



# **2021-2024 MACK MD6 & MD7 XD SERIES FRONT BUMPER INSTALLATION INSTRUCTIONS**



# SAFETY

**Know safety, no injury. Know injury, no safety. ~Author Unknown**

If there are any questions, call 1-855-HHTOUGH

## **READ ALL SAFETY INSTRUCTIONS BEFORE INSTALLATION**

- FOLLOW ALL INSTRUCTIONS FOR PROPER ASSEMBLY
- WEAR APPROPRIATE EYE PROTECTION
- EXERCISE CARE WHEN LIFTING COMPONENTS
- USE APPROPRIATE TORQUE FOR BOLTS
- RE-TORQUE HARDWARE AT EVERY OIL CHANGE.

<b>Suggested Torque Values For Steel Grade 5 Standard Bolts</b>		
BOLT DIAMETER (INCH)	THREADS PER INCH	TORQUE (POUND - FEET)
1/4	20	7
5/16	18	14
3/8	16	25
7/16	14	40
1/2	13	60
9/16	12	88
5/8	11	120
3/4	10	200
7/8	9	302
1	8	466

<b>Suggested Torque Values For Steel Grade 8.8 Metric Bolts</b>		
BOLT DIAMETER (mm)	THREAD PITCH (mm)	TORQUE (POUND-FEET)
6	1.0	7
8	1.25	16
10	1.5	32
12	1.75	55
14	2.0	88
16	2.0	140
18	2.5	195
20	2.5	275
22	2.5	375
24	3.0	475

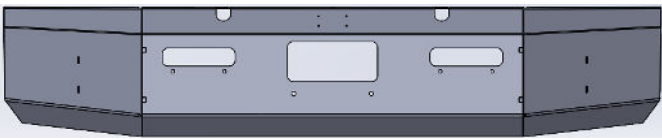
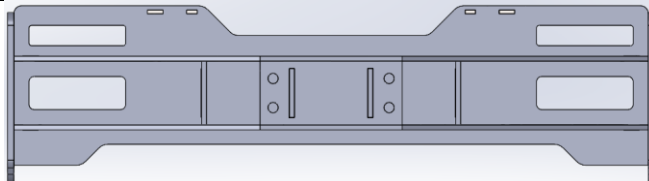
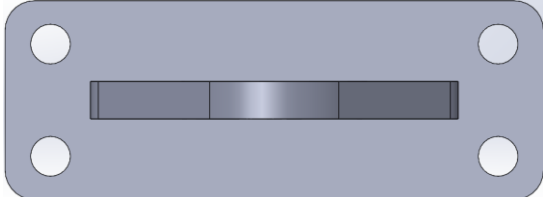


**WARNING: Cancer  
and Reproductive Harm**

[www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov)

**I. PARTS LIST**

*Note: Brush guard configuration may differ.*

Item 1	XD SERIES FRONT BUMPER	QTY. 1	Item 2	FRAME MOUNT WELDMENT	QTY. 1
					
Item 3	TOW ATTACHMENT	QTY. 1	Item 4	HARDWARE KITS	
			<div>✓ <b>HARDWARE KIT #42</b> (60K-56-0042)</div> <div>✓ <b>HARDWARE KIT #46</b> (60K-56-0046)</div> <div>✓ <b>LICENSE PLATE MOUNT KIT</b></div>		

**REMOVE CONTENTS FROM BOX AND VERIFY ALL PARTS ARE PRESENT.**

If there are any questions, call 1-855 HHTOUGH or email HHORDERS@hammerheadarmor.com

**II. TOOL LIST**

- ✓ A good friend
- ✓ Basic tool set
- ✓ Blue masking tape
- ✓ 18mm socket
- ✓ 21mm socket
- ✓ 21mm wrench
- ✓ 24mm wrench
- ✓ 1 1/8" socket
- ✓ 1 1/8" wrench
- ✓ Ratchet extension

**III. VEHICLE PREPARATION**

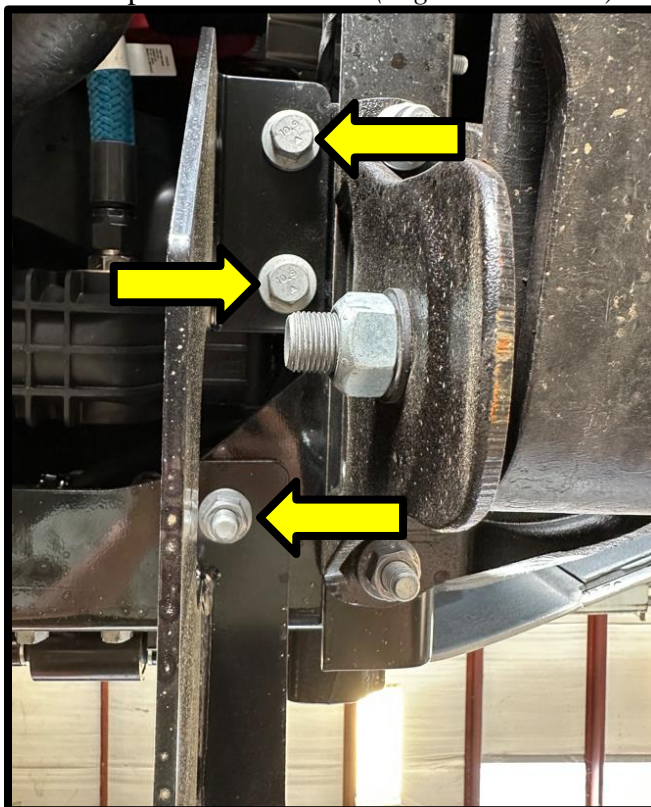
1. Park vehicle on level surface.
2. Engage parking brake and disconnect battery.
3. Using blue masking tape, mask along the profile of your truck above the bumper. This will help protect your truck from any accidental scratches.

#### IV. REMOVAL OF OE BUMPER

1. Using an 18mm socket and a 21mm wrench, remove 6 OE bolts attaching front bumper to OE frame mounts. Remove OE bumper from front of vehicle and set aside.



2. Using a 21mm socket, ratchet extension, 18mm wrench, and 24mm wrench, remove 3 OE bolts retaining OE bumper mount as shown below. Remove OE bumper mount and set aside. Set OE hardware aside to be re-used. Repeat for other side. *(Right side shown)*





**V. INSTALLATION OF HAMMERHEAD BUMPER**

1. Using a crane or a hoist, loop a strap through the slot in frame mount weldment (*ITEM 2*) and position frame mount weldment to frame of truck as shown below. Using OE hardware, secure frame mount weldment to frame of truck and align frame mount weldment to be centered on truck and fully tighten all hardware.



2. Using hardware from hardware kit #42, install tow attachment (*ITEM 3*) to front of frame mount weldment as shown below. Fully tighten all hardware using 1 1/8" socket and wrench.



3. Using a hoist or a crane, loop a strap through the slots in the bumper as pictured below. Align bumper to be centered on vehicle and fully secure bumper to frame mount weldment using hardware from hardware kit #42. Use tow attachment and opening in bumper to help center. Using a 1/18" wrench and socket, fully tighten all hardware.



**Congratulations! Your product installation is now complete.  
Thank you for your purchase!**