

# INSTALLATION INSTRUCTIONS

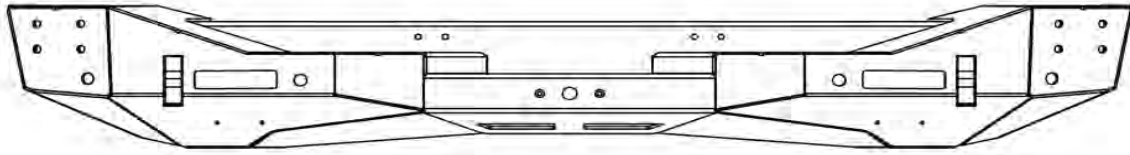
## XTS REAR BUMPER



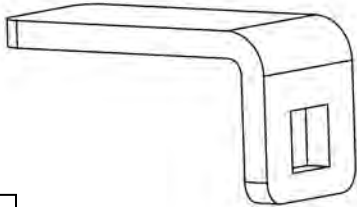
**APPLICATION:**  
2021-2024 Ford Bronco (excl. Bronco Sport)  
**PART NUMBER:**  
59-712255

CONTENT			
ITEM	QUANTITY	DESCRIPTION	TOOLS NEEDED
1	1	REAR BUMPER ASSEMBLY	18mm SOCKET
2	4	SENSOR L-TAB	16mm SOCKET
3	4	SENSOR HOLE PLUG	10mm SOCKET
4	2	M12 BOLT PLATE	19 MM SOCKET
5	2	SENSOR HARNESS EXTENSION	18mm WRENCH
6	1	DRIVER S. STEEL COVER	16mm WRENCH
7	1	PASSENGER S. STEEL COVER	10mm WRENCH
8	1	DRIVER RUBBERIZED CORNER STEP	TRIMMING TOOL
9	1	PASSENGER RUBBERIZED CORNER STEP	RATCHET
10	1	HITCH DELETE SPACER	TORQUE WRENCH
11	1	INNER CAMERA HOLDER	ALLEN WRENCH
12	1	OUTER CAMERA HOLDER	
13	1	CAMERA HOLDER COVER	
14	4	M6 HEX NUT	
15	4	M6 FLAT WASHER	
16	4	M6 SPLIT LOCK WASHER	
17	4	M6 ROUND HEAD SQUARE NECK BOLT	
18	2	M12 HEX NUT	
19	10	M12 FLAT WASHER	
20	2	M12 SPLIT LOCK WASHER	
21	2	M6 SERRATED FLANGE NUT	
22	4	M12 HEX HEAD BOLT	
23	12	M12 SERRATED FLANGE HEX NUT	
24	8	M12 SPLIT LOCK WASHER	
25	8	M12 FLAT WASHER	
26	8	M12 BUTTON HEAD BOLT	
27	8	M8 BUTTON HEAD BOLTS	
ANTI-SEIZE LUBRICANT MUST BE USED ON ALL STAINLESS STEEL FASTENERS TO PREVENT THREAD DAMAGE AND GALLING			

CONTENT			
ITEM	QUANTITY	DESCRIPTION	TOOLS NEEDED
28	8	M8 SERRATED FLANGE NUT	
29	8	M8 FLAT WASHER	
30	8	M8 SPLIT LOCK WASHERS	
31	2	M6 FLAT HEAD SCREWS	
ANTI-SEIZE LUBRICANT MUST BE USED ON ALL STAINLESS STEEL FASTENERS TO PREVENT THREAD DAMAGE AND GALLING			



