



Thank you for your purchase of our 2023+ Ski Doo Gen 5 850 / 850 Turbo Front EXO Bumper.

Please read instructions and view pictures entirely before installation.

Here is what is included with the bumper:

- (12) 1/4-20 x 1" Button Head Bolt
- (13) 1/4-20 Flanged Nut
- (4) Large Head Rivets
- (4) M6 Fender Washers
- (2) Aluminum Bulkhead Mounts (1/4" Thick Left and Right)
- (1) 1/4-20 x 3/4" Button Head Bolt

1. Remove Hood, exhaust pipe and unbolt factory bumper. You will have to drill 4 rivets out holding bumper to belly pan. Use 3/16" drill bit. Remove Front Facia piece (it is snapped in and bolted), pop the front corners out of the nose cone / belly pan. Getting the bumper out is a little tricky. See attached pictures 1-3

2. If you are using a skid plate on your snowmobile, fit it to the machine following the Ski-Doo Directions. There are 2 marked holes in the skid plate that need to be drilled through. See picture 4

3. There are 2 holes in the nose cone plugged with plastic plugs, remove these plugs. See picture 1

4. Locate the factory dimples in the bulkhead on each side (4 total) drill these to 1/4". (Picture 5 for location). Install the supplied aluminum bulkhead mounts with (4) - 1" bolts and flanged nuts. The tab will be facing forward with the bend facing outwards. Tighten bolts so the tab can still move around. Picture 8

5. Test fit and trim area of side panel where the bumper goes through it. You will need to trim and fit repeatedly until the sides and the nose cone snap back together without distortion. This is important to make sure the panels of the snowmobile fit back together correctly. Using a Dremel tool or a die grinder with a carbide bit or a sanding drum works the best to look nice. Picture 6 & 7

6. Slide your new bumper in through the belly pan for the final time. Use (4) - 1" long bolts and bolt the upper bumper mount to the aluminum bulkhead mounts. Bumper will sit on top of the mounts. Do not tighten these bolts all the way yet. Picture 6

7. The bottom of the bumper will align with the 2 holes you removed the plugs from in the nose cone previously (as well as drilling through the skid plate if you are using one). Picture 4. Install (2) 1" bolts from inside out through the belly pan and into the bumper, use 2 fender washers on the inside and the nuts on the outside. Tighten them enough to hold the bumper and the nose cone together (sandwiching the skid plate if using). Picture 9

8. Using a 1/4" Drill bit, drill holes through the bottom holes in the bumper and the aluminum bulk head. Install (2) 1" Bolts from the bottom up with fender washers on the bottom under the bolt head. Picture 9 & 10

7. Now you may tighten all the bumper mounting bolts. Don't go crazy, they are only a 1/4" bolt! Also snap the sides and nose cone back together and reinstall the front fascia piece.

8. Drill (4) 3/16" holes through the belly pan where the factory bumper was attached. Install supplied rivets. Picture 1

9. Reinstall the exhaust pipe. The module for the sensor is bolted back to the factory bumper mounting tab with the supplied 1/4 – 20 x 3/4" bolt and nut. Picture 8. Complete sled assembly and enjoy!

