



FORD 2021-23 BRONCO FRONT TUBULAR BUMPER

Thank you for choosing Rough Country for all of your accessory needs.

Rough Country recommends that a certified technician install this system. In addition to these instructions, professional knowledge of disassemble/reassembly procedures as well as post installation checks must be known. Attempts to install this system without this knowledge and expertise may jeopardize the integrity and/or operating safety of the vehicle. Please read all the instructions before beginning the installation.

Check the kit hardware against the "Kit Contents" list. If question exist, please call us @1-800-222-7023. We will be happy to answer any questions concerning this product. Check all fasteners for proper torque. Check to ensure for adequate clearance between all components. **Periodically check all hardware for tightness.**

Be sure you have all the needed parts and understand where they go. Also, please review the "Tools Needed" list to be certain you have the necessary tools to complete the installation.

TOOLS NEEDED:

- Jack
- Safety Stands
- Wheel Chocks
- Wire Cutters
- Wire Crimpers
- Small Pry Tool
- T-35 Torx Driver
- Pliers
- Metric Wrench/Socket**
- 10mm
- 13mm
- 14mm
- 15mm
- 18mm

KIT CONTENTS:

- Bumper
- Light Mount Hoop
- Wire Tie - 10
- Foam Washer - 6
- Sensor Hole Plug - 6
- Sensor Retaining Cap - 6
- Foam Plug - 6
- Sensor Wire Extension - 2
- License Plate Plug - 2
- License Plate Bracket
- ACC Mounting Bracket
- ACC Plastic Cover
- 2" Cube Light - 4
- Winch Plate (51205 only)

HARDWARE INCLUDED:

- 12mm Single Flag Stud - 2
- 12mm Double Flag Stud - 2
- 12mm Lock Washer - 6
- 12mm Hex Nuts - 6
- 12mm Flat Washer - 6
- 10mm Flat Washer - 4
- 10mm Lock Washer - 2
- 10mm Hex Nut - 2
- 10mm x 110mm Bolt - 2
- 8mm x 25mm Button Head Bolt - 4
- 8mm Lock Washer - 6
- 8mm Flat Washer - 16
- 8mm Lock Nut - 2
- 8mm Hex Nut - 6
- 8mm x25mm Bolt -4
- 6mm x 20mm Combo Bolt - 2
- 4mm Self Tapping Screw -12
- 12mm Plastic Bolt Retainer-6
- 6mm Flat Washer -10
- 6mmx25mm Button head bolt-7
- 6mm Hex Nut-7
- 6mm Lock Washer-7

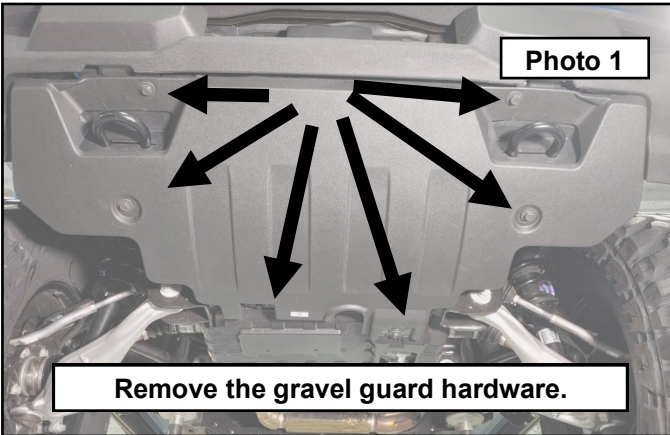
**OPTIONAL WINCH MOUNT
HARDWARE INCLUDED in
51205BOX1**

- 12MM Lock Washer-2
- 12mm x 50mm Hex Bolt-2
- 12mm Flat Washer-2
- 10mm x35mm Hex Bolt-2
- 10mm Lock Nut-2
- 10mm Large OD Flat Washer-4

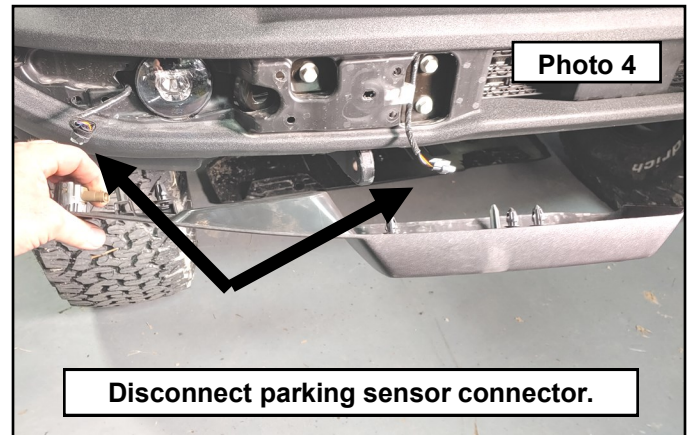
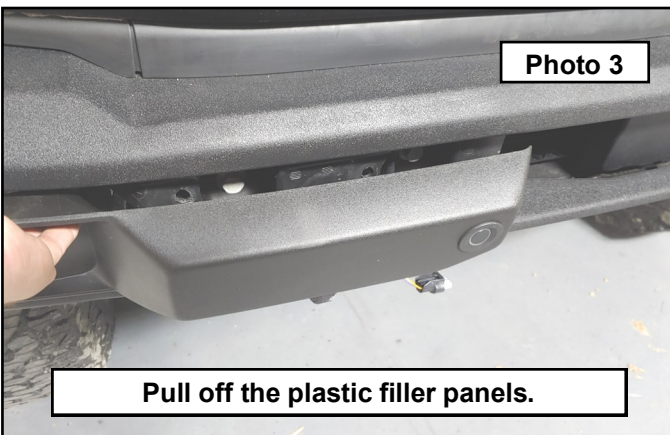


Front Bumper Installation:

