



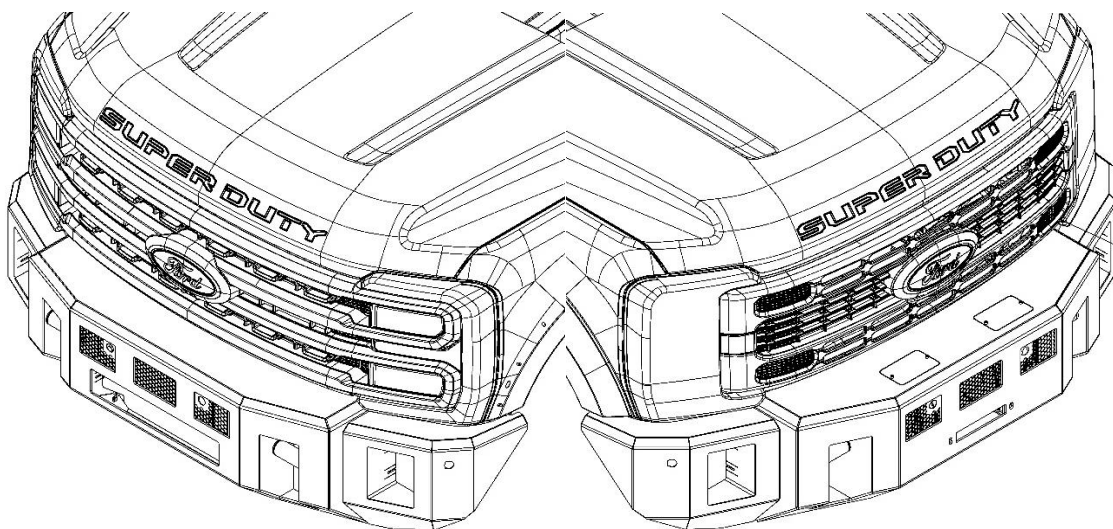
# Alpha and Delta Series Front Bumper Installation Manual

- 2023 Ford Super Duty

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# Alpha and Delta Series Front Bumper

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**Delta  
Light**

**Alpha  
Winch**

## - Contents

- Kit Numbers.....	(3)
- Introduction.....	(4)
- Safety.....	(5)
- Bumper Removal .....	(6)
- Bumper Preparation .....	(9)
- Bumper Assembly.....	(10)
- Bumper Installation.....	(14)
- Parts Key.....	(16)
- Contact Information.....	(18)

# Kit Numbers

- This installation manual covers the following front bumpers.

Kit Number	Description
KLM-402021023-001020000	2023+ F250 Alpha Winch – Adaptive Cruise – Stock Width
KLM-402021023-002020000	2023+ F250 Alpha Winch – Stock Width
KLM-402021023-001021200	2023+ F250 Alpha Winch – Adaptive Cruise – Wide Width
KLM-402021023-002021200	2023+ F250 Alpha Winch – Wide Width
KLM-402022023-001020000	2023+ F350 Alpha Winch – Adaptive Cruise – Stock Width
KLM-402022023-002020000	2023+ F350 Alpha Winch – Stock Width
KLM-402022023-001021200	2023+ F350 Alpha Winch – Adaptive Cruise – Wide Width
KLM-402022023-002021200	2023+ F350 Alpha Winch – Wide Width
KLM-402023023-001021200	2023+ F450 Alpha Winch – Adaptive Cruise – Wide Width
KLM-402023023-002021200	2023+ F450 Alpha Winch – Wide Width
KLM-402023023-001021200	2023+ F450 Alpha Winch – Adaptive Cruise – Wide Width
KLM-402023023-002021200	2023+ F450 Alpha Winch – Wide Width
KLM-402024023-001021200	2023+ F550 Alpha Winch – Adaptive Cruise – Wide Width
KLM-402024023-002021200	2023+ F550 Alpha Winch – Wide Width
KLM-402024023-001021200	2023+ F550 Alpha Winch – Adaptive Cruise – Wide Width
KLM-402024023-002021200	2023+ F550 Alpha Winch – Wide Width
KLM-402032023-001021200	2023+ F600 Alpha Winch – Adaptive Cruise – Wide Width
KLM-402032023-002021200	2023+ F600 Alpha Winch – Wide Width
KLM-402032023-001021200	2023+ F600 Alpha Winch – Adaptive Cruise – Wide Width
KLM-402032023-002021200	2023+ F600 Alpha Winch – Wide Width
KLM-402021023-001040000	2023+ F250 Delta Light – Adaptive Cruise – Stock Width
KLM-402021023-002040000	2023+ F250 Delta Light – Stock Width
KLM-402021023-001041200	2023+ F250 Delta Light – Adaptive Cruise – Wide Width
KLM-402021023-002041200	2023+ F250 Delta Light – Wide Width
KLM-402022023-001040000	2023+ F350 Delta Light – Adaptive Cruise – Stock Width
KLM-402022023-002040000	2023+ F350 Delta Light – Stock Width
KLM-402022023-001041200	2023+ F350 Delta Light – Adaptive Cruise – Wide Width
KLM-402022023-002041200	2023+ F350 Delta Light – Wide Width
KLM-402023023-001040000	2023+ F450 Delta Light – Adaptive Cruise – Stock Width
KLM-402023023-002040000	2023+ F450 Delta Light – Stock Width
KLM-402023023-001041200	2023+ F450 Delta Light – Adaptive Cruise – Wide Width
KLM-402023023-002041200	2023+ F450 Delta Light – Wide Width
KLM-402024023-001040000	2023+ F550 Delta Light – Adaptive Cruise – Stock Width
KLM-402024023-002040000	2023+ F550 Delta Light – Stock Width
KLM-402024023-001041200	2023+ F550 Delta Light – Adaptive Cruise – Wide Width
KLM-402024023-002041200	2023+ F550 Delta Light – Wide Width
KLM-402032023-001040000	2023+ F600 Delta Light – Adaptive Cruise – Stock Width
KLM-402032023-002040000	2023+ F600 Delta Light – Stock Width
KLM-402032023-001041200	2023+ F600 Delta Light – Adaptive Cruise – Wide Width
KLM-402032023-002041200	2023+ F600 Delta Light – Wide Width

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# Introduction

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- **Important**

It is important that the entire installation instructions be read thoroughly before proceeding with bumper installation.

