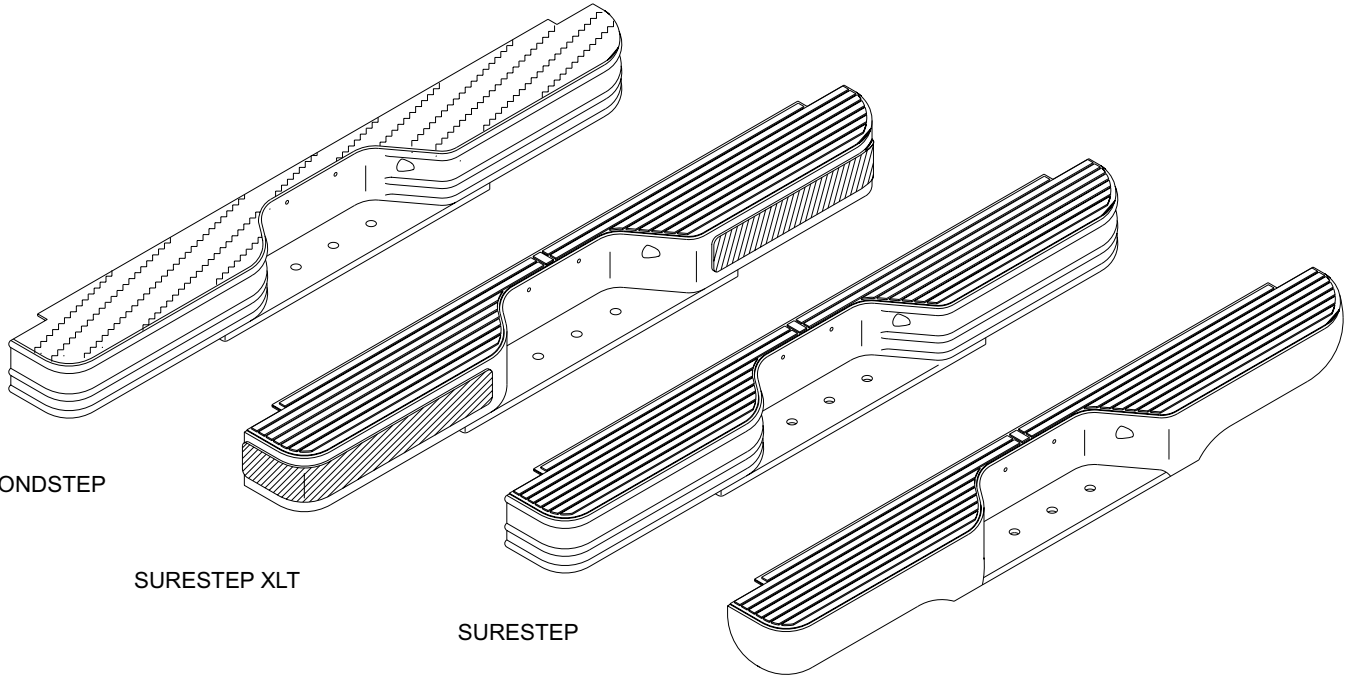# INSTALLATION INSTRUCTIONS

APPLICATION: 1967 - 96 FORD F/S TRUCK (1/2 TON)
1967 - 98 FORD F/S TRUCK (3/4 & 1 TON)

MOUNT KIT : #23/92300

DIAMONDSTEP

SURESTEP XLT

SURESTEP

CONTOUR

MOUNTING KIT CONTENTS

QTY	DESCRIPTION
1	DRIVER SIDE MOUNTING BRKT
1	PASSENGER SIDE MOUNTING BRKT
4	1/2" BOLT, NUT, FLAT WASHER, AND LOCK WASHER
4	14mm BOLT, NUT, FLAT WASHER, AND LOCK WASHER

BUMPER KIT CONTENTS

QTY	DESCRIPTION
1	BUMPER
1	LICENSE PLATE LIGHT KIT

TOOLS REQUIRED

22mm SOCKET

22mm WRENCH

3/4" SOCKET

3/4" WRENCH

RATCHET

TORQUE WRENCH

1967 - 72 Application

(37 3/4 frame width)

STEP 1: Using 14mm hardware (yellow zinc plated), loosely install mounting
brackets on the outside of truck frame rails with the offset outwards.
Refer to figure 1A. DO NOT TIGHTEN mounting hardware.

