



INSTALLATION INSTRUCTIONS

FULLY HIDDEN KIT

Part Number: 113590

Application: 2015-2020 Ford F-150

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.
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- **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.

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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.

This kit will fit:

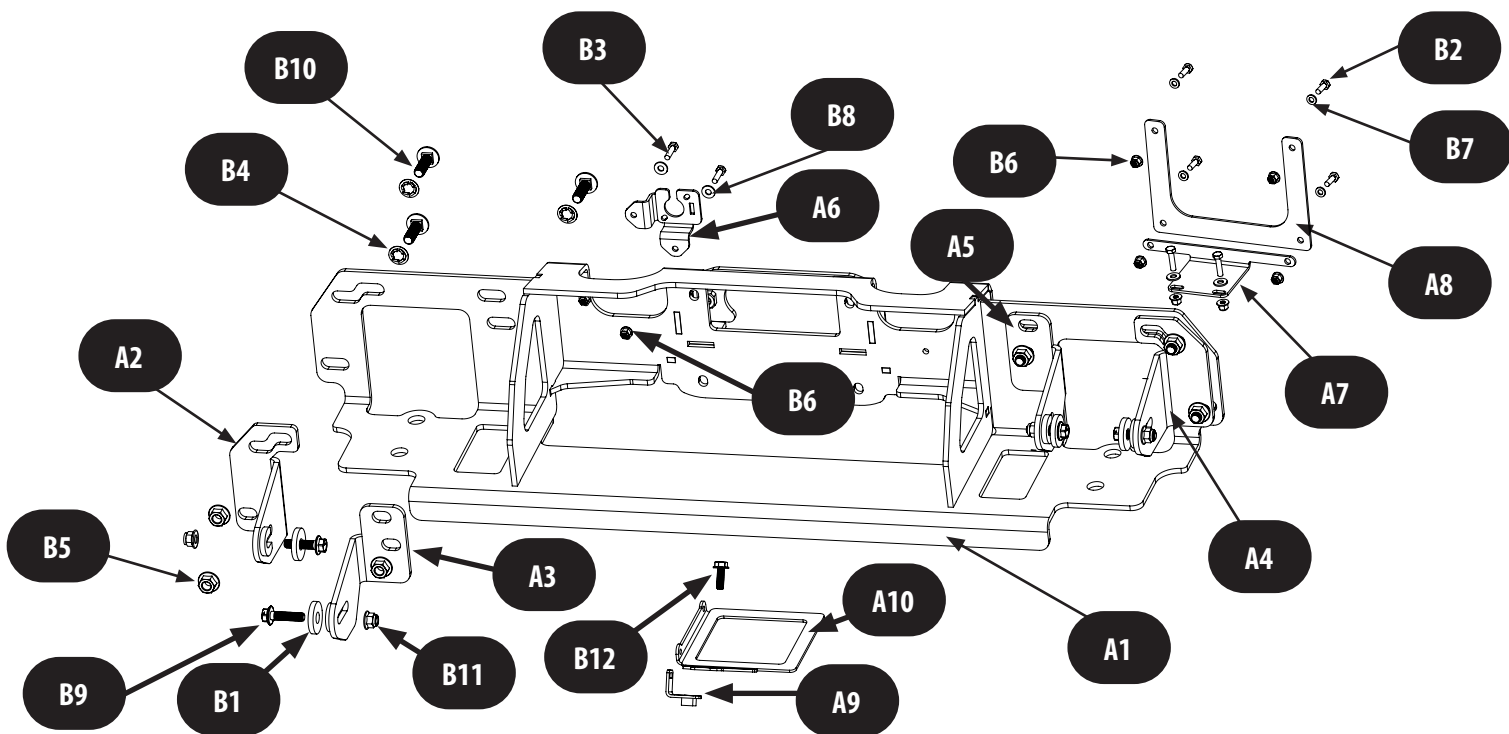
- 5.0L V8 models
- EcoBoost and Raptor R models (*these vehicles require an aftermarket high mount front intercooler kit and the Warn Zeon XC control pack relocation kit*)

TOOLS REQUIRED

- Standard wrenches and sockets
- Metric wrenches and sockets
- Ratchet

PARTS LIST

ITEM	QTY	NAME	PN	ITEM	QTY	NAME	PN
A1	1	FULLY HIDDEN MOUNT	113591	B1	4	SPACER	3693
A2	1	FRAME BRACKET LH OUTER	112599	B2	4	M6-1.0 X 18MM SCREW (SILVER)	25114
A3	1	FRAME BRACKET LH INNER	112602	B3	4	M6-1.0 X 25MM SCREW (BLACK)	25338
A4	1	FRAME BRACKET RH OUTER	112604	B4	6	INTERNAL TEETH LOCK WASHER	78160
A5	1	FRAME BRACKET RH INNER	112606	B5	6	M12-1.75 FLANGE LOCK NUT	79465
A6	1	WINCH REMOTE BRACKET	112608	B6	8	M6-1.0 FLANGE LOCK NUT	83125
A7	1	LICENSE PLATE BRACKET	112609	B7	4	M6 FLAT WASHER (SILVER)	83349
A8	1	LICENSE PLATE MOUNTING PLATE	112610	B8	4	M6 FLAT WASHER (BLACK)	86558
A9	1	WELD NUT L BRACKET	113606	B9	4	M10-1.50 X 40MM FLANGE BOLT	87233
A10	1	CNTRL PACK RELOCATION BRCKT	113605	B10	6	M12-1.75 X 40MM CARRIAGE BOLT	107751
				B11	4	M10-1.50 FLANGE NUT	109769
				B12	1	M8-1.25 X 25MM FLANGE BOLT	82348



