



Thanks for your purchase of our 2012+ Arctic Cat EXO Rear Bumper.

Please read instructions and view pictures entirely before installation. Use caution when drilling into the snowmobile. Locations will be clearly marked in the following pictures.

You cannot reuse the factory snow flap with this bumper. The strength will not be there to support the rear of the snow flap area. If you want to still run a snow flap we have an option available on our website.

If you chose the raised rear handle option, you will need a new solution for a taillight and snow flap.

Here is what is included with the rear 153/154 bumper:

- (2) Bumper Side Plates
- (1) Bumper Handle
- (22) short rivets
- (6) medium rivets
- (2) long rivets
- (8) 1/4-20 x 5/8" Button Head Bolt
- (4) 1/4-20 x 1" Button Head Bolt
- (12) 1/4-20 Flanged nylock nut
- (30) Rivet washers

Here is what is included with the rear 162/165 bumper:

- (2) Bumper Side Plates
- (1) Bumper Handle
- (26) short rivets
- (6) medium rivets
- (2) long rivets
- (4) 1/4-20 x 5/8" Truss Head Bolt (torx bit)
- (4) 1/4-20 Flanged nylock nut
- (34) Rivet washers

1. Slightly elevate the rear of the snowmobile to aid in removing and installing rear bumper. Remove the rear most suspension bolts from the tunnel hangers. Support the sled with either jack stands or strap to ceiling by the running boards.
2. Remove factory bumper. Use a 3/16" drill bit and remove every rivet holding the rear bumper on. The 4 front rivets that are through the rear suspension hanger on each side can be tough. (Shown in second picture) We have found grinding the heads off the rivet from the inside of tunnel to work best. Remove the front two factory bolts holding the bumper to sled. Save these for the new bumper. Remove the rest of the rivets shown in picture 3.
3. Once bumper is off you will see two rivets (one on each side of rear of sled) that have to be drilled out. Shown in first picture.
4. Now clamp on the new bumper side plates to tunnel. Align the front hole and re-use the factory bolt to secure bumper. Align the rear of the bumper plate as shown in picture 4. You will have to drill out tunnel to 1/4" holes.
5. Refer to picture 5. Using the bumper as a drill guide, use a 3/16" drill bit and drill holes in tunnel. You will have to use the tunnel as a drill guide to install the rivets along the bottom of the bumper plate.
6. Refer to picture 6 to install hardware in the front of bumper plates. All the bolts used are 5/8" long. Nuts MUST be placed on the outside of tunnel, you do not want the track contacting them.
7. Now Install the rear handle. Drill the holes in tunnel out to 1/4". Install the 1" long bolts here. You may install the bolts with the nut on the inside as long as you haven't done something crazy where the track will contact those nuts!
8. Reinstall the rear suspension. Make sure all hardware is tight and won't interfere with the track.

Any questions or concerns please call or email us!