- **Product Installer Responsibilities**

Installer is responsible for installing this product in accordance with Kelderman Mfg. Inc. specifications and installation instructions.

Installer is responsible for providing proper installation of vehicle components and attachments as well as required or necessary clearance for suspension components, axles, wheels, tires, and other vehicle components to ensure a safe and sound installation and operation of this product.

- **Product Owner Responsibilities**

Owner is solely responsible for pre-operation inspection, periodic inspections, maintenance, and use of the product as specified by Kelderman Mfg. Inc. Of particular importance is the re-torque of fasteners. This re-torque must be performed within 90 days or 1000 miles of this product being put into service.

- **Definition of Terms**

- **Warning:** Indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.
- **Caution:** A potential hazardous situation may result in property damage.
- **Note:** Provide information or suggestions that help correctly perform a task.
- **Torque:** When italicized "*torque*" alerts the installer to tighten fasteners to a specified value.

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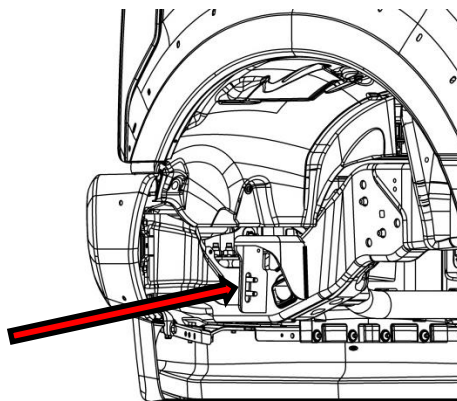
# Safety

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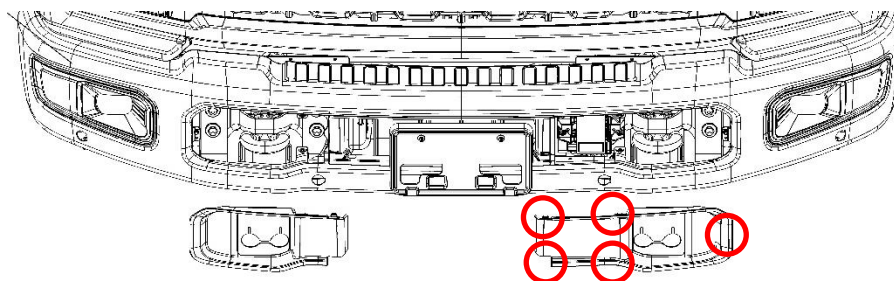
- **Your Safety and the Safety of Others is Very Important.**  
Read and understand all safety precautions and instructions before installing this product.
  
- **CAUTION: Trucks Equipped with Parking Sensors or Other Like Devices.**  
Relocation of these devices will alter the field of view. It is the responsibility of the owner to understand how these changes affect the operation of these systems.
  
- **This Product is Intended for Off-Road Use**  
All liability for installation and use rests with the owner.
  
- **WARNING: Careless Installation Can Result in Serious Injury or Property Damage**
  - Wear eye protection.
  - Disconnect the battery before doing any work on the vehicle.
  - Work on flat level ground.
  - Ensure truck is properly supported by jack stands. Never work under a vehicle supported only by hydraulic jacks.
  - Take precautions when lifting product. Due to the size and weight of this product three people are recommended for installation.
  - Never work directly under the product until it has been securely fastened to the vehicle.
  - Avoid sharp, hot, and moving components when routing electrical cables.
  - If drilling inspect both sides of the surface and remove/relocate any objects located in the way.
  - Ensure all bolts are properly tightened before driving.

# Bumper Removal

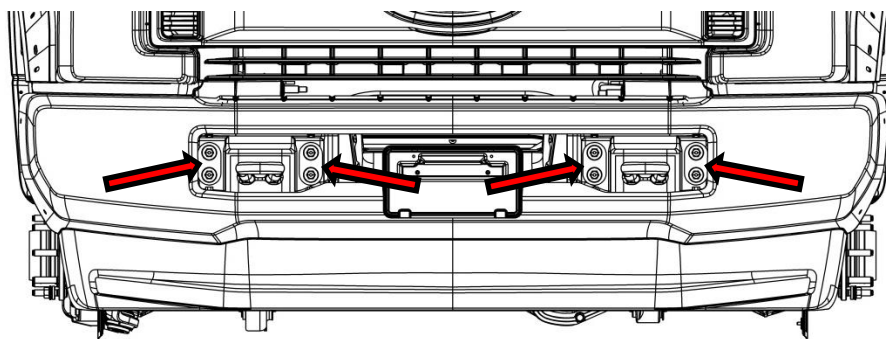
- 1: Disconnect the wiring to any lights, sensors, or other accessories mounted to the stock bumper.
- 2: Remove the bolt tab from each side that fasten the corner support to the frame.



