

**IRON CROSS  
AUTOMOTIVE INC.****2015 Ford F-150  
Rear Bumper****415-15**[www.ironcrossautomotive.com](http://www.ironcrossautomotive.com)**Installation Instructions****Rear Bumper Hardware**

4	½" Bolts	4	½" Nuts
4	½" Lock Washers	8	½" Flat Washers
6	¾" Bolts	6	¾" Nuts
6	¾" Lock Washers	12	¾" Flat Washers
2	Tag Lights		

**Stock Bumper Removal**

- 1) Begin by unplugging the tag lights and the trailer lighting plug (FIG 1) from the backside of the bumper underneath the truck. Be certain the wiring is free and clear from the factory rear bumper.



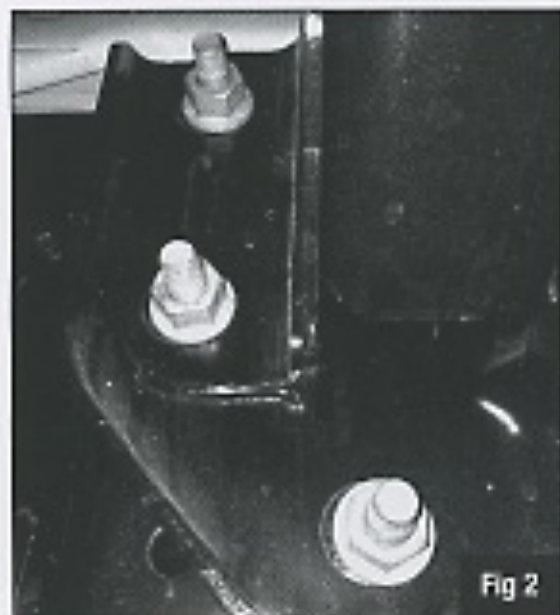
Fig 1



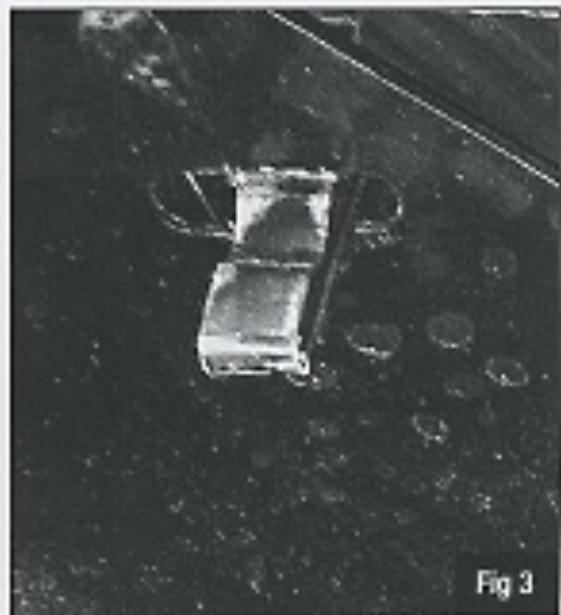
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## Stock Bumper Removal

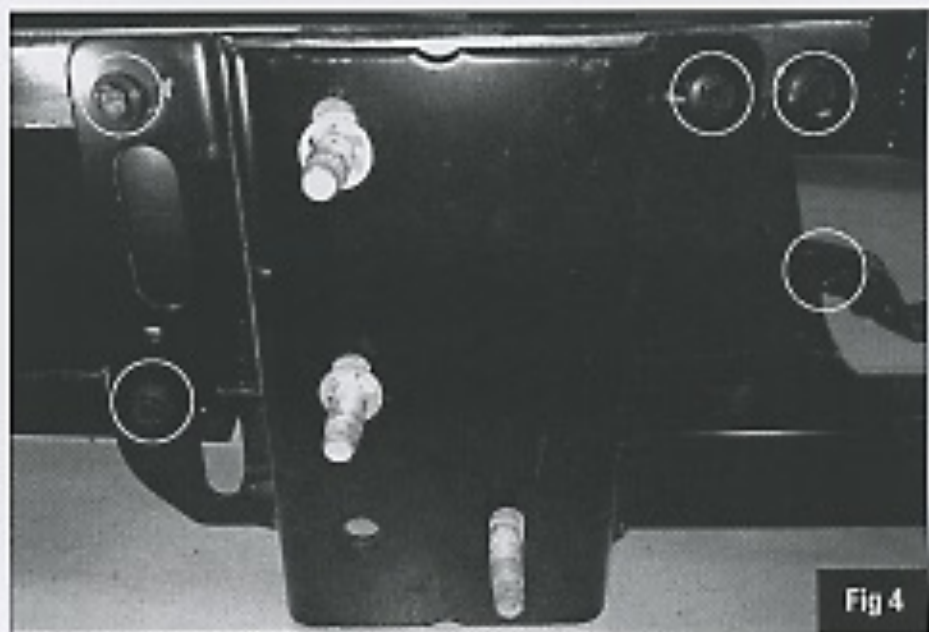
2) Remove the six factory bolts (3 on each side, FIG 2) to free the rear bumper from the truck. An assistant may be needed for this step.



3) With the bumper removed from the truck, separate the bumper top plastic cap from the bumper by pushing through all the plastic tabs (FIG 3)



4) Remove the factory bumper halves from the receiver hitch by removing 10 bolts, 5 per side (FIG 4).



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5) Reinstall the receiver hitch to the truck using the six factory bolts.

## ICA Bumper Installation

6) Install the ICA Bumper brackets using 6 sets of 3/8" bolts with a flat washer, then another flat washer, a lock washer and a nut; three sets for each side. (FIG 5 shows the Driver Side bracket mounted to the truck). Torque the hardware to 26 ft/lbs.



Fig 5

7) Position the rear bumper over the installed bumper brackets. Each side of the bumper will take 2 sets of a 1/2" bolt, 2 flat washers, a lock washer, and a nut. (FIG 6) Snug bolt, position bumper in correct position, then torque to hardware to 60 ft/lbs.



Fig 6

8) Locate the trailer lighting plug from under the truck and run it through the designated hole in the bumper. Plug the receptacle into the harness and fit the assembly into the bumper by pushing it in. (FIG 7) Do this same process for the tag lights.



Fig 7



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