



INSTALLATION INSTRUCTIONS

PART #	074ST17N22G
Product:	FRONT BUMPER
Vehicle:	FORD F250/350 SUPERDUTY 2011-2016

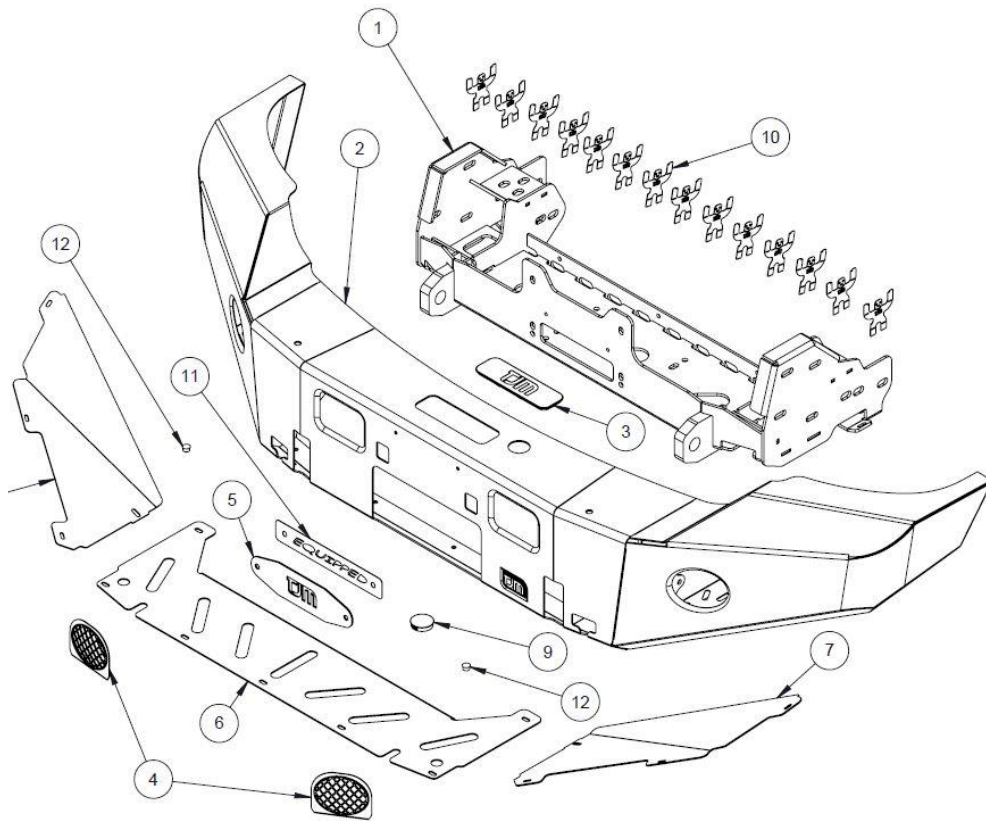
WARNING

- Read instructions completely before commencing fitment.
- Always use personal safety equipment while cutting or operating tools.
- Left hand & Right hand components are determined as seated in the vehicle.
- Check & remove any build up in all captive nuts, if fitted to the product.
- Check scale on bumper template before cutting if applicable.
- After installation, place these instructions in the glove compartment of the vehicle.

Torque all hardware to the following settings unless stated otherwise;

	Metric			Standard		
	Bolt Dia. (mm)	Nm	ft. lb	Bolt Dia. (inch)	Nm	ft. lb
TORQUE SETTINGS	5	5	4	1/4"	9	7
	6	9	7	5/16"	22	15
	8	22	16	3/8"	33	27
	10	44	32	7/16"	55	43
	12	77	57	1/2"	86	66

- Do not attach this product using hardware not intended for this product.
- Only use hardware supplied by the TJM and specified in the instructions.
- Do not use this product for any vehicle make or model other than those specified by TJM.
- Do not remove any plaques or labels from the product.
- Modifying this product in any way may void any / all warranties.

