



INSTALL INSTRUCTIONS

Evolution Front Bumper

Product : 617XEFXB, 623XEFXB

Application : 2017+ Ford Super Duty

I WARNING

Read the instructions completely before beginning installation. Before tightening bolts, drilling or cutting where required, check to make sure there are no obstructions such as brake, fuel or electrical lines which may be damaged. Also keep in mind this is an after-market product and MAY require minor shimming and/or trimming, reaming, etc. for proper fit. Road Armor is not responsible for any damages to vehicle.

❗ IMPORTANT NOTICE

- Be sure to inspect and test fit your product to ensure proper fitment before having it coated, painted, bed lined, etc.
- Road Armor will not be responsible for the cost of coating your unit if any problems with fit or finish are not

SAFETY FIRST!

- FOLLOW ALL INSTRUCTIONS, YOUR SAFETY AND THE SAFETY OF OTHERS IS MOST IMPORTANT.
- WEAR APPROPRIATE EYE PROTECTION AND EXERCISE CAUTION WHEN DRILLING / CUTTING

REQUIRED TOOLS

SAE & METRIC Socket set and wrenches

Screw drivers, pry tool, pick tool, pliers

RECOMMENDED TOOLS

Adjustable Table Cart / Table/Pallet Lift or Hoist

Impact driver

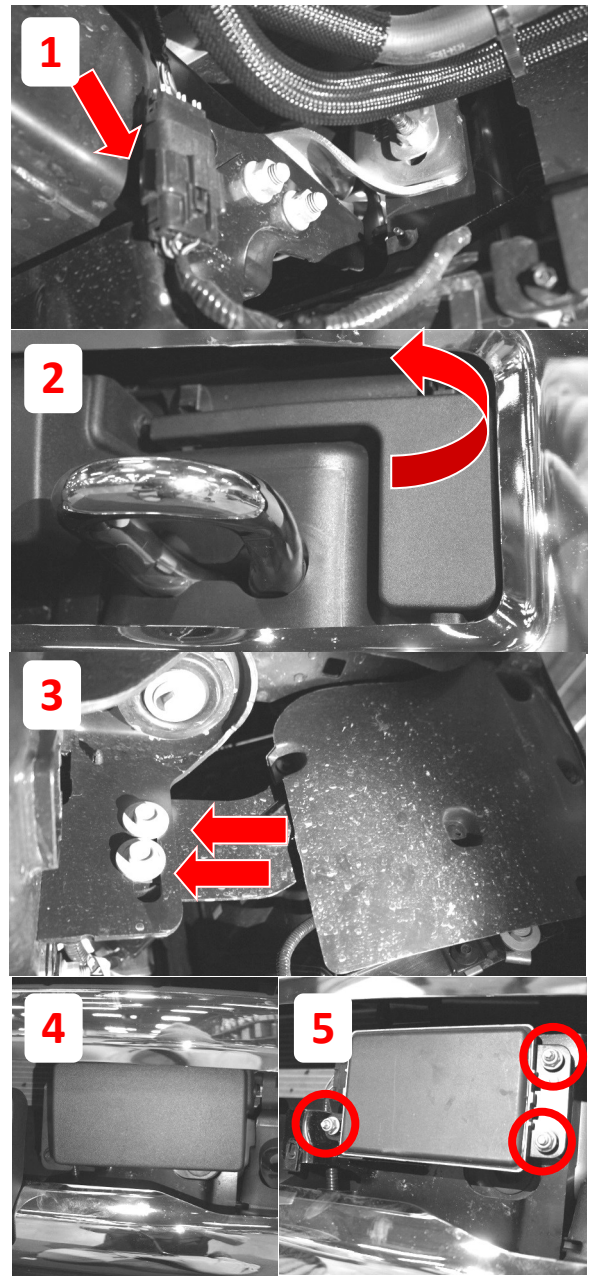
INCLUDED HARDWARE

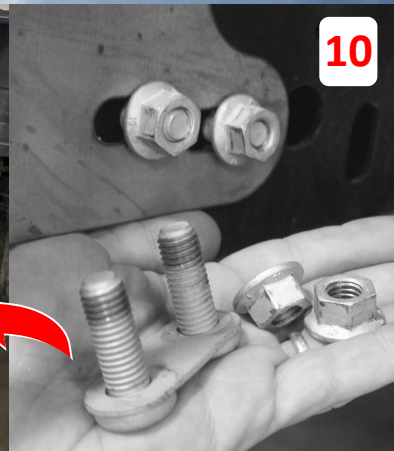
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|--|-------------------------------|
| 2 1/2" Bolt 15/16" O.D. Zinc Pushnut Bolt Retainer | 8 Regular FW 0.25 |
| 8 1.5" Single Bolt Tab (ZINC) | 22 SBHCSCREW 0.19-24x0.5-HX-N |
| 4 1/4"-20 Zinc Finish Grade A Finished Hex Nut | 4 SBHCSCREW 0.25-20x0.75-HX-N |
| 8 1/2"-13 x 1-3/4" Grade 8 Yellow Zinc Finish Hex Cap Screw | 2 Road Armor 8" Accent Light |
| 24 1/2" x 1.375" OD Thru-Hardened Yellow Zinc Finish Steel USS General Purpose Flat Washer | |
| 16 1/2" Yellow Zinc Finish High Alloy Medium Split Lock Washer | |
| 16 1/2"-13 Yellow Zinc Finish Grade 8 Finished Hex Nut | |
| 4 #10-24 Zinc Finish Steel with External Tooth Lockwasher K-Lock Nut | |
| 3 5/16"-18 x 3/4" ASTM F593 18-8 Stainless Steel Hex Cap Screw | |



****NOTE: 2020-2022 Super Duty with Adaptive Cruise will Require 620ACM Adapter Kit (Sold Separately)****

- 1 Disconnect bumper harness & block warmer (if equipped) . These plugs are located behind the bumper near the frame on the Passenger side.
 - 2 Remove plastic trim around tow hooks to reveal bolts on both Driver and Passenger sides.
 - 3 Remove inner bumper support bolts. This is a truss like support bracket located near the first body mount behind the bumper.
 - 4 Remove plastic cover over adaptive cruise control module (if equipped)
 - 5 Unbolt, unplug and carefully set aside the Adaptive Cruise Control Module (if equipped).
- *620ACM Adapter Not Provided for 2020-2022 Super Duty's***
- 6 Remove 4 bolts each side of tow hooks and pull off factory bumper.
 - 7 Remove tow hooks both sides
 - 8 Remove under-run guards and set aside hardware for later use. These double bolt plates and nuts will be used to attach the Road Armor brackets.





9 Install brackets over frame as shown

10 Re-install factory double bolt plates through frame and bracket

11 Install the half inch bolts using washers on both sides then lock washer and nut. Do not fully tighten.

12 Install one of the single bolt tabs through top inside bumper slot and affix using supplied retainer clips. These are installed by pushing on with a deep socket while holding the back.

Install ACM if equipped. Install wiring harness (2023+ SD Install Sensors).

13 Install winch and accent lights

14 Fit up the bumper, carefully aligning retained bolts with corresponding bracket slots. For fully guarded units tape off areas where tube may make contact with the vehicle.

