL SAFETY PRECAUTIONS AND OPERATING INSTRUCTIONS BEFORE INSTALLING AND OPERATING THIS PRODUCT.

This guide identifies potential hazards and has important safety messages that help you and others avoid personal injury or death. WARNING and CAUTION are signal words that identify the level of hazard. These signal words mean:

▲ **WARNING** signals a hazard that could cause serious injury or death, if you do not follow recommendations. ▲ **CAUTION** signals a hazard that may cause minor to moderate injury, if you do not follow recommendations.

This guide uses **NOTICE** to call attention to important mechanical information, and Note: to emphasize general information worthy of special attention.

▲ WARNING

IMPACT AND MOVING PARTS ENTANGLEMENT HAZARD

Failure to observe these instructions could lead to severe injury or death

- **Always** Know Your Winch. Take time to fully read the Instructions and/or Operations Guide, and/or Basic Guide to Winching Techniques, in order to understand your winch and its operations.
- **Never** work under vehicle before properly securing vehicle.
- **Always** use appropriate and adequate care in lifting components into place.
- **Never** use a jack to support the vehicle.
- **Always** use jack stands in pairs to support the vehicle.
- **Always** use jacks or jack stands only on a hard, stable, and level surface.
- **Never** exceed the rated capacity of a jack or jack stands.
- **Always** verify that the parking brake is set, the transmission is in park (automatic) or reverse (manual) and the rear wheels are blocked before working on vehicle.
- **Never** work under vehicle before properly securing vehicle.
- **Always** use appropriate and adequate care in lifting components into place.
- **Always** insure components will remain secure during installation and operation.
- **Always** tighten all nuts and bolts securely, per the installation and operation.
- **Always** perform regular inspections and maintenance on the winch, winch mount and related hardware.
- **Always** replace all worn or damaged parts before operating.
- **Never** operate this WARN product with damaged or missing parts.
- **Always** use extreme caution when drilling on any vehicle. Make sure that all fuel lines, brake lines, electrical wires, and other objects are not punctured or damaged when / if drilling on the vehicle. Thoroughly inspect the area to be drilled (on both sides of material) prior to drilling, and relocate any objects that may be damaged. Failure to inspect the area to be drilled may result in vehicle damage, electrical shock, fire or personal injury.
- **Always** use extreme caution when cutting and trimming during fitting.
- **Always** wear safety glasses when installing this kit. A drilling operation will cause flying metal chips. Flying chips can cause eye injury.
- **Always** remove jewelry and wear eye protection.
- **Never** lean over battery while making connections.
- **Never** route electrical cables across any sharp edge, through or near moving parts, near parts that become hot.

Read installation and operating instructions thoroughly.

WARN INDUSTRIES, INC. 12900 S.E. Capps Road,
Clackamas, OR USA 97015-8903, 1-503-722-1200, FAX: 1-503-722-3000
Customer Service: 1-800-543-9276
Dealer Locator Service: 1-800-910-1122
International Sales/Customer Service: 1-503-722-3008
International Fax: 1-503-722-3005

⚠ CAUTION

MOVING PARTS ENTANGLEMENT HAZARD

Failure to observe these instructions could lead to minor or moderate injury

- Part edges may be sharp!
- Always use proper posture / lifting technique or get lifting assistance while handling and installing product.

Read installation and operating instructions thoroughly.

NOTICE

EQUIPMENT DAMAGE

- **Never** tow vehicle by attaching a tow bar to the eyelets on the bumper.
- Do not attach tow bars directly to the bumper. Damage to bumper may occur. WARN bumpers are not designed to be used for flat towing. Consult with the manufacturer of your tow bar system for the proper vehicle tow bar brackets.

Read installation and operating instructions thoroughly.