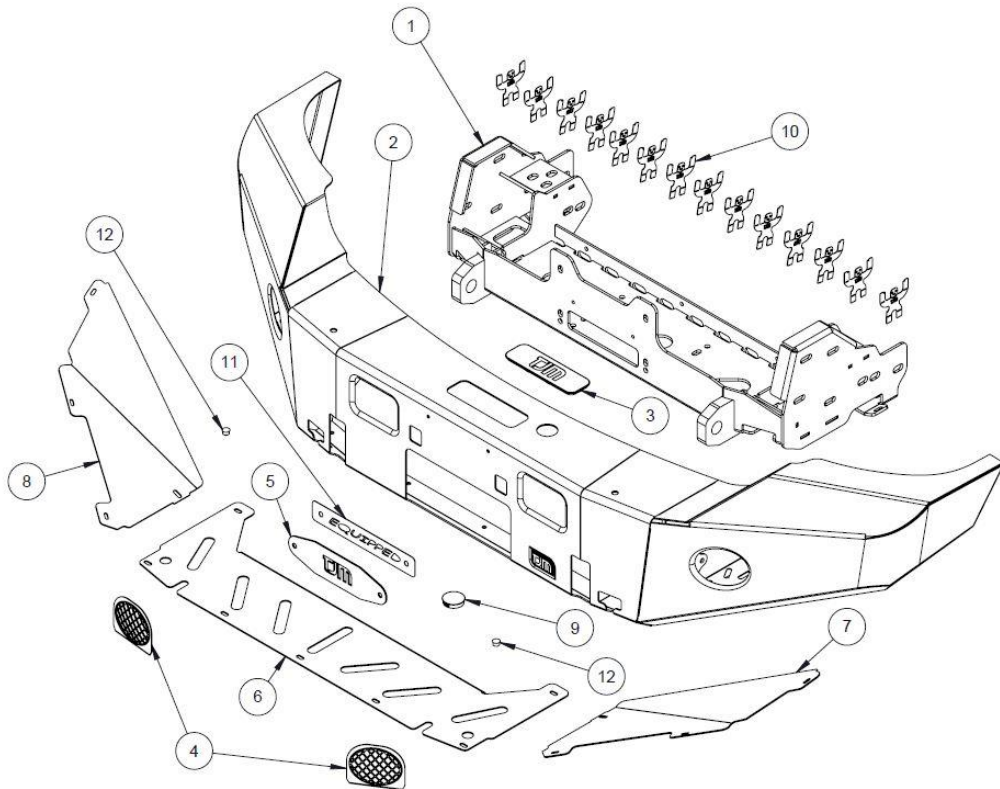


ITEM No.	Description	Qty.	Part #
----------	-------------	------	--------

PARTS LIST			
1	WINCH FRAME WELD ASSY	1	F-13027
2	T17 BUMPER WELD ASSY	1	F-13065
4	USA FOGLIGHT GRILLE MESH COVER PLATE	2	F-12820
5	FAIRLEAD COVER PLATE	1	F-12927
6	BRKT UNDER PAN CENTRE	1	F-13096
7	BRKT UNDER PAN SIDE LH	1	F-13097L
8	BRKT UNDER PAN SID RH	1	F-13097R
10	SHIM 1MM MAN SUIT M12 BOLTS	14	F-13247
11	EQUIPPED WINCH PLAQUE SS	1	F-13413

F-13225 FITTING KIT			
3	Winch Slot Cover Plate	1	92106
9	PLASTIC PLUG 45mm	1	F-13151
12	12.7MM PLASTIC PLUG	2	K0765

