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IRON CROSS
AUTOMOTIVE INC.

2009-2014 Ford Raptor
20/22-415-RAP

Installation Instructions

| Hardware | | | |
|----------|----------------------------------|---|---------------------------------|
| 10 | ½" Bolts, nuts, and lock washers | 2 | Bumper brackets |
| 20 | ½" Flat washers | 1 | Winchplate |

Removal

1. Remove (2) bolts attaching lower grill shell to the top of the bumper. These are located under the hood latch release and to the side. Picture is taken from the radiator looking forward under lower grill shell and hood latch release. Discard at this time (**Fig 1**).



Fig 1



2. Remove (6) bolts holding on skid plate. The access cover does not have to be removed to do this. Keep all hardware for reassembly (**Fig 2**).

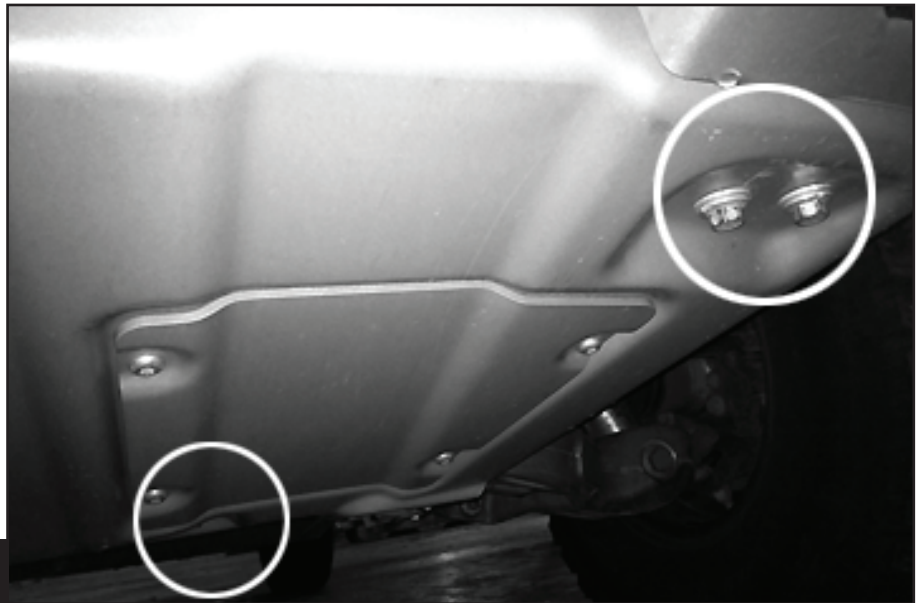


Fig 2

3. Remove (2) bolts securing front skid plate bracket. Keep all hardware for reassembly (**Fig 3**).



Fig 3

4. Detach rubber flap from bumper. There are (3) push clips to be removed (**Fig 4**).

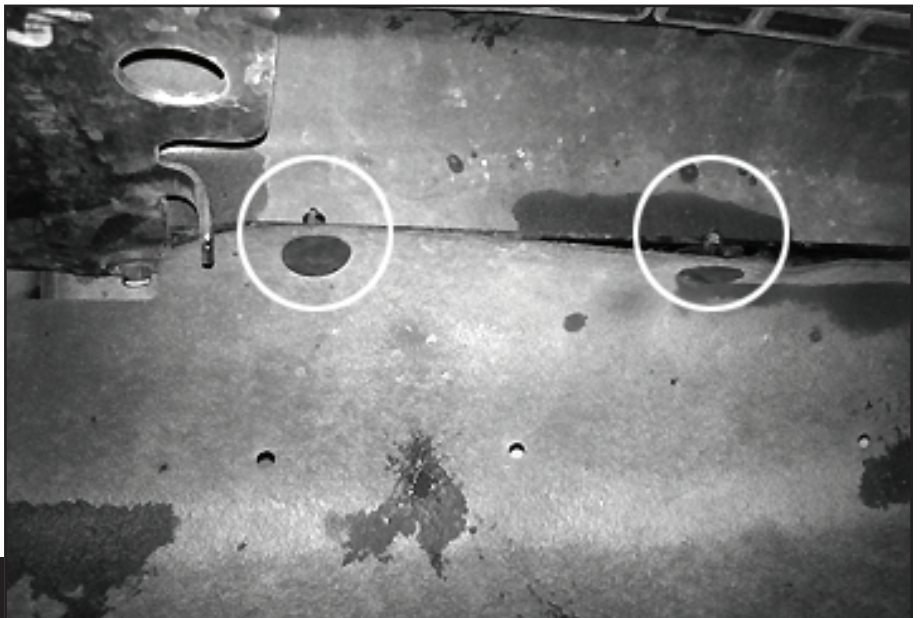


Fig 4



5. Remove (4) bolts that go through front bumper mount and the frame. These may be discarded (**Fig 5**).

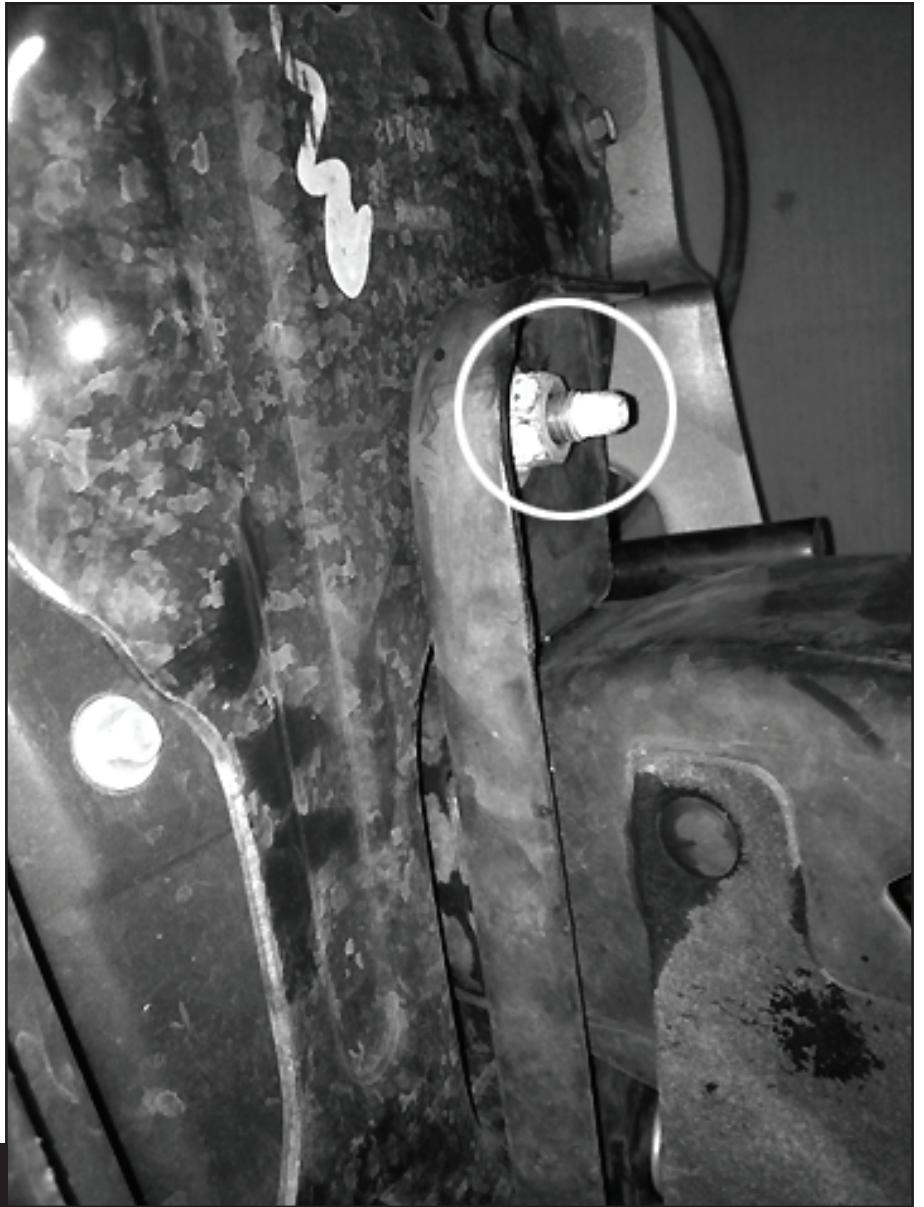


Fig 5