STEP 2: Using 1/2 inch hardware, install bumper onto mounting brackets with
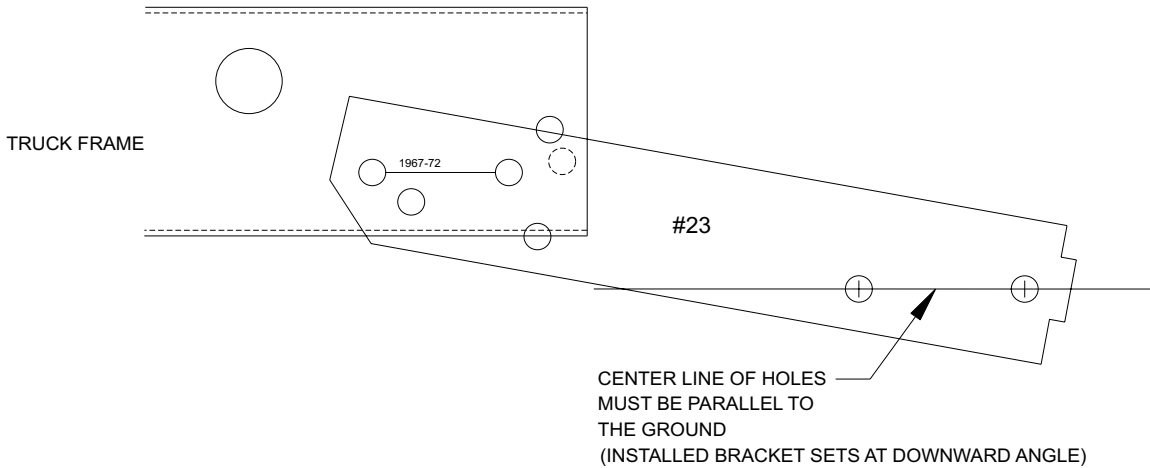brackets outside of bumper hitch. See figure 2A. DO NOT TIGHTEN.

TRUCK FRAME

1967-72

#23

CENTER LINE OF HOLES
MUST BE PARALLEL TO
THE GROUND
(INSTALLED BRACKET SETS AT DOWNWARD ANGLE)

FIGURE 1A (driver side view)

1973 - 79 Application

(37 3/4 frame width)

STEP 1: Using 14mm hardware (yellow color coated), loosely install mounting
brackets on the outside of truck frame rails with the offset inwards.
The truck frame rails may have one 14mm weld nut attached to each frame
rail. These weld nuts will be used for installing mounting brackets. (If equiped)
If the 14mm weld nut is not present use the supplied 1/2" hardware.
Refer to figure 1B. DO NOT TIGHTEN mounting hardware.

STEP 2: Using 1/2 inch hardware, install bumper onto mounting brackets with
brackets inside of bumper hitch. See figure 2B. DO NOT TIGHTEN.

TRUCK FRAME

1973-79

#23

SHACKLE MOUNT

14mm WELD NUT
ATTACHED TO FRAME

CROSSMEMBER BRACE

CENTER LINE OF HOLES
MUST BE PARALLEL TO
THE GROUND
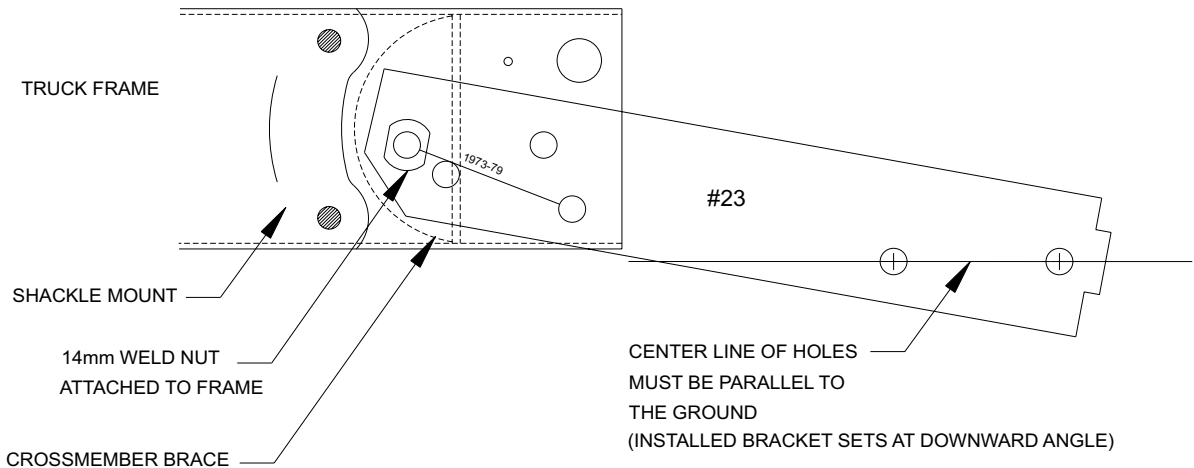(INSTALLED BRACKET SETS AT DOWNWARD ANGLE)