ITEM No.	Description	Qty.	Part #
F-13650 BOLT KIT			
13	M6 x 1.0 - NUT NYLOC SS304	12	-
14	M6 x 1.0 x 20 BUTTON SCREW - SS304	12	-
15	M6 x 12 x 1.6 - WASHER FLAT SS304	24	-
16	M8 x 1.25 - NUT NYLOC SS304	13	-
17	M8 x 24 x 2.0 - WASHER FLAT SS304	24	-
18	M8 X 25 X 1.25 BUTTON HEAD SCREW SS304	13	-
19	M10 x 1.5 x 35 HEX SCREW - ZP	4	-
20	M10 x 1.5 ZP - NUT NYLOC	4	-
21	M10 x 20 x 2.0 - Washer Flat - ZP	8	-
22	M12 x 1.25 x 040 HEX SCREW - ZP	24	-
23	M12 x 1.25 ZP - NUT NYLOC	24	-
24	M12 x 3.0 ZP - WASHER SPRING	2	-
25	M12 x 32 x 3.0 ZP - WASHER FLAT	48	-
26	CABLE TIE 250mm BLK	6	-



VEHICLE PREPERATION



1. Unclip any wiring or fog lights attached to the bumper.
2. Remove the bolts holding the side brackets to the bumper.
3. Remove the 4 bolts on the front of the bumper and remove bumper from vehicle as shown.

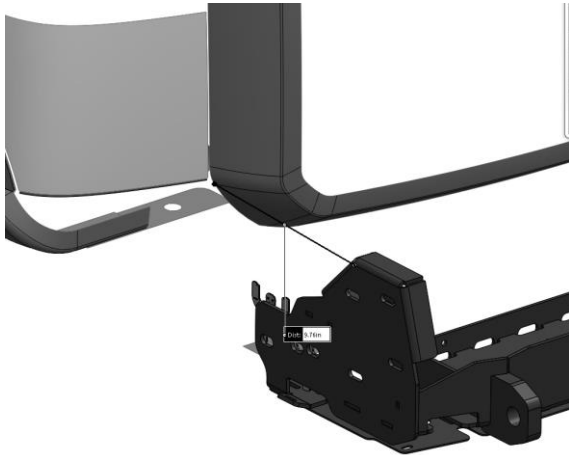


4. Remove side brackets and factory tow hooks as shown.

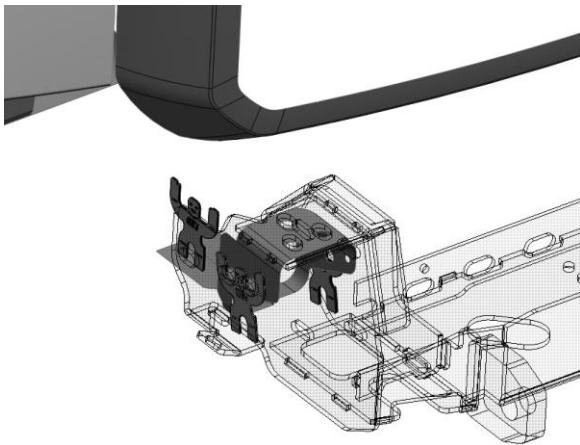
BUMPER FITMENT



5. Fit winch to winch frame using hardware supplied by winch manufacturer.
6. Using a helper, install the winch frame and winch (if fitted) to the vehicle.
7. Secure M12 chassis bolts finger tight only.



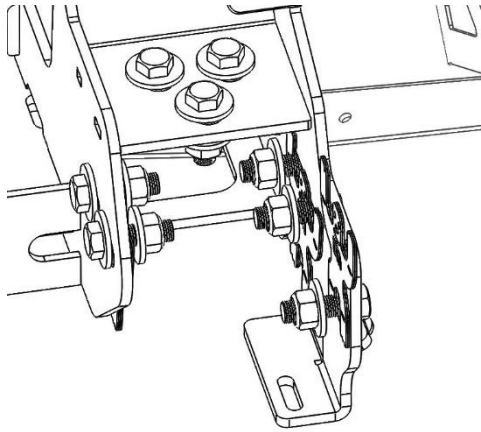
8. Measure in from the corner of the grille on each side and center the winch frame to the body using the 1mm shims provided.