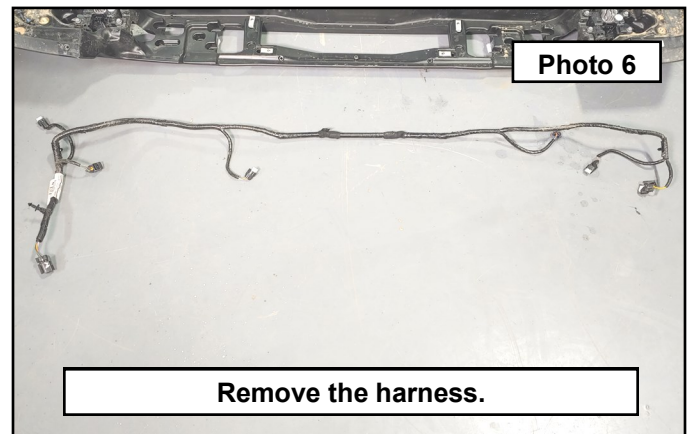
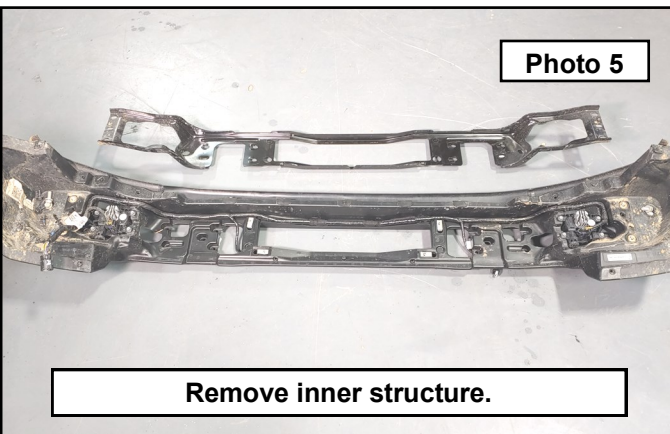
1. Park your vehicle on a clean flat surface, engage the parking brake and block the rear tires.
2. **Save all hardware removed from the vehicle unless otherwise noted.**
3. Open the hood and disconnect the negative terminal on the battery.
4. There are two types of factory bumpers, Plastic molded and Steel Modular. Follow along for your particular bumper.
Plastic bumper vehicles: Remove the gravel guard using a 15mm socket. **See Photo 1.**
5. If your vehicle has fog lights and/or parking sensors, on the driver side of the vehicle, trace the wire harness up into the wheel well. Disconnect the connector and pull down out of the way. **See Photo 2.**



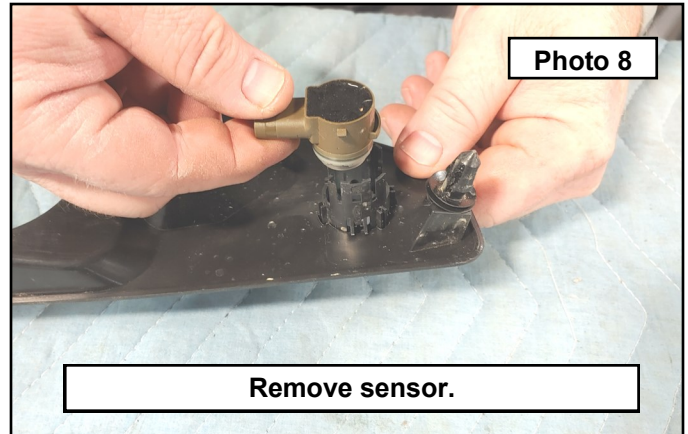
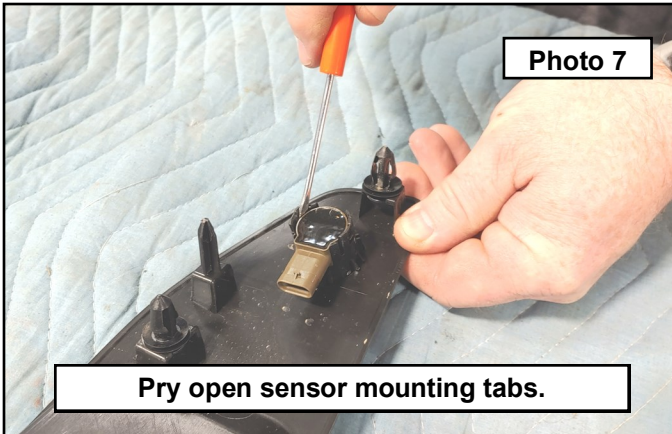
6. Remove the plastic filler panels on either side of the bumper by pulling out and away from the bumper. **See Photo 3.**
7. If your bumper is equipped with the parking assist sensors, disconnect the electrical connectors. **See Photo 4.**



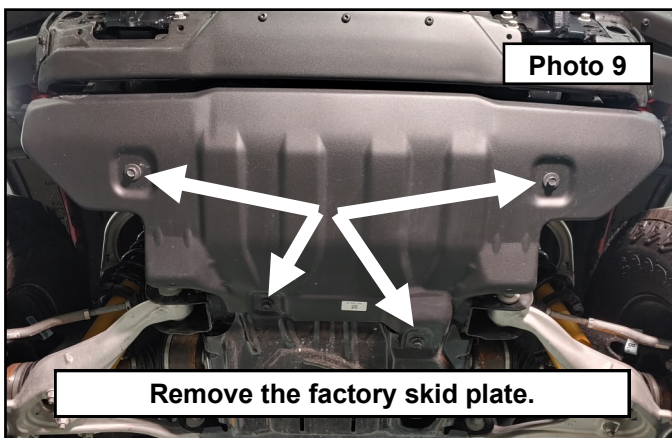
8. Behind the plastic filler panels are the main mounting bolts for the bumper. Have an assistant hold the bumper, remove the bumper mounting bolts using a 15mm socket and remove the bumper from the frame. **Sensor equipped vehicles:** Remove the inner metal structure using a 15mm socket. **See Photo 5**
9. Disconnect the sensors and/or fog light electrical connectors and harness using a pry tool to remove. **See Photo 6.**