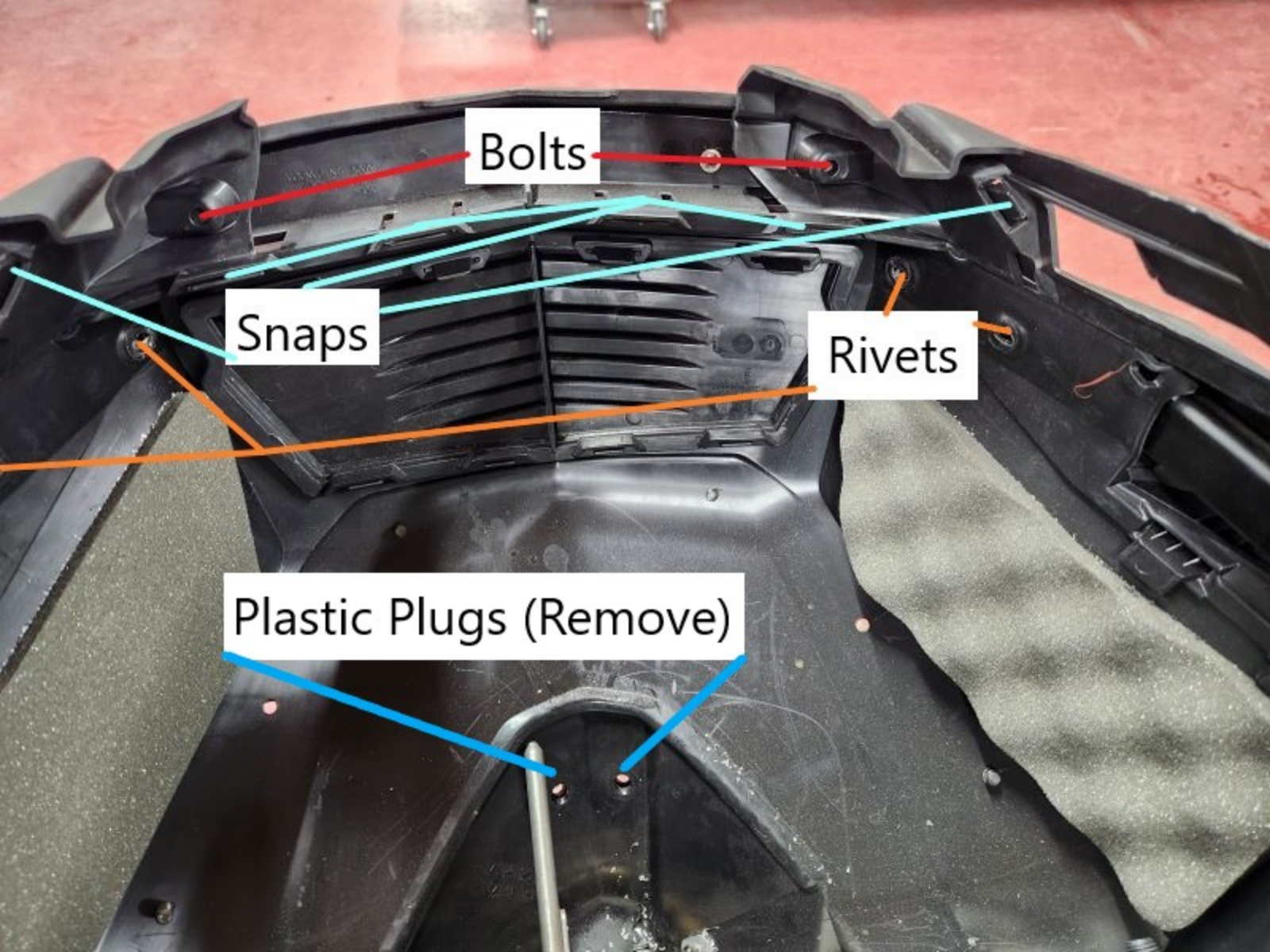
Any questions or concerns please call or email us!