9. Insert the 1MM shims between the chassis and the winch frame as shown.
10. Cable ties have been provided to aid install and lock shims to winch fame.

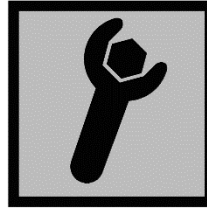
NOTE:

Fold legs or arms up if required. Retain any leftover shims for later.



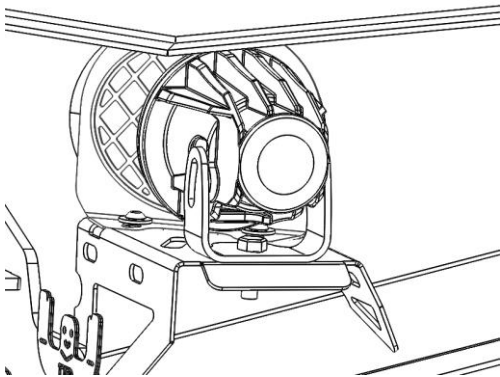
Note: Chassis not shown.

11. Using M12 hardware, fasten the winch frame to the chassis as shown. Torque to specification.



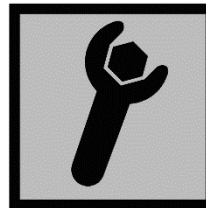
M12 – 77 Nm.

12. Recheck winch frame is in the central position and adjust and repeat if necessary.

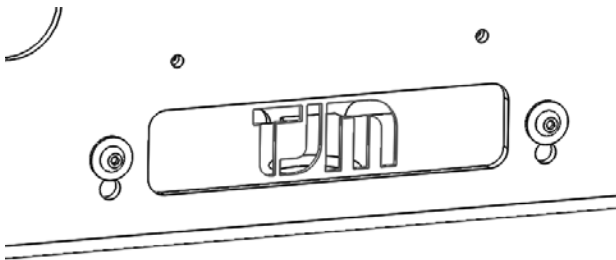


13. Install light grille to fog light bracket using M6 button head, flat washers and nyloc nut as shown.

14. If optional / aftermarket LED / foglights have been purchased, fit to bumper following manufactures instructions and using lighting manufacturer supplied hardware.



M6 - 9Nm.



15. If no winch is fitted, install TJM fairlead cover using M8 stainless steel hardware.

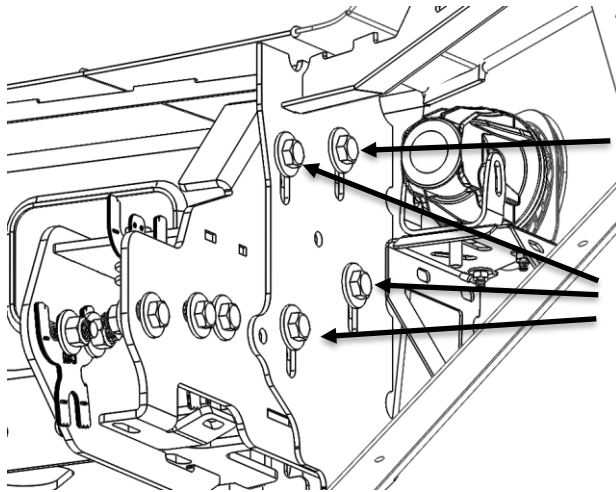
16. If winch is fitted, Install roller fairlead finger tight only using winch supplied hardware.



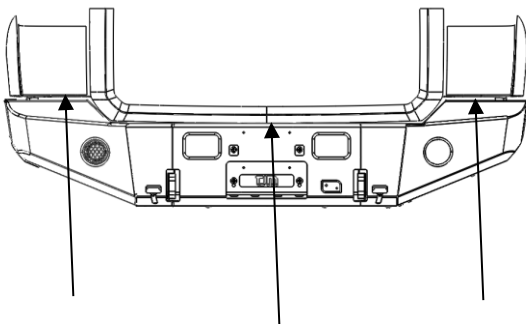
17. With the aid of a helper, fit the bumper over the winch frame being careful not to mark the vehicle as shown.