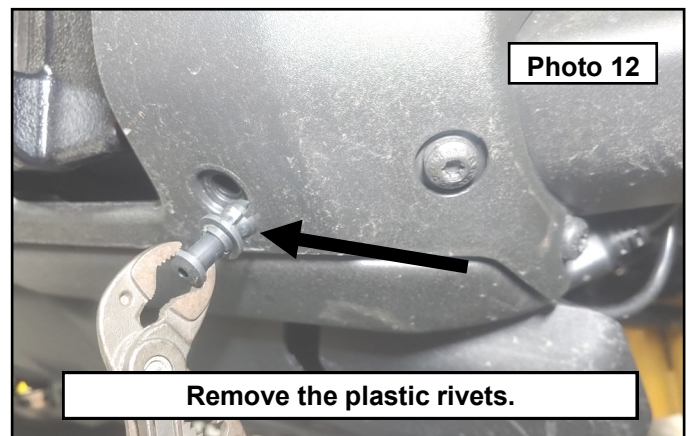
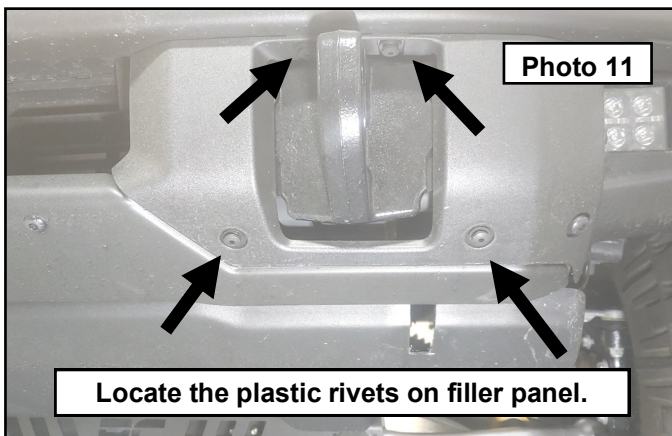
10. Remove the sensors by prying out on the mounting tabs and pulling the sensor from their mounts. Pay attention to their orientation and how they mount to the bumper as they will need to be reinstalled in the same fashion on the new bumper. **Skip steps for the Steel Modular Bumper 11 through 27. See Photo 7 / 8.**



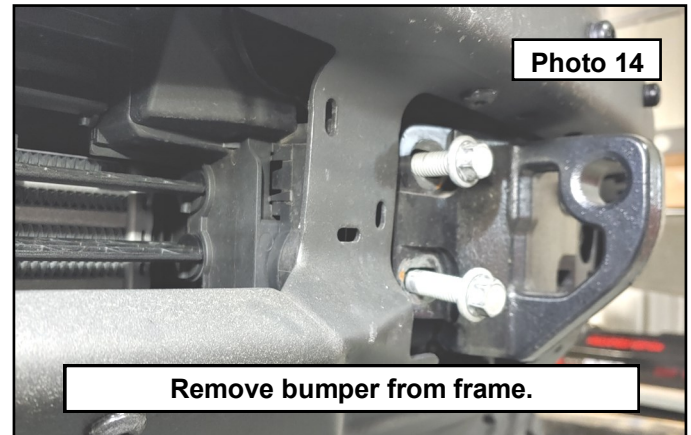
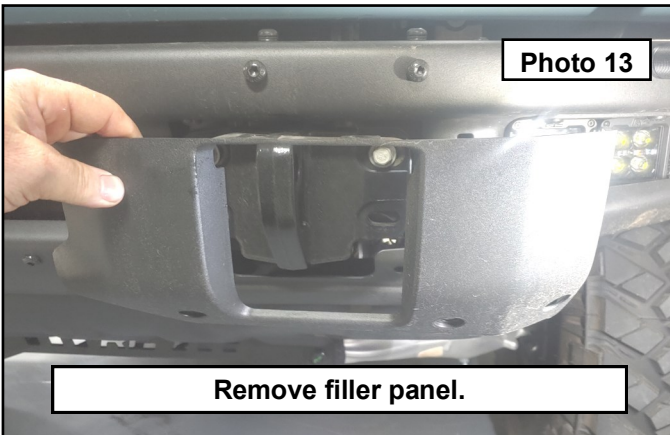
11. **Steel Modular bumper:** Remove the factory skid plate using a 15mm socket. **See Photo 9.**
12. If your vehicle has fog lights and/or parking sensors, on the driver side of the vehicle, trace the wire harness up into the wheel well. Disconnect the connector and pull down out of the way. **See Photo 10.**



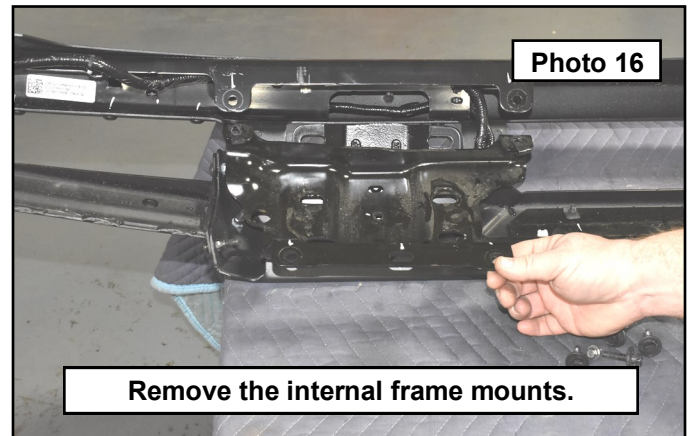
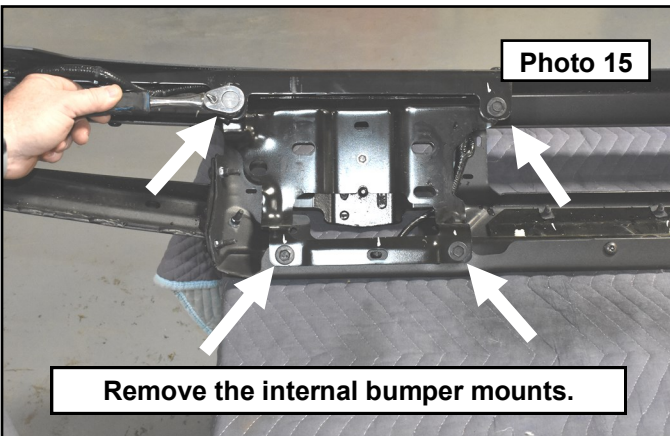
13. Locate the plastic rivets around the plastic filler panel. You will find two on the bottom edge and one on either side of the tow hook. **See Photo 11.**
14. Remove the factory plastic filler panels by pulling out the center of the plastic rivet, then pulling the body of the plastic rivet out of the holes. **See Photo 12.**