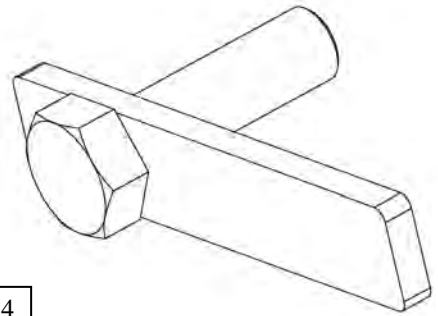
ITEM 1



ITEM 2



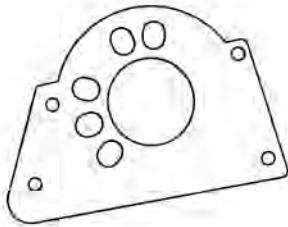
ITEM 3



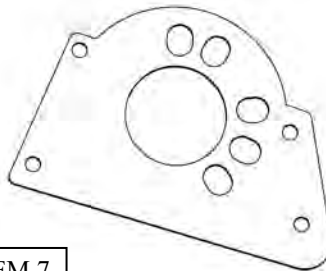
ITEM 4



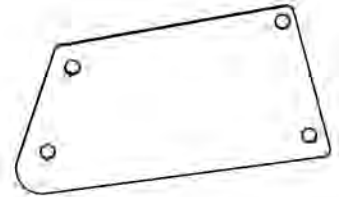
ITEM 5



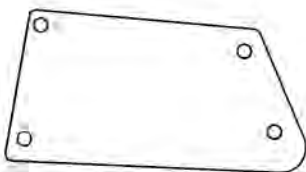
ITEM 6



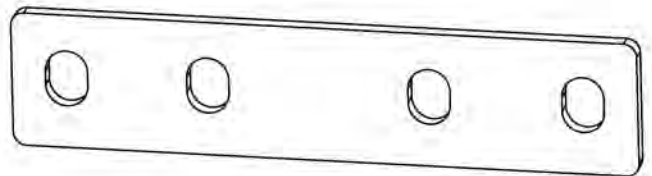
ITEM 7



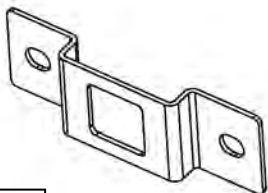
ITEM 8



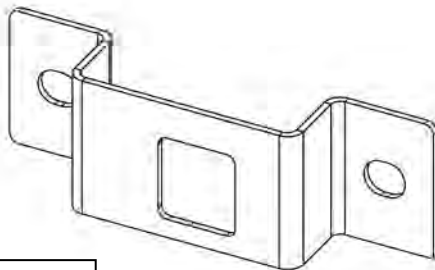
ITEM 9



ITEM 10



ITEM 11



ITEM 12



ITEM 13



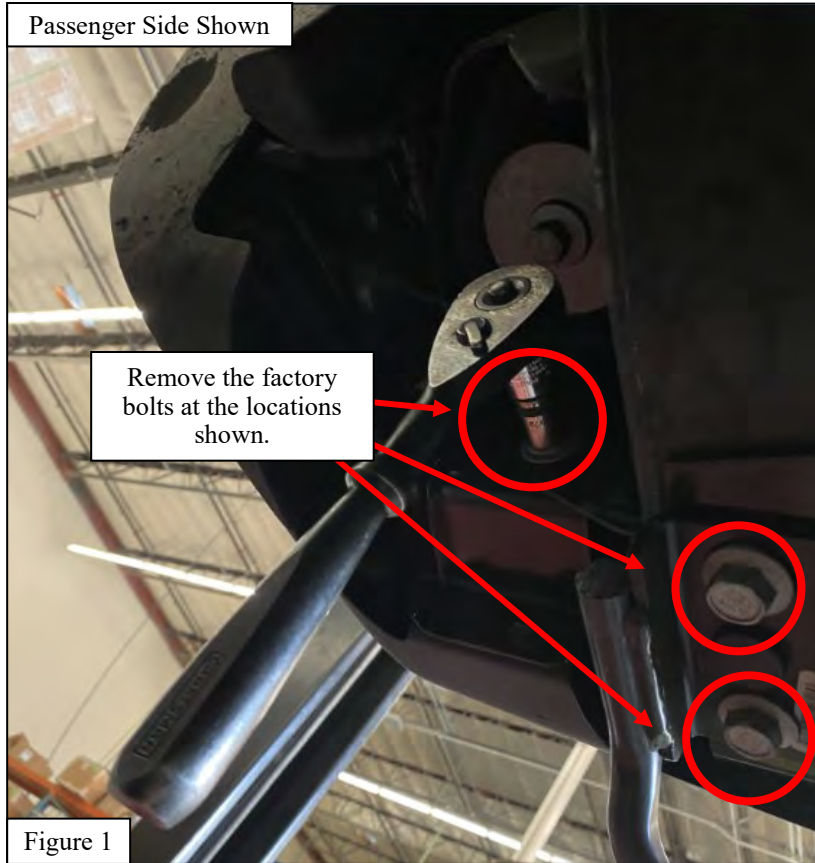
Westin Automotive Products, Inc.  
320 W. Covina Blvd  
San Dimas, Ca. 91773