B&M Fabrications

612-202-9245

info@bmfabrications.com

www.bmfabrications.com

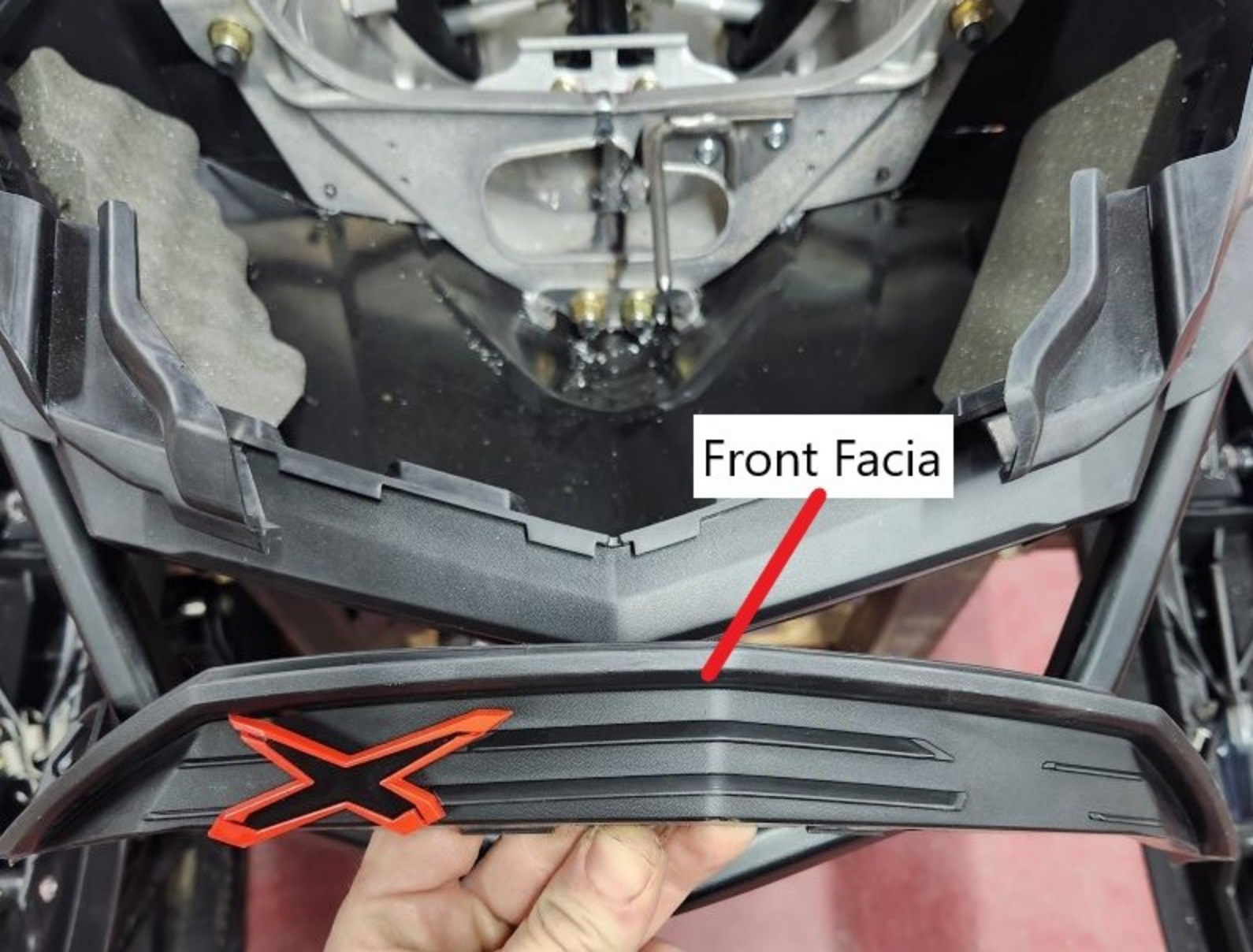


Bolts

Snaps

Rivets

Plastic Plugs (Remove)