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)			

THIS SECTION IS FOR 2015-2020 VEHICLES (Flip over for 2021-2023)

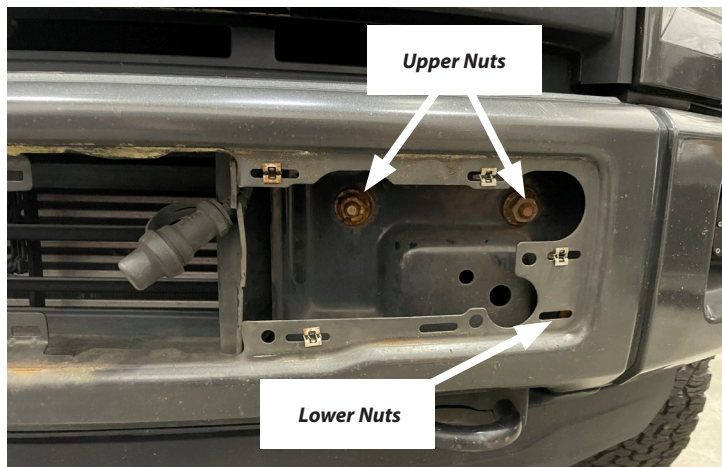


EcoBoost and Raptor R models require an aftermarket high mount front intercooler kit and the Warn Zeon XC control pack relocation kit.

- Disconnect the power and ground cables from the vehicle battery.

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

- Remove the front trim piece.
- Remove the two upper nuts (each side)
- From behind the bumper, remove the lower nut (each side).
- With assistance, slowly pull the bumper forward while un-clipping any wiring and unplugging any electrical connectors.



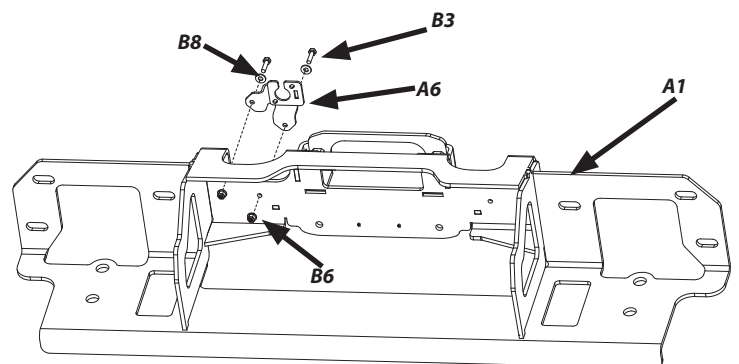
- With the bumper free, carefully remove it from the vehicle and place aside on a flat and stable surface.
- Pull the rubber tow hook covers free from tow hook (each side).



- From inside the frame rail, remove the two tow hook bolts. Remove the tow hook (each side). *Save all items as they will be reused later.*



- Install the remote bracket (A6) to the front of the fully hidden mount (A1) using two M6 x 25mm screws (B3), washers (B8) and M6 lock nuts (B6).



- Following your Warn Short Drum Zeon XC installation instructions, install the synthetic rope.

INSTALLATION INSTRUCTIONS

- **EcoBoost Vehicles Only:** Mount the control pack to the relocation bracket (A10) using the hardware and instructions provided in the Warn Control Pack Relocation Kit.
- Per your winch installation instructions, install the winch to the winch carrier.

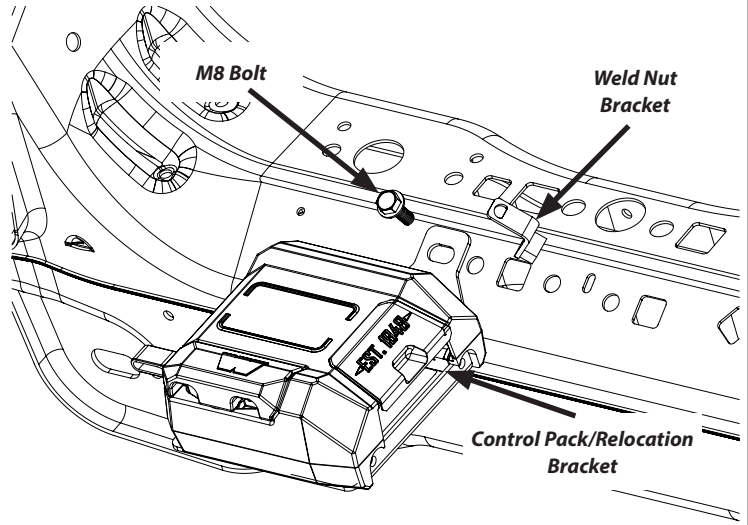


- Install the remote harness jumper to the remote bracket using the M5 screws, included in your winch kit.