FIGURE 1B (driver side view)

1980 - 92 Application

(37 3/4 frame width)

STEP 1: Using 14mm hardware (yellow color coated), loosely install mounting
brackets on the outside of truck frame rails with the offset inwards.
The truck frame rails have one 14mm weld nut attached to each frame
rail. These weld nuts will be used for installing mounting brackets.
Refer to figure 1C. DO NOT TIGHTEN mounting hardware.

STEP 2: Using 1/2 inch hardware, install bumper onto mounting brackets with
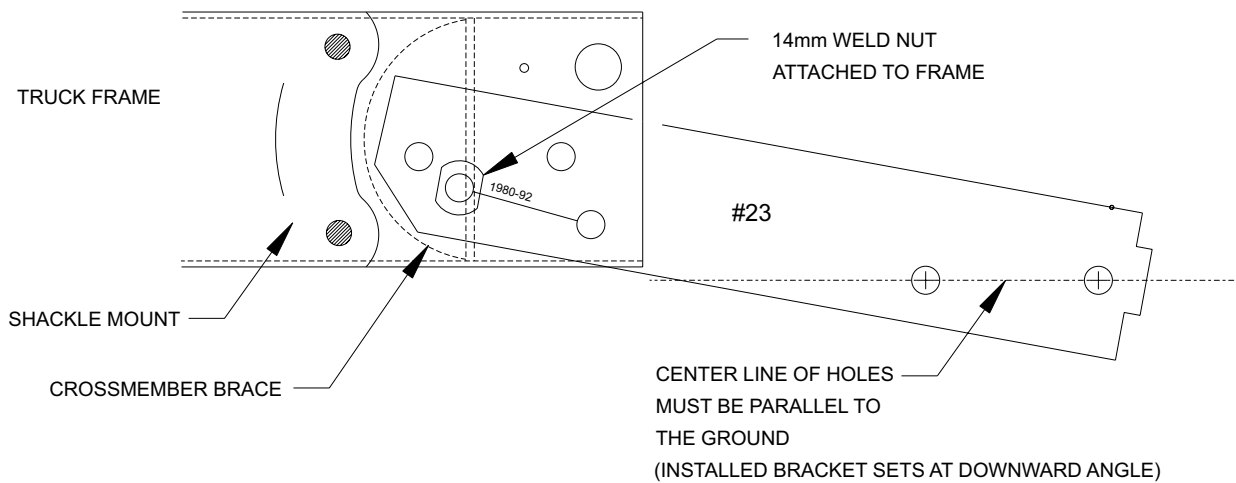brackets inside of bumper hitch. See figure 2B. DO NOT TIGHTEN.

14mm WELD NUT
ATTACHED TO FRAME

TRUCK FRAME

1980-92

#23

SHACKLE MOUNT

CROSSMEMBER BRACE

CENTER LINE OF HOLES
MUST BE PARALLEL TO
THE GROUND
(INSTALLED BRACKET SETS AT DOWNWARD ANGLE)
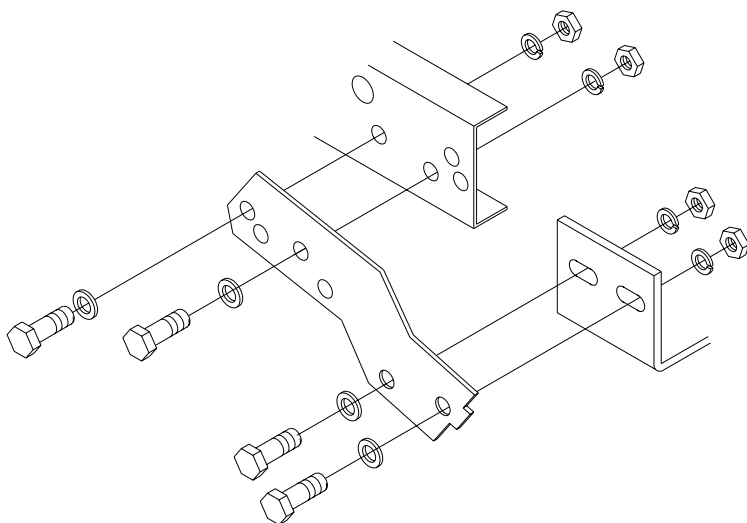
FIGURE 1C (driver side view)
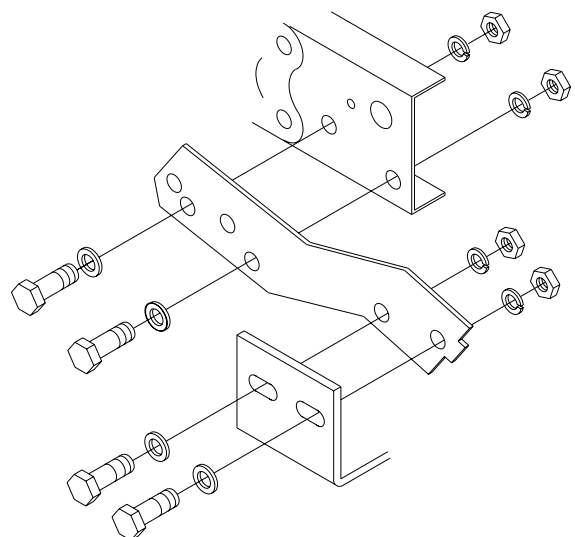
FIGURE 2A