Front Facia



Plastic interlock snaps

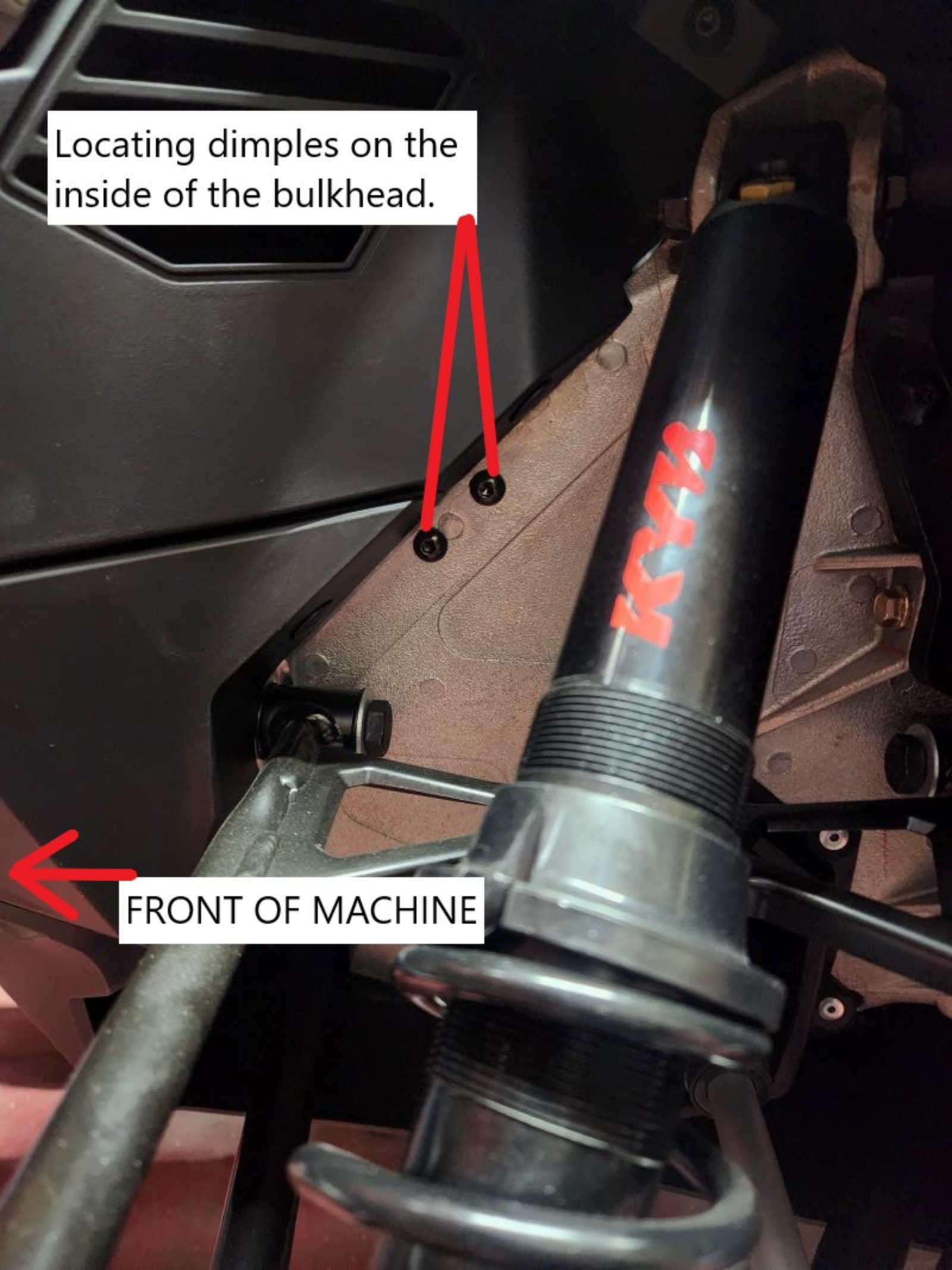
Drill Marked Holes