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BEFORE YOU BEGIN



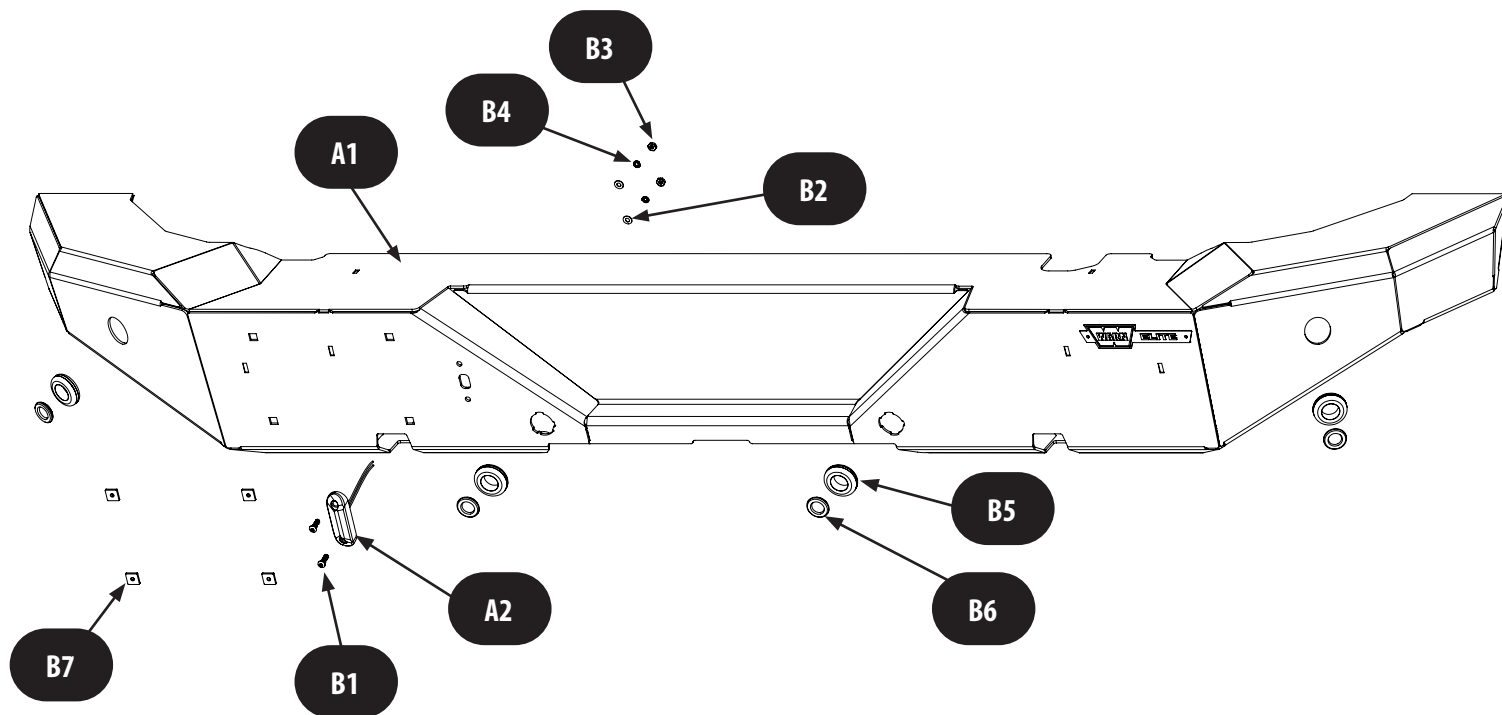
This product may interfere with driver assist systems such as adaptive cruise control and parking assist systems that have sensors or cameras installed in the bumpers or front grill area. If your vehicle is equipped with any of these systems or features, consult your vehicle owner's manual before installing this product. These systems may need to be disabled as a result of installing this product.

TOOLS REQUIRED

- standard wrenches and sockets
- metric wrenches and sockets
- ratchet
- wire cutter

PARTS LIST

ITEM	QTY	NAME	PN	ITEM	QTY	NAME
A1	1	ELITE REAR BUMPER	23299-W	B1	2	10-24 X 3/4" BUTTON SOCKET CAP
A2	1	LICENSE PLATE TAG LIGHT	61791	B2	2	10-24 NUT
A3	2	EXPOXY (NOT PICTURED)	61632	B3	2	#20 LOCK WASHER
				B4	2	#10 FLAT WASHER
				B5	4	PLASTIC GROMMET
				B6	4	PLASTIC PLUG
				B7	4	LICENSE PLATE NUT



TORQUE SPECIFICATIONS

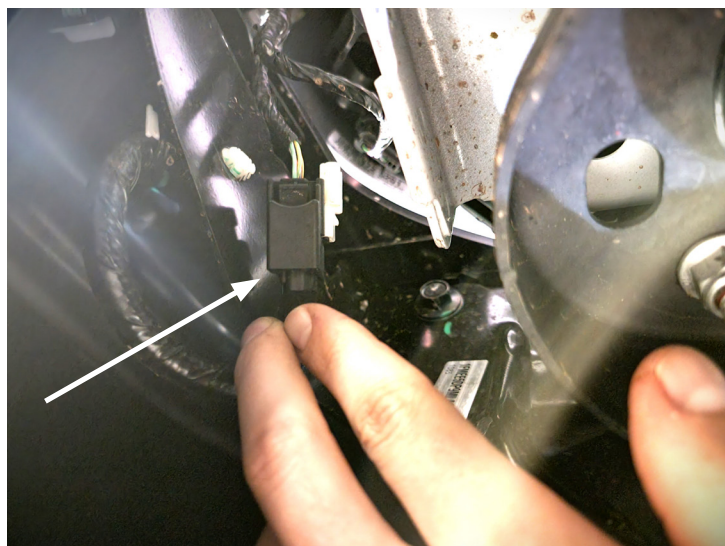
Please use the recommended torque specifications when assembling this product unless otherwise specified in the instructions.