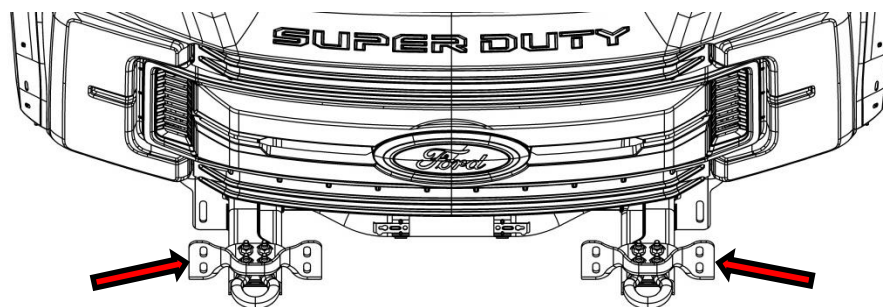
- 3: Remove the plastic covers around the tow hooks. There are five clips that secure each cover.



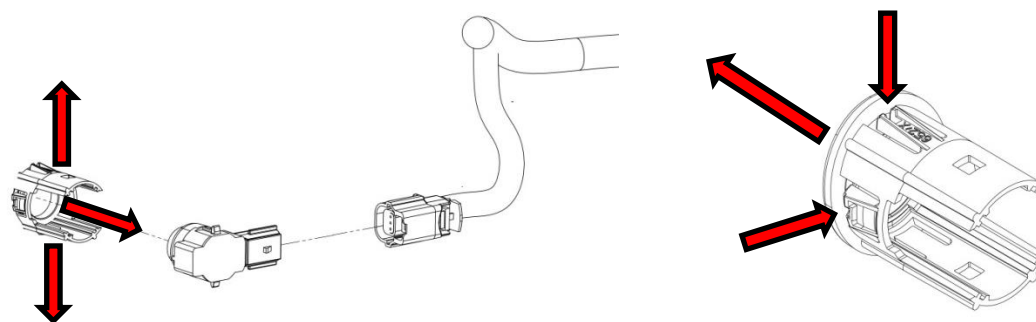
- 4: With the bumper supported remove the eight bolts located on either side of the two tow hooks. The bumper can now be removed.



- 5: Remove the eight bolts that fasten the upper bumper brackets and tow hooks to the frame. Remove the four bolt tabs that fasten the lower bumper brackets to the frame. The four bolt tabs will be reused during installation.

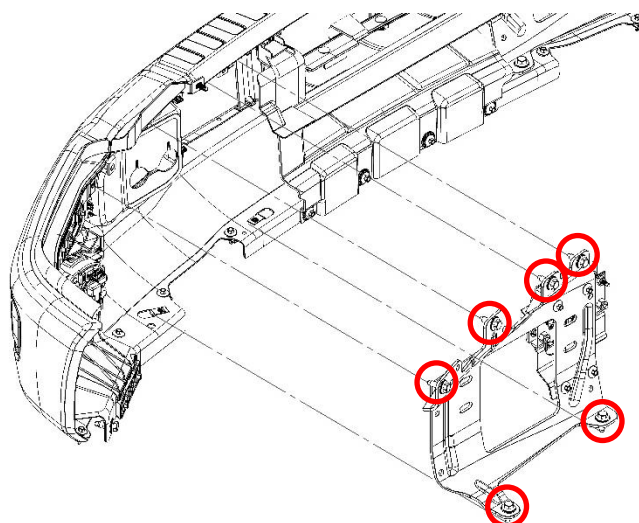


- 6:** Remove the parking sensors from the stock bumper. Spread the ears on the sensor bezel and push the sensor thru the back of the bumper. **NOTE:** Keep track of each sensors location.

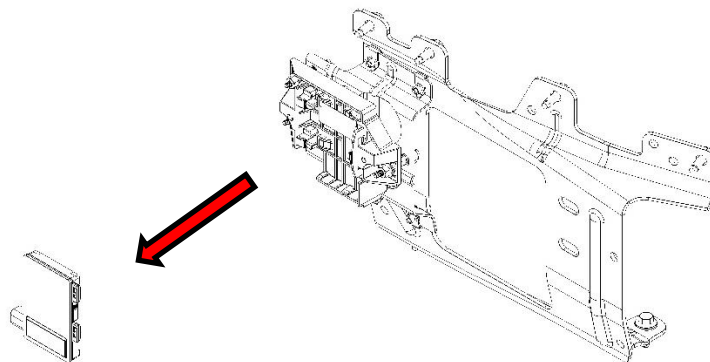


- 7:** Depress the tabs on the sensor bezel and push it thru the front of bumper.

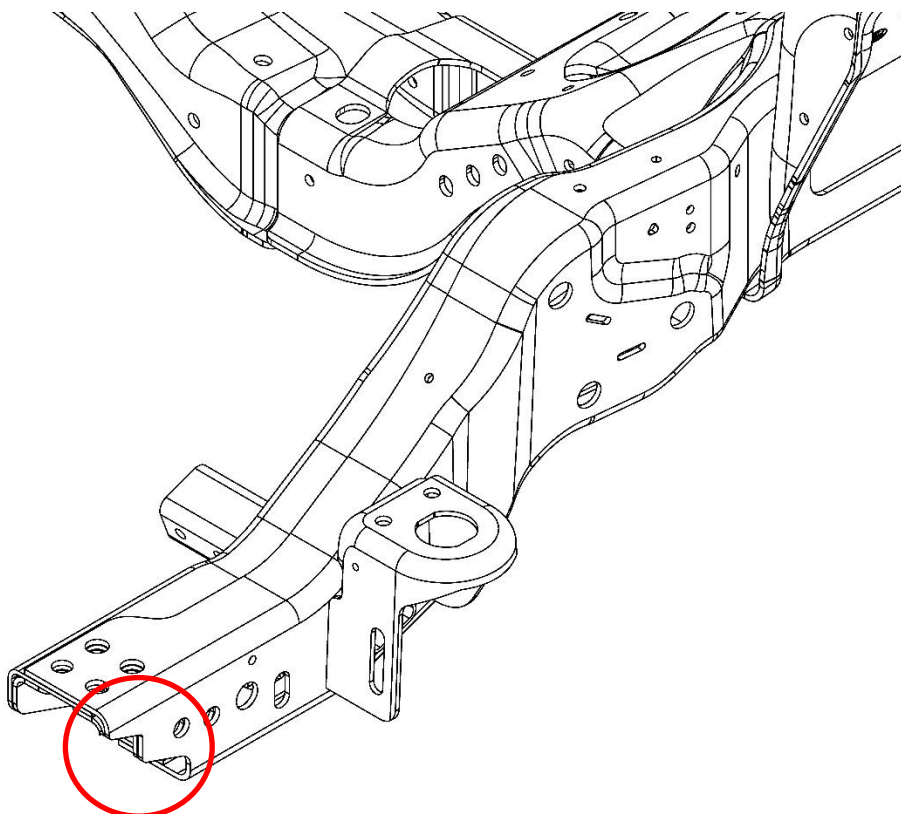
- 8:** Remove the bumper bracket from the bumper shell to gain access to the adaptive cruise sensor.