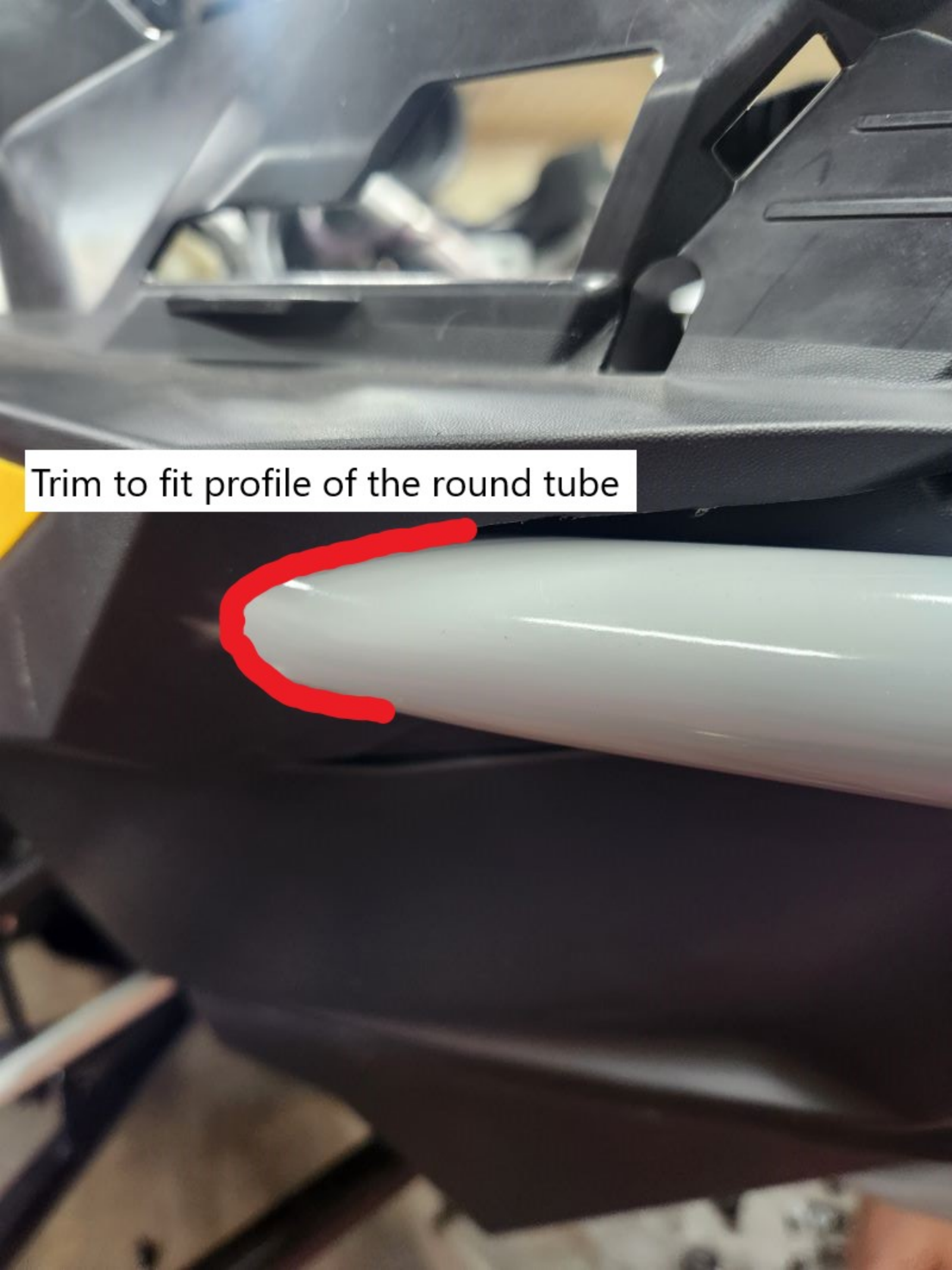


Locating dimples on the inside of the bulkhead.