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

- **EcoBoost Vehicles Only:** With assistance, bring the winch mount towards the vehicle, and install the control pack bracket onto the frame's cross member using the 25mm long M8 flange bolt (B12), and the weld nut L-bracket (A9), included in this kit.



- Continuing with assistance, bring the winch mount up against the front frame bumper mounts and align. Route and tidy wires accordingly away from all hot, sharp, moving, and rotating parts.



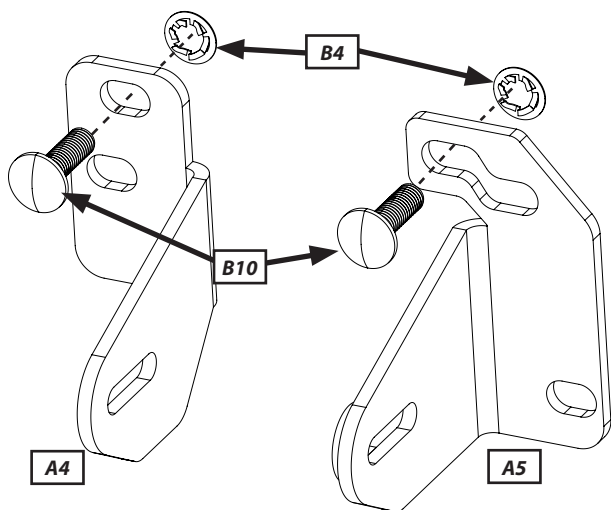
- Loosely reinstall the tow hooks using the OE hardware on each side of the vehicle.



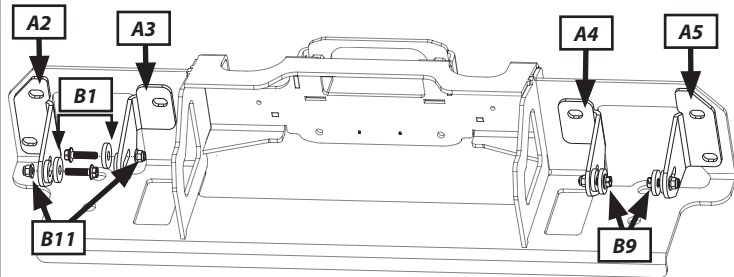
- Route the winch power cables towards the battery. A direct battery connection of the power (red) and ground (black) cable is required. **⚠ WARNING Do not connect ground to vehicle chassis.**
- Follow the instructions supplied with your Warn winch to complete wiring your winch.
- Plug in your remote harness to your winch. Route and tidy the remote harness cable.

INSTALLATION INSTRUCTIONS

- Install one carriage bolt (B10) through the designated hole cutout (*as shown below*) of the inner (A3 & A5) and outer (A2 & A4) frame brackets and secure each bolt with one internal tooth lock washer (B4).



- Install the inner and outer brackets behind the coordinating frame bumper mount (left to left; right to right) using two M10 bolts (B9), spacers (B1) and nuts (B11). *Do not tighten completely to allow for adjustment.*



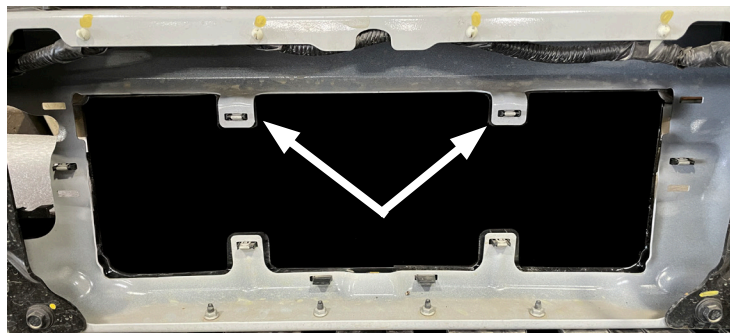
- Align and center the mounting holes on the frame brackets, frame bumper mount and winch mount, and fully tighten the frame bracket hardware.



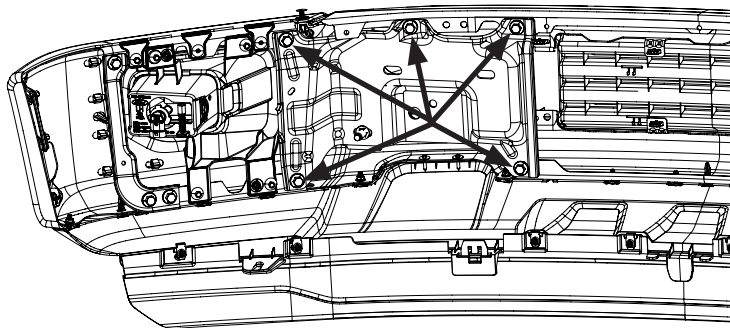
- Locate the center plastic trim removed in the beginning steps, and using a cutting tool, cut out the center cover. **OPTIONAL:** *Bend or cut the upper metal tabs to allow for a better fit of the fairlead later on.*



