



INSTALLATION GUIDE

2021-UP FORD F-150 RAPTOR

PRO-PLUS FRAME-CUT FRONT BUMPER

F210552070103



TOOLS REQUIRED

(Sockets) 9/16, 3/4, 8mm, 10mm, 13mm, 15mm, 21mm
(Box end wrenches) 9/16, 3/4, 8mm, 10mm, 13mm, 15mm, 21mm
Fastener remover or flathead screwdriver
Zip ties
Ratchet
Cutting Tool
Ruler
Marker



TIME REQUIRED

- 3 hours for OEM Removal/Bumper Install
-1 Additional Hour to Wire Lights

****Labor Rates are based on a vehicle with no pre-existing damage. Wiring labor is based on a standard wiring procedure with light switches installed in an easily accessible location. Custom light triggering or switch mounting location will result in a greater labor charge.****



SKILL LEVEL



Medium

****This installation requires 2 people for best results****



WARNINGS/CAUTIONS BEFORE STARTING INSTALLATION



-BEFORE YOU INSTALL THIS KIT-

Read and understand all instructions, warnings, cautions, & notes contained in this installation instruction guide. Consult your vehicle owner's manual for proper disconnection of electrical and lifting of vehicle if required for installation of this product.

This install may require some technical skills and knowledge of basic mechanical work. If you do not feel that you are capable of performing this install please take this product to a trained professional.

After reading this guide please contact us with any questions or concerns before installing product.
Customer Service (480) 671-0820

Addictive desert designs is not responsible for any bodily injury or harm to you or your vehicle as a result of an improper install.

Proper installation of this kit required knowledge of the factory recommended procedures for removal and installation of original equipment components.

We recommend that the factory shop manual and any special tools needed to service your vehicle be on hand during the installation. Installation of this kit without proper knowledge of the factory recommended procedures may affect the performance of these components and the safety of the vehicle.

Inspect all contents of this package to make sure product is not damaged and all installation hardware has been included. If parts are missing from kit, please be prepared to provide the following information:

1. Name of purchase location
2. Bar Code on side of box
3. Date above bar code
4. Date inside box cover

ALWAYS WEAR EYE PROTECTION WHEN OPERATING POWER TOOLS



INSTALLATION GUIDE

HARDWARE/PARTS

A.



1/4-20 X 3/4" BUTTON HEAD BOLT

QTY: 4

A1.



1/4" WASHER

QTY: 4

A2.



1/4-20 NYLON LOCK NUT

QTY: 4

B.



3/8-16 X 1" CARRIAGE BOLT

QTY: 2

B1.



3/8-16 X 1 1/2" HEX HEAD BOLT

QTY: 6

B2.



3/8 FLAT WASHER

QTY: 2

B3.



3/8 FLAT WASHER (BLACK)

QTY: 4

B4.



3/8-16 NUT CLIP

QTY: 2

B5.



3/8-16 NYLON LOCK NUT

QTY: 4

C.



1/2-13 X 1 1/2" HEX HEAD BOLT

QTY: 6

C1.



1/2 FLAT WASHER

QTY: 12

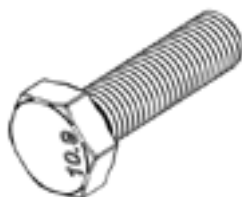
C2.



1/2-13 NYLON LOCK NUT

QTY: 6

D.



3/4-10 X 5.5" HEX HEAD BOLT

QTY: 2

D1.



3/4 FLAT WASHER

QTY: 4

D2.



3/4-10 NYLON LOCK NUT

QTY: 2

Reference this page throughout the install



INSTALLATION GUIDE

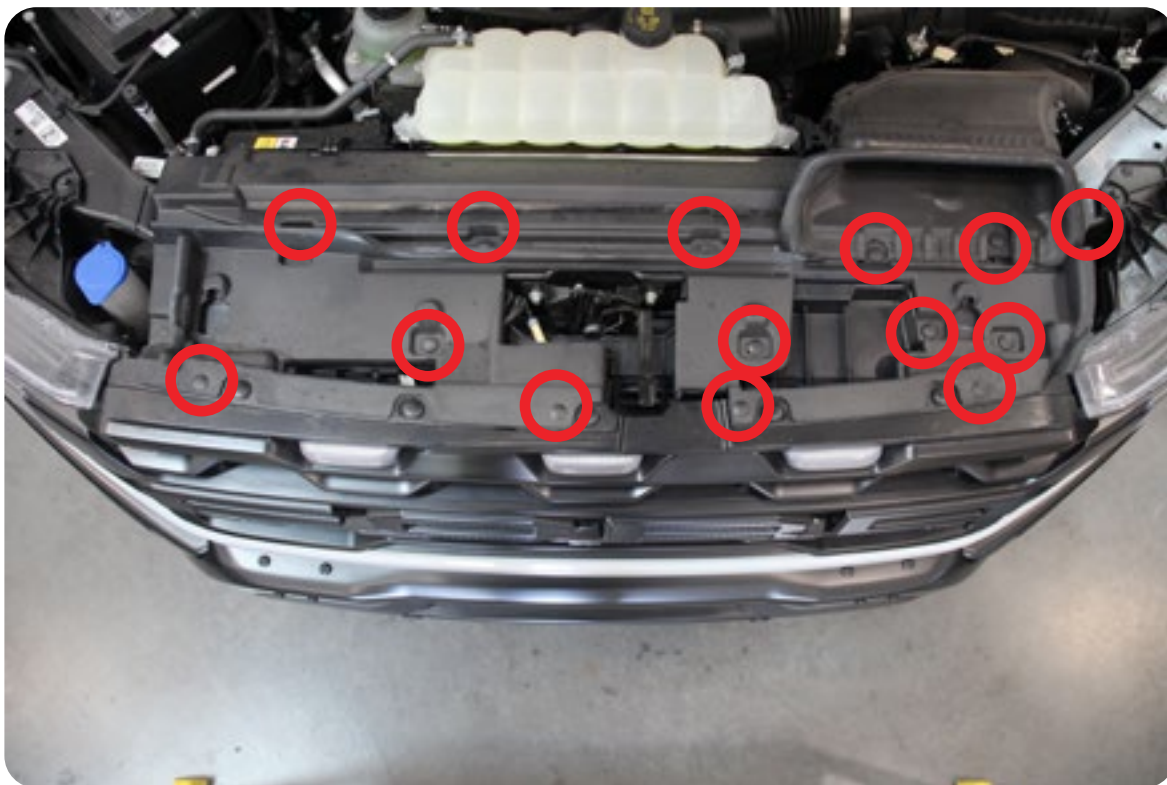
PRO-PLUS FRAME-CUT FRONT BUMPER

2021-UP FORD F-150 RAPTOR

REMOVAL

□ STEP 1

Use a plastic pry tool to remove the (14) plastic clips holding the grill cover on, you can now remove the plastic grill cover.





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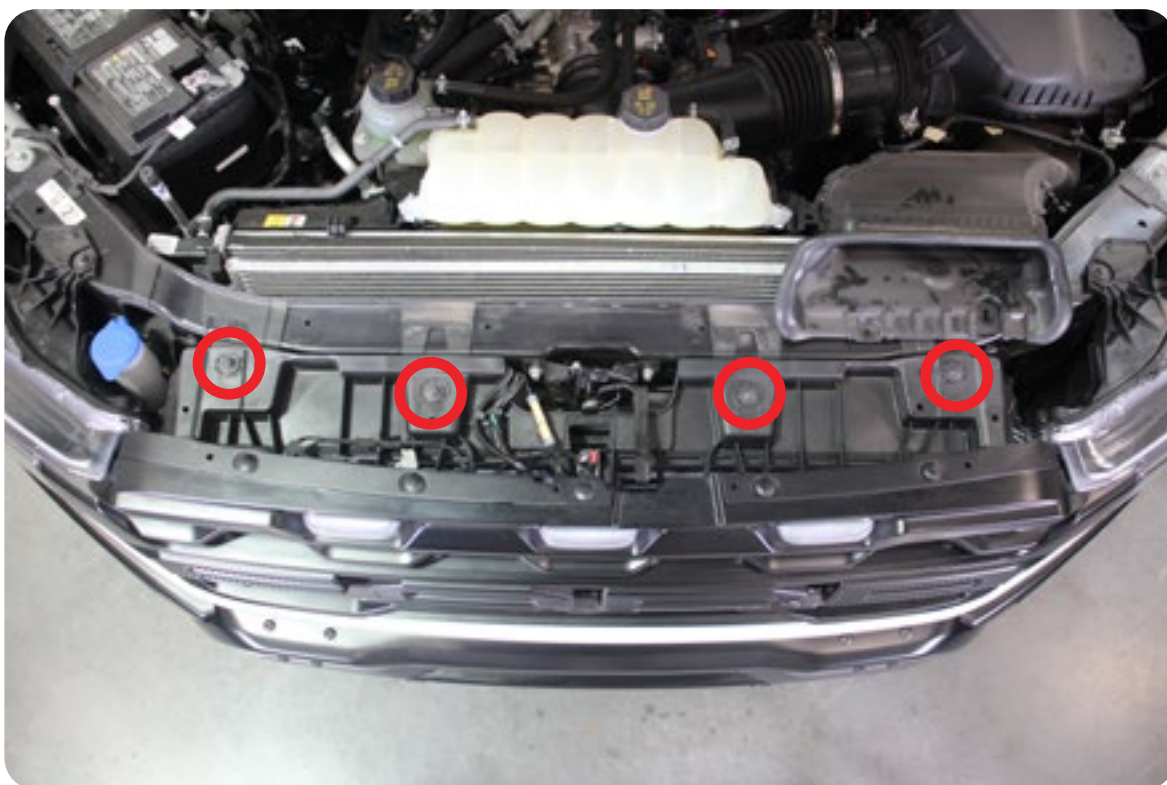
PRO-PLUS FRAME-CUT FRONT BUMPER

2021-UP FORD F-150 RAPTOR

REMOVAL

□ STEP 2

Using a (10mm) remove the (4) upper grill mounting bolts.





