

Front Bumper Installation Instructions

P/N 210548: 2020+ Ford Transit BAJA Front Bumper

Before you begin:

- *Stainless steel hardware may bind together when tightening — apply an anti-seize assembly lubricant to the threads of each bolt before assembly (not grade 8 bolts)*
- *This installation requires two or more people*



Required Tools:

- Standard and metric wrench set
- Standard and metric socket set
- Flat head screwdriver
- Cut-off wheel
- Prybar
- Hammer

Included Hardware:

P/N	Description	Quantity
70036	Hex head bolt, 1/2"-13 x 1-1/2", grade 8	12
70035	Washer, 1/2" ID	24
70033	Nut, 1/2"-13 nylon-locking, grade 8	12
70029	Hex head bold, 3/8"-16 x 1-1/4", SS	8
70028	Washer, 3/8" ID, SS	16
70024	Nut, 3/8"-16 nylon-locking, SS	8
70011	Hex head bolt, 1/4"-20 x 3/4", SS	3
70009	Washer, 1/4" ID, SS	6
70008	Nut, 1/4"-20 nylon-locking, SS	3
70246	Antiseize bolt lubricant packet, 2g	1

Additional Parts:

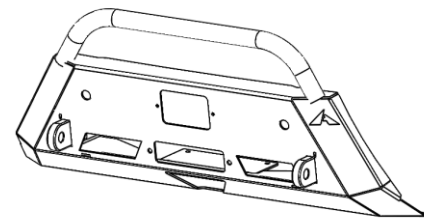
Description

Quantity

Picture

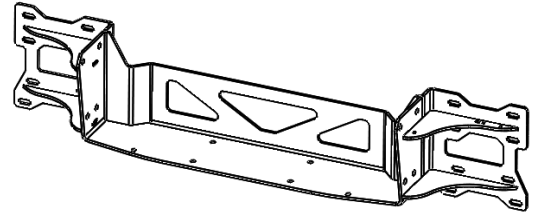
Aluminum BAJA Front Bumper

1



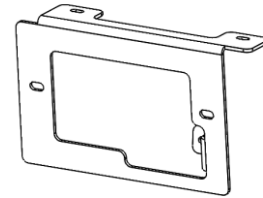
Winch Mounting Plate

1



Front Sensor Bracket

1



Stock Bumper Removal:

1. Open and secure the hood.
2. Remove the five (5) plastic rivets and four (4) 13mm bolts on the top of the grille (Figure 1).

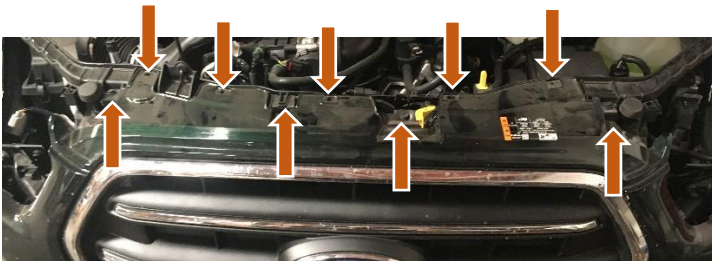


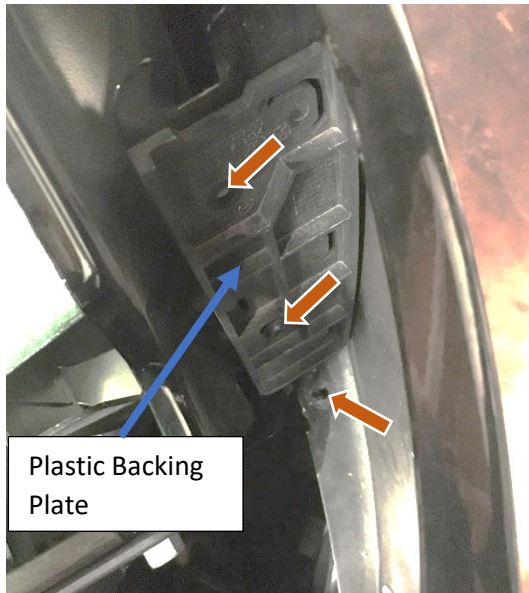
Figure 1: Plastic Rivets (Top) and Bolts (Bottom) to be Removed



Figure 2: Headlight Bolts

3. Remove the two (2) torx screws attaching each headlight. Once the bolts are removed, slide the headlight straight away from the vehicle, unclip wiring connectors, and remove the headlight (Figure 2).

