

Installation Instructions for SVC Frame-Cut Front Bumpers Mojave/Baja/Smurf

1. Remove front skid plate and belly skid plate. Using a band saw or angle grinder, shave down the front of the belly skid about 2 inches as it will interfere with new skid plate for the SVC bumper. Shave down any sharp edges. *Use caution when removing skid plate bolts. (NOTE: Avoid using impact guns or power tools when removing the skid plate, as these can break the OEM nutserts.)*



2. Remove stock front bumper using a 21mm socket. There are 4 nuts on front of the truck pictured below, and 2 behind the bumper on the back of the frame horn. Using an 8mm socket, remove the bumper braces on both passenger and driver side. Using a panel popper, remove any trim still attached to the bumper. The bumper is now ready to be removed.



3. Remove the face of the frame horn by cutting the welds attaching it to the frame. This will make the cutting of the frame much easier and more accessible.



4. Draw cut lines exactly as shown below. The top will run across the edge of the intercooler brace mount, and the bottom will run across the nutsert opening

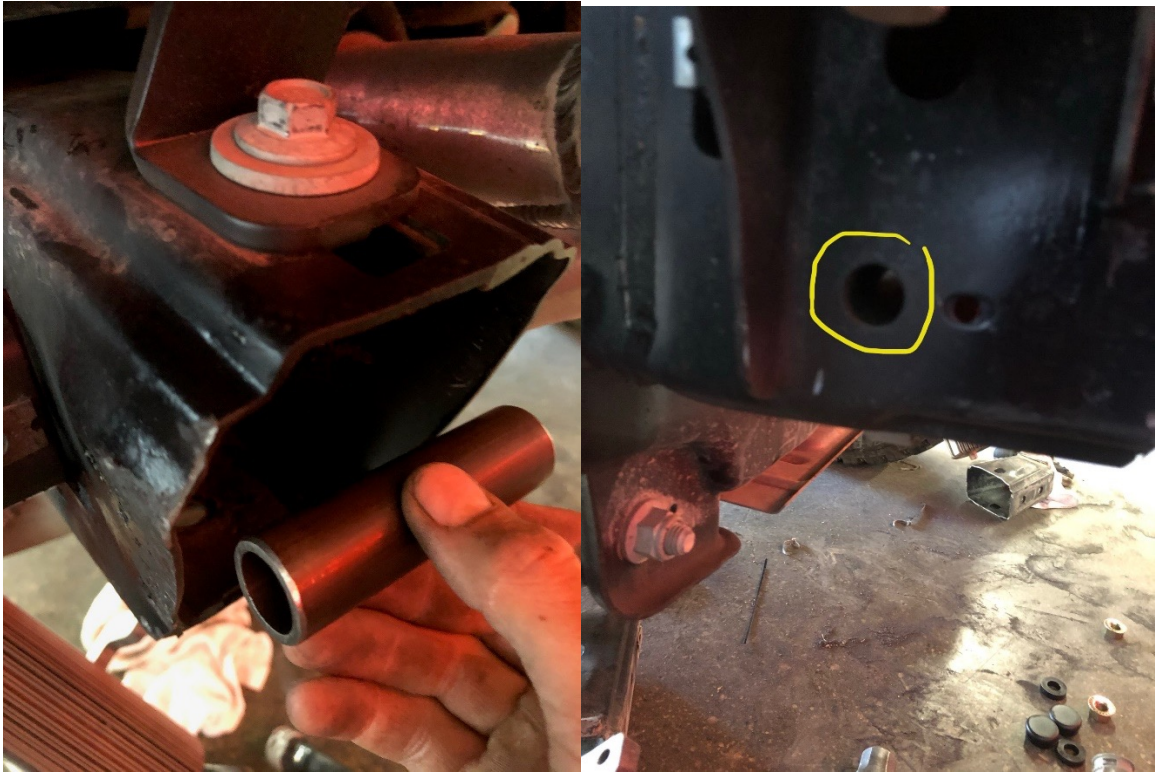
just behind the tow hitch. Make a diagonal cut connecting top to bottom on each side.



5. Grind down any sharp edges and make sure to keep frame face squared off and free of anything that will get in the way of the bumper fitting over the newly cut frame. Cut the bottom of the body mount housing as pictured below.



6. Using a hammer, carefully tap in frame sleeve insert into frame, lining the insert up with hole in frame where the bumper bolt will slide through.



7. Use a hammer to crush in the sides of the frame to ensure that the bumper slides on easily. Bend in as much as needed to get new bumper over the bulge. The new SVC bumper should now be ready to slide on. Using a jack, support the steering rack before removing steering rack bolts. This will make it much easier to get the bolts back in the steering rack.



8. Slide new SVC bumper on. Slide frame bolts through first to hold bumper in place, then secure steering rack bolts. Do not tighten fully yet. With bumper held in place, place jack underneath the bottom of the bumper support bracket located at the steering rack, jacking up bumper until you are satisfied with the fitment of the bumper to the factory valence. Fully tighten steering rack bolts to Ford recommended torque setting.
9. Secure frame bolts, making sure frame spacer is on the inside of frame, in between frame and bumper. This will prevent any crushing when tightening the bolts. Use jack to lift front end of bumper until you are content with the fitment. Tighten frame bolts to 180ftlbs.
10. Reattach belly skid. Using supplied hardware, put nutserts into skid plate tabs for your SVC skid plate. Attach skid plate and enjoy your new SVCOFFROAD bumper.

FOR MORE FRAME CUTTING PICS, PLEASE VISIT THE WEB ADDRESS BELOW

<https://svcoffroad.com/collections/2017-ford-raptor-front-and-rear-bumpers/products/2017-18-raptor-gen-2-baja-bumper>