Thank you for choosing Westin products  
for additional installation assistance please call  
Customer Service (800) 793-7846  
[www.westinautomotive.com](http://www.westinautomotive.com)

DATE: 08/19/2024

## PROCEDURE

1. Remove contents from box, verify if all parts listed are present and free from damage.  
Carefully read and understand all instructions before attempting installation.  
**Failure to identify damage before installation could lead to a rejection of any claim.**
2. Disconnect the electrical plugs from the rear bumper located on each side along the frame rail.
3. Remove the 3 OEM bolts on each side of the rear bumper. See **Figure 1** for reference.
4. Carefully remove the rear bumper. **Note:** Assistance may be needed removing the bumper.



5. Once the OEM bumper is removed from the vehicle, remove the OEM parking sensors and the OEM wiring harness. Remove the sensors carefully by using a flat head screwdriver or pry tool to remove the sensors as shown. See **Figures 2 through 4** for reference.

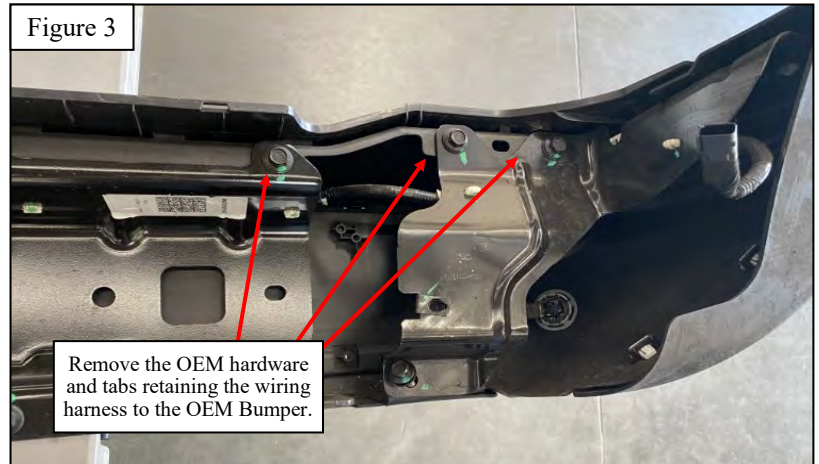
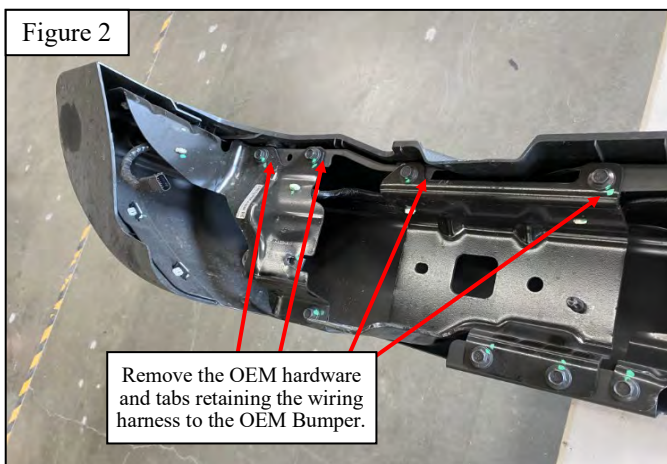