4. Remove the two (2) torx bolts holding the front fascia to the vehicle sides and the one (1) 10mm screw holding the top of the factory bumper located in the back corner underneath the headlight (Figure 3). Remove the plastic backing plate (Figure 3).



Plastic Backing Plate

Figure 3: Hidden Bolts Underneath Headlights

- Remove the four (4) torx bolts inside the inner wheel well along the fender flare (Figure 4).

PRO TIP: Access to the bolts is made much easier by turning the vehicle's wheels.



Figure 4: Torx Bolts Along Inner Wheel Well

- Gently pull each fender flare away from the vehicle starting closest to the door. Once you reach the bumper, there are three (3) plastic catches that need to be released (Figure 5 & 6).



Figure 5: Fender Flare Removal



Figure 6: Fender Flare Plastic Clips Catches

- Pull the inner wheel well down and away from the bumper to gain access behind the plastic. Remove the 10mm bolt from inside the wheel well (Figure 7). NOTE: the two (2) torx bolts now visible on the bumper do not need to be removed.



Figure 7: Bolt Accessed from Inside of the Wheel Well

8. Remove the eight (8) 13mm bolts connecting the factory bumper to the under-carriage plastic (Figure 8).

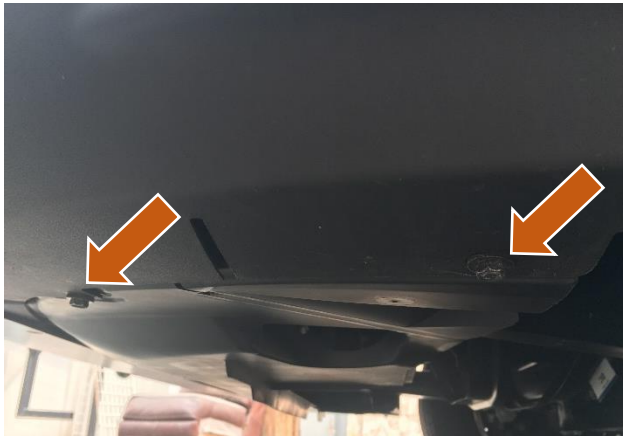


Figure 8: Bolts on Underside of Bumper

9. Remove the front license plate (if applicable). Remove the bolts or drill out the two or three (2-3) rivets attaching the license plate holder onto the factory bumper using a 1/4" drill bit.
10. Remove the now exposed bolt caps as applicable and remove the final two (2) 13mm bolts holding on the stock bumper (Figure 9).

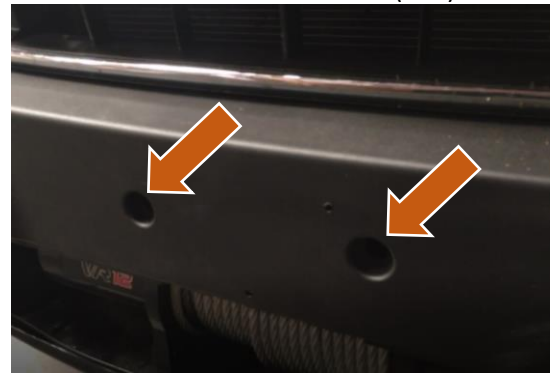


Figure 9: Front Bolts Underneath the License Plate Holder

11. Release the four (4) large plastic catches holding the grille onto the front of the vehicle (Figure 10 & 11). Note: it may be helpful to do in combination with the next step.