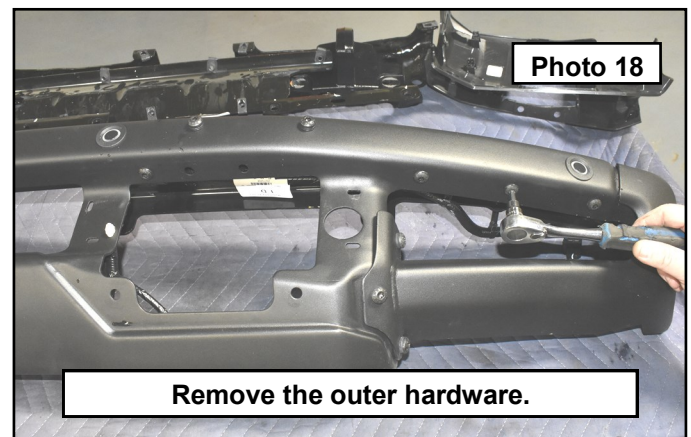
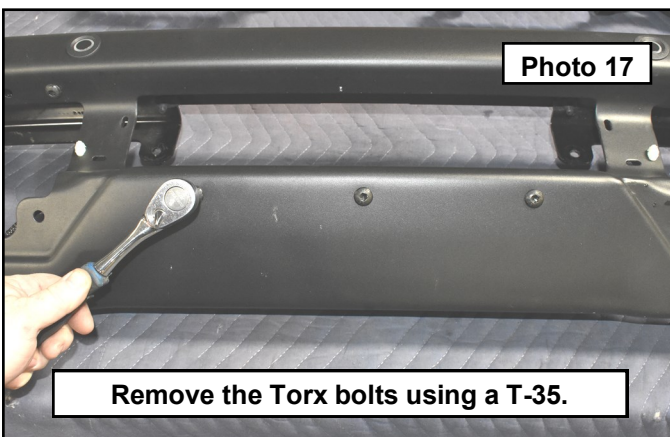
15. Once the plastic rivets are removed, pull the filler panel out and away from the bumper to release the remaining hidden clips behind the panel. **See Photo 13.**
16. Have an assistant hold the bumper, remove the 6 bumper mounting bolts using a 15mm socket and remove the bumper from the frame and set aside. **Winch Cradle Kit:** If you have the Rough Country hidden winch kit, there will be two 1/4" thick spacers on either side between the bumper and frame. These will not be reused. **See Photo 14.**



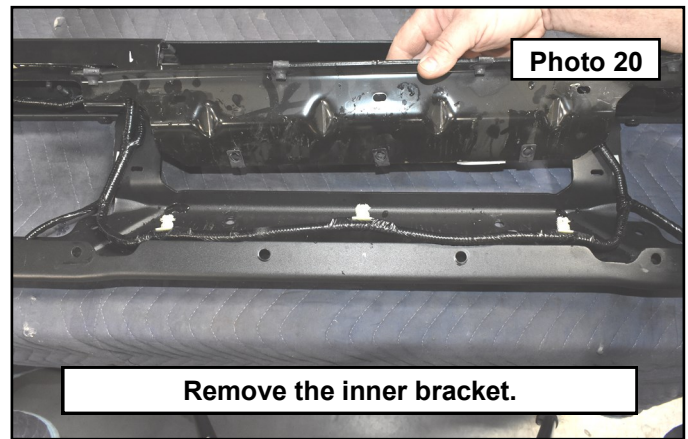
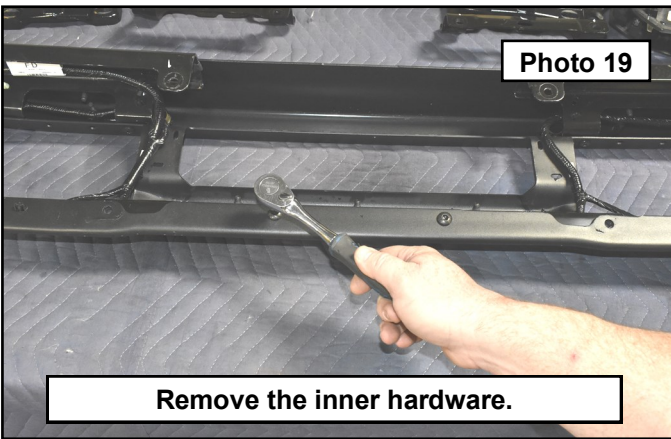
17. **Sensor equipped bumpers:** You will need to disassemble the inner structure to access the harness. Set the bumper onto a work bench face down. Start by removing the internal bumper mounts using a 15mm socket. **See Photo 15.**
18. Remove the internal frame mount and set aside. **See Photo 16.**



19. Flip the bumper over and start removing the rest of the internal bracket hardware using a T-35 Torx bit. Only remove the hardware holding the brackets that block the wire harness and sensors. Do not remove the outer wing mounting hardware. Once you have all the internal bracket hardware removed from the front of the bumper, flip it over and remove the inner hardware. **See Photo 17 / 18.**

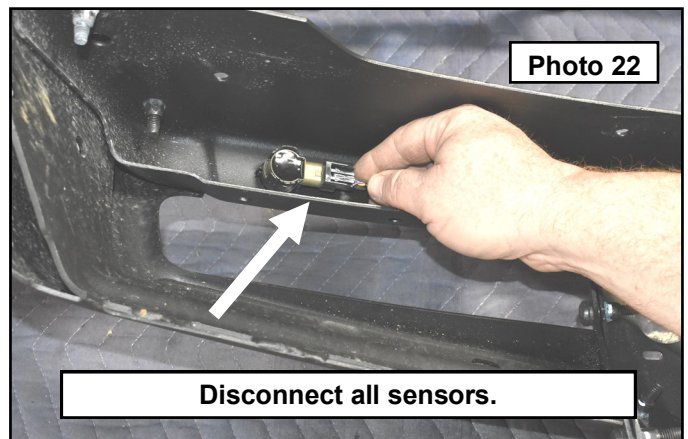
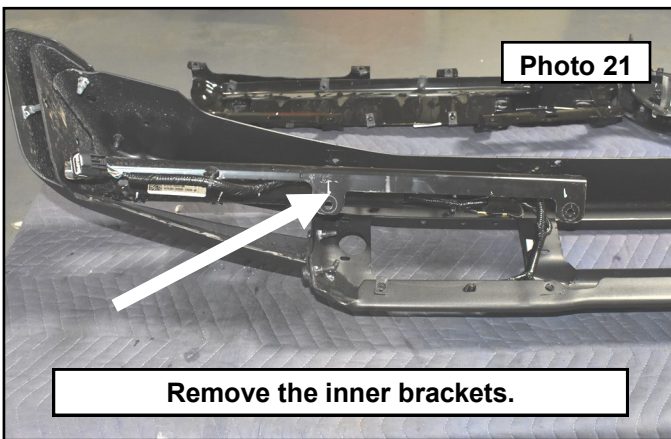