FASTENER SIZE	FASTENER TORQUE		FASTENER SIZE	FASTENER TORQUE	
	lb-ft	(N.m)		lb-ft	(N.m)
1/4"	8	(11)	M4	(2)	3
5/16"	17	(23)	M5	(4.5)	6
3/8"	30	(40)	M6	(7.5)	10
7/16"	48	(66)	M8	(18)	25
1/2"	74	(100)	M10	(37)	50
9/16"	106	(144)			
5/8"	148	(200)			
3/4"	269	(364)			

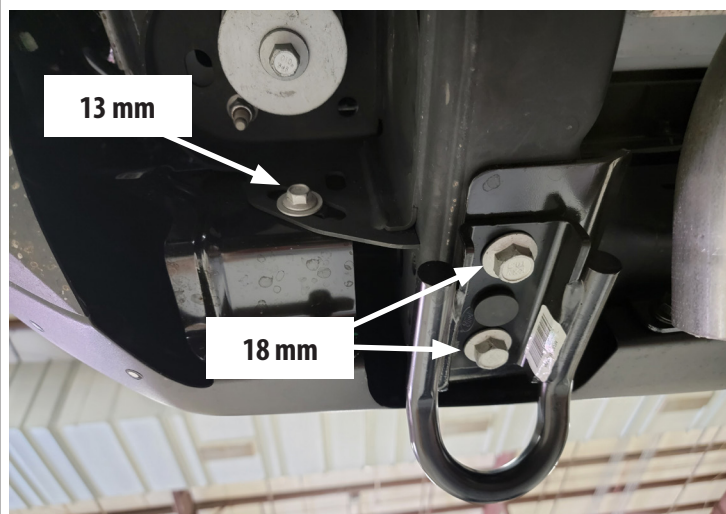
INSTALLATION INSTRUCTIONS

OEM Bumper Removal

1. Unplug the wiring harness connector located on the driver side of the vehicle between the frame and the bumper.
2. If equipped with rear parking sensors, unplug the wiring harness connector located on the passenger side of the vehicle between the frame and bumper.



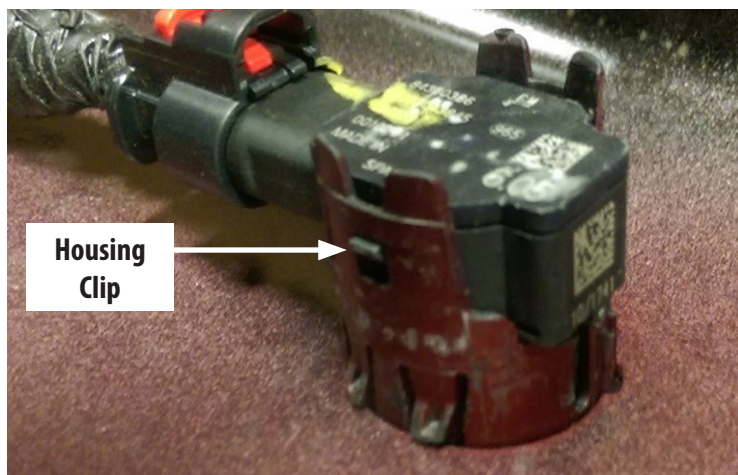
3. Using an 18-mm socket or wrench, remove the two bolts on that are on the passenger side that hold the bumper to the bottom of the frame.
4. Using a 13-mm socket or wrench, remove the bolt that holds the bumper to the frame rail pad.



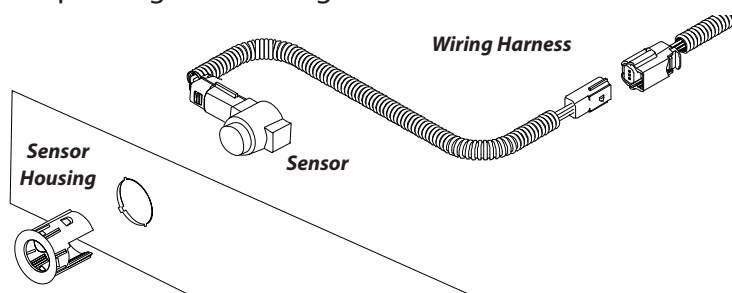
5. With assistance, hold the rear bumper and repeat these steps on the opposite side to free the bumper from the vehicle frame.
6. Place the hardware and tow hooks safely aside as they will be reused later.