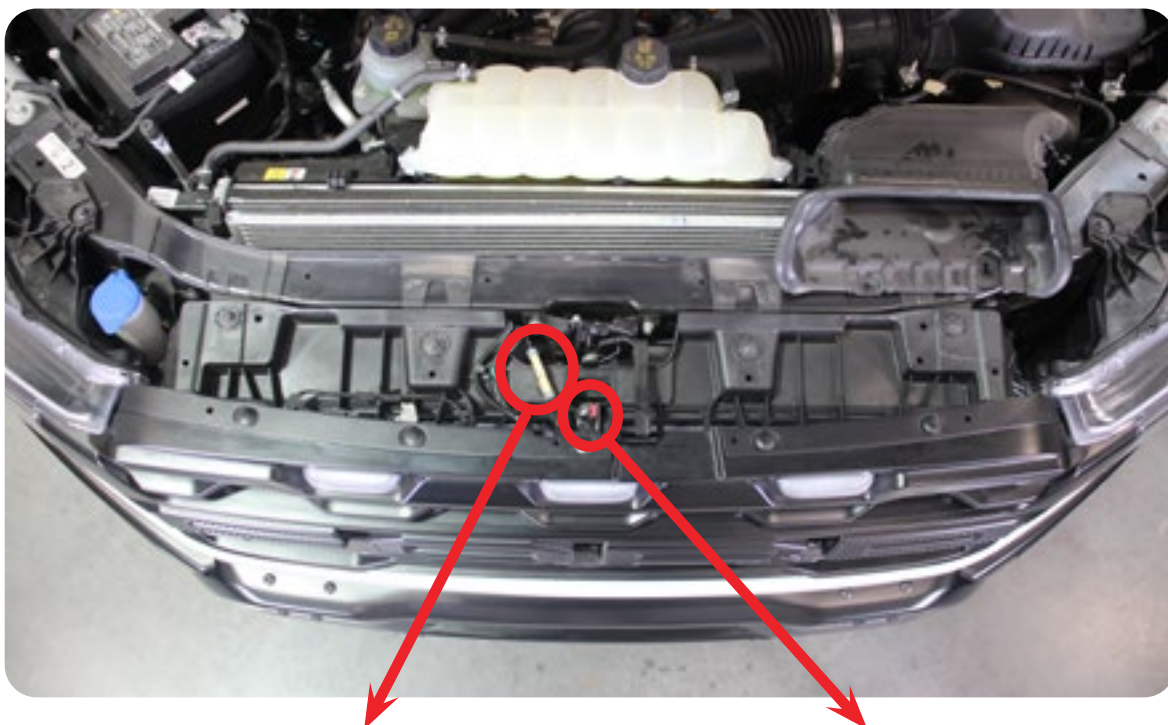
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PRO-PLUS FRAME-CUT FRONT BUMPER 2021-UP FORD F-150 RAPTOR

REMOVAL

□ STEP 3

Unplug the front parking camera plug and the upper shutter motor as shown below.





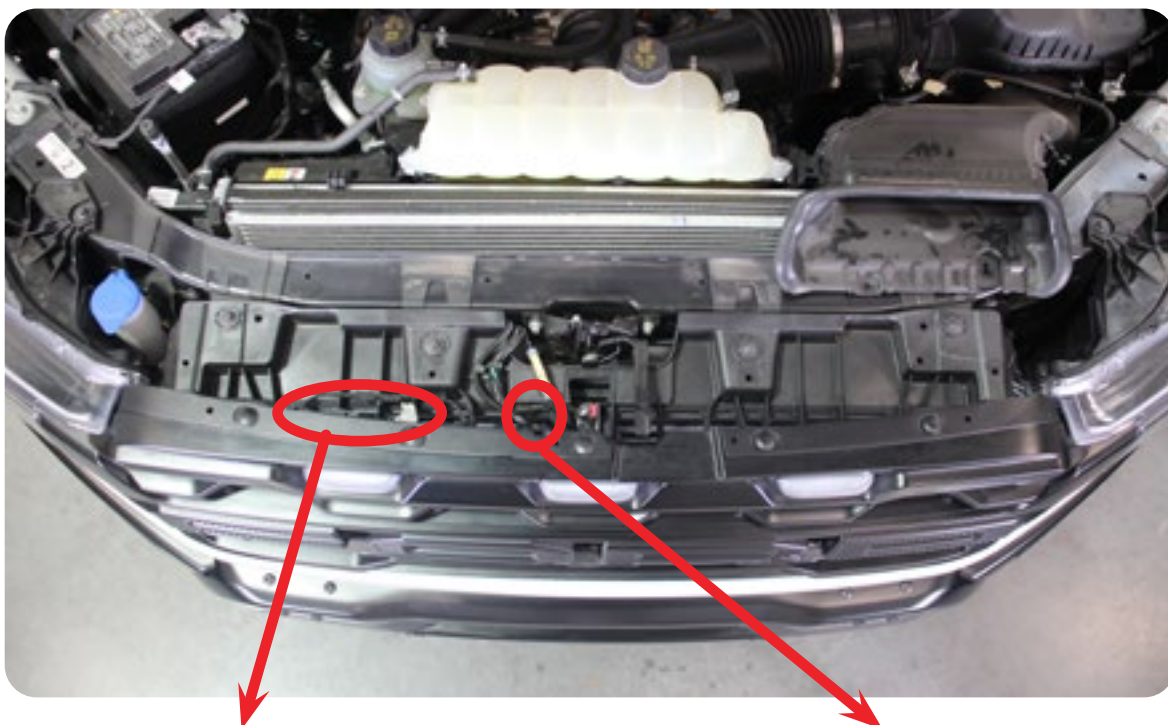
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PRO-PLUS FRAME-CUT FRONT BUMPER 2021-UP FORD F-150 RAPTOR

REMOVAL

□ STEP 4

Disconnect the washer fluid hose as shown below.





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PRO-PLUS FRAME-CUT FRONT BUMPER

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REMOVAL

□ STEP 5

Using a (7mm socket) remove the (4) fender flare bolts indicated below.





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PRO-PLUS FRAME-CUT FRONT BUMPER

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REMOVAL

□ STEP 6

With the bolts removed, pull the fender flares outwards to release the plastic retaining clips.





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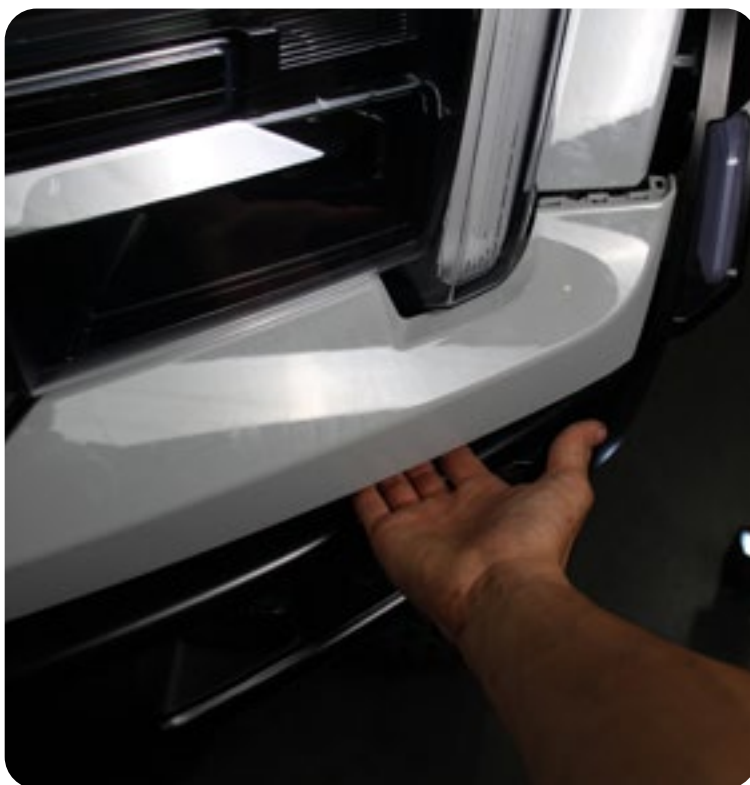
PRO-PLUS FRAME-CUT FRONT BUMPER

2021-UP FORD F-150 RAPTOR

REMOVAL

□ STEP 7

Starting from the driver side gently pull to release the clips retaining the front valance.





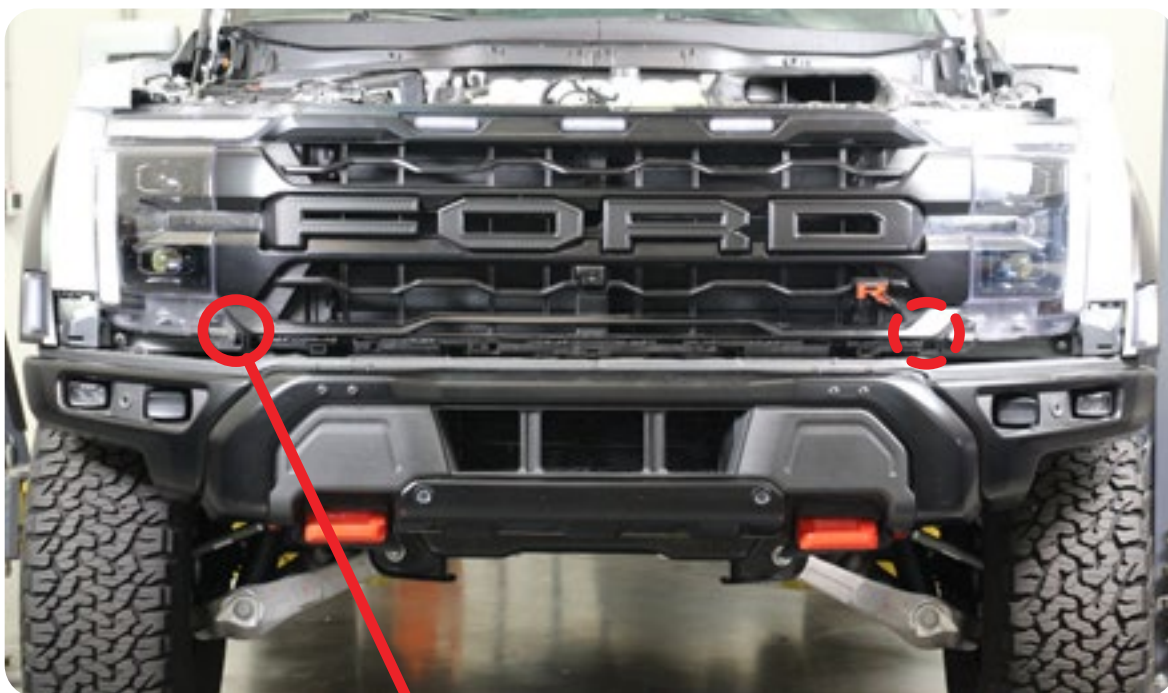
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PRO-PLUS FRAME-CUT FRONT BUMPER 2021-UP FORD F-150 RAPTOR

REMOVAL

□ STEP 8

Using a (10mm socket) remove the (2) OE bolts indicated below. You can now remove the front grill assembly.





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PRO-PLUS FRAME-CUT FRONT BUMPER

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REMOVAL

□ STEP 9

Remove the (6) bolts to release the OEM skid plate using a (13mm and a 15mm socket).





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REMOVAL

□ STEP 10

Remove the skid plate spacer.