**9:** Unclip and remove the adaptive cruise sensor from the bumper bracket.



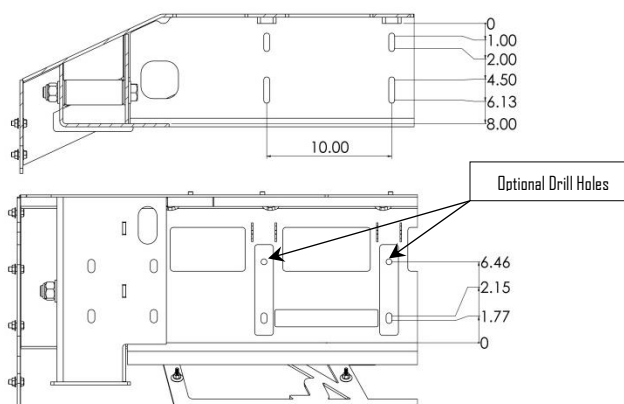
**10: Optional:** Use the template on *page 17* to mark the outside of each frame horn. Notch the frame to allow for extra room and better wrench clearance when installing the bumper.





# Bumper Preparation

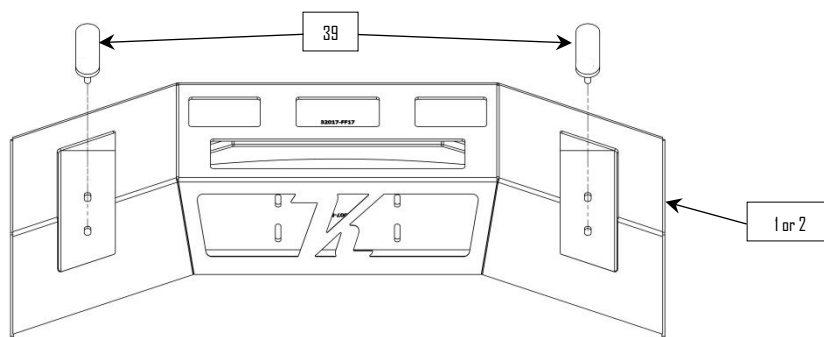
- Before painting open every box and locate all parts. There are several smaller bushing pieces, screens, and bolt tabs that are packaged separately inside the main box.
- **CAUTION:** Kelderman Mfg. Inc. cannot guarantee correct out of the box fitment across all winch brands and sizes. The installer is responsible for test fitting the winch into the bumper and making any required modifications before the bumper is sent to paint. See Image below for the bolt pattern in the Kelderman bumper.
  - **NOTE:** When installing larger winches (16,500lb) the installer maybe required to drill two extra holes into the face of the bumper in order to properly mount the winch.



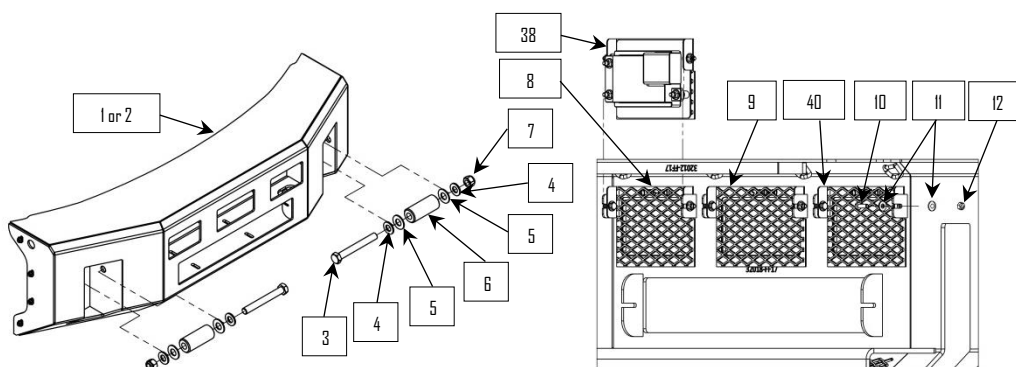
- **CAUTION:** Kelderman Mfg. Inc. cannot guarantee correct out of the box fitment across all light brands and sizes. The installer is responsible for test fitting all lights into the bumper and making any required modifications before the bumper is sent to paint. This bumper has been designed to utilize the following Rigid Industries lights.
  - Rigid Industries E-Series 20 Inch Light (Center)
  - Rigid Industries E-Series 4 Inch Light (End Cap)
- **Tow Hook Pocket Painting**
  - If a heavily textured thick coating is being applied, take note that buildup does not hinder the installation of the tow hooks. Each bumper is supplied with four rubber washers to let tow hooks rotate without damaging the paint. If thick coatings are applied, installation of hooks may only allow for the use of one or no rubber washers.