B&M Fabrications

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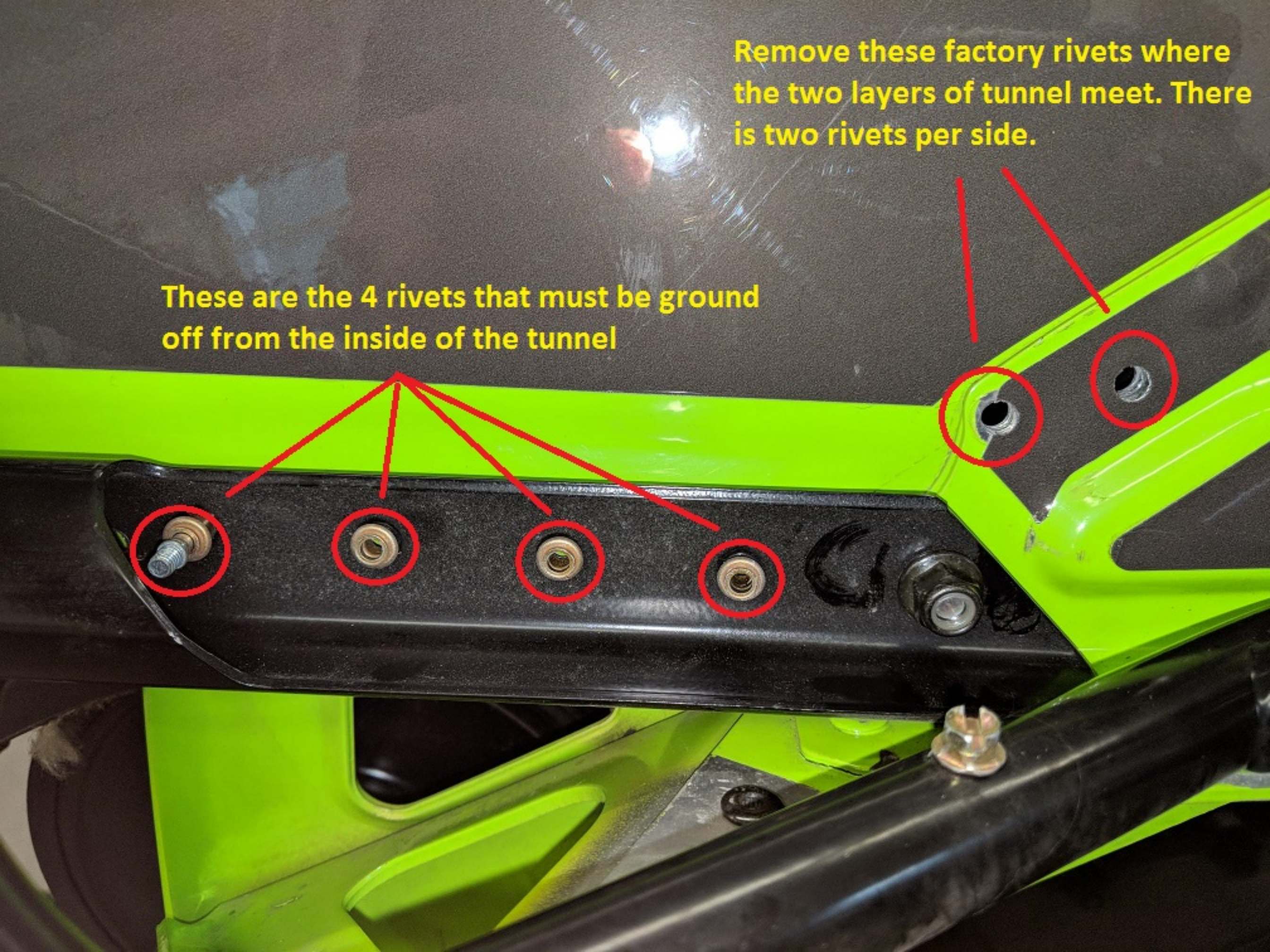
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**Here is the location of the factory rivet
you must remove AFTER the factory
bumper is removed. One on each side.**



Remove these factory rivets where the two layers of tunnel meet. There is two rivets per side.