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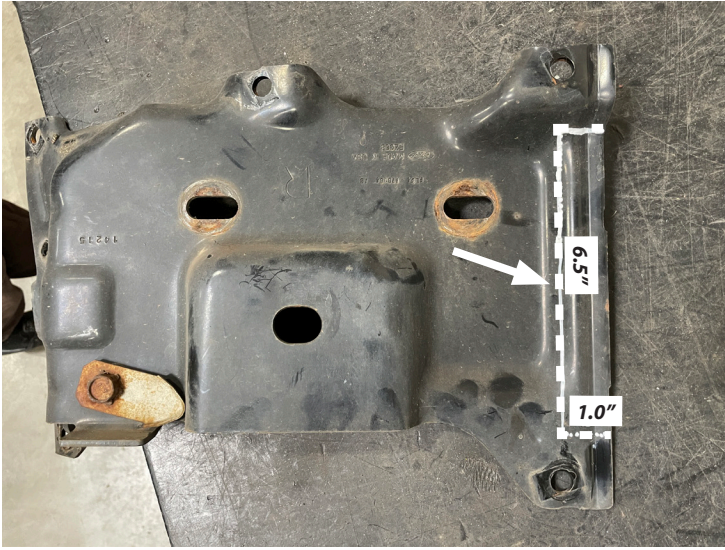


- From inside the OEM bumper, remove the five bolts to free the bumper mount bracket (each side).

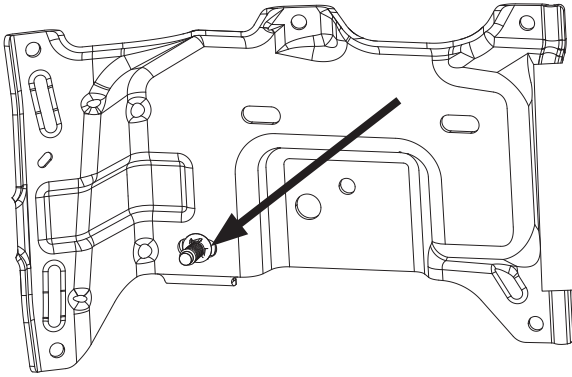


- On each bumper mount bracket, measure 6.50" downward and 1.0" inward from the edge. With a paint pen, mark a cutting line and carefully cut along that line.
- Use a sanding tool to deburr and clean the bracket's cut edge. Use touch up paint to prevent rust from the exposed metal.

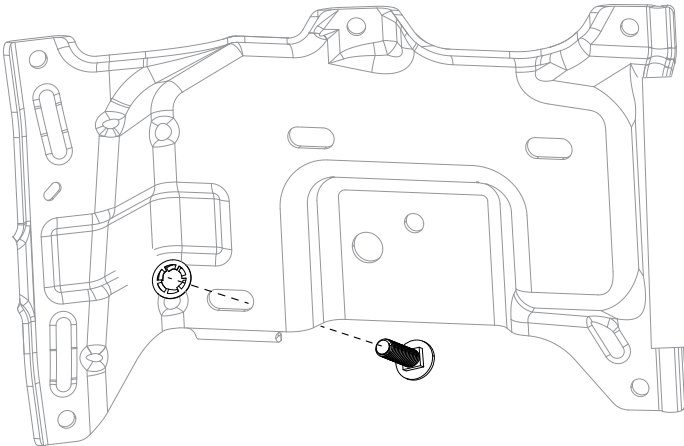
INSTALLATION INSTRUCTIONS



- Flip each bumper mount over. Using a cutting tool, carefully cut the OEM internal tooth lock washer and remove the bolt.



- Locate two carriage bolts (B10) and internal lock washers (B4). Insert one carriage bolt into the bracket (in the same location as the OEM bolt you just removed). Secure with a tooth lock washer.



- Install the OEM bracket back onto the bumper.
- Re-install the brackets with the new longer carriage bolts back onto the bumper.

- Re-install the fog light brackets back onto the bumper.
- On the passenger side of the bumper, install the license plate bracket (A7) into the two holes just above the tow hook opening, using two of the longer black M6 screws (B3), washers (B8), and flange nuts (B6).



- Re-install the rubber tow hook covers on each side of the vehicle.



- With assistance, carefully bring the bumper towards the front of the vehicle, and clip and plug in any wiring and electrical connectors.
- Place the bumper on the vehicle, ensuring the mounting studs pass through the winch mount, frame, and the frame brackets.
- Align and center the bumper and fully install and tighten the six nuts (B5) on the bumper studs.



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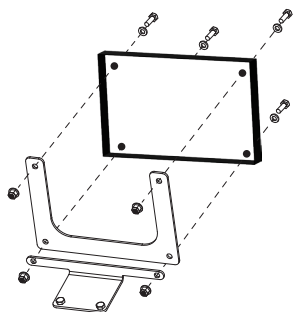
- Locate the fairlead and two 7/16" bolts included with your winch kit.
- Thread the winch rope through the fairlead and then install the fairlead to the front of the mount with the 7/16" bolts.
- Install the hook and strap provided in your winch kit.
- Locate and install the rubber remote plug dust boot, included in your winch kit.