Figure 4

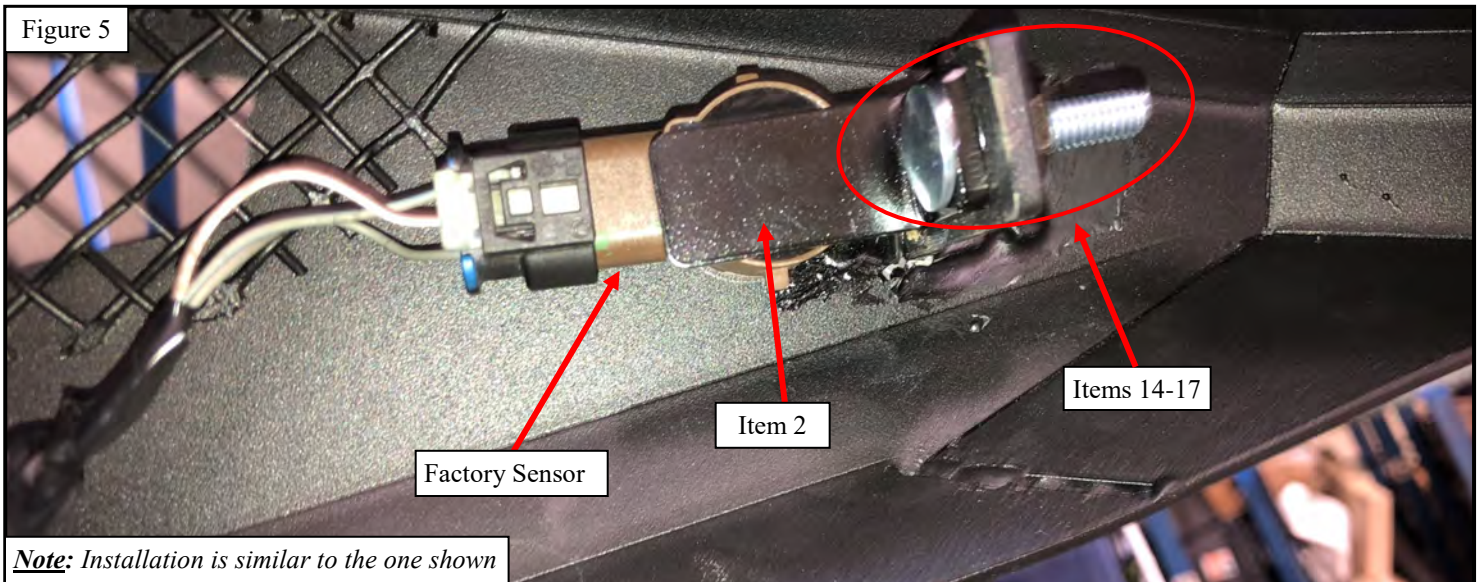


### PARKING SENSOR INSTALLATION

**If not installing the parking sensors, install Hole Plugs into the holes on the bumper and proceed.**

6. Make sure to reuse the factory rubber grommet to isolate the sensor from the metal.
7. Use the Sensor Tab (**Item 2**) along with the supplied M6 Hardware (**Items 14-17**) to install the sensors as shown in **Figures 5 through 8**.
8. Carefully route the harness around the bumper. **Note:** Zip ties or double sided tape can be used to route the wiring harness and to hold the sensors in position. The wiring harness extensions (Item 5) may also be used as necessary.