FIGURE 2B

STEP 3: Position bumper squarely to tailgate and allow clearance for tailgate to
        open. Tighten hardware as follows: 1/2 Inch to 60-65 ft lbs
                                            14mm to 60-65 ft lbs

STEP 4: Using square plastic grommets and sheet metal screws, install license
        plate. See figure 3.

STEP 5: Install pop lights into bumper (figure 4). Using supplied connectors,
        splice pop light wires into truck illumination wire as shown in figure 4.
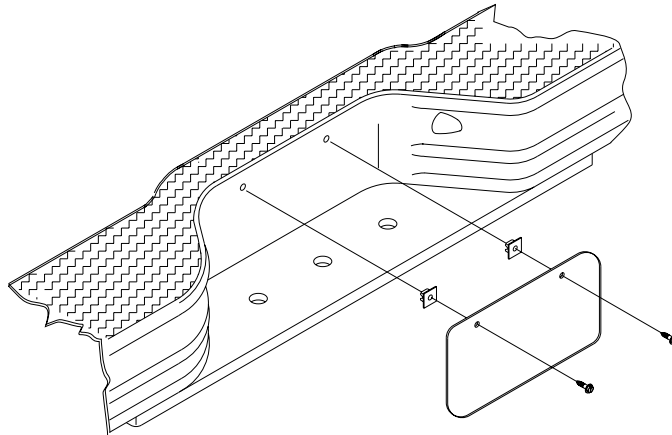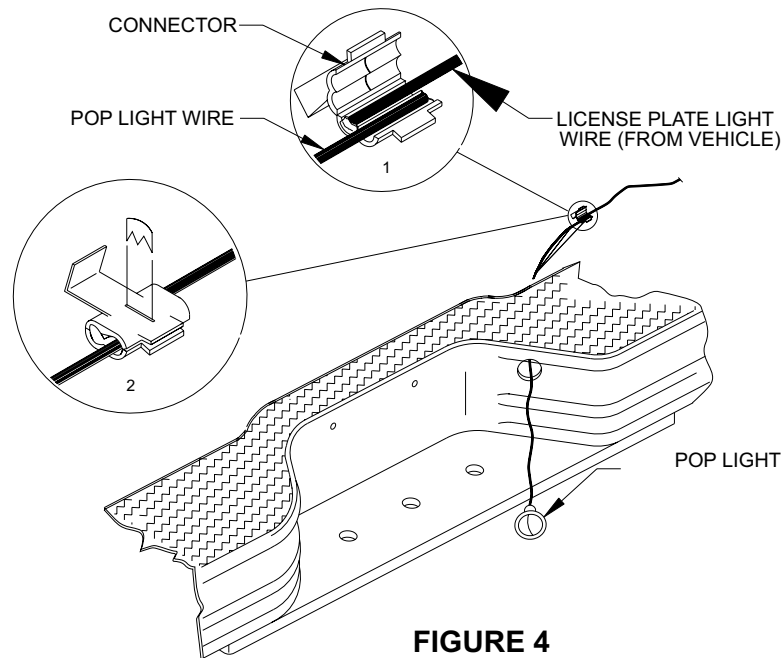   Make sure license plate lights are working properly.

FIGURE 3

CONNECTOR

POP LIGHT WIRE

LICENSE PLATE LIGHT
WIRE (FROM VEHICLE)

1

2

POP LIGHT

FIGURE 4