Figure 10: Locations of the Large Plastic Catches

NOTE: The middle two catches are underneath the top plastic cover of the grille as shown in Figure 10.

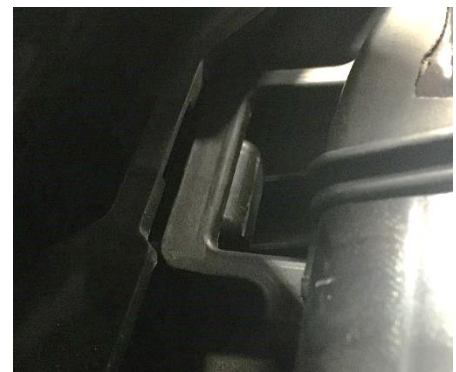


Figure 11: Close Up of Plastic Catch

12. Remove stock front bumper and grille by pulling directly away from vehicle, slowly working from the edges closest to the doors toward the center (Figure 12).



Figure 12: Factory Bumper Removal

13. Be sure to disconnect any sensors that are attached to the bumper during removal (Figure 13).



Figure 13: Sensor Being Disconnected

14. Remove all parking sensors from back of the plastic factory bumper (Figure 14).



Figure 14: Parking Sensors from Backside of Bumper

15. Remove the inner plastic radiator air deflectors (Figure 15 & 16) by removing all plastic push pins. Cut air deflectors to as shown (Figure 17).



Figure 15: Upper Push Pin Location

(Passenger Side Shown without Air Deflector)



Figure 16: Radiator Air Deflector with Cut Line Shown

16. Remove any and all sensors from the factory steel bumper:
 - a. Temperature sensor (Figure 17).



Figure 17: Temperature Sensor Removed

- b. Collision prevention / adaptive cruise control sensor – unclip from sensor and remove all clips from steel (Figure 18).

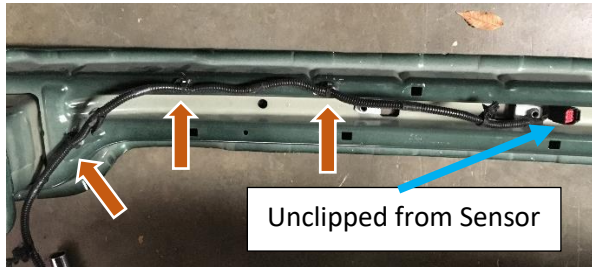


Figure 18: Front Radar Wiring Harness Removal

- c. Remove entire adaptive cruise control system from steel bumper (2X – 8 mm bolts and 1X – torx bolt) (Figure 19).



Figure 19: Front Radar and Bracket Uninstalled

17. Remove the plastic under-carriage by loosening the two (2) 10mm bolts and pull down (Figure 20).



Figure 20: Under-Carriage Bolt

18. Remove the eight (8) 13mm bolts from the backside of the steel bumper (Figure 21).

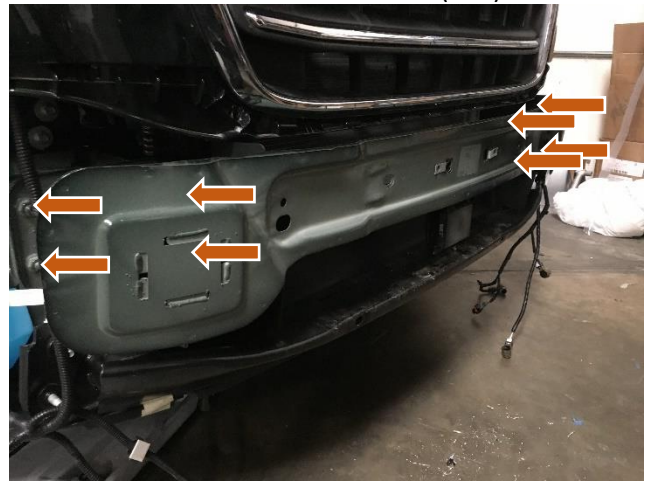


Figure 21: Factory Bumper Removal

19. Remove the 4 spot welds (2 per side) holding on the bumper to the frame (Figure 22). To remove, there are a couple of options:
- d. Drill out each spot weld
 - e. Gently pry the bumper away from the frame and use a Sawzall to cut weld
 - f. Use an angle grinder to grind the spot welds down enough to use prybar/hammer to remove.