# Bumper Assembly

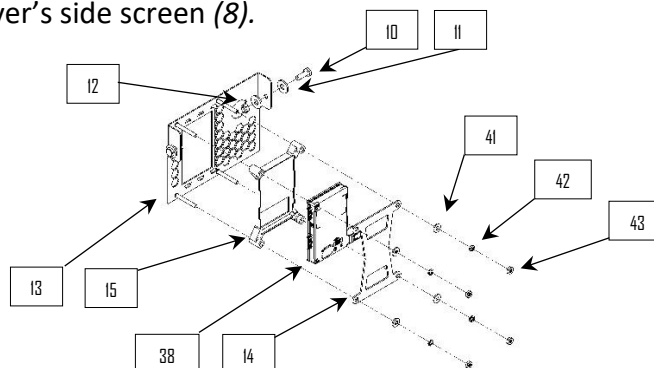
- On a clean flat non-scratching surface place the bumper center section (1 or 2) face down.
- Insert bumper mount bolting tabs (39) thru each pocket in the center section. Use tape or zip ties to temporarily hold in place.



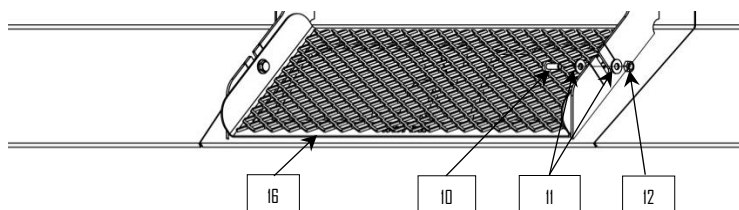
- Install the tow hooks (6) into the pockets using the provided 7/8" hardware. Tow hooks (6) and rubber washers (5) go inside the pocket. Tighten the 7/8" nut (7) to the point where the tow hook will still spin but not freely.



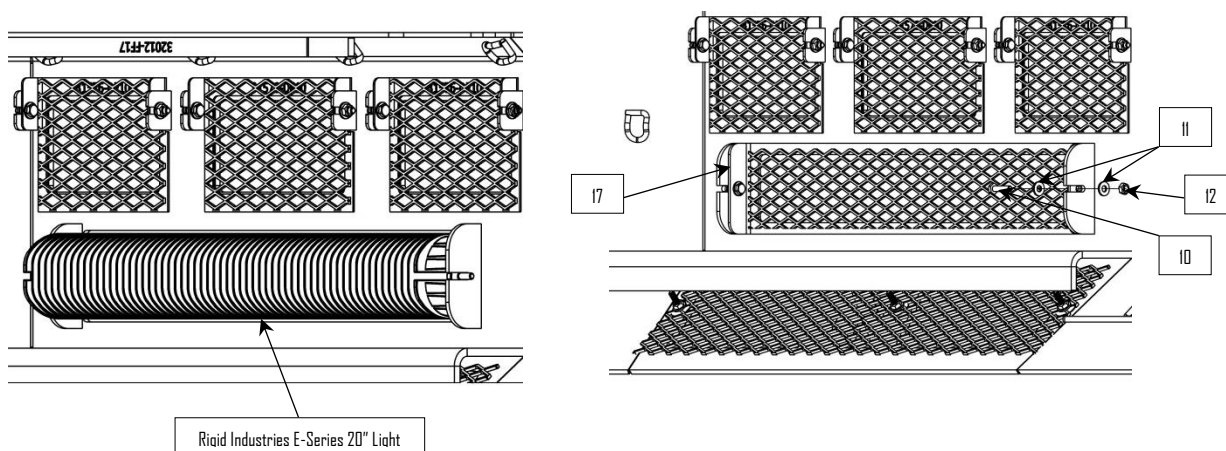
- Bolt the three upper screens (9, 13, & 40) into the center section.
  - Model Year 2023+ If your truck has an adaptive cruise control sensor (38) install the optional adaptive cruise screen assembly (13) in place of the driver's side screen (8).



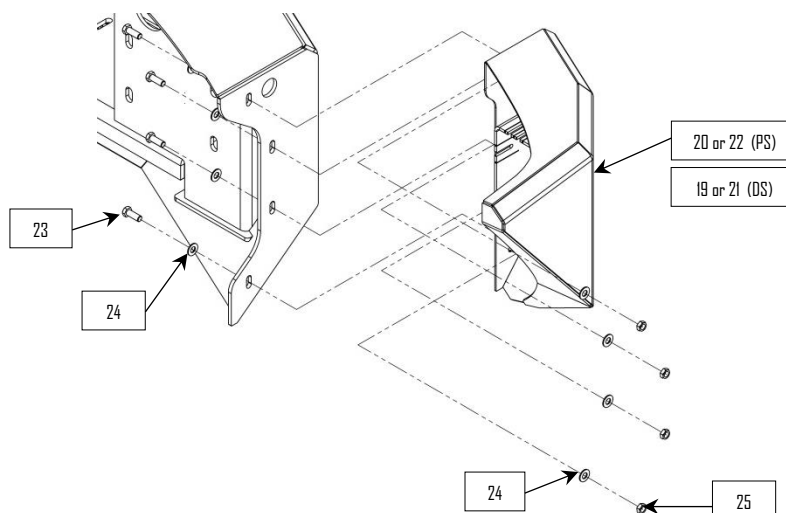
- Bolt the lower screen (16) into the center section, using the supplied  $\frac{1}{4}$ " hardware (10, 11, & 12).