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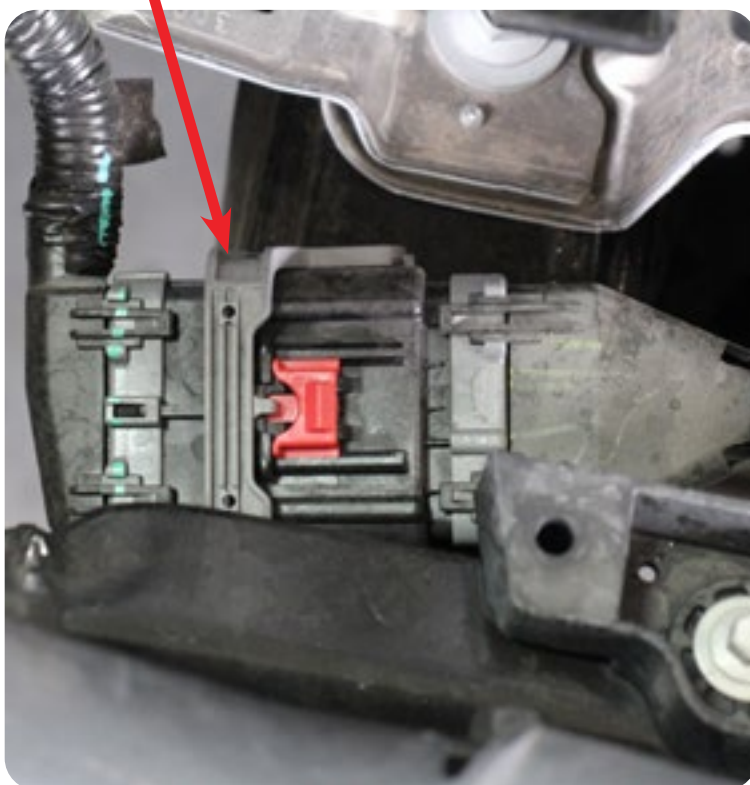
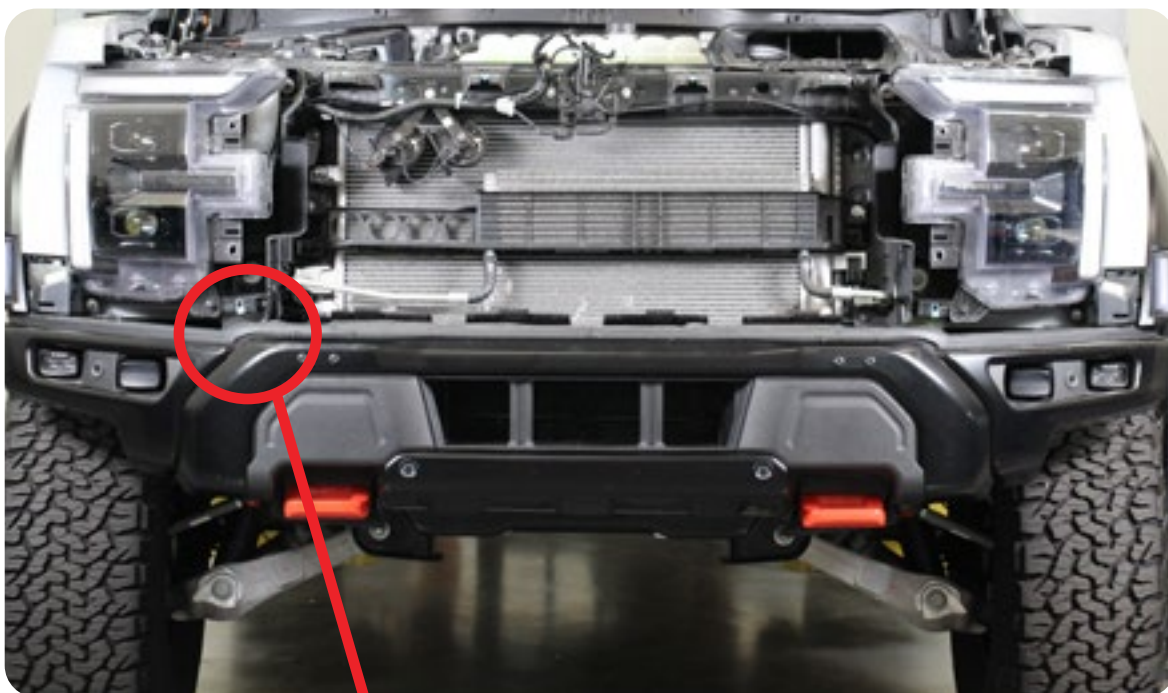
PRO-PLUS FRAME-CUT FRONT BUMPER

2021-UP FORD F-150 RAPTOR

REMOVAL

□ STEP 11

With the grill removed, unplug the main wire harness plug located on top of the passenger side frame horn.





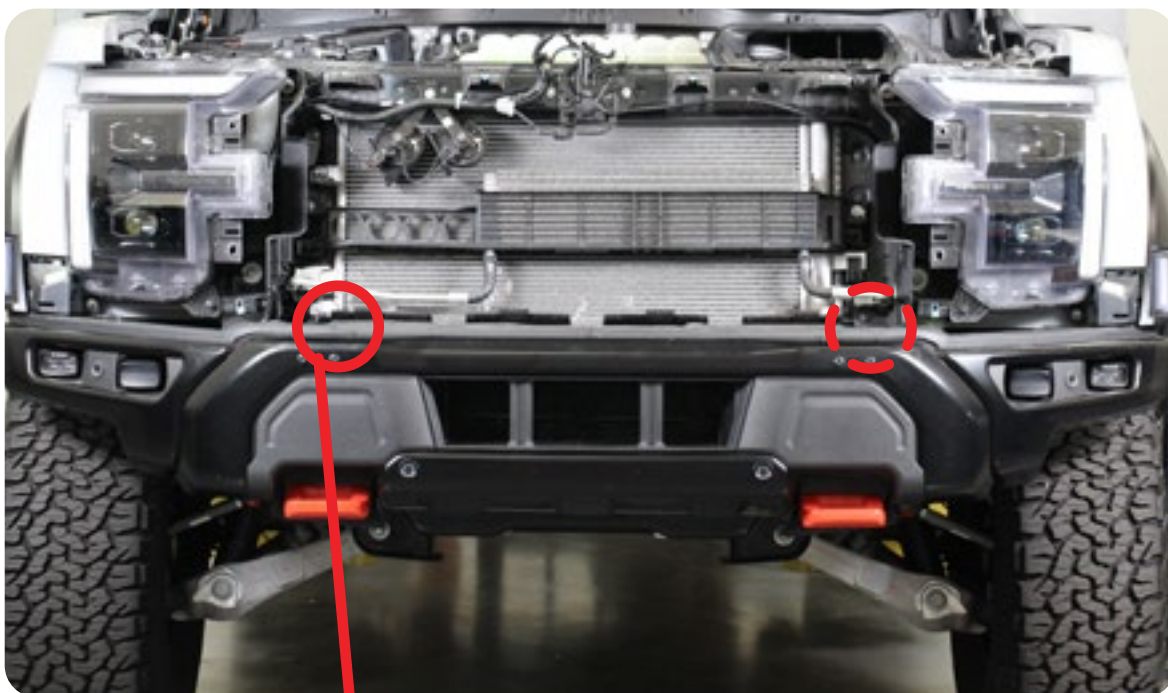
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REMOVAL

□ STEP 12

Using a (8mm socket) remove the (2) support braces as shown below.





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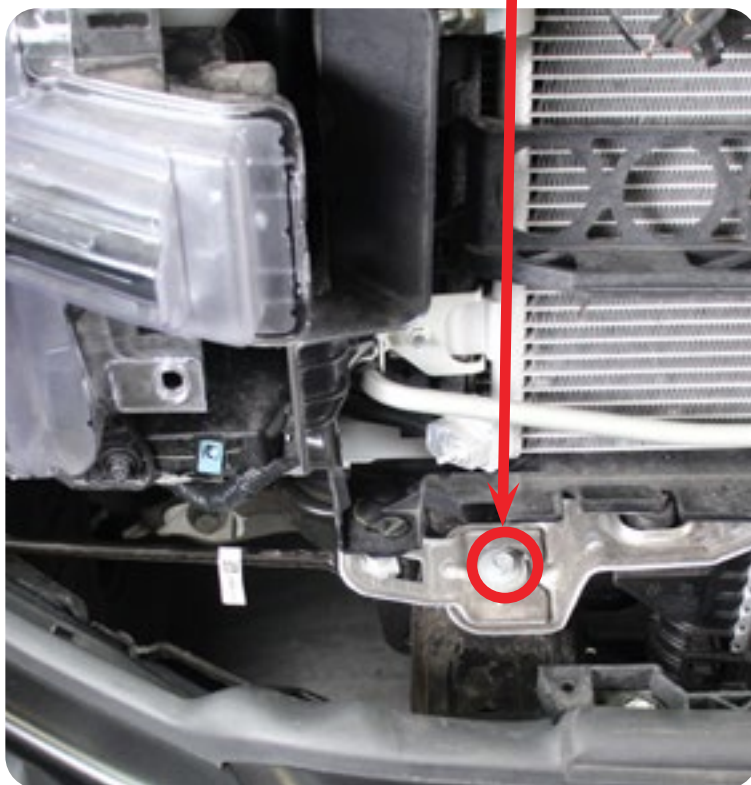
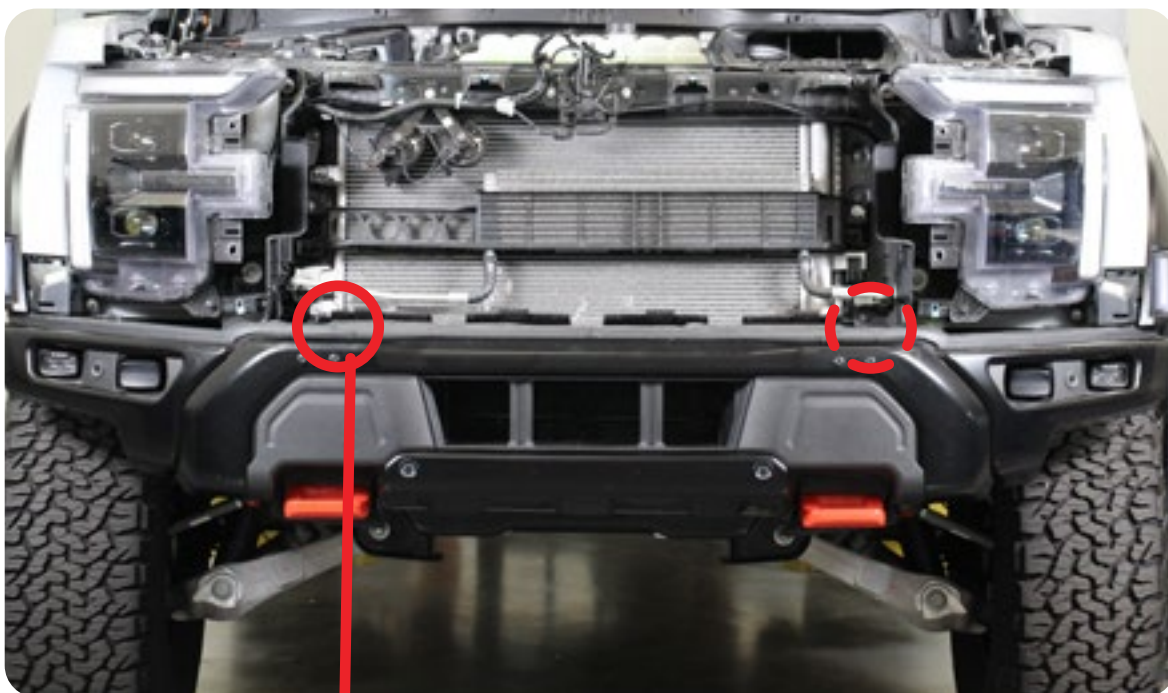
PRO-PLUS FRAME-CUT FRONT BUMPER

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REMOVAL

STEP 13

Using a (13mm socket) remove the (2) lower core support bolts indicated below.