Figure 22: Example of Spot Weld (Shown from the Back)

20. Remove eight (8) 13mm bolts to remove the lower factory scuff guard (black steel member; Figure 23).

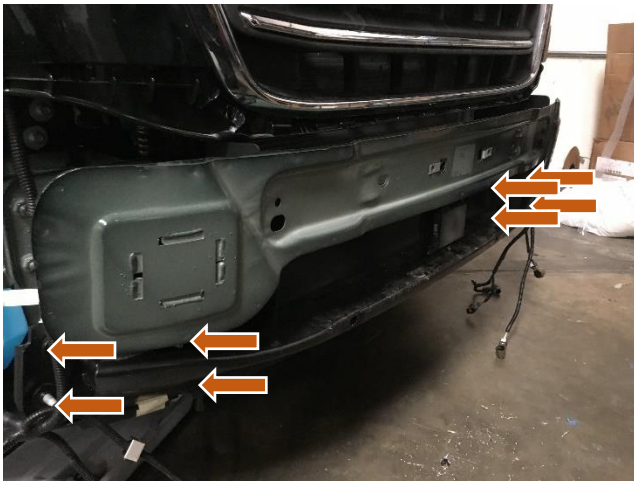


Figure 23: Lower Scuff Guard Removal

21. Separate any remaining wiring from the front of the frame and touch up any exposed metal surfaces with appropriate paint (Figure 24).

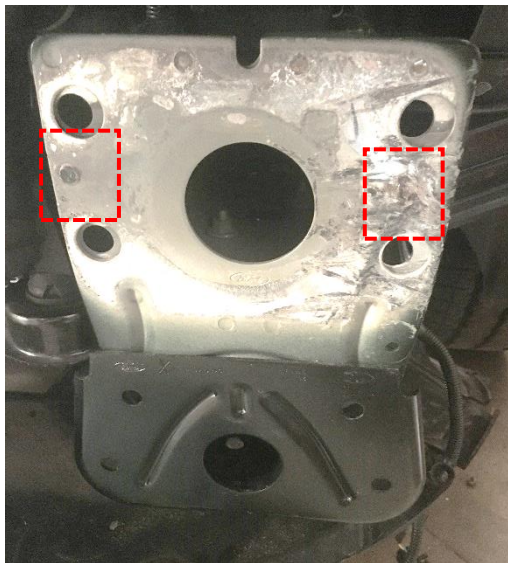


Figure 24: Exposed Metal from Bumper Removal

22. Cut the front radar bracket as shown in Figure 25 using a cut off wheel.

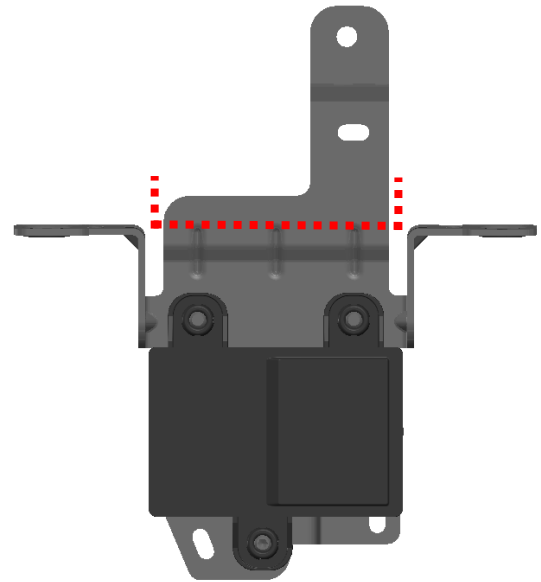


Figure 25: Cut Line for Front Radar Bracket

Front Bumper Installation:

23. Install the factory radar bracket onto the front sensor bracket using the provided 1/4"-20 hardware (Figure 26). Ensure the bottom bolt is pointed down to minimize the profile for the best fitment with a winch.

