



Thanks for your purchase of our 2017+ Ski Doo Gen 4 850 Front EXO Bumper.

Please read instructions and view pictures entirely before installation.

Here is what is included with the bumper:

- (6) 1/4-20 x 1" Flanged Bolt
- (10) 1/4-20 Flanged Nut
- (4) Large Head Rivets
- (4) 1/4-20 x 3/4" Truss Head Bolt
- (1) A-Arm Brace Mount
- (2) Aluminum Bulkhead Mounts (1/4" Thick)
- (1) Exhaust sensor plug mount

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.
2. Support front of sled so front lower a-arm bolts may be removed. Drill the two factory rivets out that attach the lower belly pan to the aluminum bracket on a-arms.
3. Remove the factory nuts from the front lower a-arm bolts. Slide bolts back so bracket may be removed. Re-install the supplied A-arm brace mount and re-use the factory nuts.
4. Locate the factory dimples in the bulkhead on each side (4 total) drill these to 1/4". Refer to pictures 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.
5. Slide your new bumper in through the belly pan. Use the (2) remaining 1" long bolts and bolt the upper bumper mount to the aluminum bulkhead mounts. Bumper will sit on top of the mounts. At this time install the provided sensor tab on the right side of upper bumper mount (shown in pictures). Do not tighten these bolts yet.

6. The bottom of the bumper will align with the a-arm brace you installed earlier. The LOWER holes need to be reamed out with a 1/4" drill bit. You will be able to visually see the holes line up through the existing factory rivet hole. Once drilled out, install the lower (2) 1/4-20 x 3/4" Truss head bolt from outside in with the flanged nuts on the inside. You can now run the drill bit through the belly pan in the remaining bumper holes. The drill bit will come through the inside through the a-arm brace mount. Install the remaining truss head bolts and nuts.

7. Now you may tighten all the bumper mounting bolts. Pay attention to the rotating on the sensor mount, keep it in alignment with the bumper itself. Don't go crazy, they are only a 1/4" bolt!

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

9. Reinstall the exhaust pipe and sensor mount on provided tab. Complete sled assembly and enjoy!

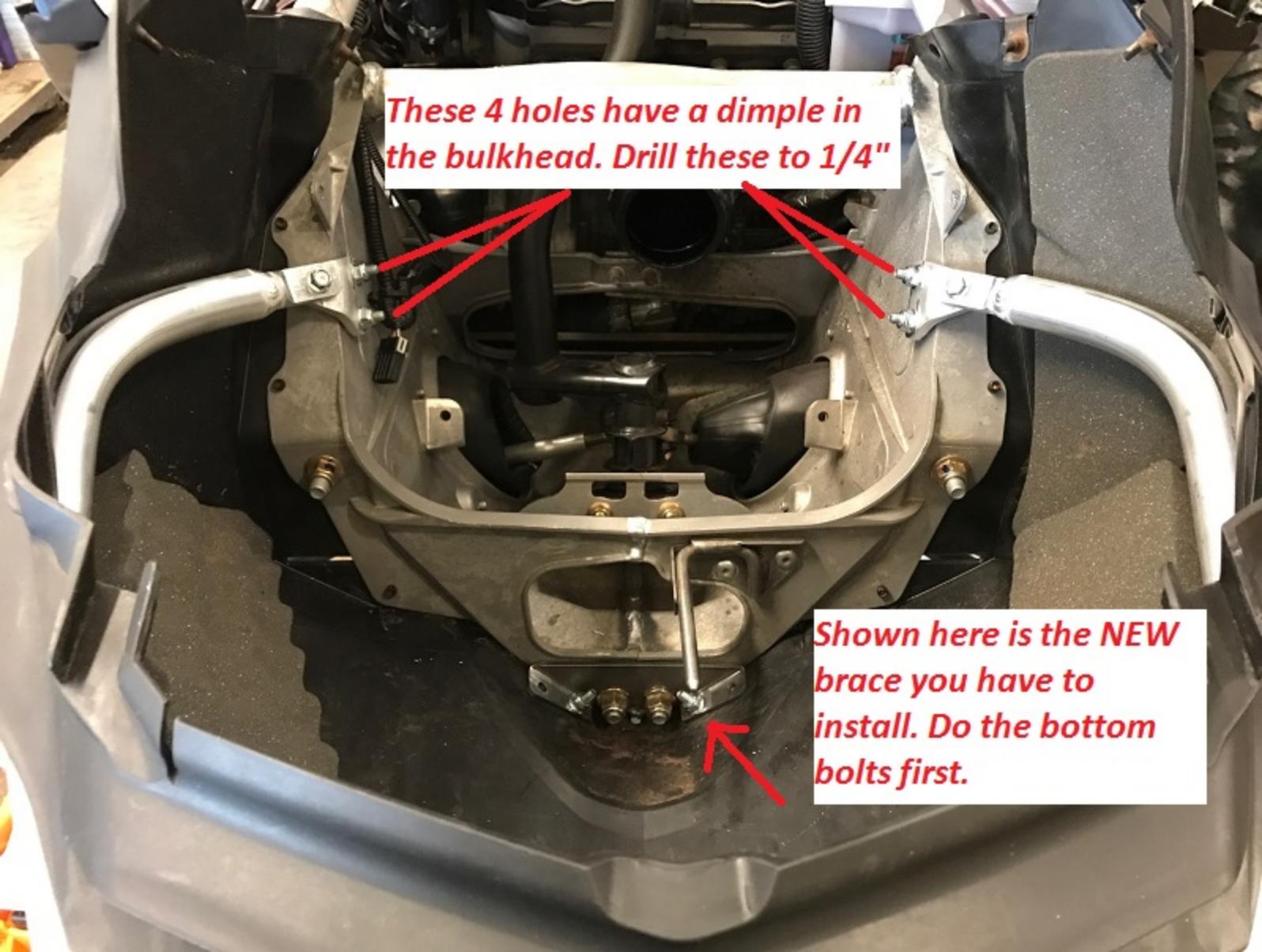
Any questions or concerns please call or email us!