20. Remove the internal center bracket blocking access to the wire harness and sensors. See Photo 19 / 20.

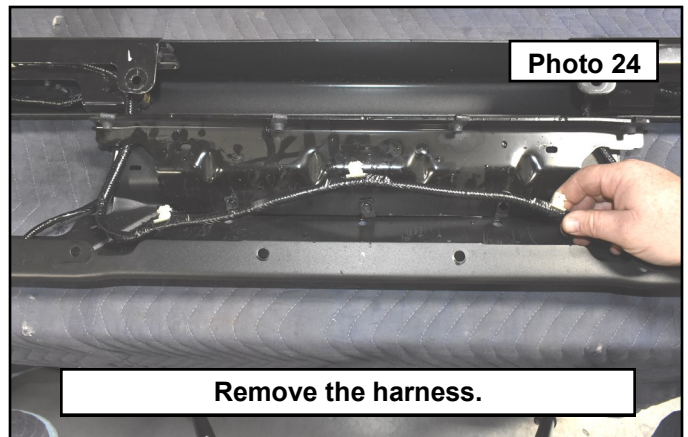
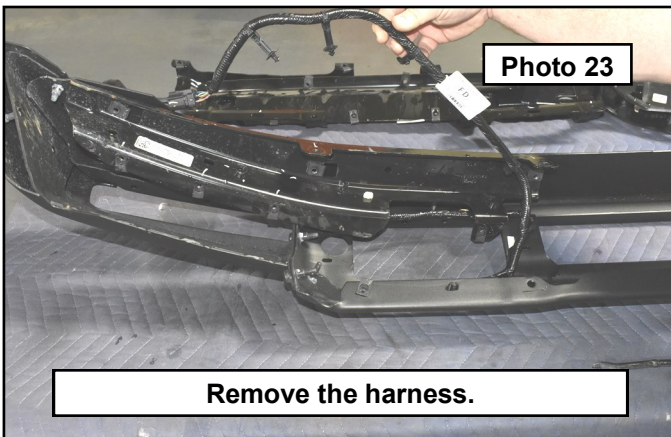


21. Remove the bumper wing internal inner bracket blocking access to the wire harness and sensors. See Photo 21

22. Disconnect the sensor electrical connectors. See Photo 22.

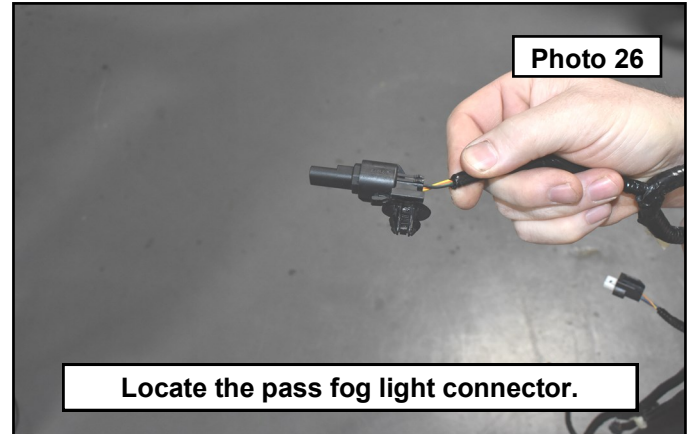
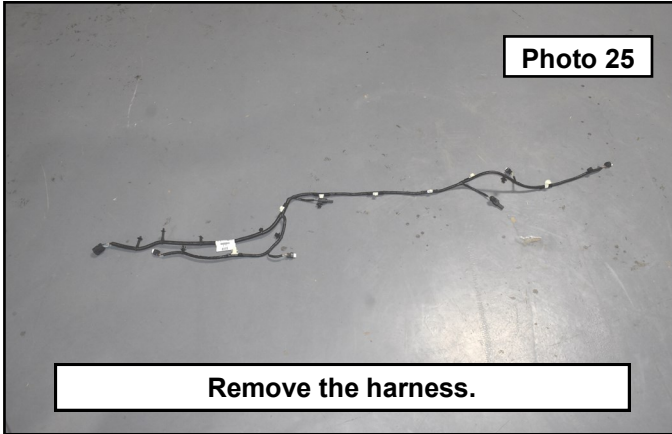


23. Use a pry tool to remove the harness plastic clips from the bumper. See Photo 23 / 24.

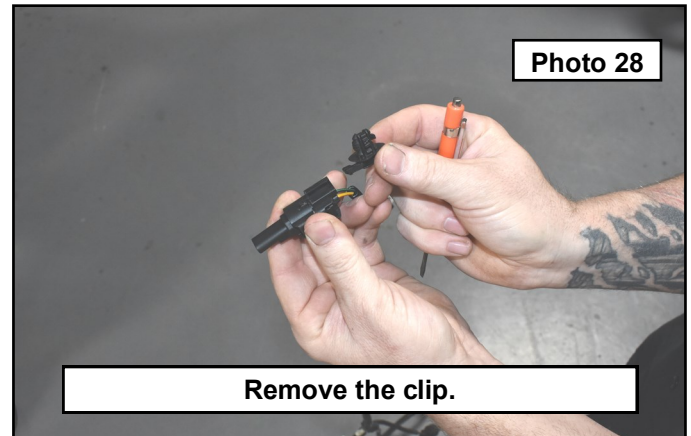
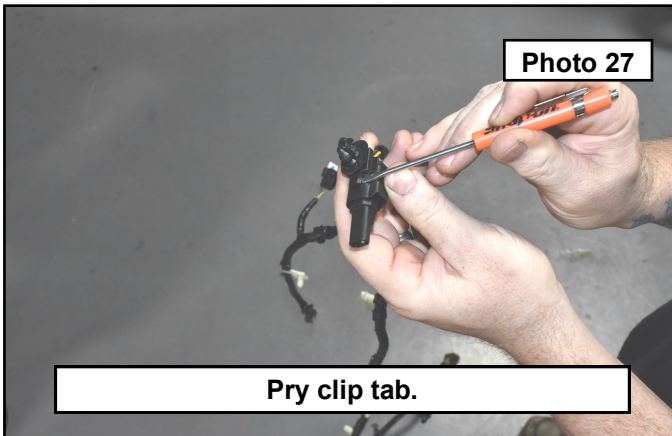