These are the 4 rivets that must be ground off from the inside of the tunnel



**Make sure all these circled rivets are removed along the tunnel.
The new rear bumper will utilize these holes.**



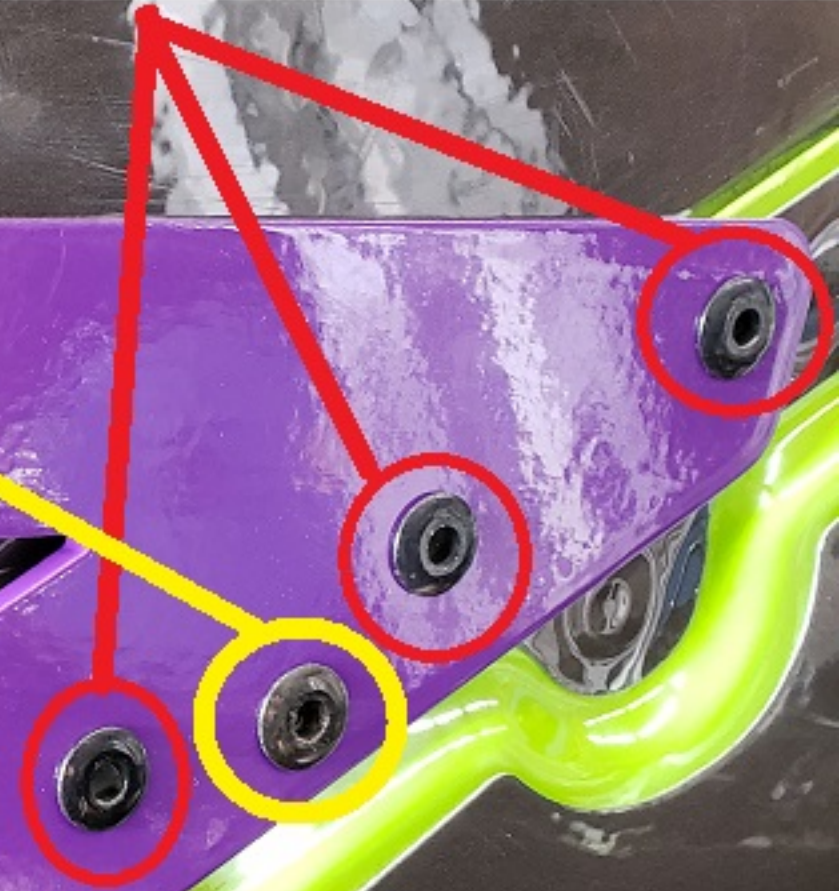
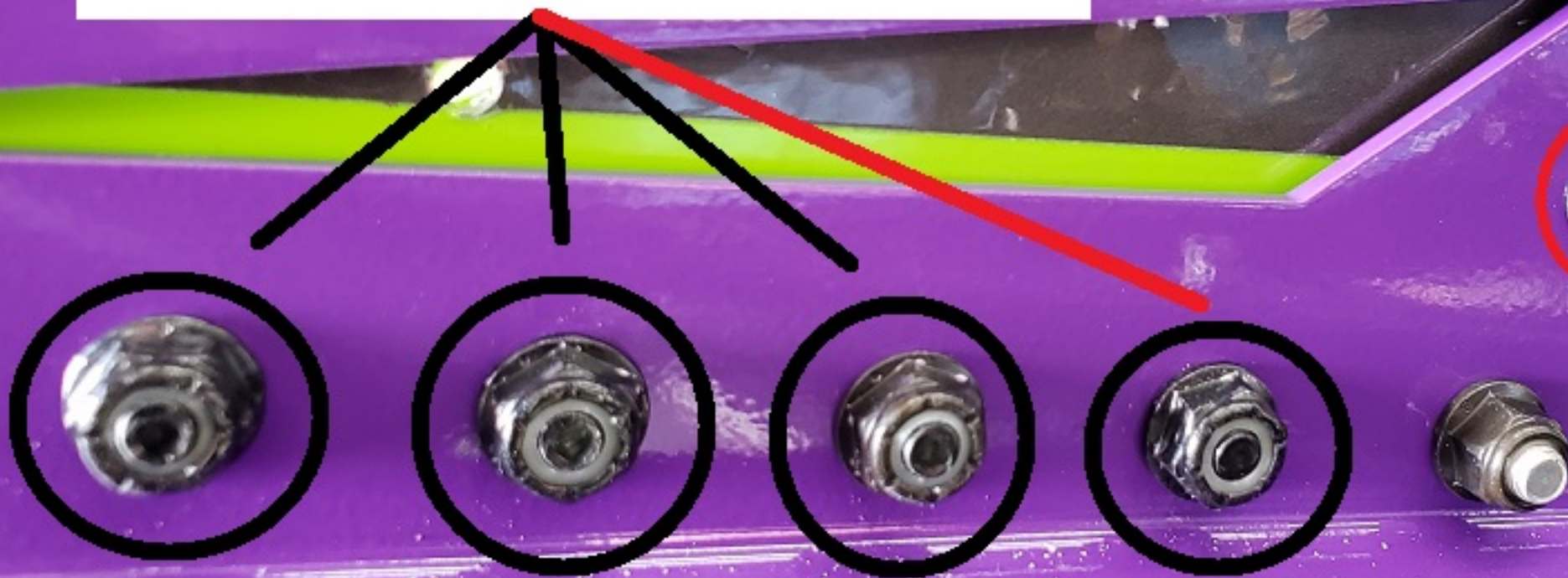


All circled rivets are SHORT RIVETS. Use a rivet washer on the tunnel side as well. Install all of these before proceeding to front section of bumper.



The red circled rivets are MEDIUM in length. Drill these holes from inside out. The yellow circled rivet is a LONG rivet. Make sure to use rivet washers on the tunnel side.

Drill the holes for these bolts to 1/4" from the inside out! Keep the button head on inside of tunnel.



Install rear handle with the 1" bolts and nylock nuts. Shown here is the raised handle with an aftermarket taillight.

