



# INSTALL INSTRUCTIONS

## Stealth Front Bumper

Product : 617FXX, 6232FXX

Application : 2017-2022 Ford Super Duty,  
2023+ 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

## INCLUDED HARDWARE

- 8 1.5" SINGLE BOLT TAB (ZINC)
- 8 1/2" Grade8 Bolts
- 24 1/2" Flat Washer
- 16 1/2" Split Lock Washer
- 16 1/2"-13 Grade 8 Hex Nut
- 2 Retainer Clips
- 1 Winch Kit
- 1 Logo Kit
- 2 Brackets

**\*\*NOTE: 2020-2022 Super Duty with Adaptive Cruise will Require 618ACM & 620ACM Adapter**

## RECOMMENDED TOOLS

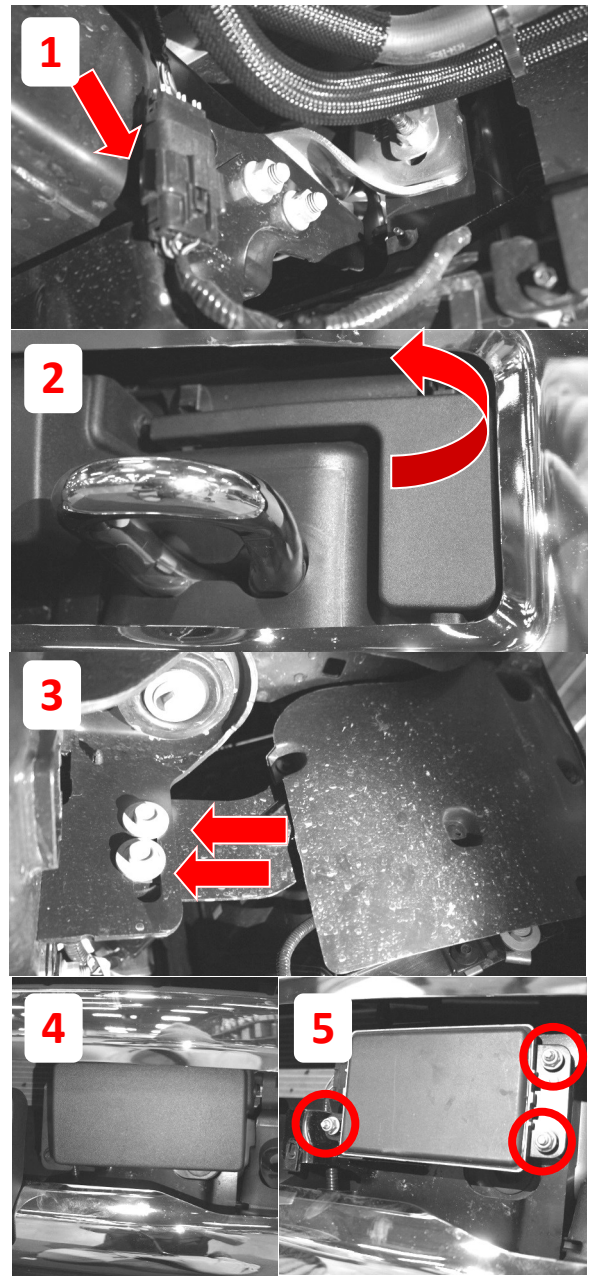
Adjustable Table Cart / Table/Pallet Lift or Hoist