- Re-install the front plastic trim piece.



- Locate your license plate, the license plate mounting plate (A8) and four M6 bolts (B2), washers (B7) and nuts (B6).
- Install the license plate's to the license plate mounting plate and bracket using the M6 hardware.



- Verify all hardware is tighten and wiring is connected.

- Reinstall battery connections.

⚠ WARNING Always connect red (+) power cable **ONLY** to the positive (+) terminal of the battery.

⚠ WARNING Always connect black ground (-) power cable **ONLY** to the negative (-) terminal of the battery.

- First, attach the winch power (red) cable to the positive (+) battery terminal. Second, attach the winch (black) cable to the negative (-) battery terminal. Tighten securely.



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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MOVING PARTS ENTANGLEMENT HAZARD

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

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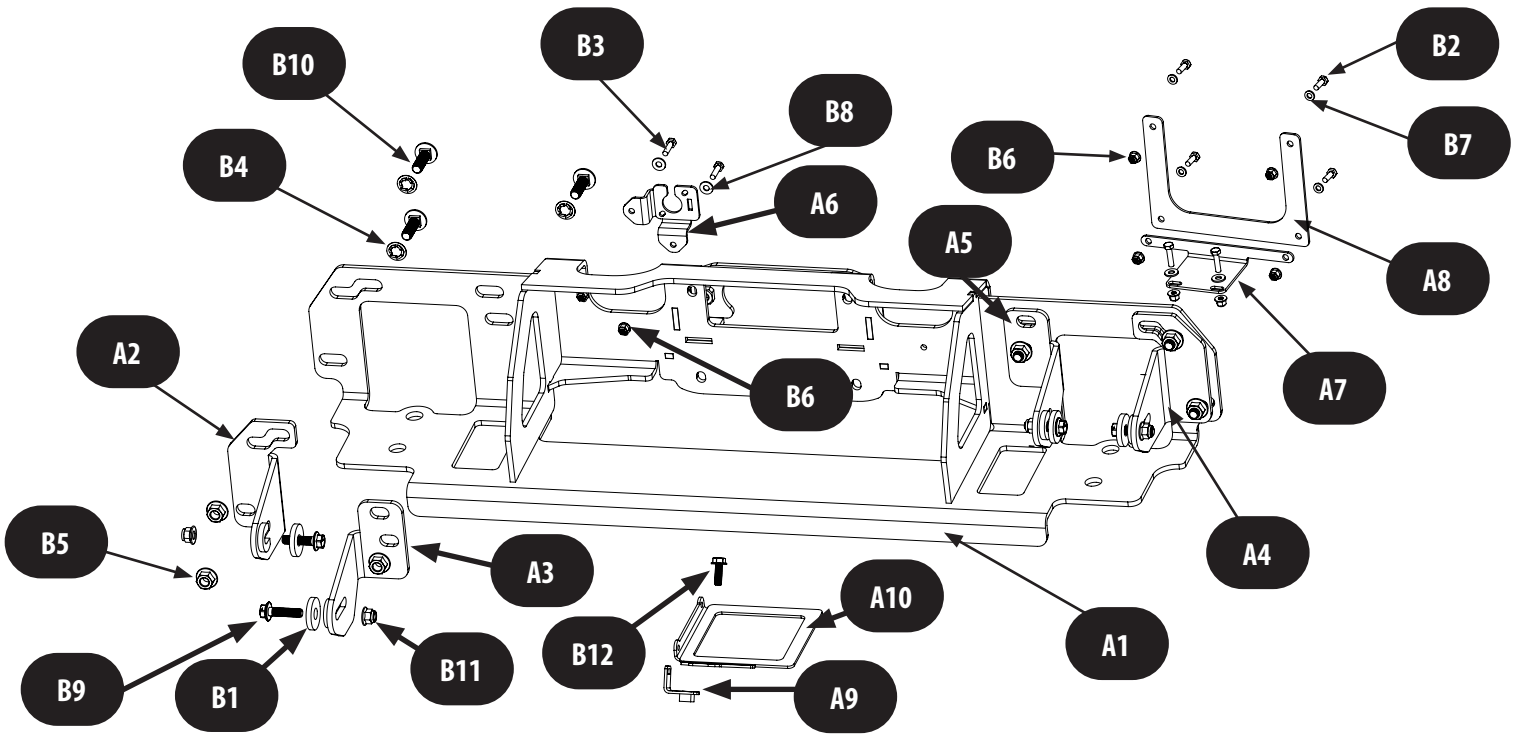
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- Metric wrenches and sockets
- Ratchet

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A9	1	WELD NUT L BRACKET	113606	B9	4	M10-1.50 X 40MM FLANGE BOLT	87233
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				B12	1	M8-1.25 X 25MM FLANGE BOLT	82348



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	
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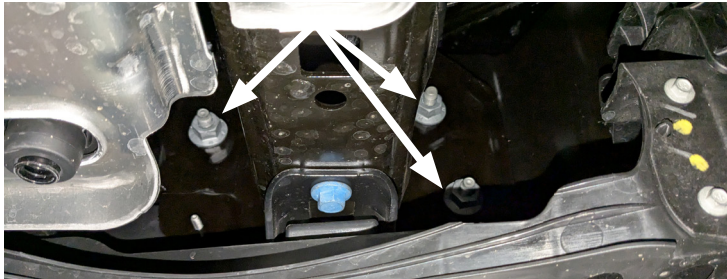