NOTE:

Roller fairlead should be fitted finger tight only if fitted as shown.

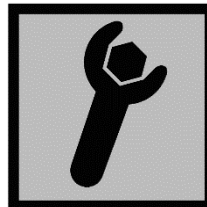


18. Install bumper to winch frame, finger tight only using M12 hex bolts, flat washers and nyloc nuts as shown.

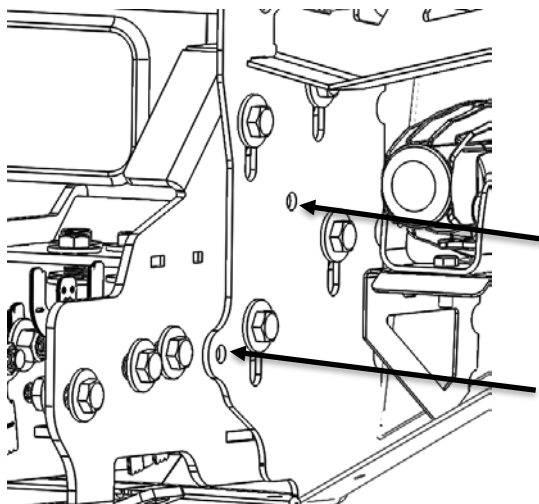


19. Align bumper with vehicle maintaining an even gap of $\frac{3}{8}$ to $\frac{1}{2}$ inch from grille to bumper as shown.

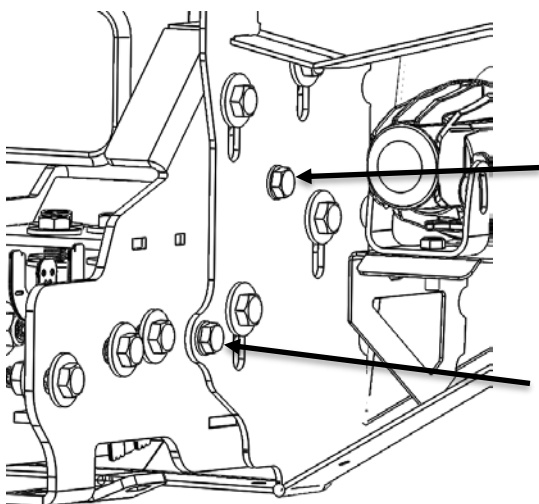
20. Torque bumper to winch frame M12 fasteners to specification.



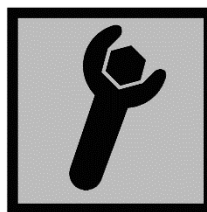
M12 – 77Nm.



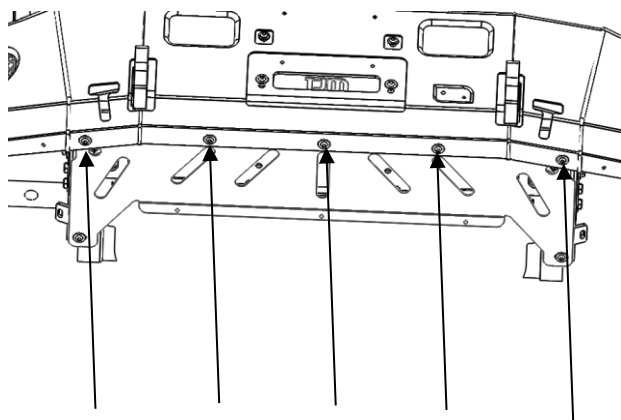
21. Double check alignment to all bumper surfaces.
22. Using an M10 drill bit, drill pinning bolts and apply paint to all bare metal.