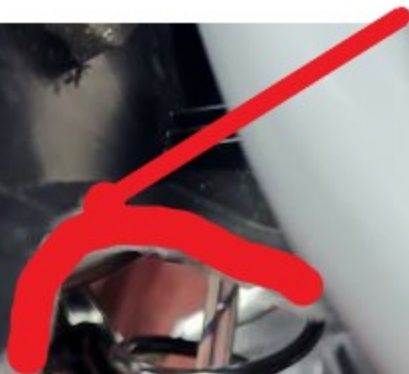
FRONT OF MACHINE





Trim to fit profile of the round tube

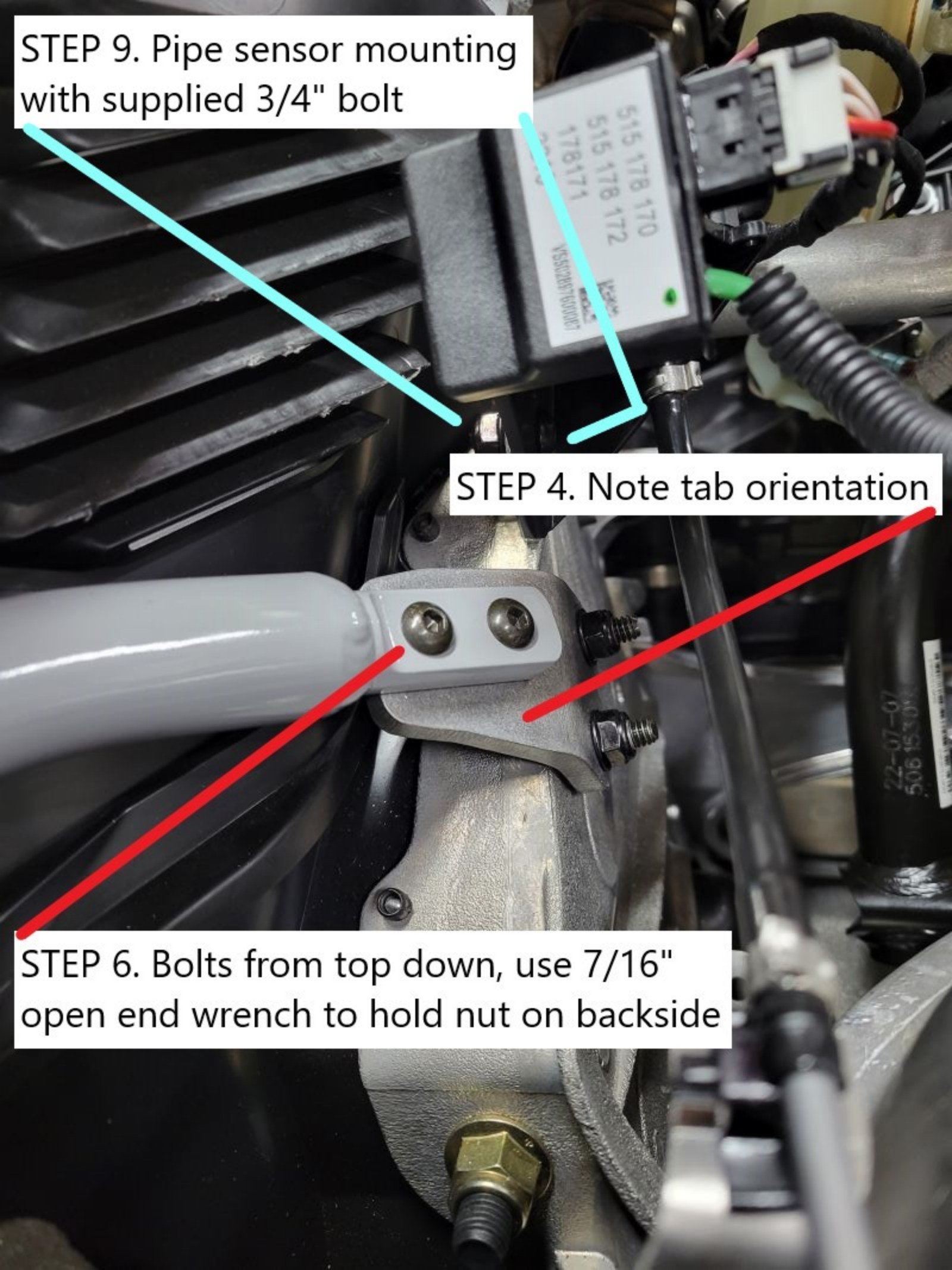
Trimming to fit round tube

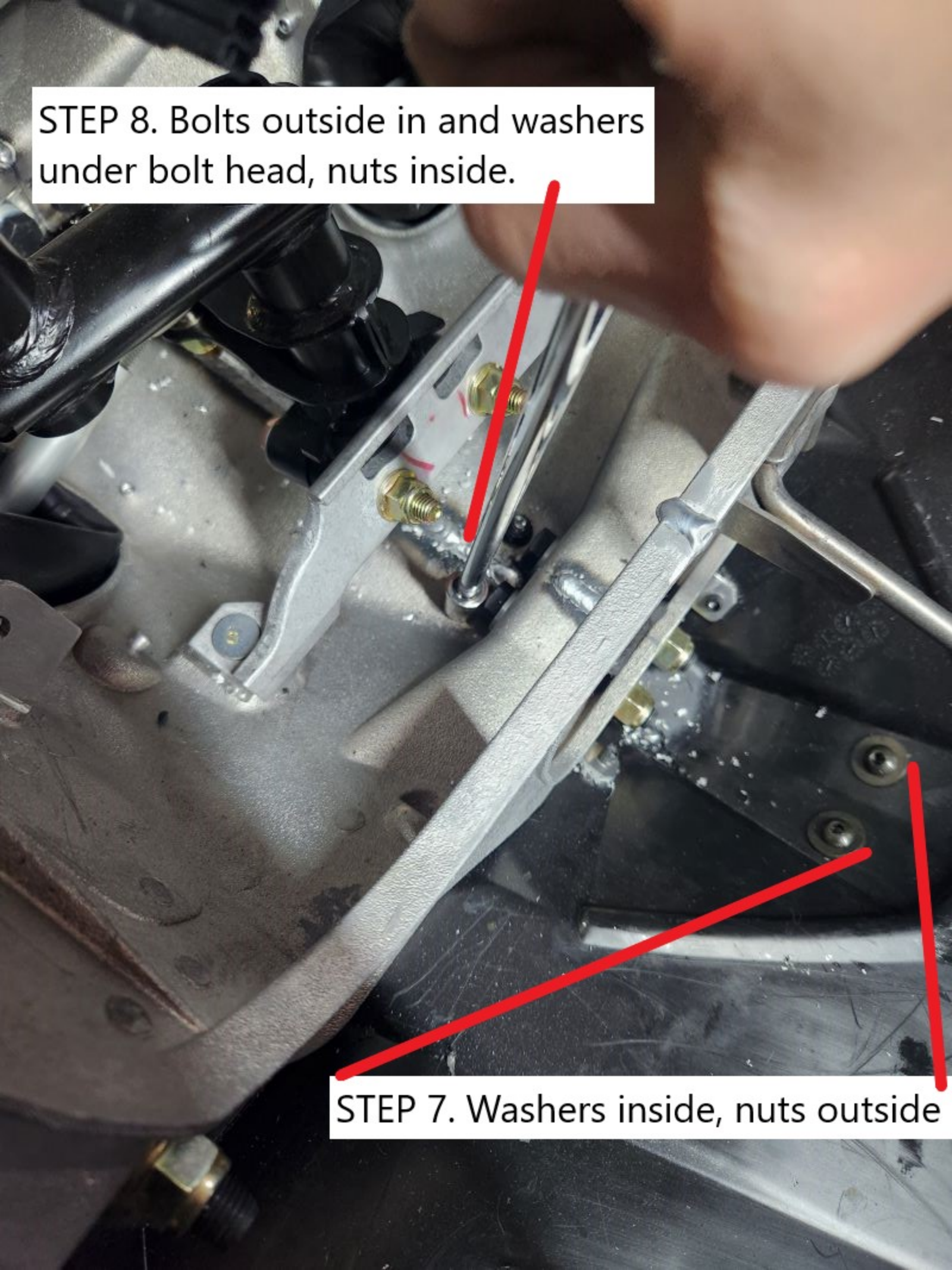