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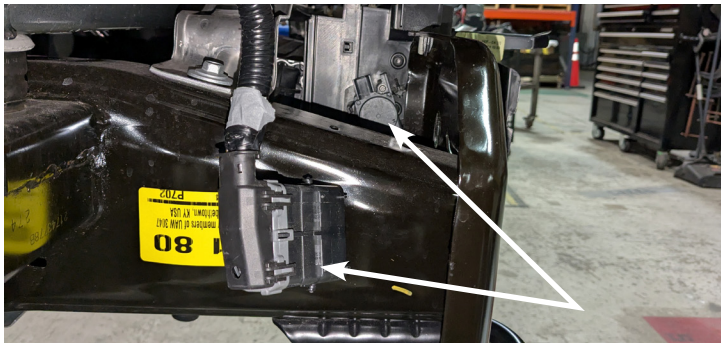
- Disconnect the power and ground cables from the vehicle battery.

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

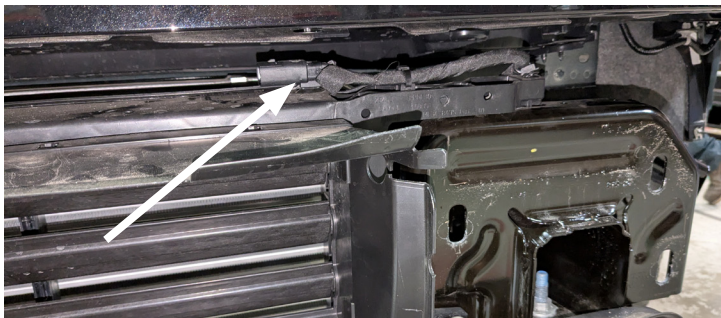
- From behind the bumper, remove the three nuts from the frame's bumper mount (each side).



- With assistance, slowly pull the bumper forward to access the wiring harness connections on the vehicle.
- From the passenger side of the vehicle, disconnect the two plugs.



- From the front of the vehicle, on top of the louvers, disconnect the single plug.



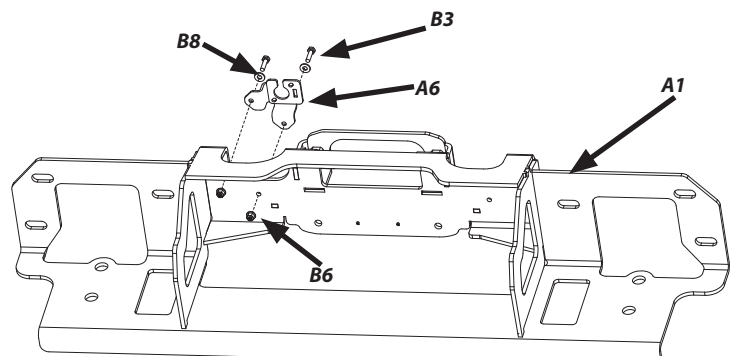
- With the bumper free, carefully remove it from the vehicle and place aside on a flat and stable surface.
- Pull the rubber tow hook covers free from tow hook (each side).



- From inside the frame rail, remove the two tow hook bolts. Remove the tow hook (each side). *Save all items as they will be reused later.*



- Install the remote bracket (A6) to the front of the fully hidden mount (A1) using two M6 x 25mm screws (B3), washers (B8) and M6 lock nuts (B6).



INSTALLATION INSTRUCTIONS

- Following your Warn Short Drum Zeon XC installation instructions, install the synthetic rope.
- **EcoBoost Vehicles Only:** Mount the control pack to the relocation bracket (A10) using the hardware and instructions provided in the Warn Control Pack Relocation Kit.
- Per your winch installation instructions, install the winch to the winch carrier.

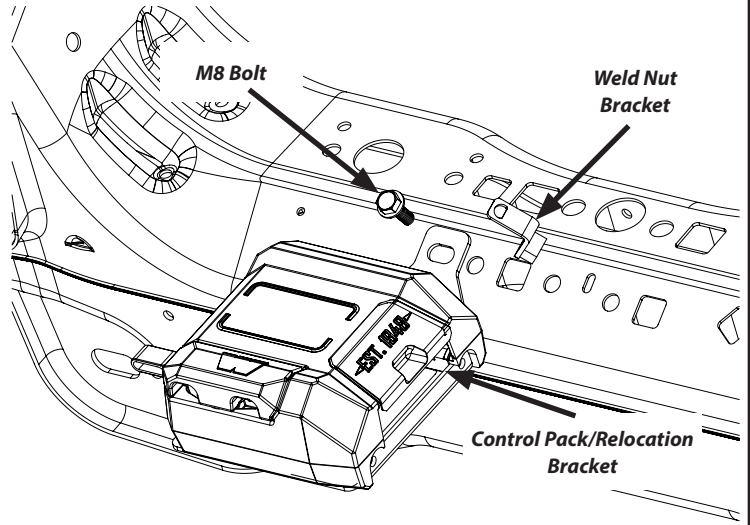


- Install the remote harness jumper to the remote bracket using the M5 screws, included in your winch kit.