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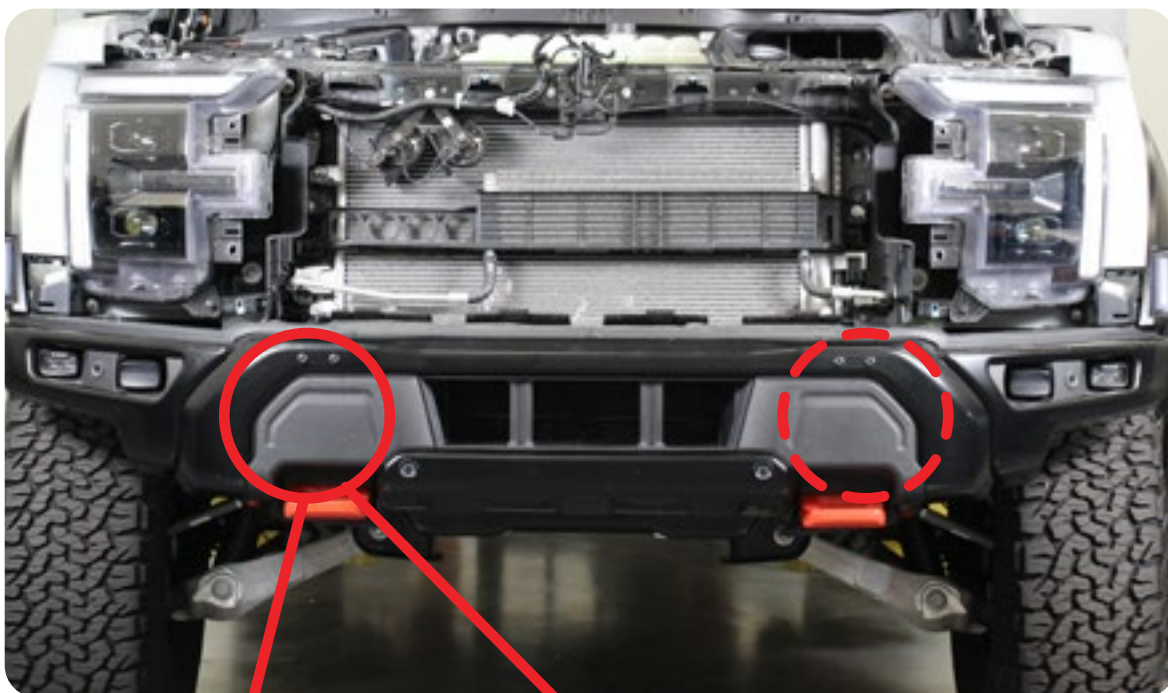
PRO-PLUS FRAME-CUT FRONT BUMPER

2021-UP FORD F-150 RAPTOR

REMOVAL

□ STEP 14

Using a (13/16 socket) remove the (3) bumper mounting bolts as shown below. (Repeat on other side) You can now remove the front bumper.





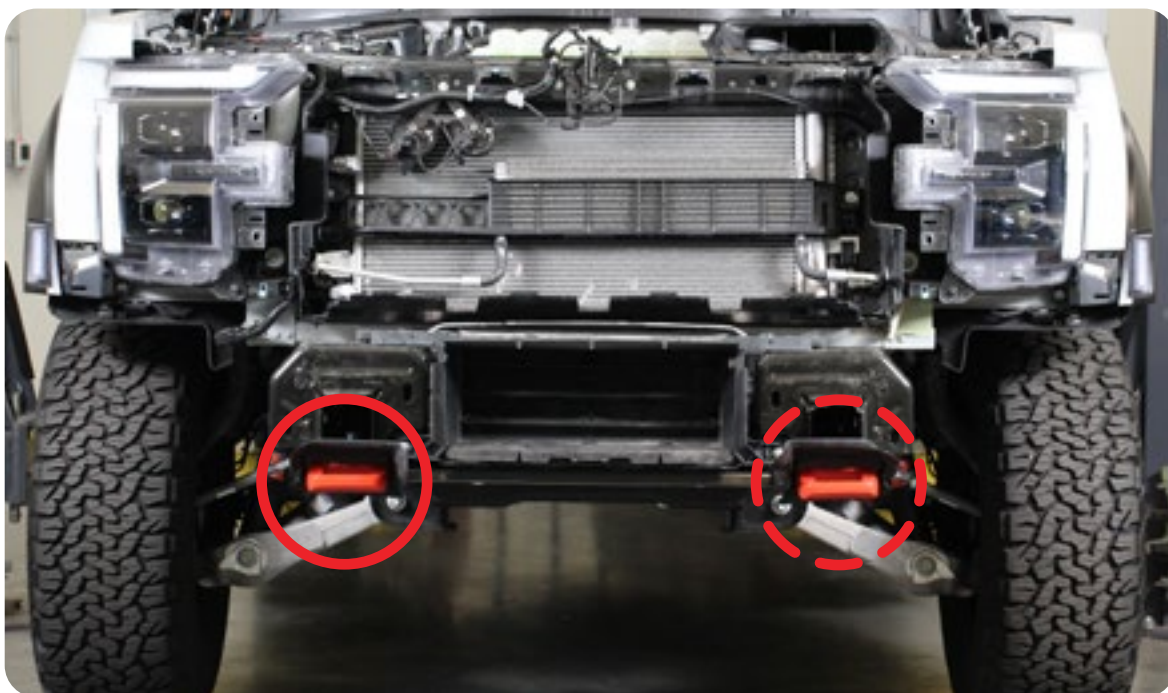
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PRO-PLUS FRAME-CUT FRONT BUMPER 2021-UP FORD F-150 RAPTOR

REMOVAL

□ STEP 15

Using a (15mm socket) remove the (2) front tow hooks along with the (2) flag nuts located inside of the frame horn.





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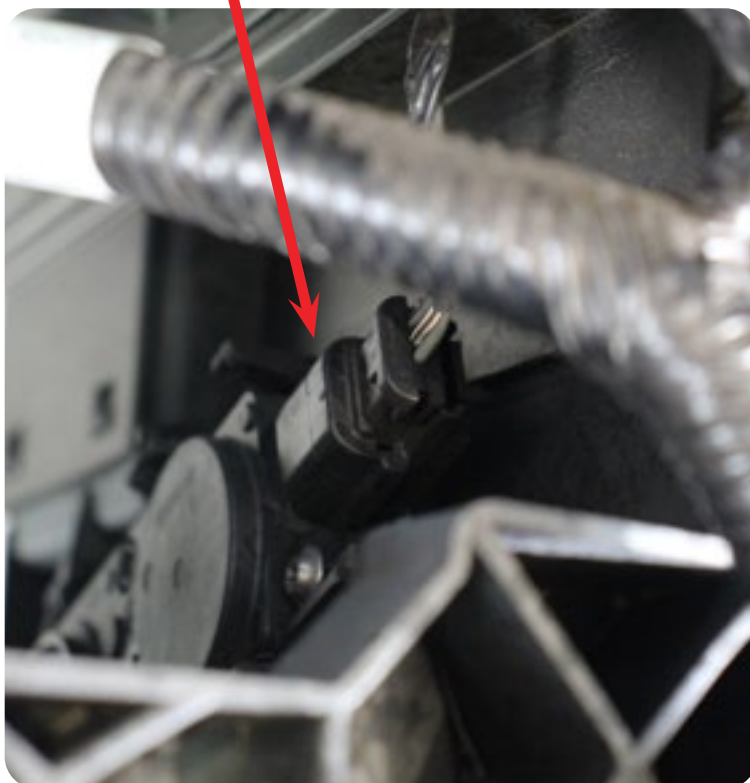
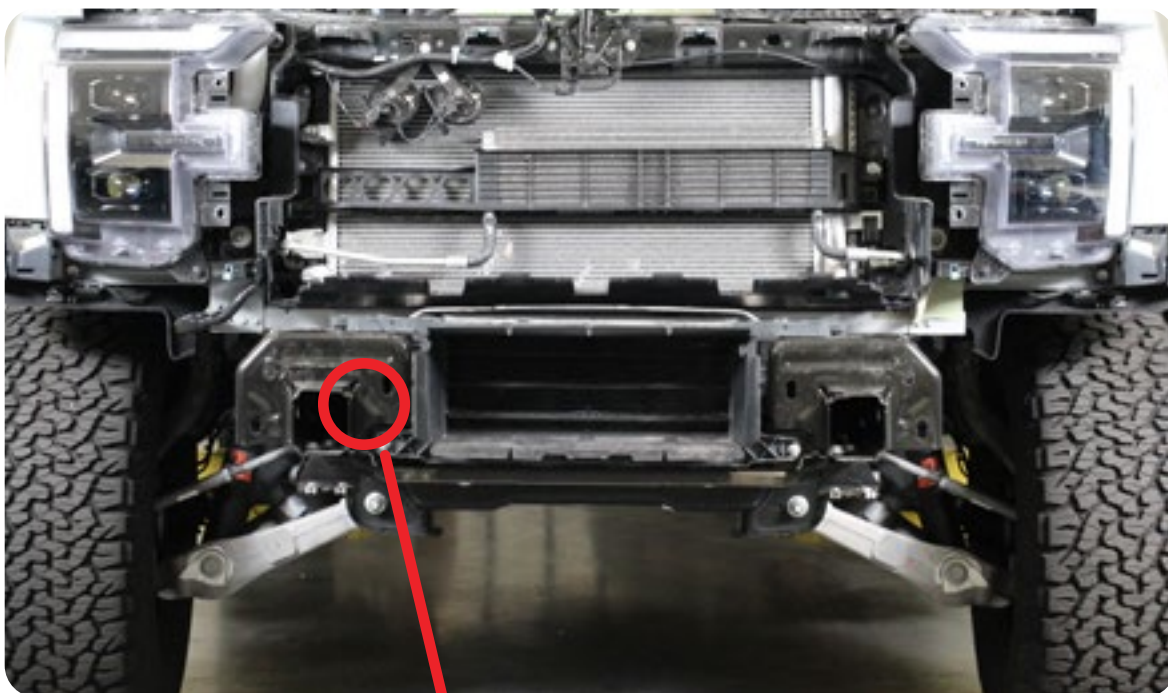
PRO-PLUS FRAME-CUT FRONT BUMPER

2021-UP FORD F-150 RAPTOR

REMOVAL

□ STEP 16

Locate the heat exchanger/intercooler shutter motor plug as shown below.