24. Remove the harness from the bumper and set aside. **See Photo 25.**

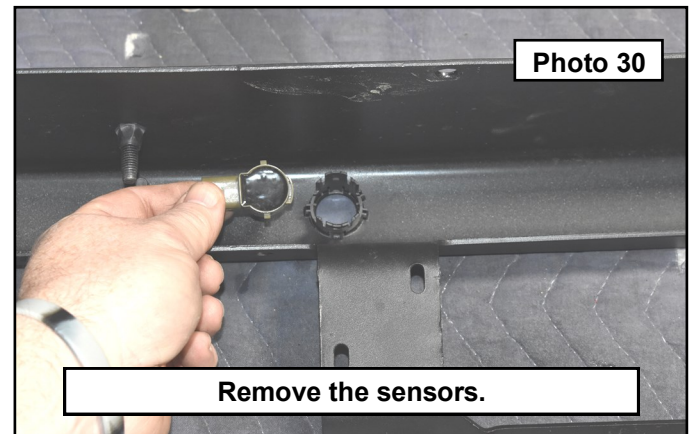
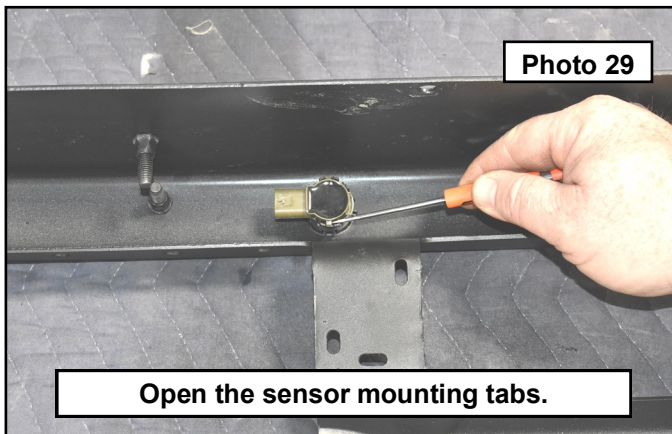
25. On the passenger side of the harness, you will find the fog light connector (if no fog lights are installed, then there will be a block off connector installed). **See Photo 26.**



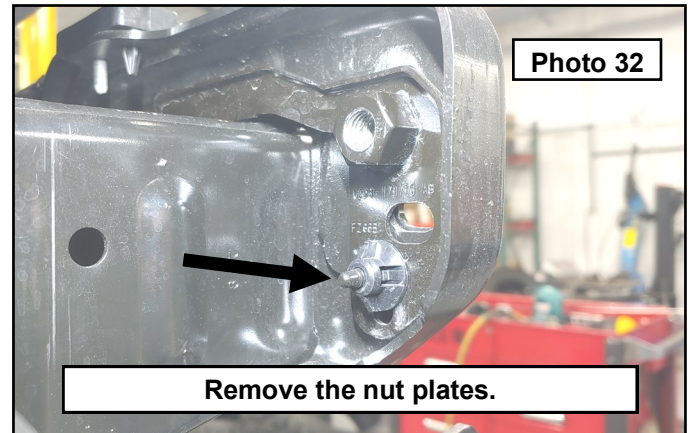
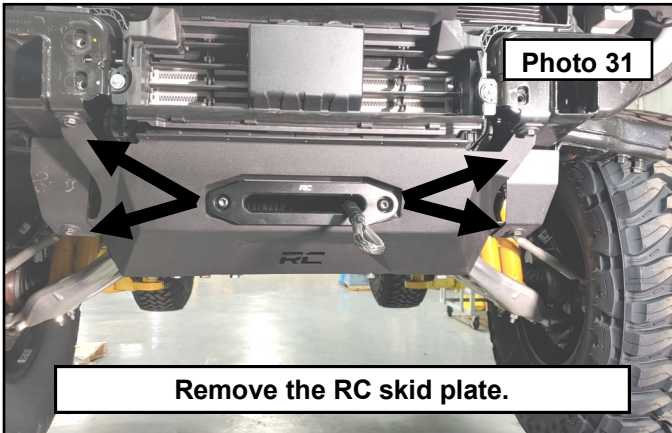
26. Remove the plastic mounting clip using a small pry tool. This needs to be done so that the harness will pass through the openings in the new bumper easily. **See Photo 27 / 28.**



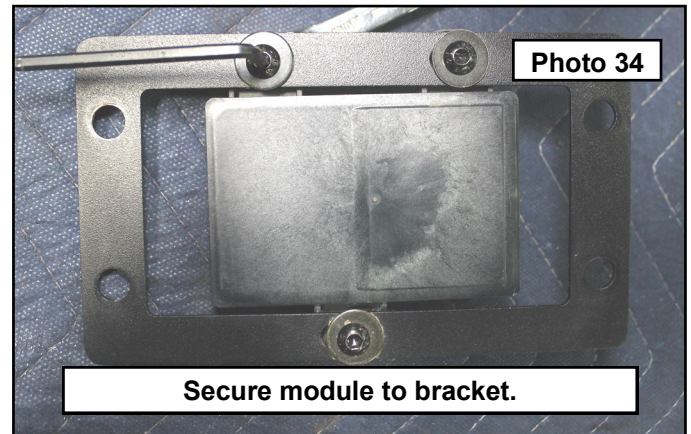
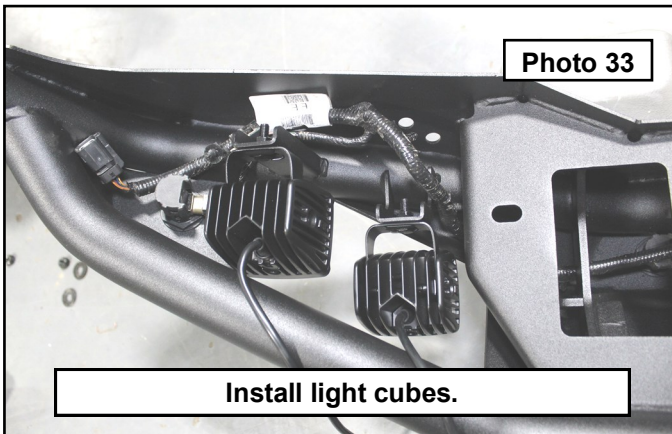
27. Remove the sensors from their mounts by using a small pry tool to open the clips out of the way and pulling the sensors out of their mounts. Make sure to pay attention to their orientation for reinstallation into the new bumper. **See Photo 29 / 30.**