Impact driver

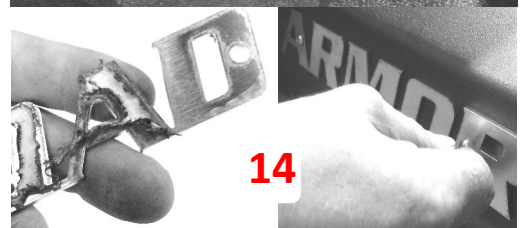
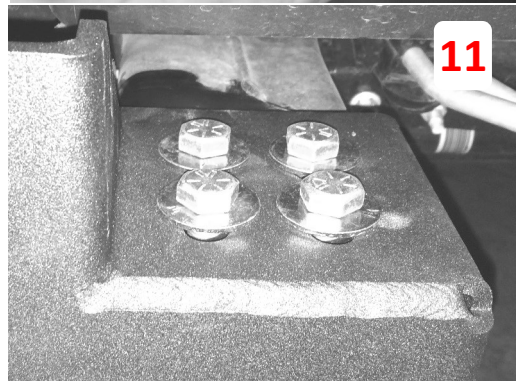
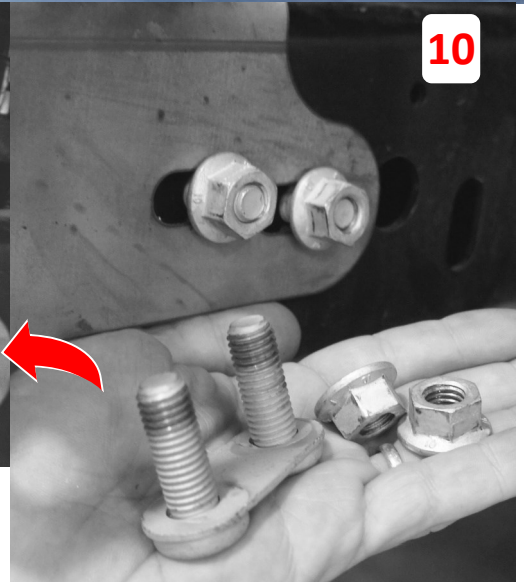
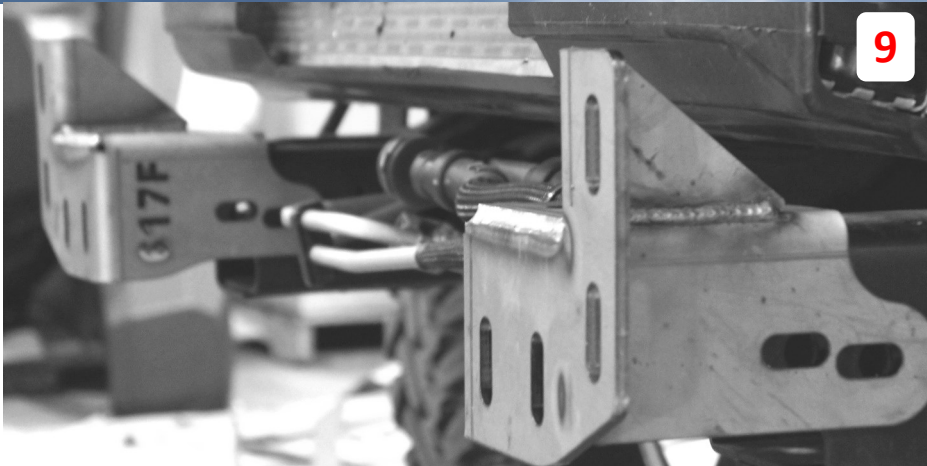




- 1 Disconnect bumper harness & block warmer (if equipped) . These plugs are located behind the bumper near the frame on the Passenger side.
- 2 Remove plastic trim around tow hooks to reveal bolts on both Driver and Passenger sides.
- 3 Remove inner bumper support bolts. This is a truss like support 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). This module can be disabled or at your option you may purchase from Road Armor part# 618-ACM to accommodate the module and firmly affix it to the Road Armor bumper.  
**\*620ACM Required 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.
- 13** Fit up the bumper, carefully aligning retained bolts with corresponding bracket slots. Adjust Fitment to liking and Tighten all Nuts and Bolts. 90 ft-lbs Torque.
- 14** Peel off protective layer from brushed stainless logo letters then proudly install using supplied #10 stainless hard ware.







**Finished!**