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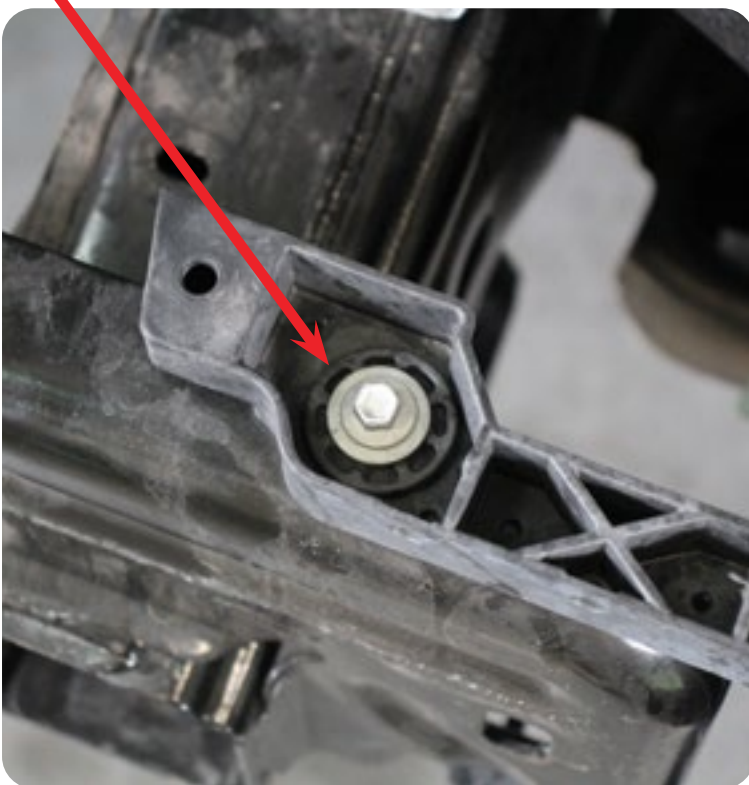
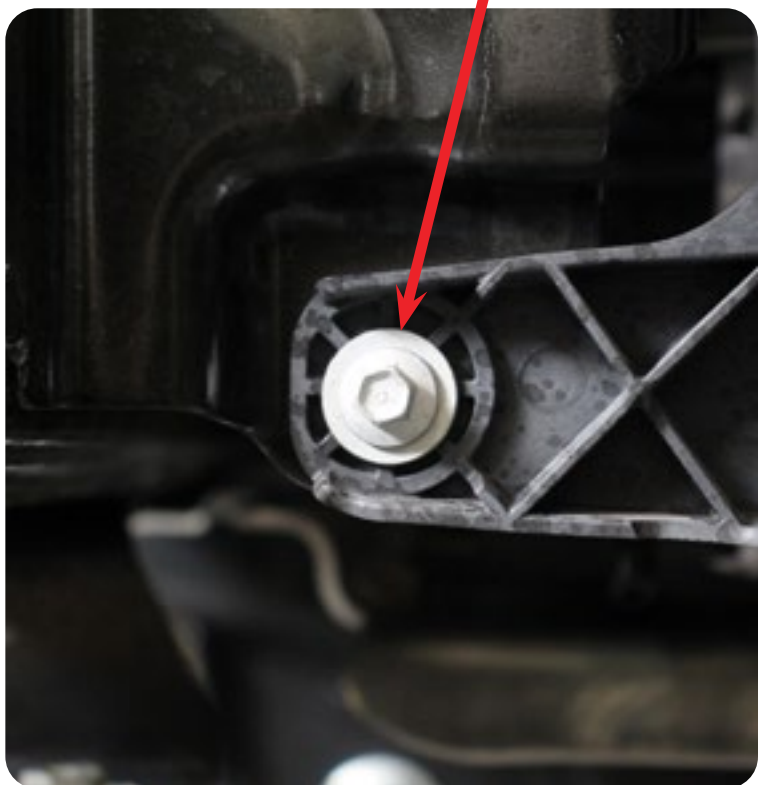
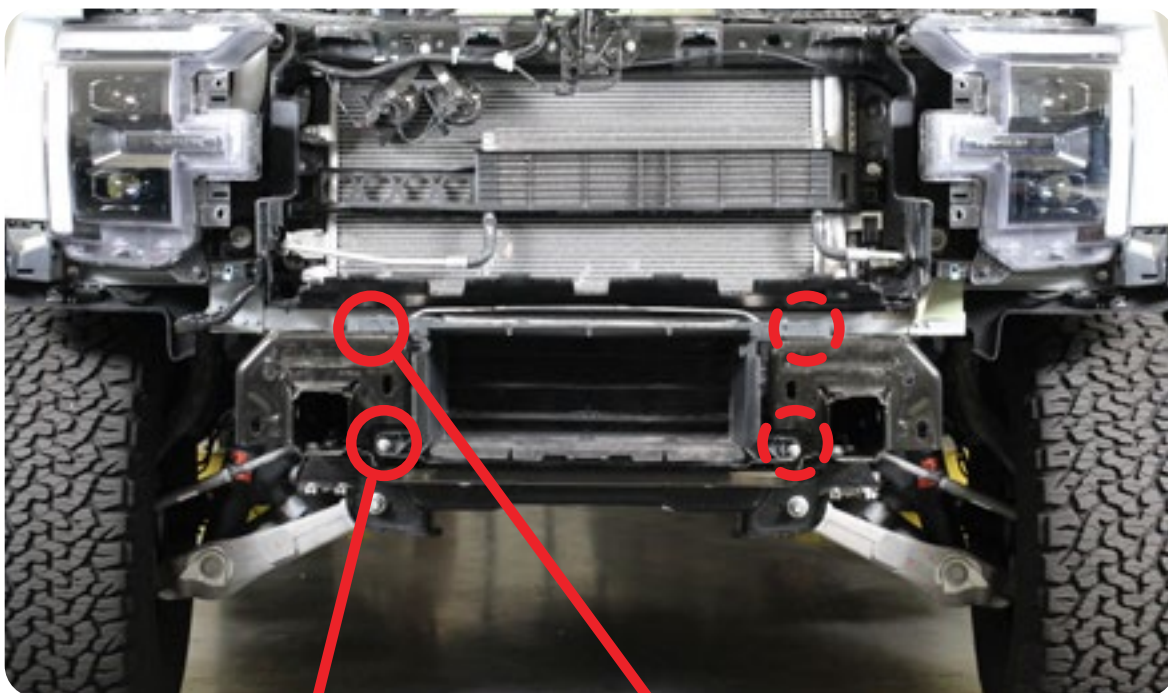
PRO-PLUS FRAME-CUT FRONT BUMPER

2021-UP FORD F-150 RAPTOR

REMOVAL

□ STEP 17

Using a (10mm socket) remove the (4) bolts indicated below.
Then remove the heat exchanger/intercooler shutter grill.





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PRO-PLUS FRAME-CUT FRONT BUMPER

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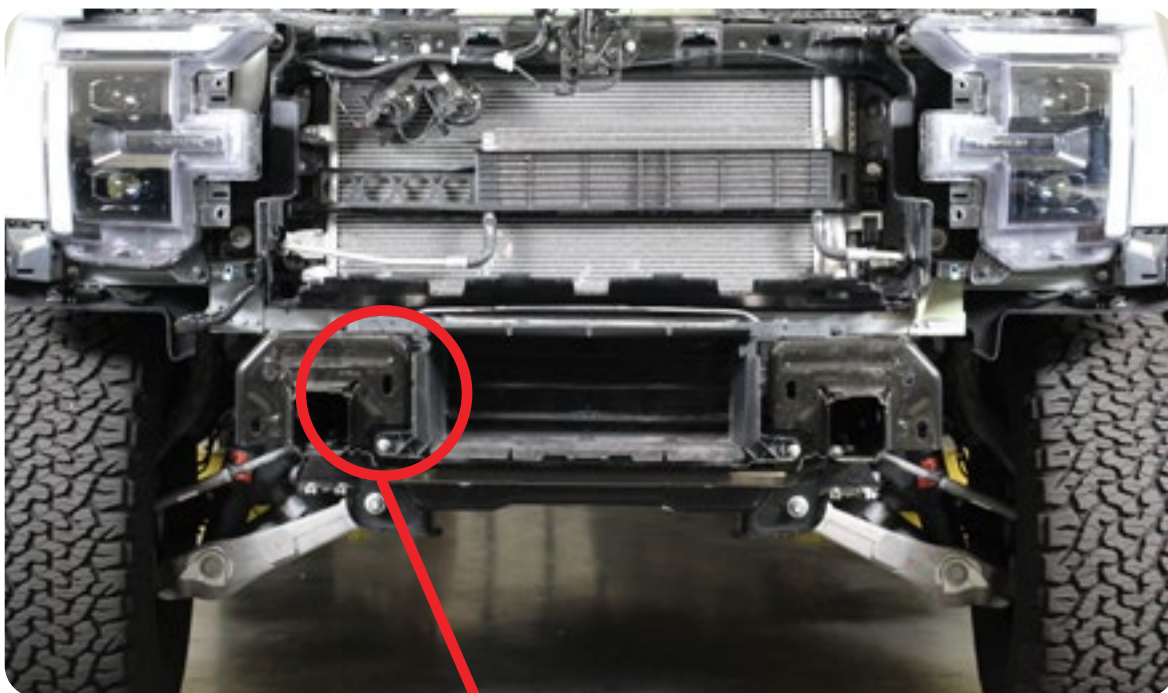
REMOVAL

□ STEP 18

Locate the shutter motor on the side of the shutter grille, Then use a (T27 Torx) to remove the shutter motor.

Refer to the install guide linked below for the shutter motor relocation kit.

https://www.addictivedesertdesigns.com/cdn/shop/files/ADD_InstallGuide_AC1300900NA.pdf?v=4894805209185784070





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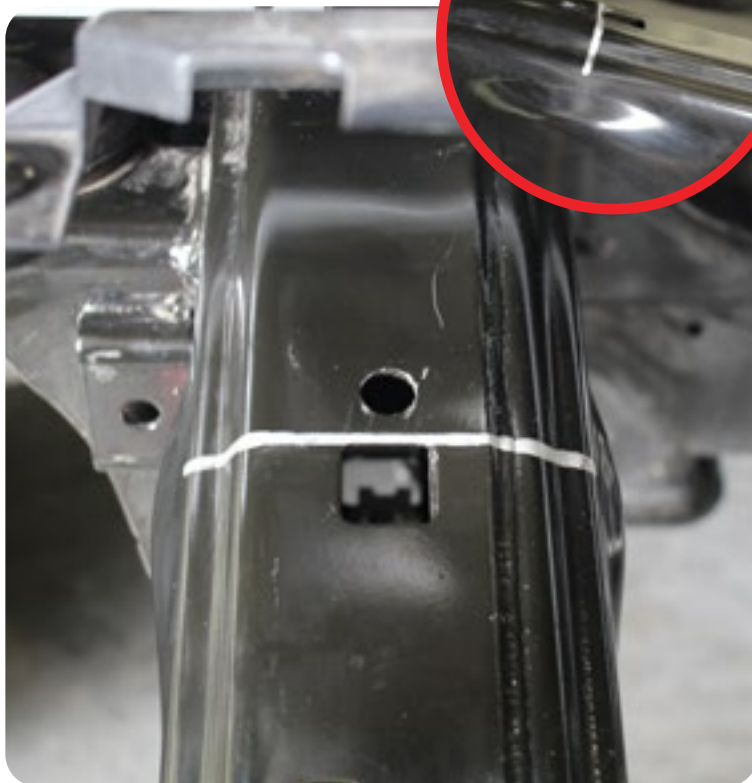
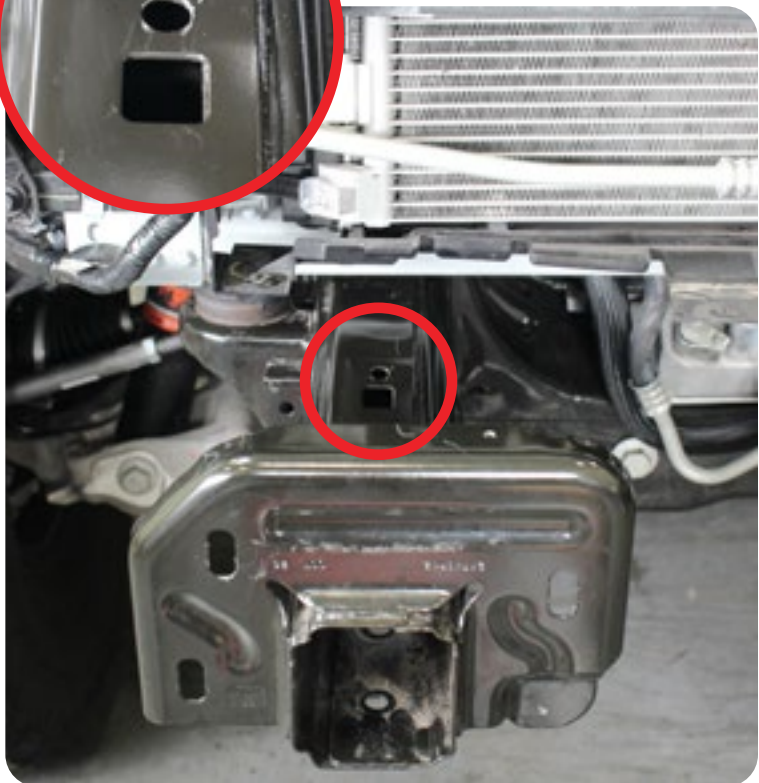
PRO-PLUS FRAME-CUT FRONT BUMPER

2021-UP FORD F-150 RAPTOR

REMOVAL

□ STEP 19

With everything now removed use a straight edge to mark along the top of the frame as shown below.
(Ensure you have removed the factory U-Nut before marking any lines.)