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

- **EcoBoost Vehicles Only:** With assistance, bring the winch mount towards the vehicle, and install the control pack bracket onto the frame's cross member using the 25mm long M8 flange bolt (B12), and the weld nut L-bracket (A9), included in this kit.



- Continuing with assistance, bring the winch mount up against the front frame bumper mounts and align. Route and tidy wires accordingly away from all hot, sharp, moving, and rotating parts.



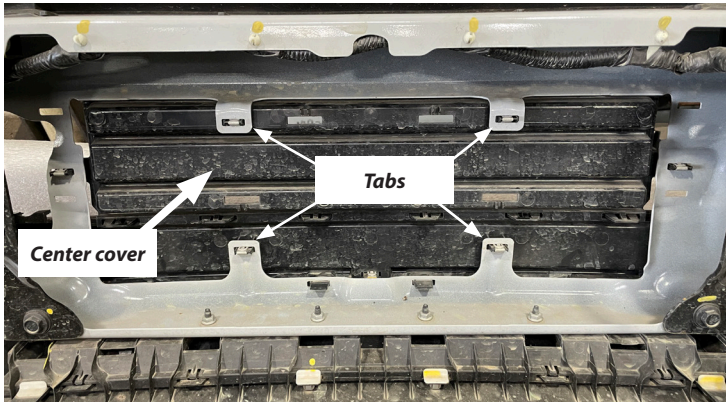
- Loosely reinstall the tow hooks using the OE hardware on each side of the vehicle.



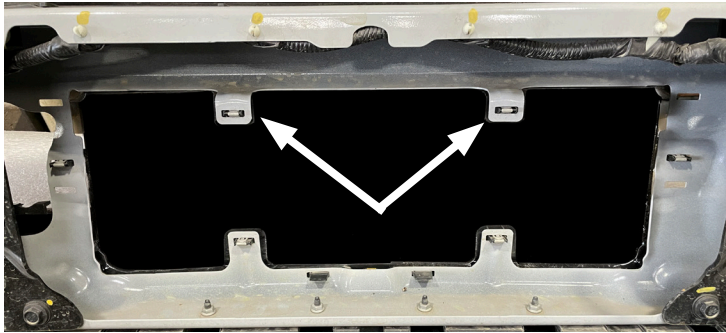
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- Follow the instructions supplied with your Warn winch to complete wiring your winch.
- Plug in your remote harness to your winch. Route and tidy the remote harness cable.

INSTALLATION INSTRUCTIONS

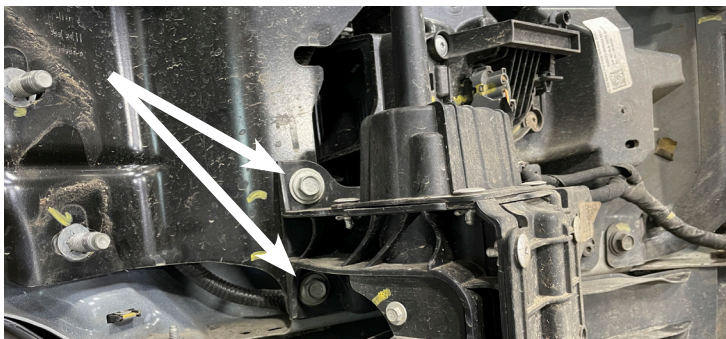
- From the inside of the OE bumper, using a pry tool, remove the center cover from the bumper structure (you will not be reusing). *There will be multiple clips holding cover in place. **OPTIONAL:** Bend or cut the upper metal tabs to allow for a better fit of the fairlead later on.*



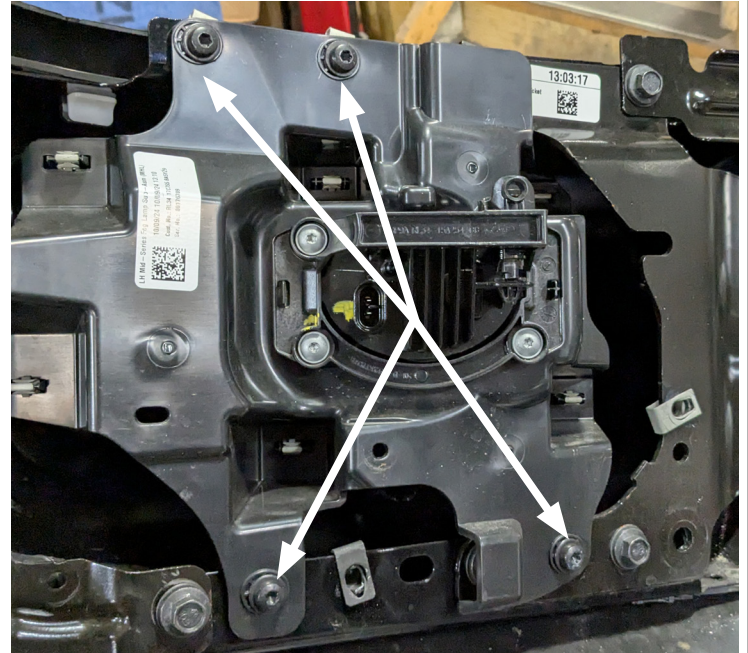
OPTIONAL: Bend or cut the upper metal tabs to allow for a better fit of the fairlead later on.