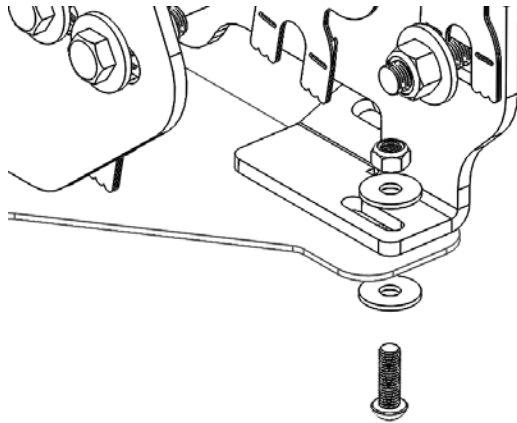
23. Fasten pinning bolts using M10 hex bolts, flat washers and nyloc nuts as shown.
- Torque to specification.



M10 – 44Nm.

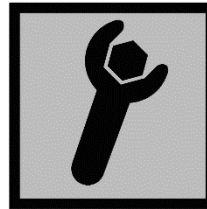


24. Attach the centre stone shield on the inside of the front bumper using M6 button head screws, flat washers and nyloc nuts for the front 5 bolts.

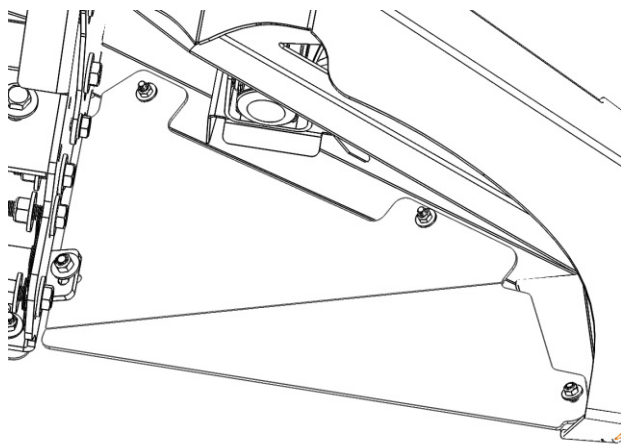


25. Attach the rear of the center stone shield using M8 hardware as shown.

26. Center the stone shield to the bumper / vehicle and torque all fasteners to specification.

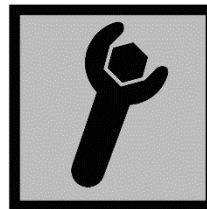


M6 – 9Nm.
M8 – 22Nm.



27. Install right hand stone shield using M6 hardware as shown.

28. Repeat on left hand side of vehicle.
29. Align stone shields to bumper and torque all fasteners to specification.



M6 – 9Nm.

Fitment Options;



Winch and Equipped plaque fitted – No front license plate.



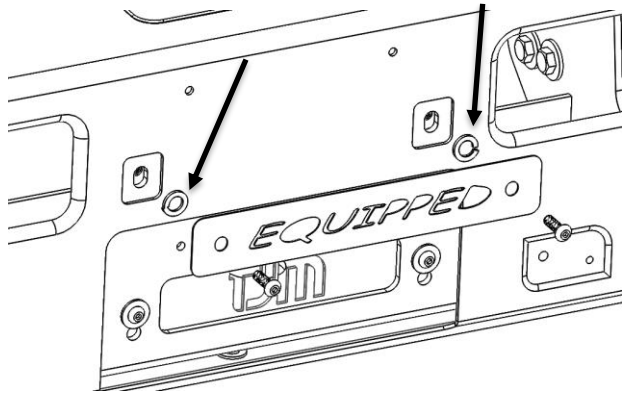
Winch and license plate fitted.



Non winch - Equipped plaque and license plate fitted.