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PRO-PLUS FRAME-CUT FRONT BUMPER

2021-UP FORD F-150 RAPTOR

REMOVAL

□ STEP 20

Use a straight edge to mark along the bottom of the frame as shown below.

(Ensure you have removed the factory U-Nut before marking any lines.)





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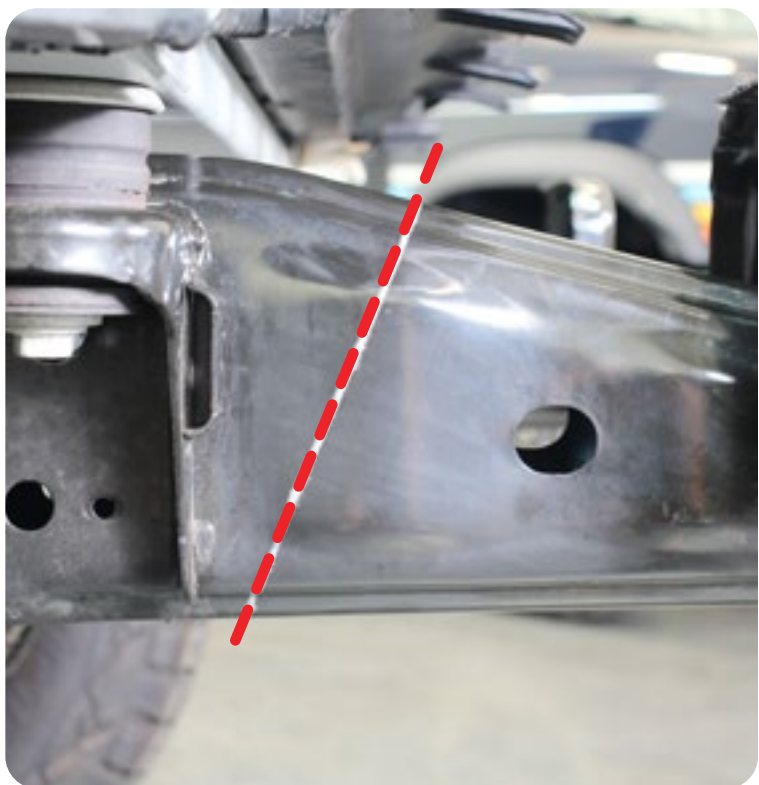
PRO-PLUS FRAME-CUT FRONT BUMPER

2021-UP FORD F-150 RAPTOR

REMOVAL

□ STEP 21

With both the top and bottom of the frame horn marked connect the lines using a straight edge and a marker. Once all lines are marked cut the frame horn using your cutting tool of choice.





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PRO-PLUS FRAME-CUT FRONT BUMPER

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INSTALL

□ STEP 22

You can now loosely install the supplied mounting plates to the frame using the supplied (D, D1, D2) 3/4" hardware, and the OE bolts previously removed.





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PRO-PLUS FRAME-CUT FRONT BUMPER

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INSTALL

At this point please refer to the install guides that correlate with your vehicle.

2015-Up Ford F-150 & Raptor ADD High Mount Intercooler Upgrade Kit

<https://www.addictivedesertdesigns.com/collections/3rd-gen-f-150-raptor-accessories/products/ford-raptor-add-intercooler-upgrade-kit>

2023-Up Ford F-150 Raptor R ADD High Mount Performance Heat Exchanger Kit

<https://www.addictivedesertdesigns.com/collections/new-off-road-products/products/raptor-r-high-mount-heat-exchanger-kit>



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PRO-PLUS FRAME-CUT FRONT BUMPER 2021-UP FORD F-150 RAPTOR

REMOVAL

□ STEP 23

Using a (10mm socket), remove the covers to expose the wire harness.





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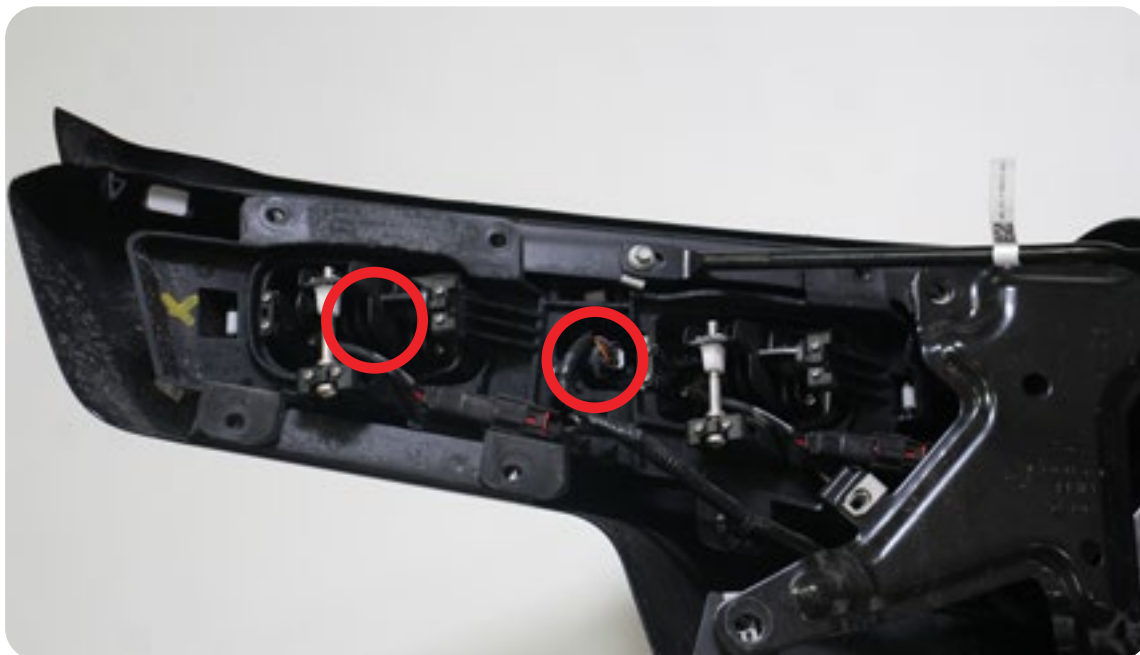
PRO-PLUS FRAME-CUT FRONT BUMPER

2021-UP FORD F-150 RAPTOR

REMOVAL

□ STEP 24

Disconnect both electrical connectors on the factory fog lights indicated below. You can now remove the factory fog light housing.





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PRO-PLUS FRAME-CUT FRONT BUMPER

2021-UP FORD F-150 RAPTOR

REMOVAL

□ STEP 25

Once removed locate the ACC module and release the electrical connector.
(Reference the [ADD Adaptive Cruise Control Relocation Bracket install guide](#))





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REMOVAL





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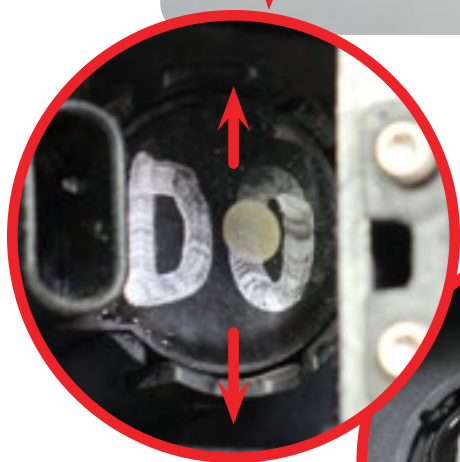
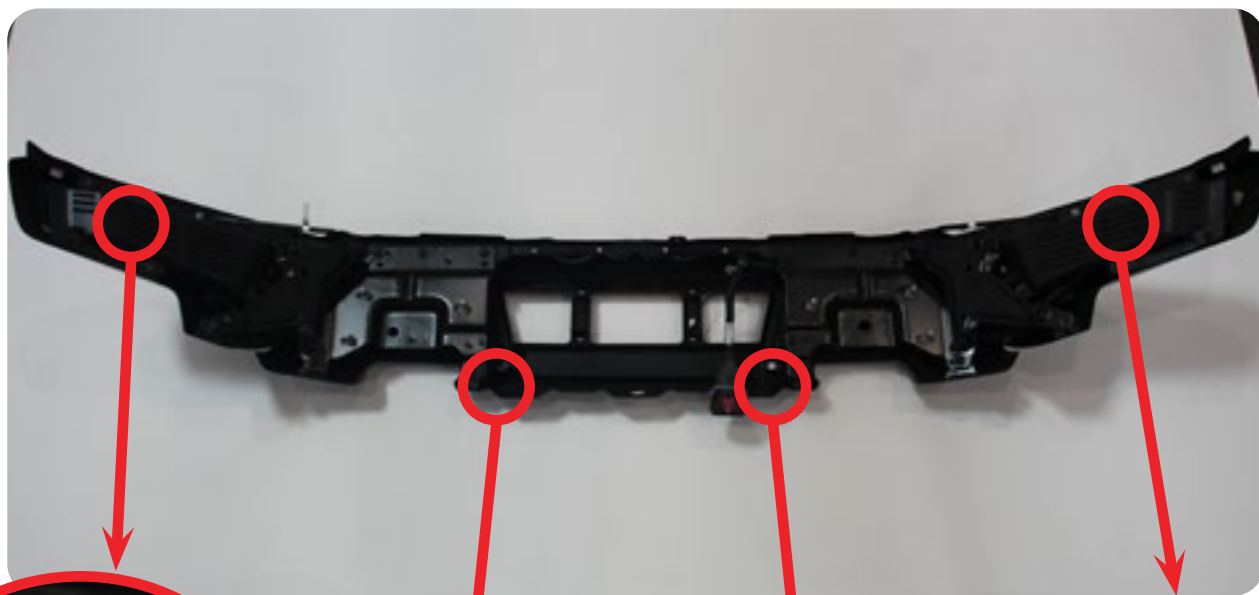
PRO-PLUS FRAME-CUT FRONT BUMPER

2021-UP FORD F-150 RAPTOR

REMOVAL

□ STEP 26

Remove all four parking sensors from the stock bumper and remove wire harness.
(Remember the factory orientation of each sensor for the install)



PRO-PLUS FRAME-CUT FRONT BUMPER 2021-UP FORD F-150 RAPTOR

REMOVAL

□ STEP 27

Remove all (4) sensor bezels by pushing the tabs together and then pressing them outward towards the face of the bumper.