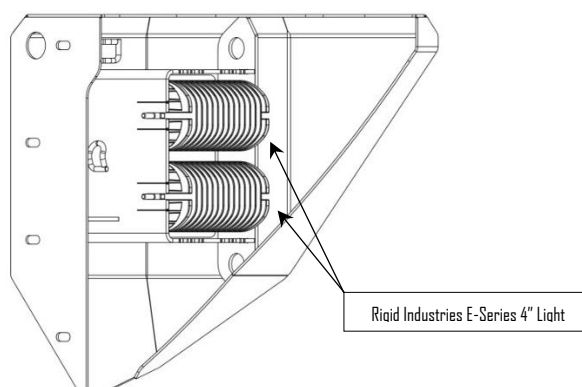
- Winch Bumpers
  - Install winch according to winch manufacture's specifications. When installing large winches two extra holes may need to be drilled into the face of the bumper. **NOTE:** Use the internal spacer plates as a drill guide. (See Bumper Preparation Section)



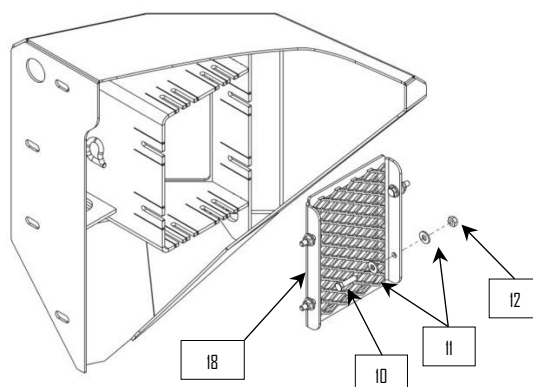
- Light Bumpers
  - Install the Rigid Industries E-Series 20 inch light bar (or similar light) into the center cut out using the hardware supplied with the light.
  - Or if optioned install the Kelderman center light delete screen (17) using the hardware supplied with the light delete kit.
- Bolt the end caps onto the center section using the supplied hardware. Repositioning may be required after bumper is installed onto truck. **NOTE:** while positioning use masking tape to protect painted surfaces that come into contact.



- Install the lights into each end cap.

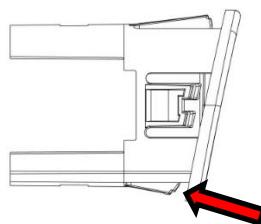


- Install horizontally two Rigid Industries 4 inch E-Series light (*or similar light*) into each end cap using the hardware supplied with the light.
  - **NOTE:** The light mounting ears will deform and draw up tight to the light as they are tightened.

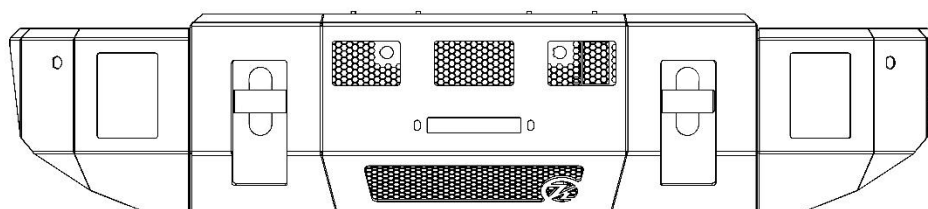
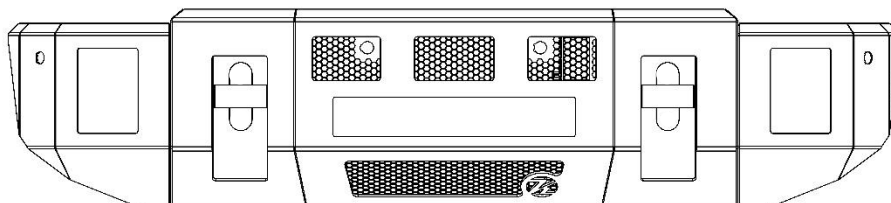


- Or if optioned, install the Kelderman end cap light delete screen (18) using the hardware supplied with the light delete kit.
- If equipped install the sensors into the end caps and center screens by reversing the process *from steps five and six*. Be sure to install them back in the correct location.

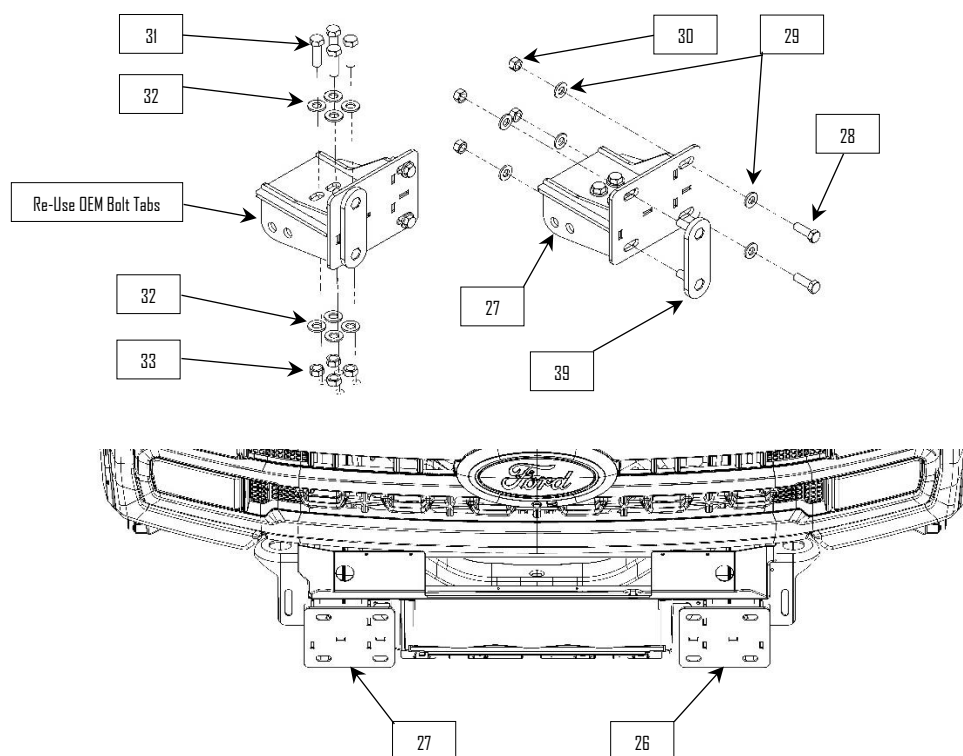
**NOTE:** If bezels will not snap into place file the tabs down a little at a time until they will catch.



