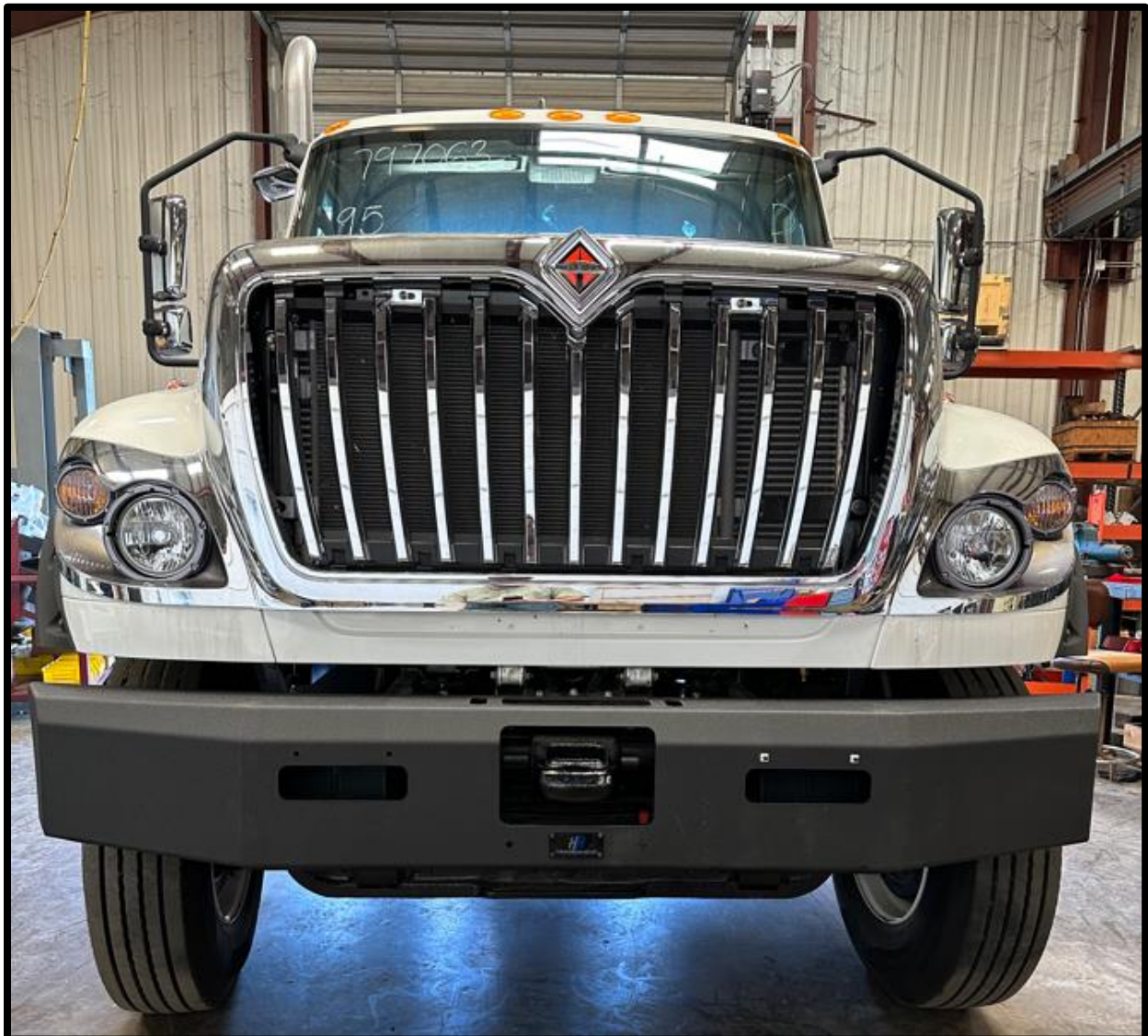




# 2017-2024 INTERNATIONAL HV513 SFA XD SERIES BUMPER INSTALLATION INSTRUCTIONS



# 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

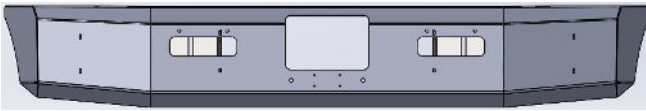
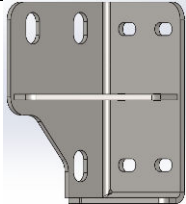
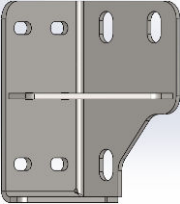
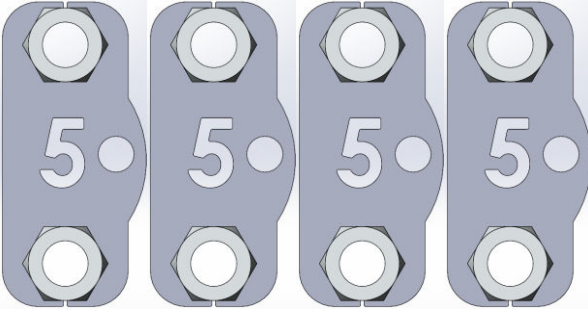