6. Remove (4) bolts holding on tow hooks. Keep all hardware and parts for reassembly (**Fig 6**).

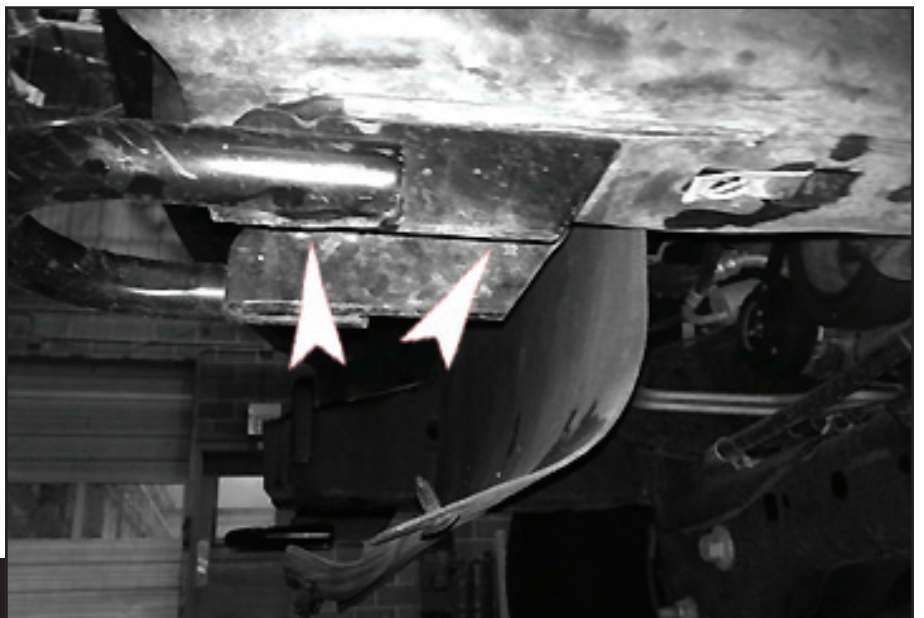


Fig 6



Installation

1. Align the winchplate on the underside of the frame and the backside of the frame. It's easiest to use a ½" bolt and nut to hold the plate in position. Now reattach the factory tow hooks, using the factory hardware. The tow hooks will sandwich the winchplate between them and the frame. Tighten bolts only snug enough to still allow the winchplate to move front to rear. If you used the ½" to hold the winchplate in position, remove at this time (**Fig 7**).

