



INSTALL INSTRUCTIONS

Evolution Rear Bumper

Product : 617ER0X

Application : 2017-22 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

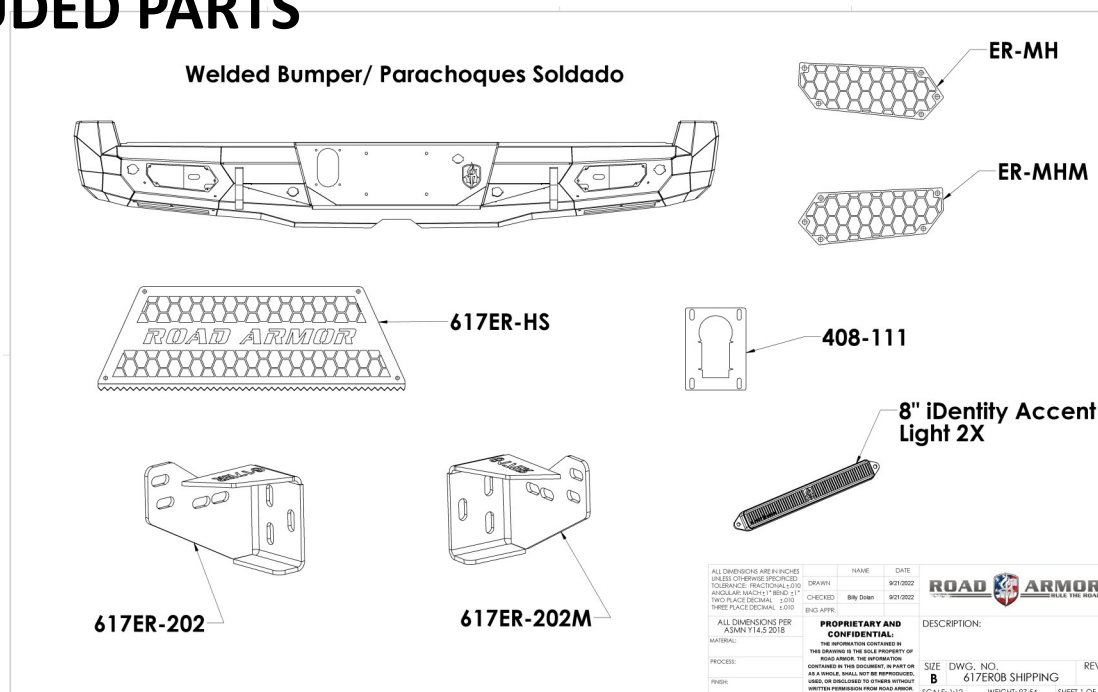
Screw drivers, pry tool, pick tool, pliers

RECOMMENDED TOOLS

Adjustable Table Cart / Table/Pallet Lift or Hoist

Impact driver

INCLUDED PARTS



INCLUDED HARDWARE

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	37407	# 10-24 Zinc Finish Steel with External Tooth Lockwasher K-Lock Nut	12
2	73735	# 10-24 x 1" ASTM F879 Hex Drive 18-8 Stainless Steel Button Socket Cap Screw	4
3	94030	# 10-24 x 1/2" ASTM F835 Hex Drive Zinc Finish Alloy Steel Button Socket Cap Screw	18
4	1.09 inch plug	1 1/16" Dome plug	4
5	11218-05078	1.5" Single Bolt Tab (ZINC)	6
6	33895	1/2" Yellow Zinc Finish High Alloy Medium Split Lock Washer	6
7	33861	1/2" x 1.375" OD Thru-Hardened Yellow Zinc Finish Steel USS General Purpose Flat Washer	6
8	36410	1/2"-13 Yellow Zinc Finish Grade 8 Finished Hex Nut	6
9	33078	1/4" x 0.625" OD Low Carbon Zinc Finish Steel SAE General Purpose Flat Washer	8
10	1137410	1/4"-20 Zinc Finish Steel with External Tooth Lockwasher K-Lock Nut	4
11	11003	1/4"-20 x 3/4" ASTM A307 Grade A Zinc Finish Hex Bolt	4

ALL DIMENSIONS ARE IN INCHES
UNLESS OTHERWISE SPECIFIED
TOLERANCE: FRACTIONAL: ±0.010
DECIMAL: ±0.005
THREE PLACE DECIMAL: ±0.010

DATE: 9/21/2022
NAME: Billy Dolan
DRAWN: ENG APPR:

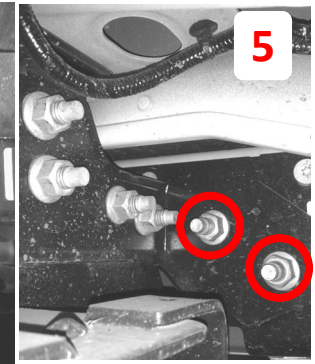
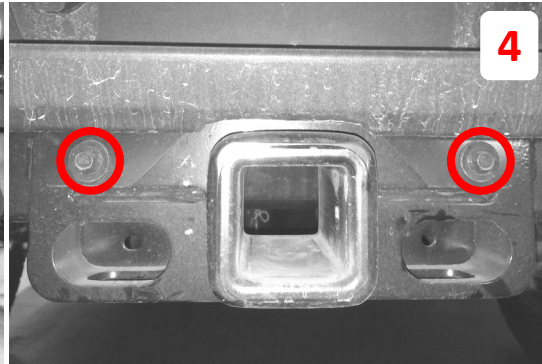
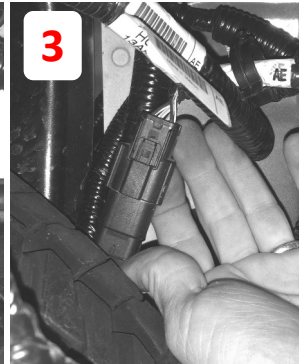
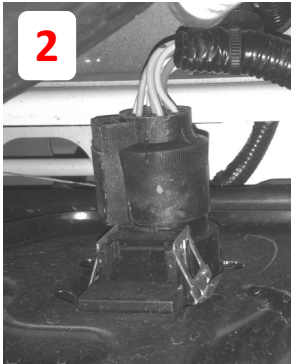
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DESCRIPTION:

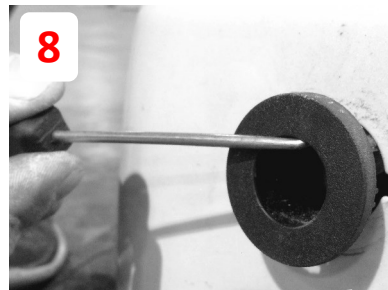
SIZE: **B** DWG. NO. **617ER-BOLTKIT** REV

SCALE: 1:8 WEIGHT: 0.35 SHEET 1 OF 1

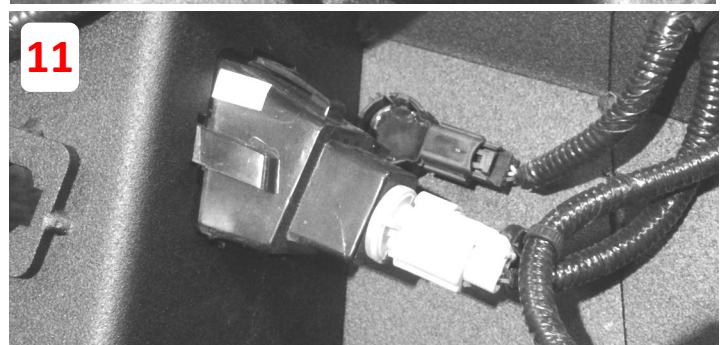
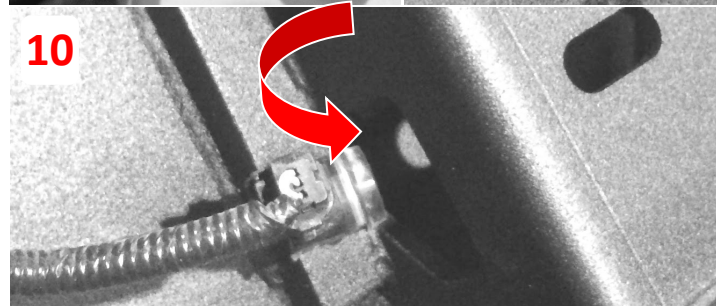
- 1** Park the vehicle on a flat, level surface if possible.
- 2** Disconnect the trailer plug from the inside of the bumper.
- 3** Disconnect the bumper harness plug, located above the spare tire. (This one is a little hard to find)



- 4** Remove the two bolts on either side of the receiver hitch.
- 5** Remove the two nuts as indicated on both the driver and passenger sides from the inside of the bumper brackets. Remove Bumper.



- 6** Free up the wiring harness by removing all of the clips.
- 7** Disconnect the wiring harness from the license plate lights and remove the lights.
- 8** Use a right angled pick tool to carefully pry the sensor housing from the stock bumper.
- 9** Reinstall the sensor grommets into your new Road Armor bumper in the order they were removed.
- 10** Feed the wiring harness through the weld in bracket and begin to install the sensors into their corresponding housing. (Take care not to do this step backwards)



- 11** Install license plate lights into your new Road Armor bumper. (Note the installed sensor behind)
- 12** Install the trailer plug retainer plate into the inside of the Road Armor bumper as shown with trailer plug attached. If Large Plug is equipped, put plate on the outside of the bumper. Use the included #10 stainless hardware.
- 13** Transfer the spare tire access lock from your stock bumper to the Road Armor bumper.
- 14** Install the Road Armor Step Plate before fitting bumper to truck. (This is much more difficult to do after the bumper has been installed).
- 15** Install all single bolt tab per side using included retainer clips by pushing on with a deep socket while holding the back. Note: Install Lights after bolt tabs to make easier.
- 16** Install the brackets on the outside of the frame and fit up the bumper.



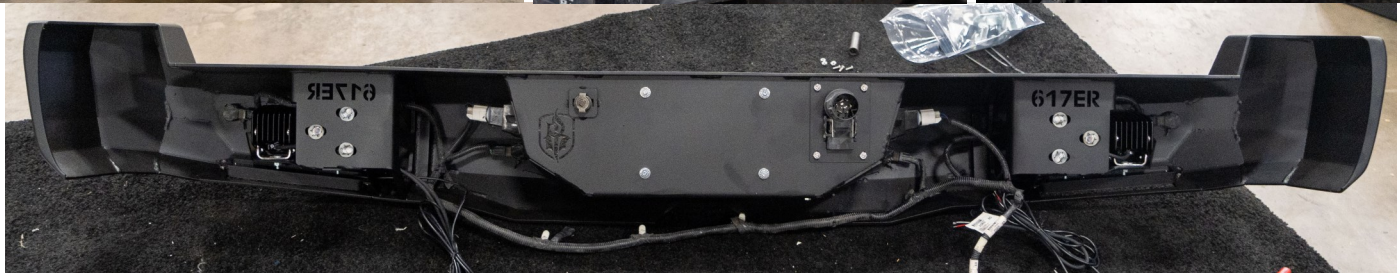
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16



15



- 17** Adjust Bumper fitment to desired position and tighten all nuts.

Note Mesh for the end pods can be installed before or after the bumper is on the truck.

Finished!