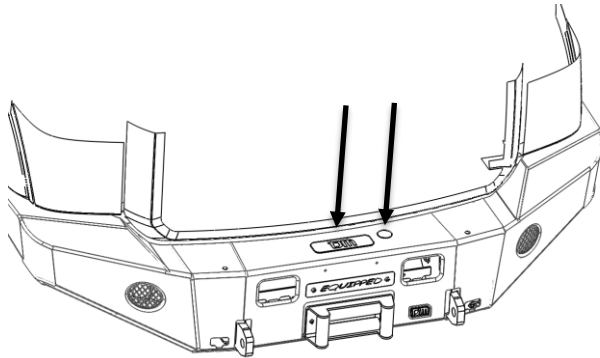


Non winch / no front license plate - Equipped Plaque and TJM fairlead cover fitted.



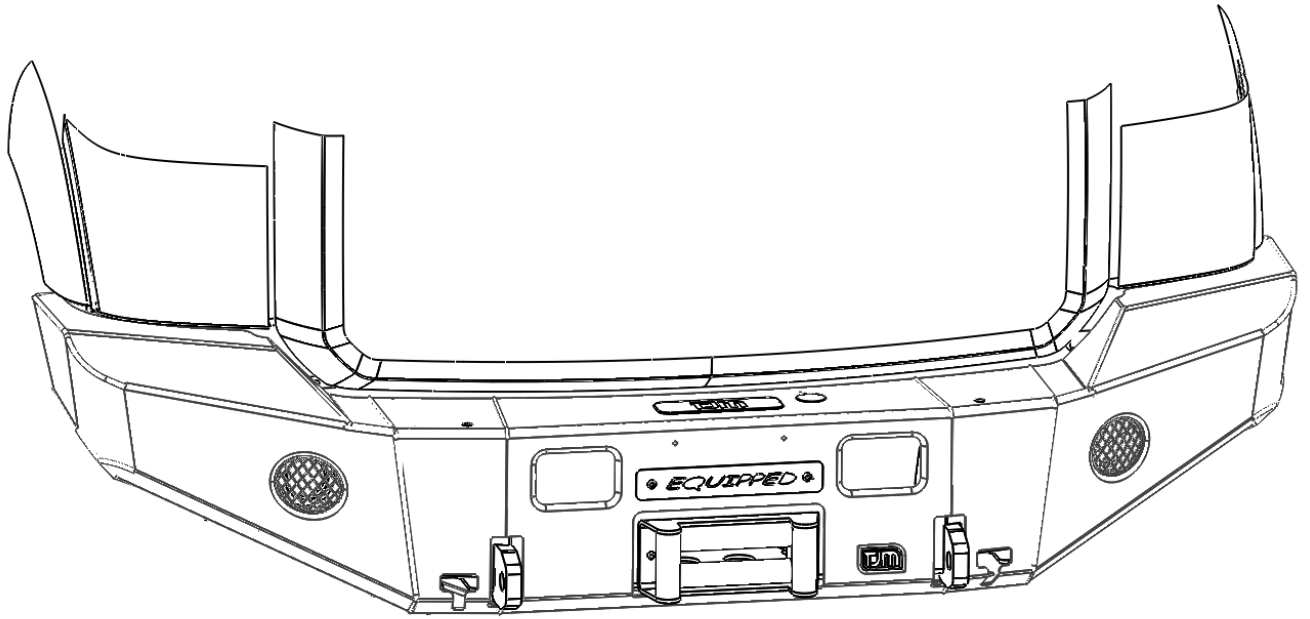
30. If winch is installed, use winch supplied bolts and insert an M12 spring washer between the EQUIPPED plaque and the winch frame as shown.

31. If no winch is to be fitted, install plaque using M8 button head bolt, M8 washer, M8 nyloc nut and the M12 spring washer as shown to retain.



32. Install winch cover plate and winch control access plug into the top of bumper as shown.

33. Ensure all bumper fasteners are fastened to their correct torque settings.



074ST17N22G

Roller Fairlead and fog lights are optional accessories and not included.