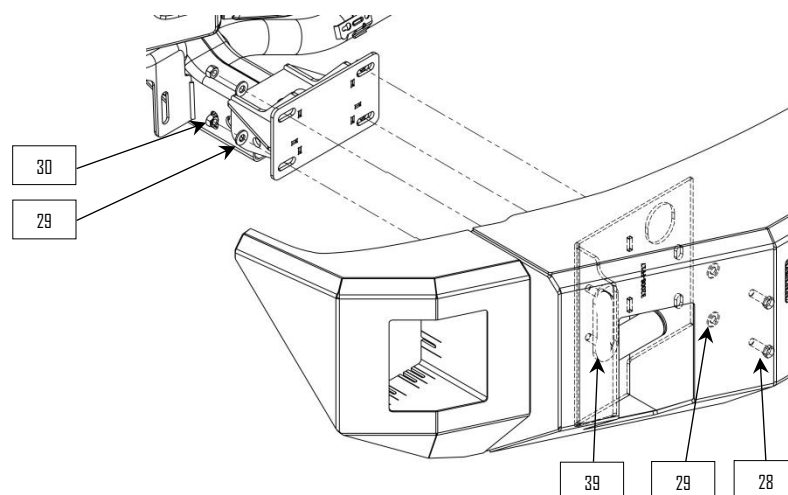
- Install the OEM wiring harness into the bumper. zip tie wiring to the tie downs welded inside the bumper.
- The Bumper is now ready for installation.



# Bumper Installation

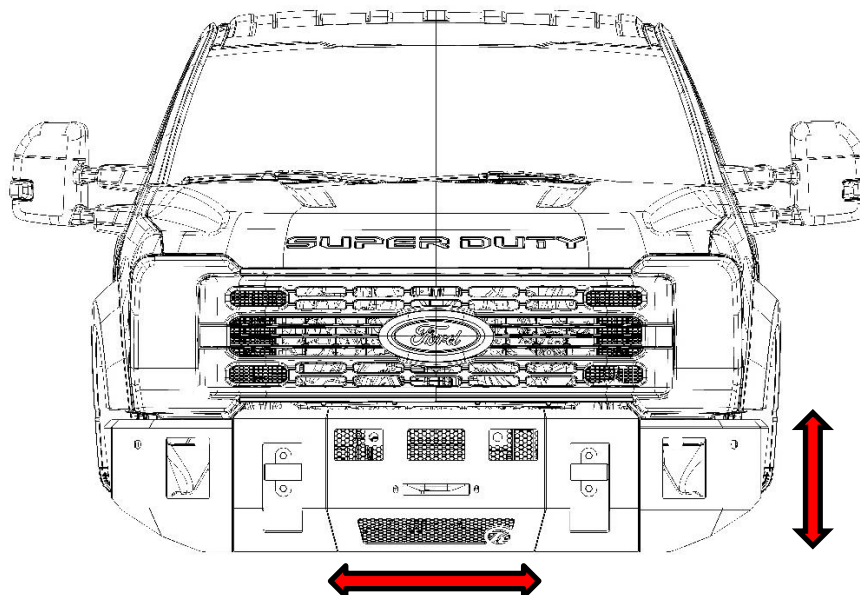


- 1: Install the bumper frame brackets (26 & 27). Use the provided 9/16" bolts (31) and nuts (33) to bolt thru the top of the frame. Re-use the bolt tabs from step 4 to bolt thru the sides of the frame.



- 2: Use the studs of the bumper mount bolting tabs (39) to position the bumper on the frame brackets (26 & 27). Use washer (29) and nut (30) to fasten the bumper to the mount.
- 3: Insert the remaining 1/2" hardware thru the bumper and bracket.

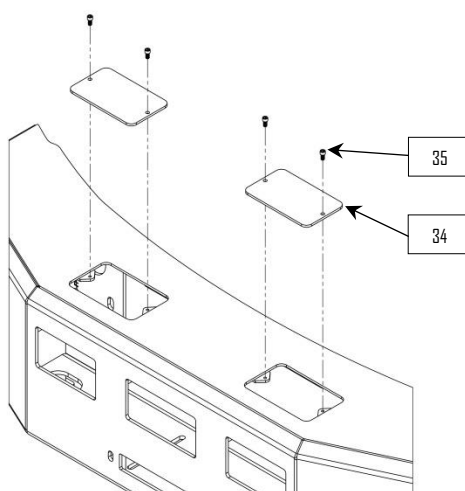
- 4:** Align the bumper on the truck and tighten the mounting hardware. **NOTE:** the end caps can be re-adjusted at this point if required.



- 5:** Torque all fasteners according to the chart below.

Bolt Size	Torque
1/4"-20	70 in-lb
3/8"-16	20 ft-lb
1/2"-20	50 ft-lb
9/16"-18	70 ft-lb
7/8"-9	250 ft-lb

- 6:** Finish wiring accessories.