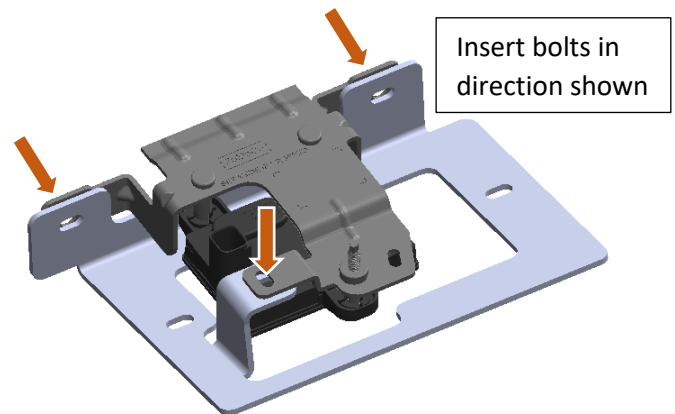


Figure 26: Front Radar Mounting to Aluminess Bracket

24. Install the now assembled radar sensor into the aluminum bumper behind the sensor window (Figure 27).

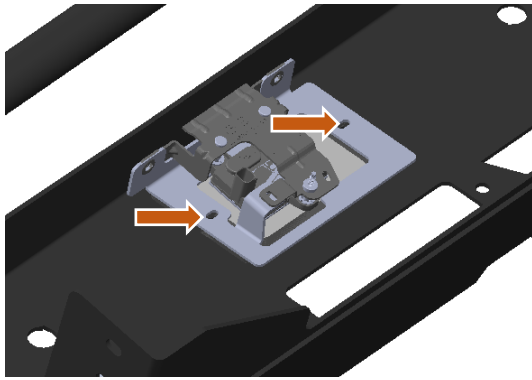


Figure 27: Radar Sensor Installed into Aluminum Bumper

25. Install the winch tray onto the frame using 1/2"-13 hardware through the top four (4) frame holes and 3/8"-16 bolts on the bottom four (4) scuff guard extension holes (Figure 28). Loosely install all 16 bolts through the frame/scuff guard and center the winch tray onto the vehicle before tightening. Once located, tighten the 1/2"-13 bolts to 80 ft-lbs and tighten the 3/8"-16 bolts to 20 ft-lbs.

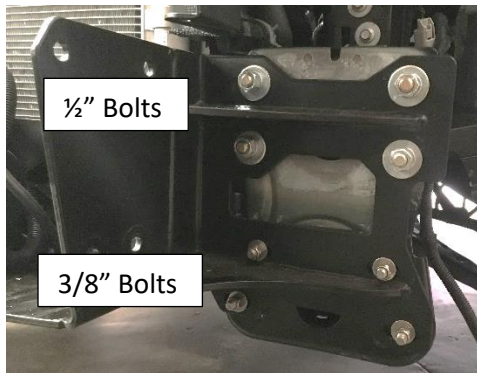


Figure 28: Winch Tray Installed onto Frame

26. Install winch onto winch tray per the manufacturer's instructions if desired (Figure 29).



Figure 29: Winch Installed onto Winch Plate

27. Install the plastic radiator air deflectors after being cut by reusing the top push pin (reference Figure 16 & 29).
28. If applicable, install the parking sensors into Aluminess front bumper using the Parking Sensor Upgrade Kit (P/N 210560) and by following the separately included instructions.
29. Using a cut off wheel, cut the plastic factory bumper to allow the aluminum bumper to be installed through the plastic bumper (Figure 30).

NOTE: Cut the bumper and test fit onto vehicle for desired fitment. If used in combination with a winch, cut a larger opening for access to clutch and controller connector.