(Remember the factory orientation of each sensor bezel for the install)





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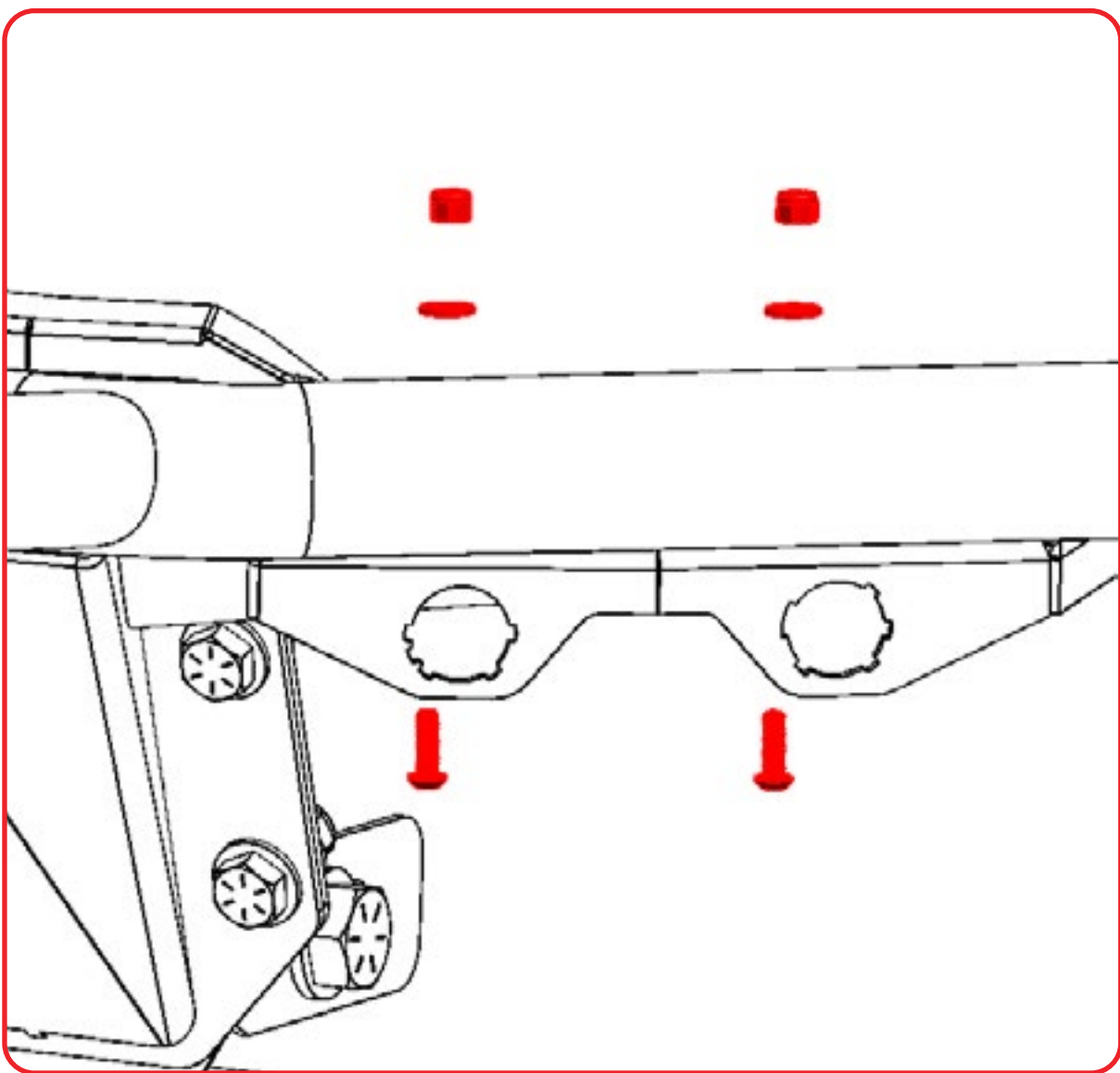
PRO-PLUS FRAME-CUT FRONT BUMPER

2021-UP FORD F-150 RAPTOR

INSTALL

□ STEP 28

Install the parking sensor brackets using the provided (A, A1, A2) 1/4 hardware, 5/32 allen, and a 7/16 wrench.





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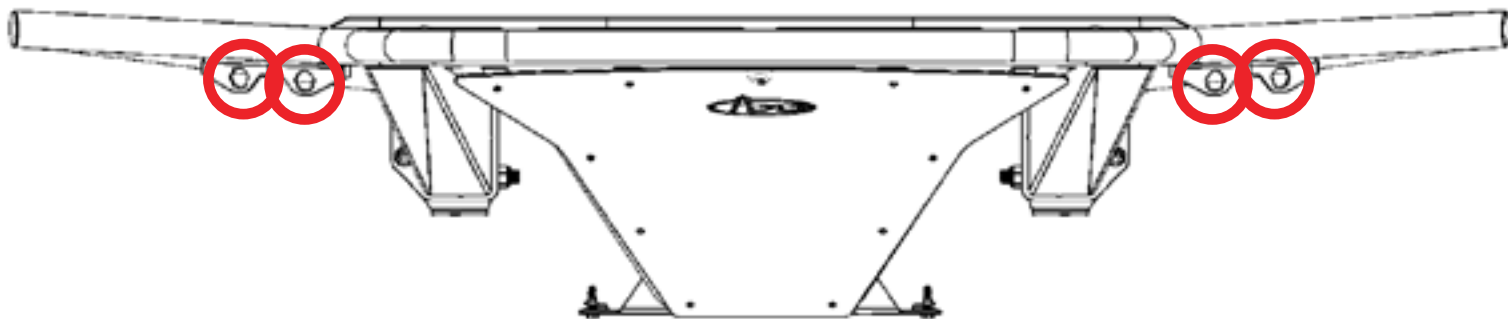
PRO-PLUS FRAME-CUT FRONT BUMPER

2021-UP FORD F-150 RAPTOR

INSTALL

□ STEP 29

Install the sensor bezels into the ADD bumper. ****If the bezels do not click into place you may have to trim the tabs to match the thickness of the bumper as shown below****





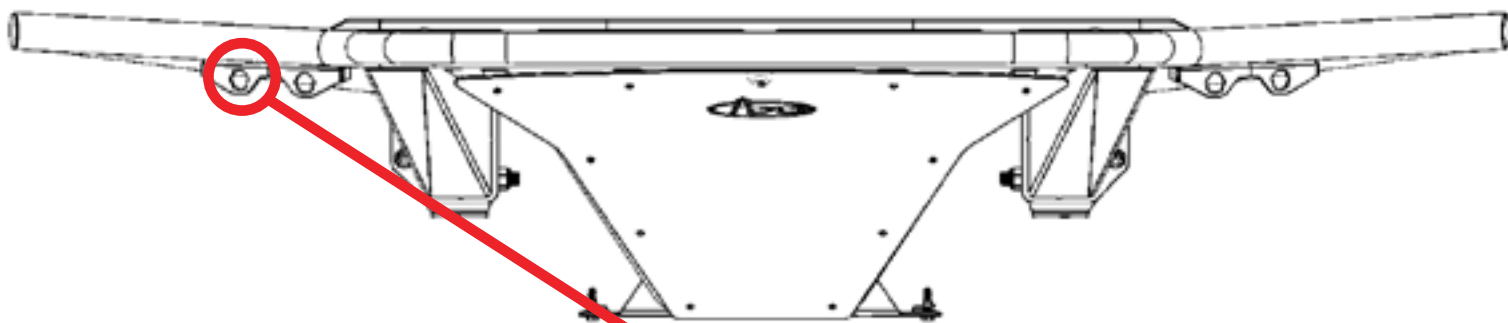
INSTALLATION GUIDE

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INSTALL

□ STEP 30

Passenger outer sensor orientation





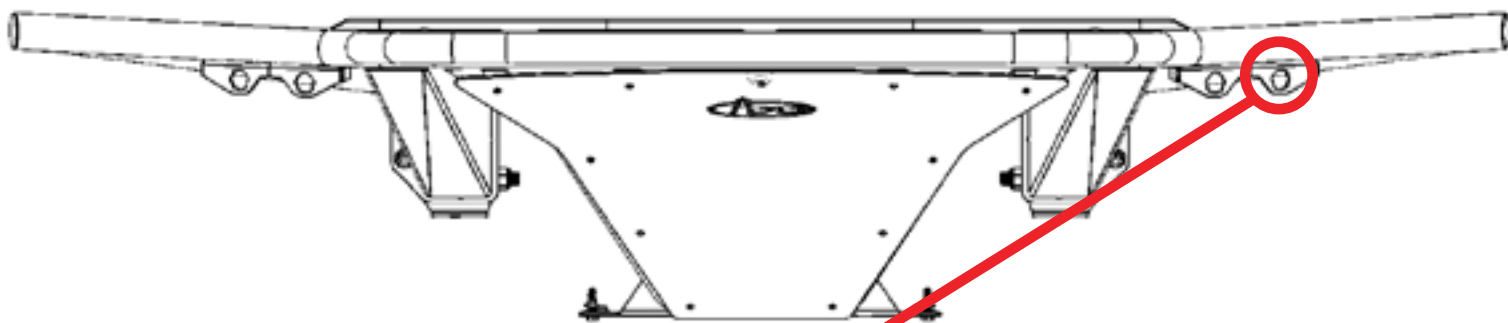
INSTALLATION GUIDE

PRO-PLUS FRAME-CUT FRONT BUMPER 2021-UP FORD F-150 RAPTOR

INSTALL

□ STEP 31

Driver outer sensor orientation





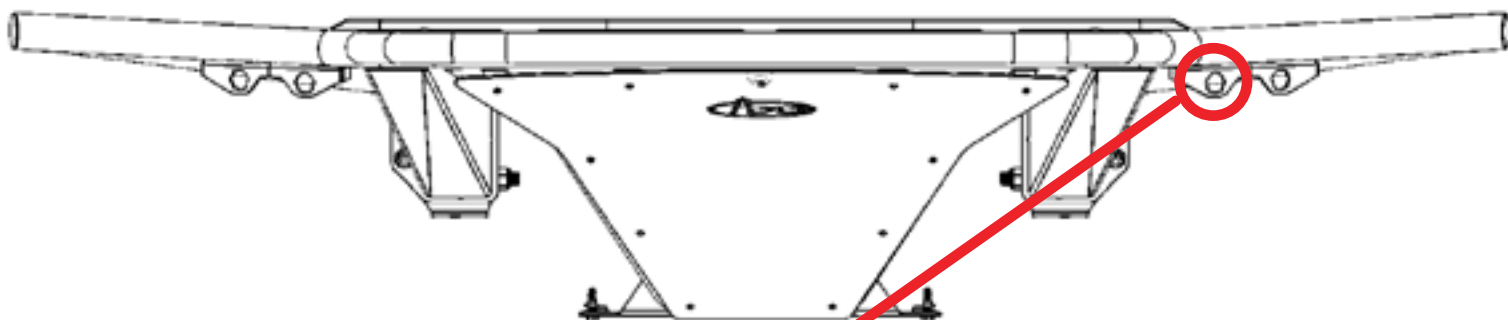
INSTALLATION GUIDE

PRO-PLUS FRAME-CUT FRONT BUMPER 2021-UP FORD F-150 RAPTOR

INSTALL

□ STEP 32

Driver inner sensor orientation.