STEP 9. Pipe sensor mounting
with supplied 3/4" bolt

STEP 4. Note tab orientation

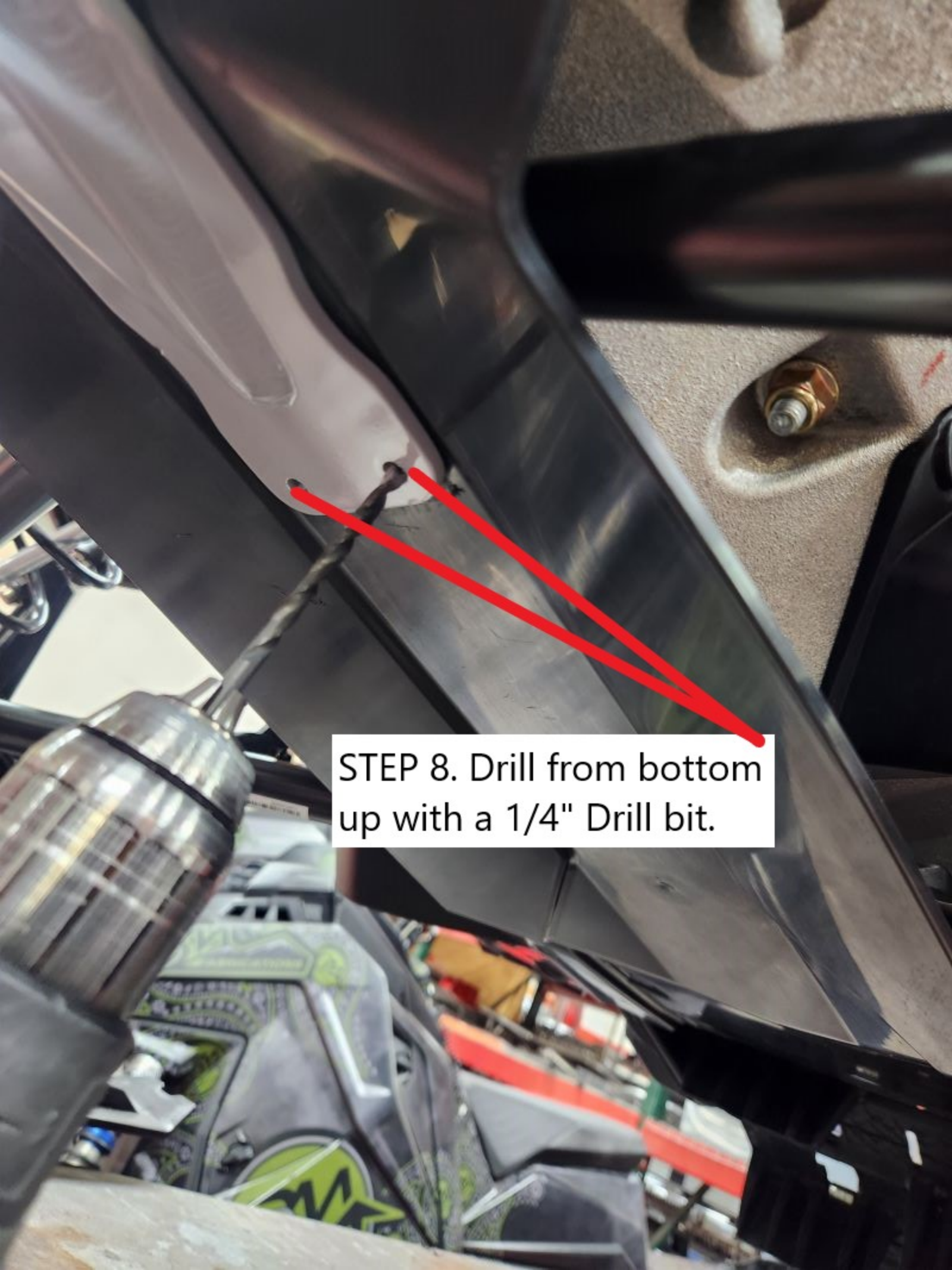
STEP 6. Bolts from top down, use 7/16"
open end wrench to hold nut on backside





STEP 8. Bolts outside in and washers under bolt head, nuts inside.

STEP 7. Washers inside, nuts outside



STEP 8. Drill from bottom up with a 1/4" Drill bit.