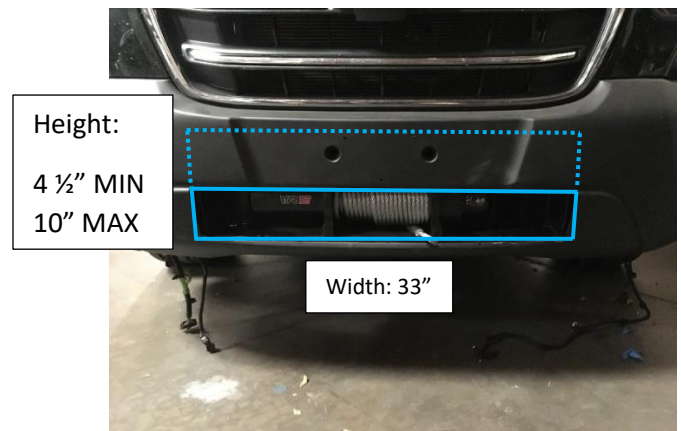


Figure 30: Cutting the Plastic Factory Bumper

30. Reinstall the factory plastic bumper and grille by following the disassembly instructions in reverse for all applicable steps.
31. Connect front radar sensor and two parking sensors to the aluminum bumper as applicable.

NOTE: In order for the parking sensor to reach, you may need to work upstream on the wiring harness to release any attachment point to get the sensors to reach the mounting location.

32. Install the aluminum bumper onto the winch plate and loosely fasten them together using the remaining 1/2"-13 hardware. Use the bottom two (2) holes on each side of the bumper and winch mount to bolt through (Figure 31).

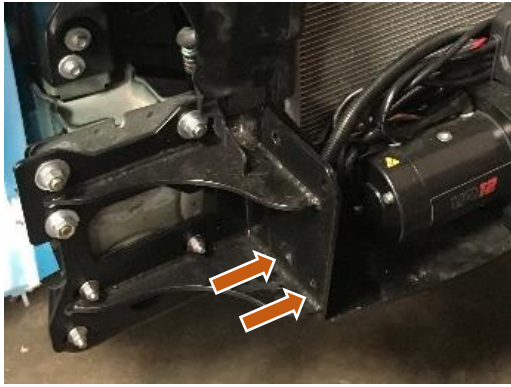


Figure 31: Aluminum Bumper Bolting Locations

(Factory Plastic Bumper not yet Installed)

33. With the factory bumper installed, access to the inner bolts can be tricky, but can be gained from behind the washer fluid bottle along the inside of the bumper (Figure 32).

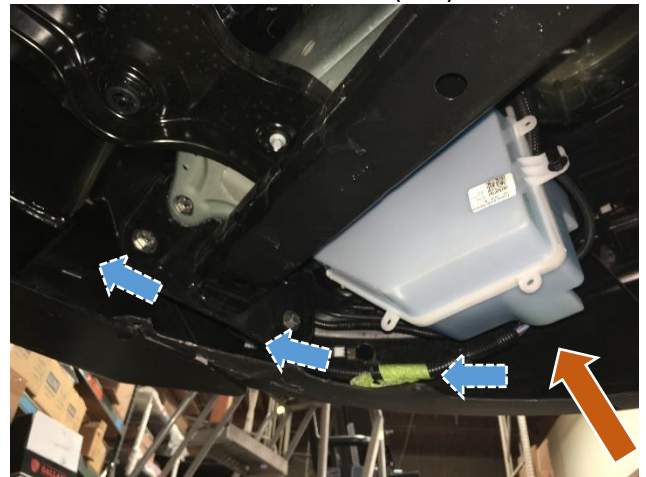


Figure 32: Access to Bolts from Behind Factory Bumper

34. Position bumper into desired location and tighten $\frac{1}{2}$ "-13 hardware to 80 ft-lbs.
35. Your bumper is now installed! Verify all sensors are working correctly and adjust as needed. Check all hardware after the first 100 miles and periodically thereafter.



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