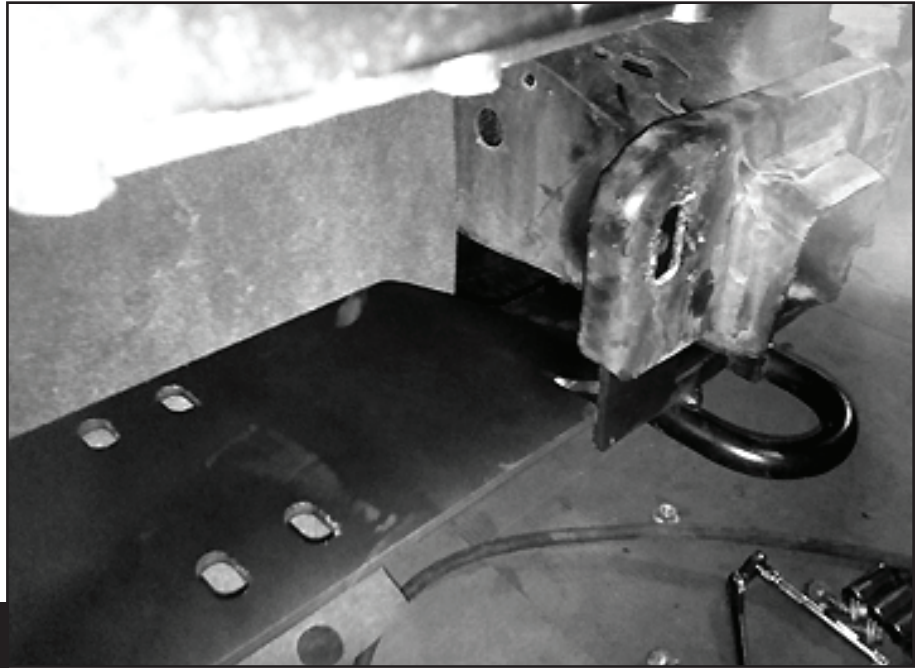


Fig 7

2. Attach the bumper brackets to the front of the frontside of the frame, using supplied ½" hardware. The bolts will go all the way through the winchplate. Tighten the bolts enough to allow the brackets to move left to right (**Fig 8**).

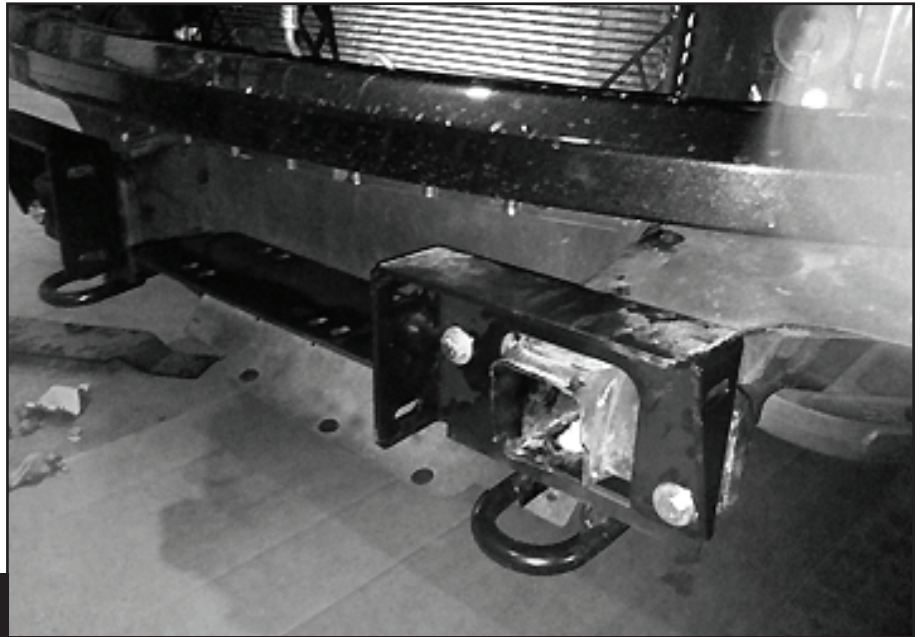


Fig 8

3. Install the bumper on the truck using supplied ½" hardware. The brackets mounted on the truck will go inbetween the mounts welded in the bumper. Only snug the inside bolts at this time, allowing the bumper to be moved up and down.

4. Center the bumper left to right. When this is done, tighten the ½" bolts that attach the bumper brackets to the frame.

5. Now tighten the factory tow hook bolts.

6. Align the bumper up and down and tighten all bumper mount bolts to the bumper brackets. It is best to leave ½" clearance between the bumper and any factory body part. This allows for frame and body flex.

7. Reinstall skid plate mounts and skid plate, using factory hardware. The rubber flap that was unattached from the factory bumper can rest between the winchplate and skid plate.

