

INSTALL INSTRUCTIONS

Stealth Rear Bumper

Product : 617RRX, 6232R0X

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 noted and addressed beforehand.

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

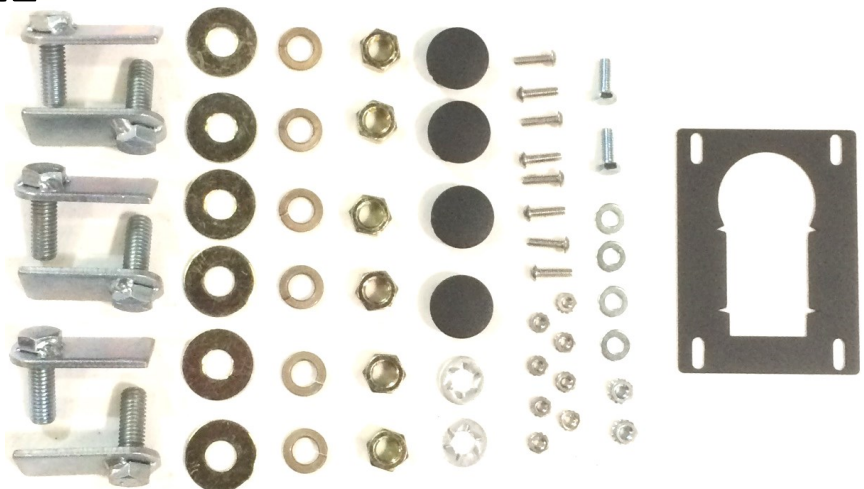
RECOMMENDED TOOLS

Adjustable Table Cart / Table/Pallet Lift or Hoist

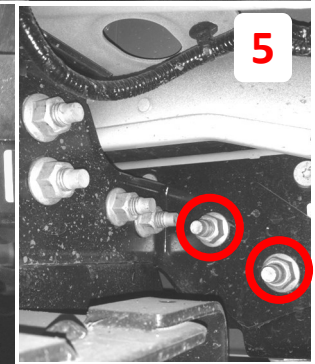
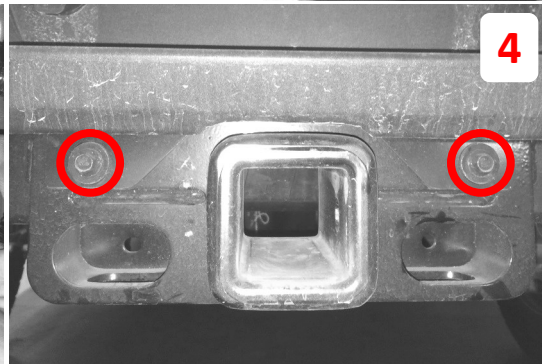
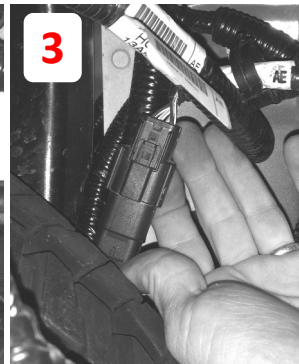
Impact driver

INCLUDED HARDWARE

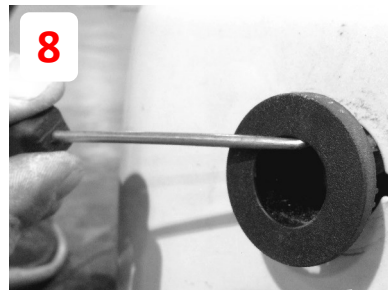
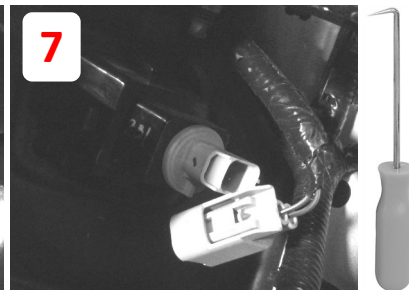
- 6 1.5" SINGLE BOLT TAB (ZINC)
- 6 1/2" Flat Washer
- 6 1/2" Split Lock Washer
- 6 1/2"-13 Grade 8 Hex Nut
- 2 Retainer Clips
- 4 Plastic Dome Plug
- 1 Winch Kit
- 1 Logo Kit
- 2 Brackets
- 1 Trailer Plug Adapter Plate



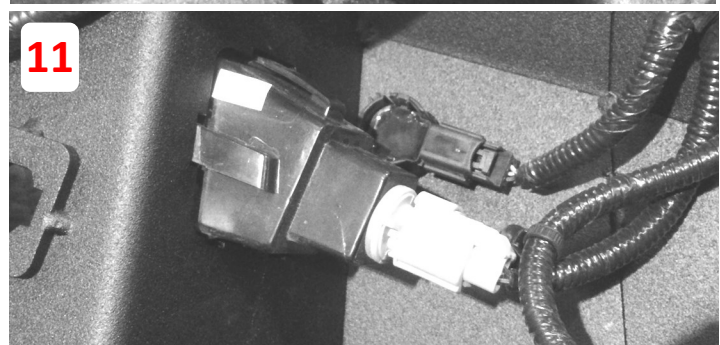
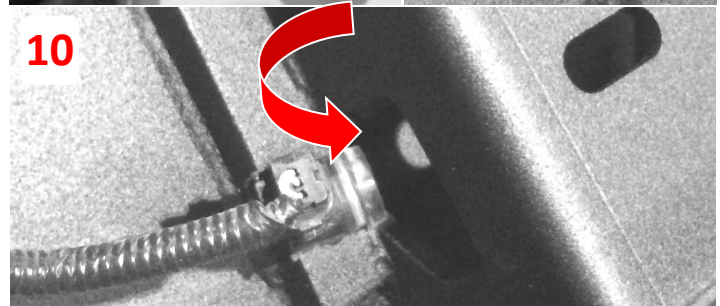
- 1** Park the vehicle on a flat, level surface if possible.
- 2** Disconnect the trailer plug from the inside of the bumper.
- 3** Disconnect the bumper harness plug, located above the spare tire. (This one is a little hard to find)