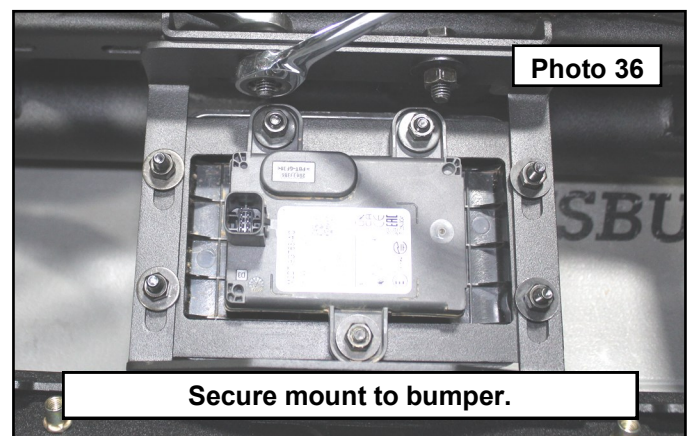
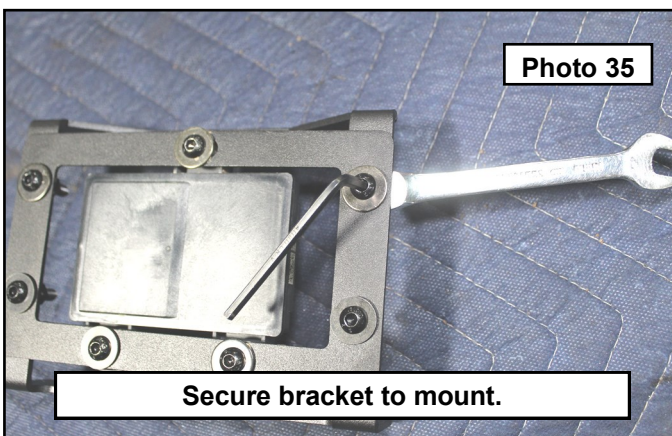
28. If you have the Rough Country hidden winch kit installed, pull out about a foot of rope out of the winch or remove the hook. Then remove the skid plate using a 15mm socket and set aside. This is done for installation of the new bumper hardware. **See Photo 31.**
29. Behind the frame horns are the factory nut plates. Remove these by twisting off the plastic nuts holding them in place. **See Photo 32.**



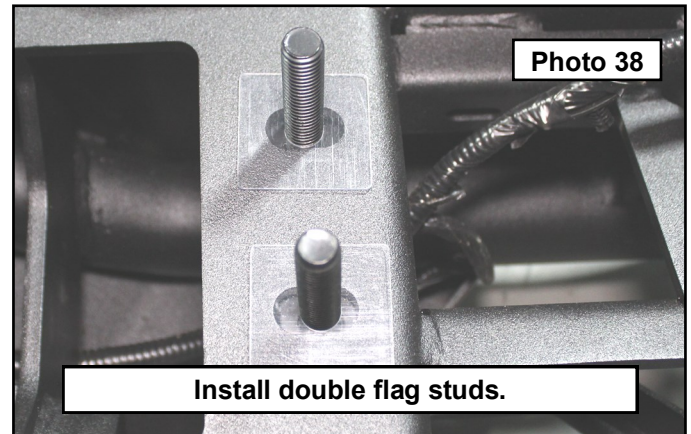
30. Install the four cube lights onto the bumper with a 14mm wrench. **See Photo 33.**
31. Install the adaptive cruise control module into the module bracket with a 10mm wrench and 4mm Allen wrench using the supplied 6mm hardware. **See Photo 34.**



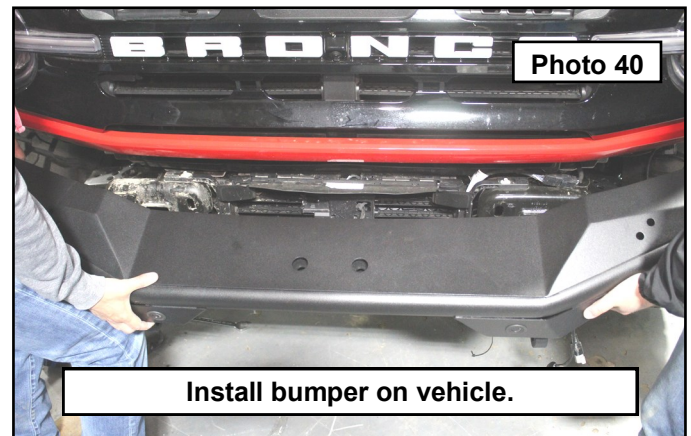
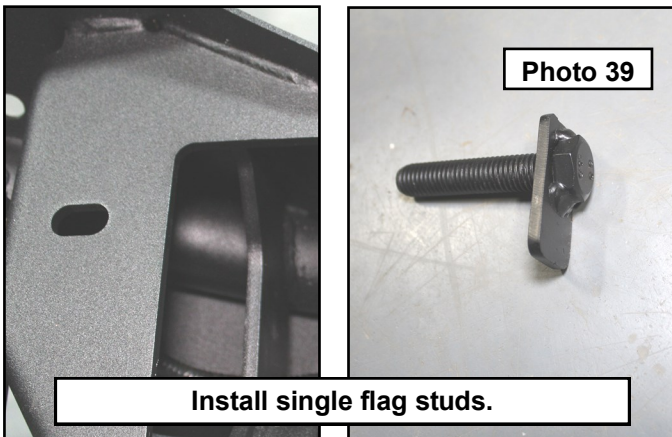
32. Install the adaptive cruise control module/bracket onto the module mount with the supplied 6mm hardware. Tighten with a 4mm Allen wrench and 10mm wrench. **See Photo 35.**
33. Install the adaptive cruise control mount to the new bumper using supplied 8mm hardware and tighten with a 13mm wrench. **See Photo 36.**