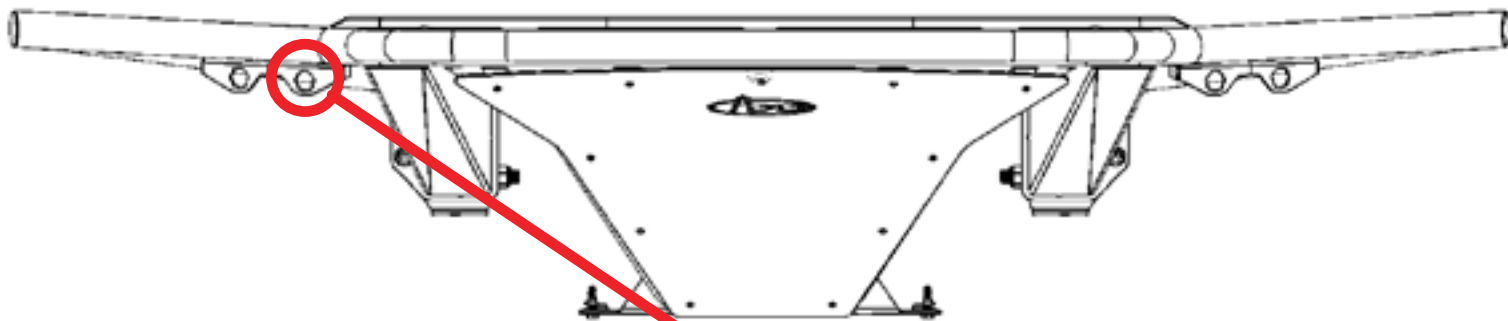
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INSTALL

□ STEP 33

Passenger inner sensor orientation.





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INSTALL

□ STEP 34

Route the wiring harness underneath the light bar and zip tie to the bumper using the provided zip tie tabs along the back of the light mount.





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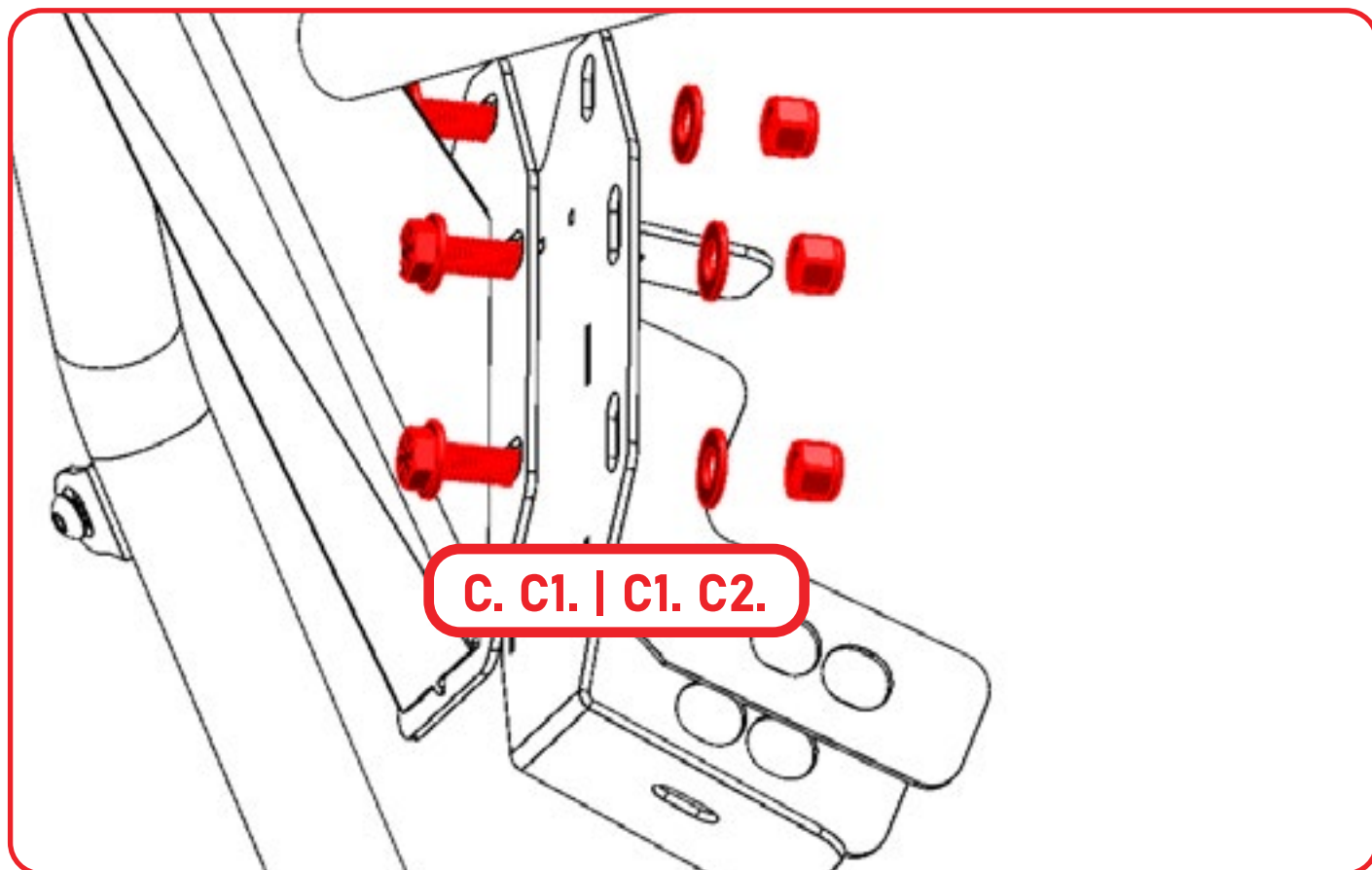
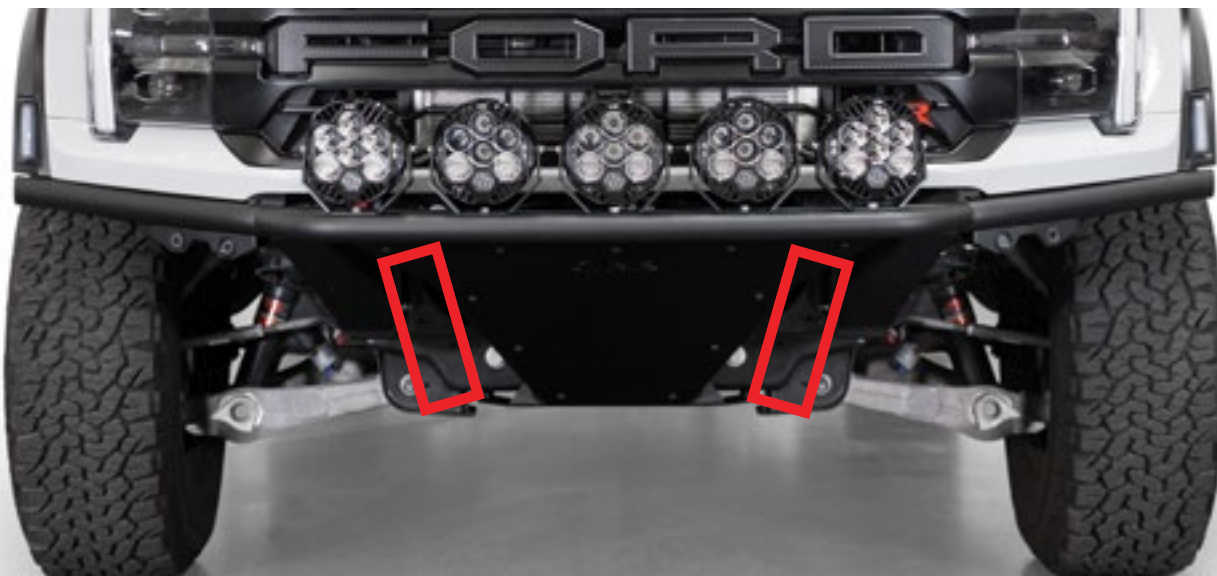
PRO-PLUS FRAME-CUT FRONT BUMPER

2021-UP FORD F-150 RAPTOR

INSTALL

□ STEP 35

You can now install front bumper using the provided (C, C1, C2) 1/2" hardware and a 3/4 wrench and socket. Once adjusted to desired fitment tighten all mounting hardware including the mount adapter hardware.





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INSTALL

□ STEP 36

Secure the skid plate using the OE spacer previously removed and the provided (B1, B2) 3/8 hardware and a (9/16 wrench).





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INSTALL

☐ STEP 37

Now would be a good time to install your lights.





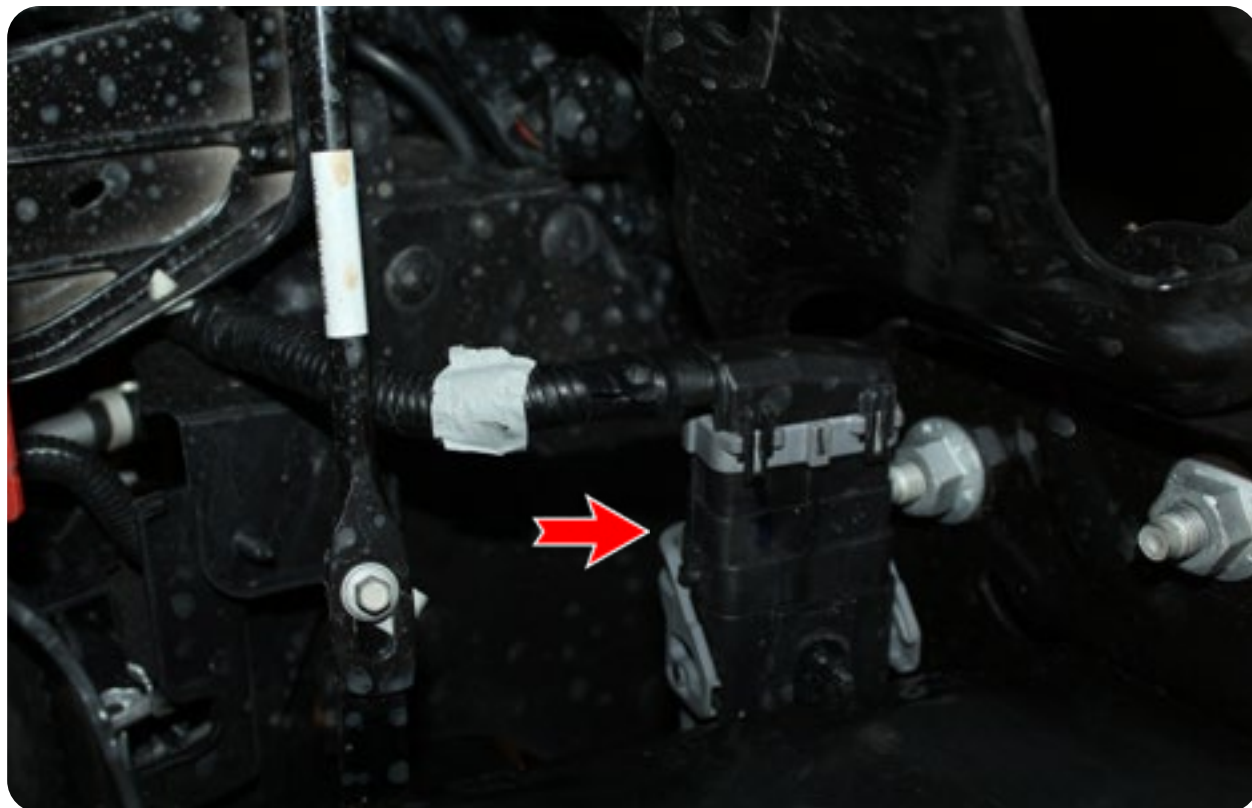
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INSTALL

□ STEP 38

Plug in the wire harness. ****Ensure the clip is fully pushed down when plugged in as shown below****





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FINAL

□ STEP 39

Stand back and enjoy your new ADD Pro-Plus Frame-Cut Front Bumper.

Check and re-tighten all mounting bolts after 100 miles and periodically thereafter.



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EMAIL INFO@ADDICTIVEDESERTDESIGNS.COM