

# IRON CROSS AUTOMOTIVE INC.

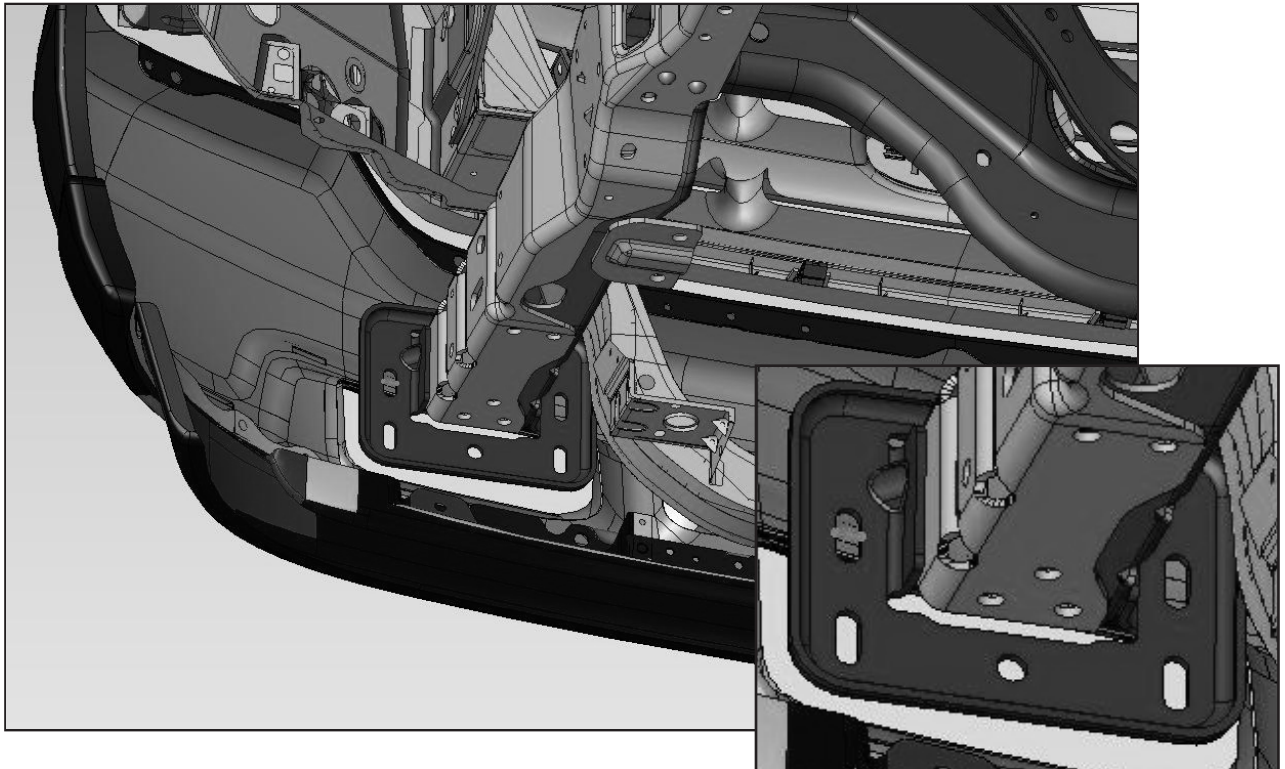
INSTALLATION INSTRUCTIONS FRONT BUMPER

## 20/22/24-425-99

## 99-04 FORD SUPER DUTY

### PARTS LIST

|    |                   |
|----|-------------------|
| 16 | 1/2" FLAT WASHERS |
| 8  | 1/2" LOCK WASHERS |
| 8  | 1/2" HEX BOLTS    |
| 8  | 1/2" HEX NUTS     |
| 1  | FRONT BUMPER      |



#### OEM BUMPER REMOVAL

- A) Disconnect OEM fog lamp connectors; zip tie harness to frame.
- B) Remove fasteners holding OEM bumper to chassis. Repeat for other side.

**THIS PRODUCT IS FOR OFFROAD USE ONLY. ALL LIABILITY FOR INSTALLATION AND USE RESTS WITH THE OWNER.**

**CARELESS INSTALLATION AND OPERATION CAN RESULT IN SERIOUS INJURY OR EQUIPMENT DAMAGE.**

- C) Remove OEM bumper assembly.
- D) Remove OEM tow hooks.



## BUMPER INSTALL

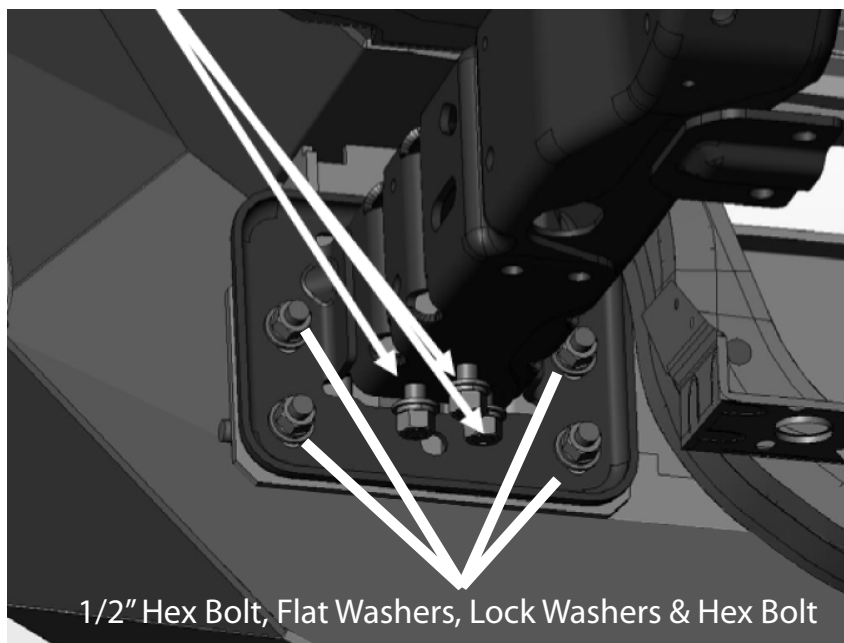
A) Carefully lift bumper and up the mounting flanges. Hold bumper against mounting flanges, slide flat washer over bolt, and slide through each of the four mounting holes using 1/2" bolts, flat washers, lock washers, and nuts. Tighten to finger tight until final alignment is finished. Repeat for other side.

C) Adjust the bumper to achieve good visual alignment as follows:  
1. Adjust left/right and up/down with the bumper/bracket flange bolts.

D) Tighten all fasteners, beginning with frame mounts. Then tighten all mount-to-bumper fasteners.

F) Install bolts (with washers and nuts) through tow hook frame holes as shown. Tighten fully. Repeat for other side.

OEM tow hook hardware



1/2" Hex Bolt, Flat Washers, Lock Washers & Hex Bolt