B&M Fabrications

612-202-9245

info@bmfabrications.com

www.bmfabrications.com

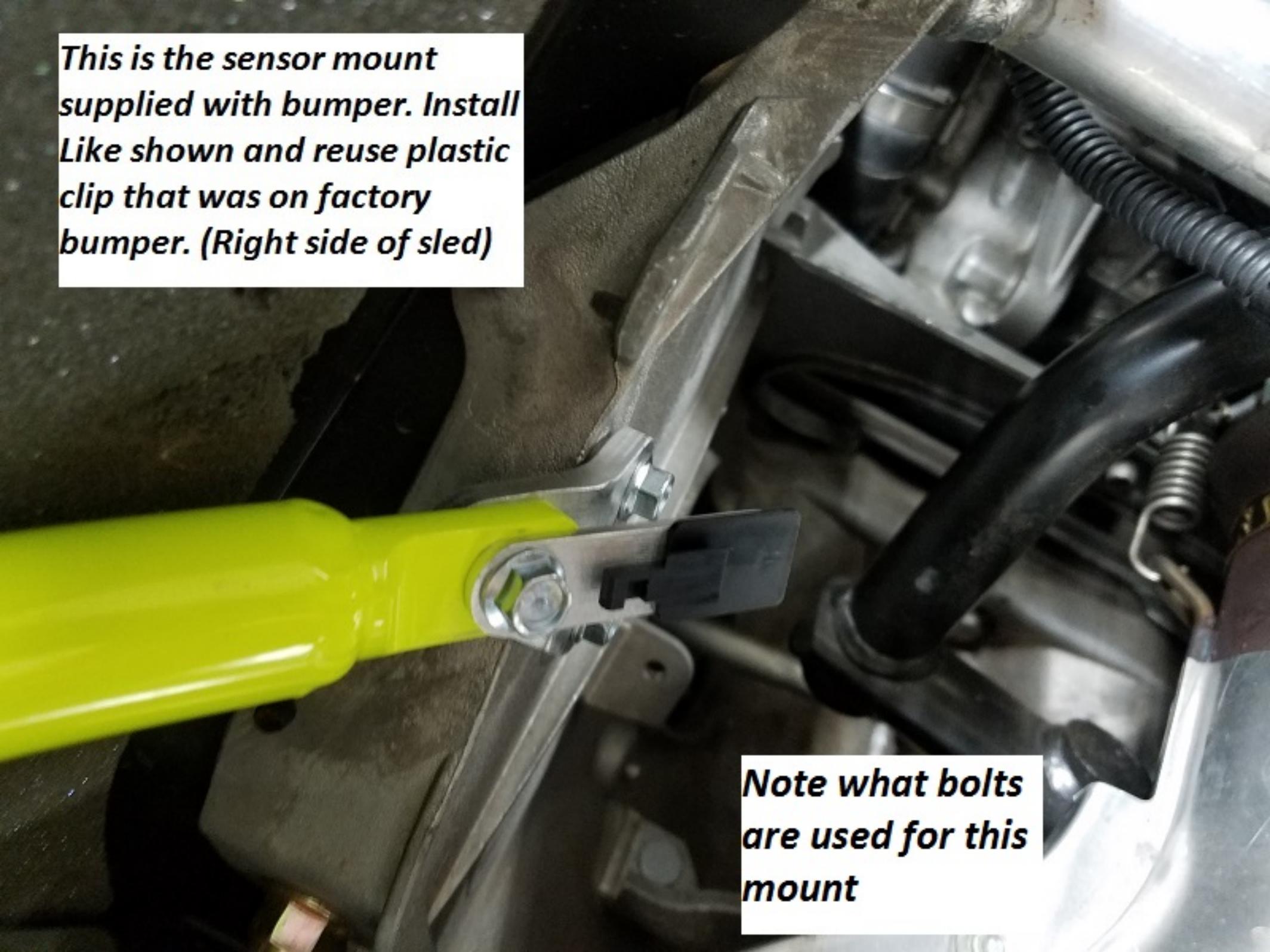


These 4 holes have a dimple in the bulkhead. Drill these to 1/4"

Shown here is the NEW brace you have to install. Do the bottom bolts first.

This is the sensor mount supplied with bumper. Install Like shown and reuse plastic clip that was on factory bumper. (Right side of sled)

Note what bolts are used for this mount



A close-up photograph of a motorcycle bumper assembly. The bumper is a bright yellow plastic component with two circular holes. Two black bolts are already installed in these holes. Two red arrows point to the bolts. The bumper is mounted to a dark grey metal frame. The background shows a wooden floor and a black plastic fairing with a green and black graphic.

Drill top hole in belly pan once lower bolt is in place.

This lower bolt is the same hole as the factory rivet. Line up the bumper with the NEW brace on inside and clearance the hole in belly pan to 1/4" then install the Truss head bolt and flanged nut. Do not tighten bumper bolts until all bolts are installed.

***What final
assembly should
look like***