**WARNING: Cancer  
and Reproductive Harm**

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

**I. PARTS LIST**

*Note: Brush guard configuration may differ.*

<p><b>Item 1</b>      <b>XD SERIES BUMPER</b>      <b>QTY. 1</b></p> 	<p><b>ITEM 2</b>    <b>RIGHT FRAME MOUNT WELDMENT</b>    <b>QTY. 1</b></p> 
<p><b>ITEM 3</b>    <b>LEFT FRAME MOUNT WELDMENT</b>    <b>QTY. 1</b></p> 	<p><b>ITEM 4</b>      <b>HARDWARE KITS</b></p> <ul style="list-style-type: none"> <li>✓ <b>HARDWARE KIT #57</b> (60K-56-0057)</li> <li>✓ <b>HARDWARE KIT #62</b> (60K-56-0062)</li> <li>✓ <b>LICENSE PLATE MOUNT KIT</b></li> </ul>
<p><b>ITEM 5</b>      <b>WELDNUT TAB 5</b>      <b>QTY. 4</b></p> 	

**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
- ✓ Torx 50 Bit
- ✓ 18mm wrench
- ✓ 15/16" socket
- ✓ 15/16" wrench
- ✓ 3/4" socket or wrench
- ✓ Ratchet extension

### III. VEHICLE PREPARATION

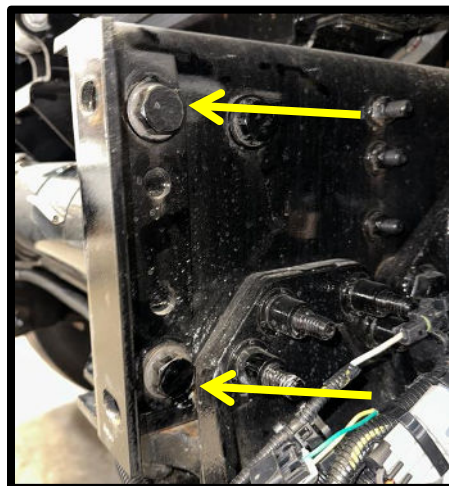
1. Park vehicle on level surface.
2. Engage parking brake and disconnect battery.
3. Using blue masking tape, mask along the profile of your truck above the bumper. This will help protect your truck from any accidental scratches.

### IV. REMOVAL OF OE BUMPER

1. Using a torx 50 bit and 18mm wrench, remove 4 bolts retaining OE bumper. Remove bumper and hardware and set aside.



2. Using a 15/16" socket and 15/16" wrench, remove 2 bolts retaining OE bumper mount to frame. Remove and set aside. OE hardware will be re-used but OE bumper mount will not. Repeat for other side.



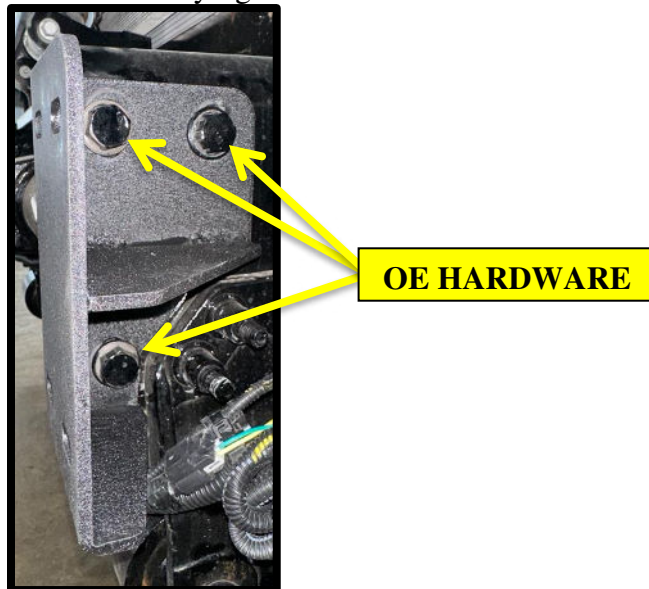


- Using the same tools from the previous step, remove third OE bolt from frame. Set hardware aside to be re-used. Repeat for other side.



#### V. INSTALLATION OF HAMMERHEAD BUMPER

- Lay bumper face down on a carpeted surface or a piece of cardboard. Install any accessories onto bumper at this time.
- Using OE hardware from removal steps 2 and 3, install left frame mount weldment (*Item 3*) to frame of vehicle as shown below. Do not fully tighten.



3. Layout hardware from hardware kit #62 as well as weld nut tabs from install kit. Using the help of a hoist or crane, secure bumper to left and right frame mount weldments. Ensure hood has enough clearance to open. Using a  $\frac{3}{4}$ " wrench or socket and tools from removal steps 2 and 3, fully tighten all hardware.



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