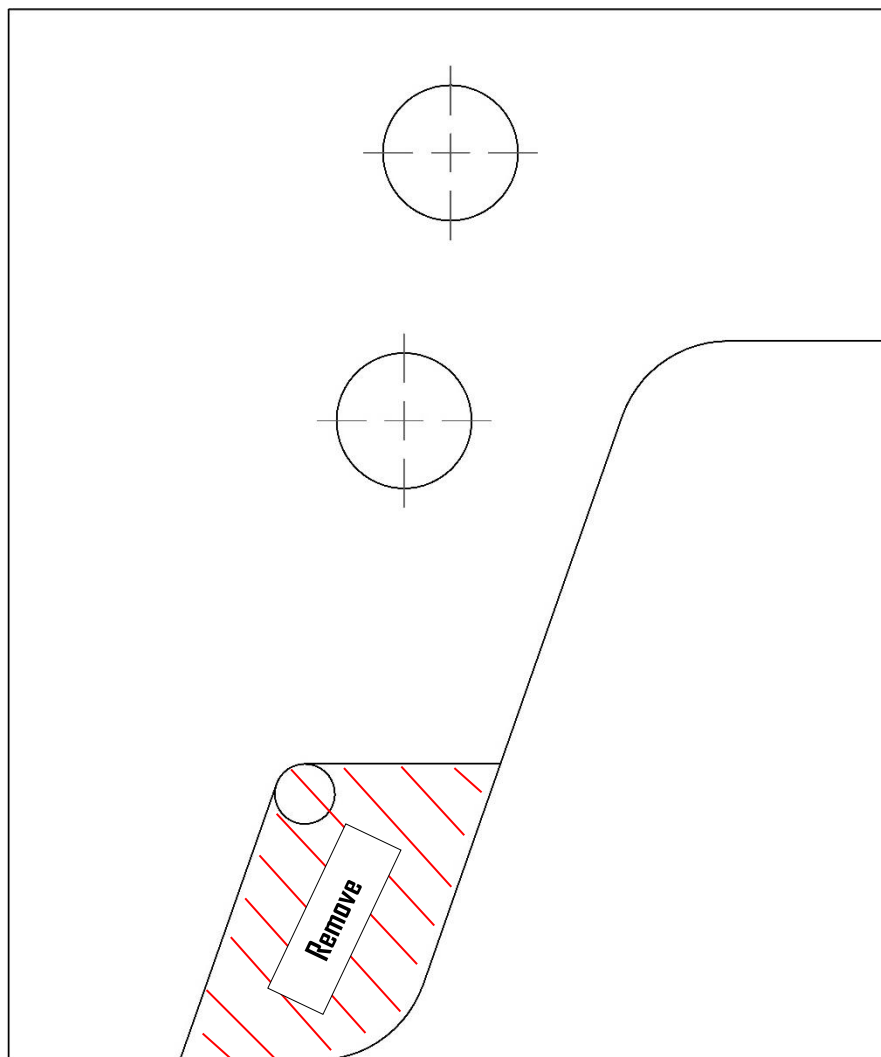
- 7:** Winch bumpers, install winch access covers (34) using bolts (35).

# Parts Key

Item Number	Part Number	Description
1	10014834	Center Section - Alpha Winch
2	10014869	Center Section - Delta Light
3	12644	Bolt: 7/8"-9 X 7.00"
4	13010	Flat Washer: 7/8"
5	80043	Rubber Washer: 1" ID X 2" OD
6	31552	Tow Hook
7	13110	Lock Nut: 7/8"-9
8	10008104	Outer Screen – 7"
9	10008105	Inner Screen – 8"
10	12108	Bolt: ¼"-20 X ¾"
11	13000	Flat Washer: ¼"
12	13100	Lock Nut: ¼"-20
13	10015298	2023+ Adaptive Cruise Screen
14	10015297	Adaptive Cruise - Retainer
15	10015296	Adaptive Cruise - Plastic Housing
16	10008106	Lower Screen
17	10010502	Light Delete Screen Center ( <i>Optional</i> )
18	10010503	Light Delete Screen End Cap ( <i>Optional</i> )
19	10014845	End Cap (DS) Stock Width
20	10014842	End Cap (PS) Stock Width
21	10014910	End Cap (DS) Wide Width
22	10014914	End Cap (PS) Wide Width
23	12210	Bolt: 3/8"-24 X 1-1/4"
24	13002	Flat Washer: 3/8"
25	13102	Lock Nut: 3/8"-24
26	10014987	Bumper Frame Mount (DS)
27	10015015	Bumper Frame Mount (PS)
28	12007	Bolt: ½"-20 X 1-1/2"
29	13004	Flat Washer: ½"
30	13124	Lock Nut: ½"-20
31	12307	Bolt: 9/16"-18 X 1-3/4"
32	13005	Flat Washer: 9/16"
33	13125	Lock Nut: 9/16"-18
34	32016	Winch Access Cover
35	13503	Socket Head Screw: ¼"-20 X ½"
36	13140	Nut: ¼"-20
37	13042	Lock Washer: ¼"
38		2023+ Ford Adaptive Cruise Sensor
39	31760	Bumper Mount Bolting Tab
40	10014909	Outer Screen – 7" Parking Sensor
41	14062	Flat Washer: #10
42	14086	Split Lock Washer: #10
43	14097	Hex Nut: #10



# Notes



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## Contact Information

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- Kelderman Manufacturing appreciates your business. We strive to meet the needs of our customers by providing the highest quality products. If you have any questions concerning our products please call or email us at the following:

**2686 Highway 92**  
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