- Remove the three bolts holding the active air dam motor actuator to the OE bumper structure (each side). Safely move it aside.



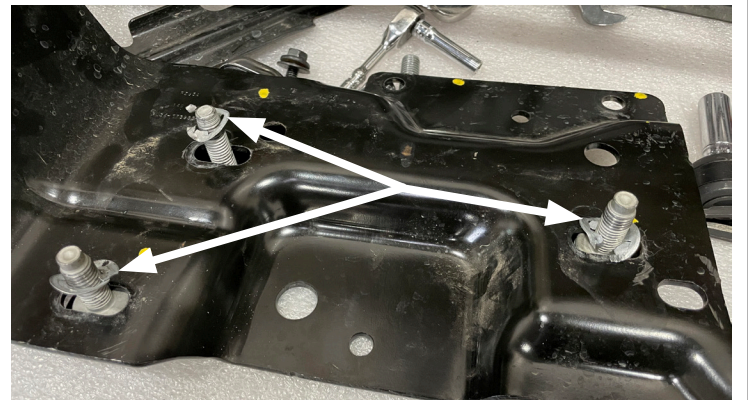
- Remove the four screws to free the fog light bracket and safely move it aside (each side).



- Remove the eight bolts to free the bumper bracket (each side).



- Using a cutting tool, carefully cut and remove the internal tooth lock washer from the three studs in the bumper bracket (each side).



INSTALLATION INSTRUCTIONS

- Remove the stud plate assembly from the bracket and discard (each side).



- Install three M12 carriage bolts (B10) and internal tooth lock washers (B4) to the bumper bracket (each side). *TIP: A deep socket is helpful to push the tooth lock washers flush with the bracket.*



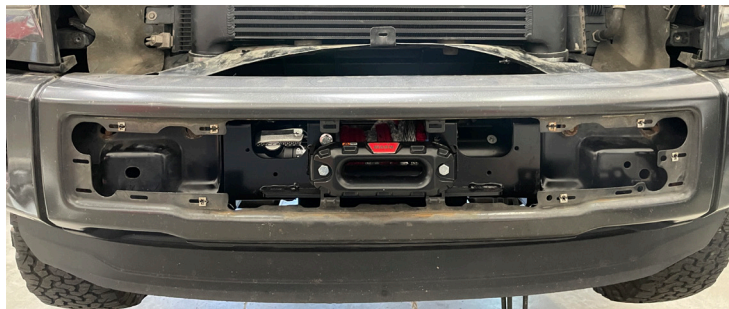
- Re-install the brackets with the new longer carriage bolts back onto the bumper.
- Re-install the fog light brackets back onto the bumper.
- Re-install the active air dam motor actuator back onto the bumper.
- Repeat the above steps to install the three carriage bolts on the opposite side of the bumper.
- On the passenger side of the bumper, install the license plate bracket (A7) into the two holes just above the tow hook opening, using two of the longer black M6 screws (B3), washers (B8), and flange nuts (B6).



- Re-install the rubber tow hook covers on each side of the vehicle.



- With assistance, carefully bring the bumper towards the front of the vehicle, and reinstall the two wiring harness plugs on the passenger side and the single plug in the center.
- Place the bumper on the vehicle, ensuring the mounting studs pass through the winch mount, frame, and the frame brackets.
- Align and center the bumper and fully install and tighten the six nuts (B5) on the bumper studs.



- Locate the fairlead and two 7/16" bolts included with your winch kit.
- Thread the winch rope through the fairlead and then install the fairlead to the front of the mount with the 7/16" bolts.
- Install the hook and strap provided in your winch kit.
- Locate and install the rubber remote plug dust boot, included in your winch kit.

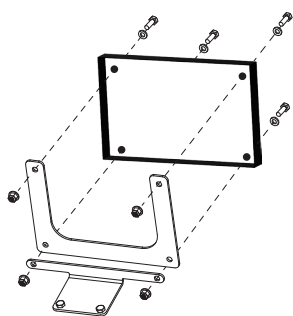


INSTALLATION INSTRUCTIONS

- Re-install the plastic bumper side covers.



- Locate your license plate, the license plate mounting plate (A8) and four M6 bolts (B2), washers (B7) and nuts (B6).
- Install the license plate's to the license plate mounting plate and bracket using the M6 hardware.



- Verify all hardware is tighten and wiring is connected.

- Reinstall battery connections.

⚠ WARNING Always connect red (+) power cable **ONLY** to the positive (+) terminal of the battery.

⚠ WARNING Always connect black ground (-) power cable **ONLY** to the negative (-) terminal of the battery.

- First, attach the winch power (red) cable to the positive (+) battery terminal. Second, attach the winch (black) cable to the negative (-) battery terminal. Tighten securely.



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.