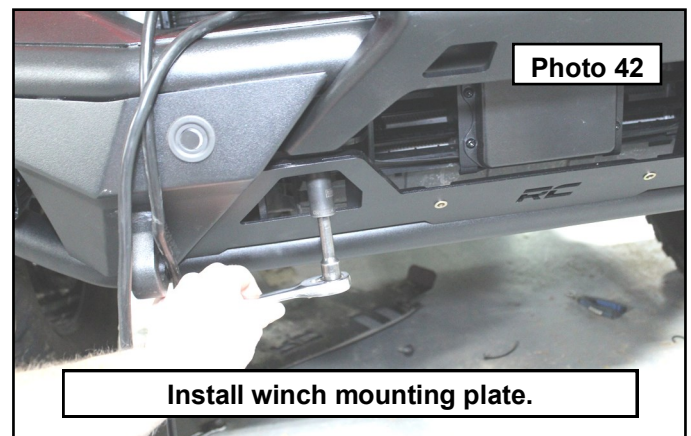
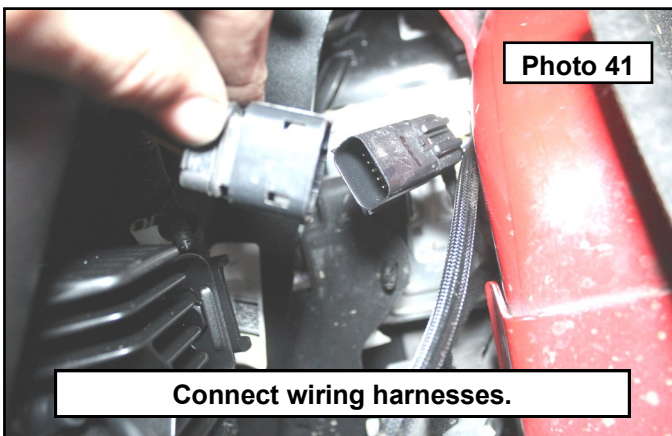
34. Route the previously removed factory front bumper wiring harness through the new bumper. Install the front parking sensors if equipped. **See Photo 37.**
35. Install the double flag studs on the innermost bumper mounting holes. Place plastic lock washers to hold them in place. **See Photo 38.**



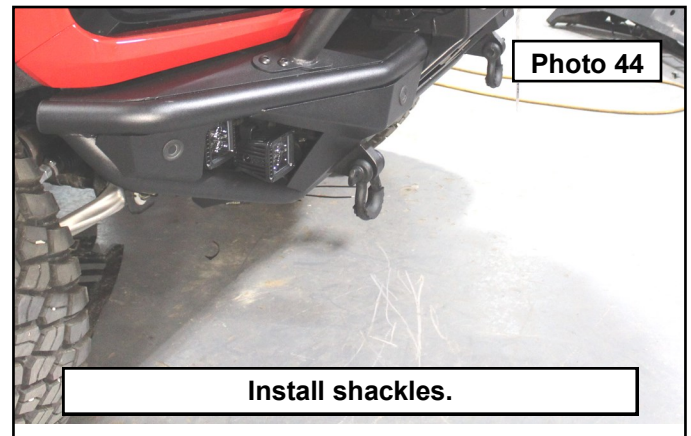
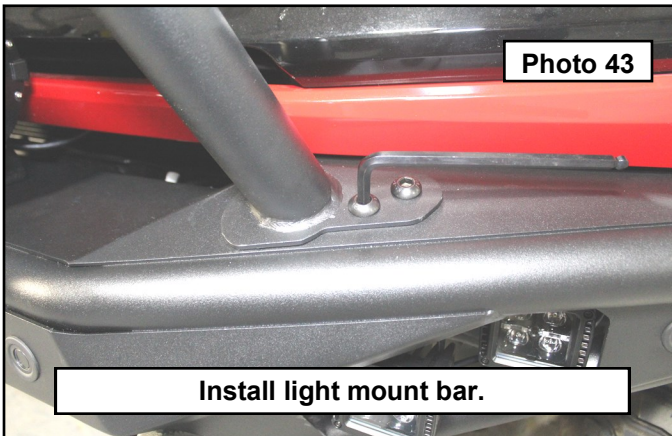
36. Install the single flag stud through the outer hole of the bumper mounting holes. Place plastic lock washer to hold it in place. **See Photo 39.**
37. Place the bumper onto the vehicle by lining up the previously installed flag studs with the vehicle bumper mounts. Use the supplied hardware to secure the bumper. Tighten with an 18mm wrench. **See Photo 40.**



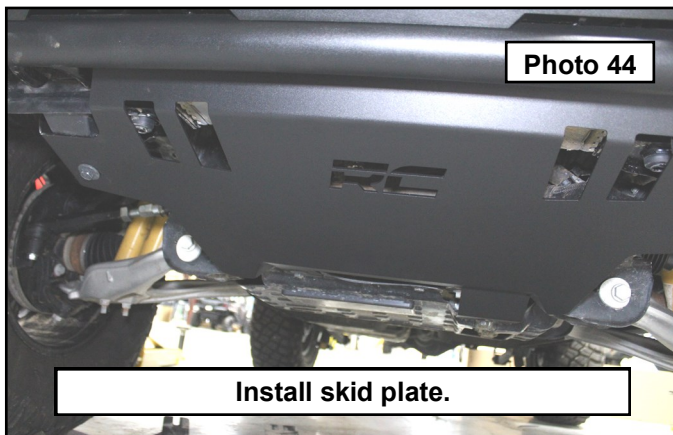
38. Plug the bumper wiring harness and adaptive cruise control module to the vehicle wiring harness. **See Photo 41.**
39. **Bumper with winch option:** Install the winch (sold separately) to the winch mounting plate using the hardware supplied with the winch.
40. Install the winch mounting plate to the bumper using the supplied 10mm hardware. Tighten with a 16mm wrench. **See Photo 42.**
41. Install the fairlead using the supplied 12mm hardware. Tighten with an 8mm Allen wrench and 18mm wrench.



42. Run the winch power wires to preference.
43. Run the cube light wires to preference.
44. Install the light mount / stinger bar onto the bumper with the supplied 12mm hardware. Tighten with an 8mm Allen wrench and 18mm wrench. **See Photo 43.**
45. Install supplied shackles. **See Photo 44.**



46. Install skid plate with factory hardware. Tighten with a 15mm wrench. **See Photo 45.**



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