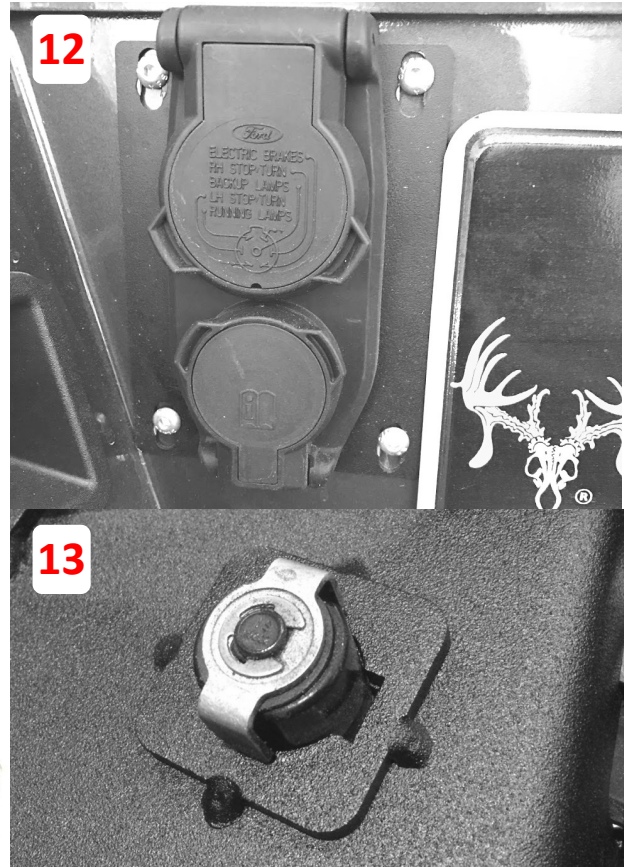
- 4** Remove the two bolts on either side of the receiver hitch.
- 5** Remove the two nuts as indicated on both the driver and passenger sides from the inside of the bumper brackets.



- 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 grommet 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)

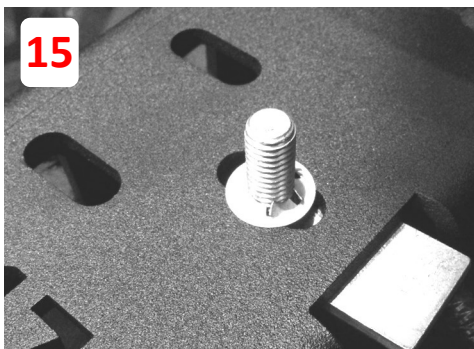


- 11** Install the license plate lights into your new Road Armor bumper. (Note the installed sensor behind)
- 12** Install the trailer plug retainer plate into the outside of the Road Armor bumper as shown with trailer plug attached. Use the included #10 stainless hardware.
- 13** Use your key to transfer the spare tire access lock from your stock bumper to the Road Armor bumper.
- 14** Install the Road Armor logo before fitting bumper to truck. (This is much more difficult to do after the bumper has been installed).



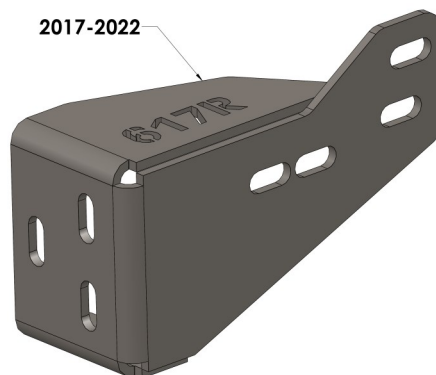
ROAD ARMOR

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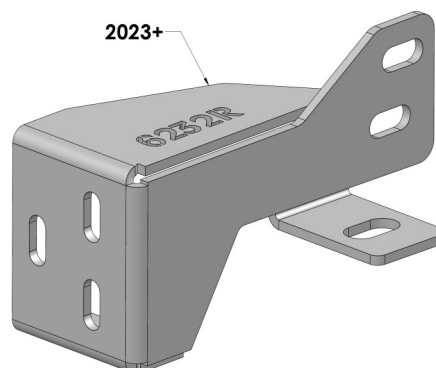


- 15** Install one single bolt tab per side using included retainer clip by pushing on with a deep socket while holding the back.
- 16** Install the brackets on the outside of the frame and fit up the bumper.

2017-2022



2023+



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|---|---|---|
| ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED TOLERANCES: FINISHED SURFACES ±.015" HOLE LOCATIONS ±.015" HOLE DIAMETERS ±.015" HOLE SPACING ±.015" HOLE DEPTH ±.015" HOLE RADIUS ±.015" HOLE CHAMFER ±.015" | NAME: [blank] DATE: 10/23/2023 DRAWN: [blank] CHECKED: [blank] DATE: 10/23/2023 | DESCRIPTION: Driver Side Frame Mounting Bracket |
| PROPRIETARY AND CONFIDENTIAL THIS DRAWING IS THE PROPERTY OF ROAD ARMOR. THE INFORMATION CONTAINED HEREIN IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION FROM ROAD ARMOR. | SIZE: DWG. NO. 6232R-202_A SCALE: 1:4 WEIGHT: 6.022121 | REV: [blank] |
| MATERIAL: 1/4" INCH SHEET METAL FINISH: RAW STEEL | | |