Parking Sensor Removal

1. If your vehicle is equipped with rear sensors, carefully remove the sensors from their housings by gently pulling the housing clips away and pulling the sensor out. **NOTICE** Be sure to mark the location and orientation of each sensor plug. *TIP: Numbering each sensor with tape and marking the top with a paint pen works well OR name (Driver side outer, Driver side inner, Passenger side outer, Passenger side inner).*



2. Remove the wiring harness from the bumper by prying all the plastic push pins free.
3. Remove the housing from the OEM bumper by compressing the clips on the inside and pushing the housing free.



Parking Sensor Install

1. From the front of the bumper, carefully install each sensor housings into the WARN® Elite rear bumper. Use the provided epoxy to hold them in place.

INSTALLATION INSTRUCTIONS

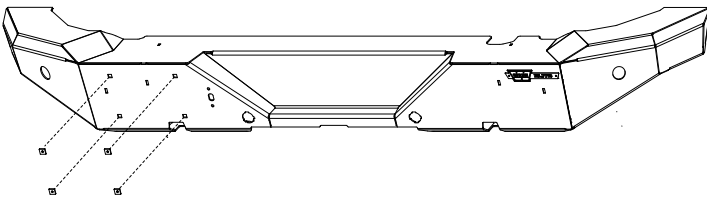


2. Install the parking sensors into their respective housings by carefully pushing them in until the clip engages. **NOTE: Be sure sensors match the orientation of the stock bumper.**

NOTE: If vehicle does not come equipped with parking sensors, install the provided rubber grommets (B5) and plugs (B6) into the sensor cutouts.



3. Insert the four plastic license plate nuts (B7) into the four square cutouts of the Warn Elite Rear Bumper.



License Plate Light Install

1. Find the license plate plug on the OEM wiring harness, and carefully cut the loom or electrical tape free to expose the two wires that lead to the plug.



2. Carefully cut the two wires, make sure to give yourself enough length to later splice them into the supplied LED license plate light (A2).

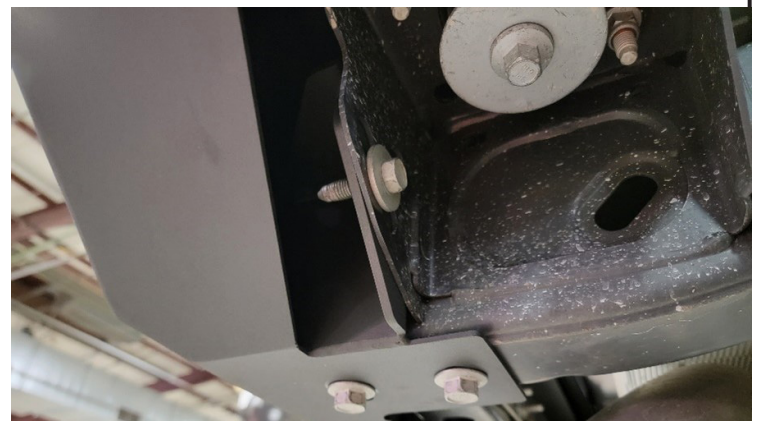
NOTE: It is recommended to use two heat shrink butt connectors (not included in the kit) when attaching the wires together.

3. Feed wires through the license plate light hole and complete connection to the light.
4. Install the license plate light into the Warn Elite Rear Bumper using the provided #10 hardware (B1, B2, B3, and B4).

Warn Elite Bumper Install

CAUTION Always use proper posture / lifting technique or get lifting assistance while handling and installing product.

1. With assistance, hold the bumper up to the frame and use the OEM hardware removed in the OEM removal steps, along with the tow hooks *if equipped*, to install the bumper to the frame. Do not completely tighten.



INSTALLATION INSTRUCTIONS

2. Align the bumper and then fully tighten all mounting hardware to recommended torque.
3. Plug the wiring harness connectors on both sides of the vehicle.

Your installation is complete.

MAINTENANCE / CARE

1. Inspect all parts on the winch, winch mount, and related hardware prior to each use. Replace all hardware that appears rusted or deformed.
2. Inspect all nuts and bolts on the winch, winch mount,, and related hardware prior to each use. Tighten all nuts that appear to be loose. Stripped, fractured, or bent bolts or nuts need to be replaced.
3. Check all cables prior to use. Replace cables that look worn or frayed.
4. Check all moving or rotating parts. Remove debris that may inhibit the part from moving freely.

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