Figure 5



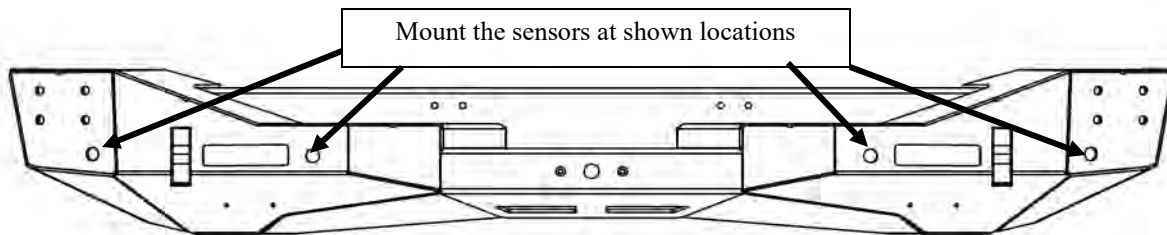


Figure 6

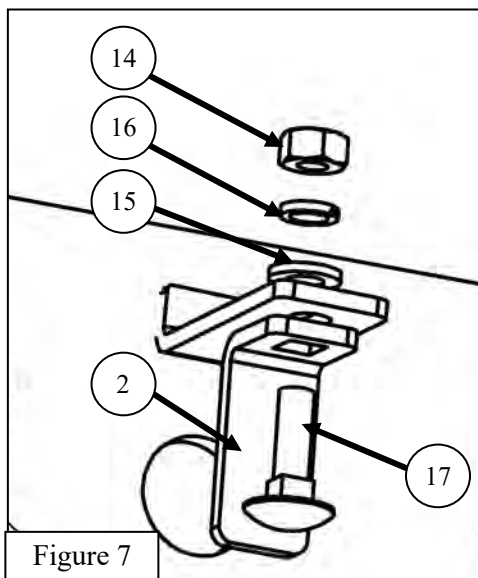


Figure 7

9. Install the (4) Sensor L-Tabs (item 2), using the M6 hardware as shown in **Figure 7** in the interior of the bumper at the locations shown in **Figure 6**. Install the (4) Sensor hole plugs at the locations shown in **Figure 6**.
10. If camera is not installed, loosely install the camera holder cover (Item 13) to the bumper (Item 1) using (2) M6 Flat Head hardware (Items 27 and 21). Once loosely installed, tighten all the hardware. See **Figure 8**.

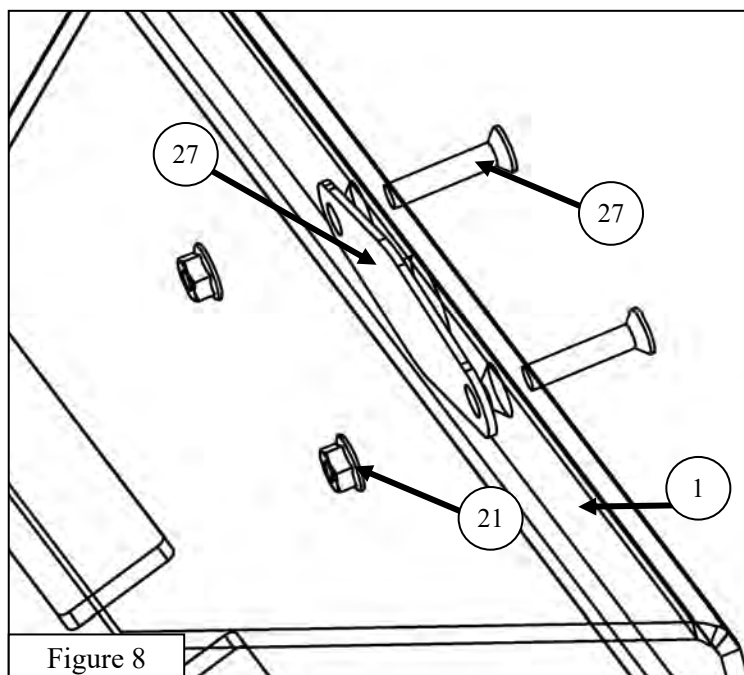


Figure 8

#### OPTIONAL CAMERA RELOCATION

- Align the inner camera holder (item 11) to the front side of the camera and align the outer camera holder (item 12) on the back side of the camera, so that everything fits correctly. See **Figures 9&10**. On the backside of the camera. The camera holder assembly should look like **Figure 10**.
- Once aligned, align the inner camera holder to the screw holes and loosely mount the three parts to the bumper using the (2) M6 Flat head hardware ( items 27&21) See **Figure 8** for hardware placement. Once everything is mounted correctly tighten the bolts. See **Figures 11**.

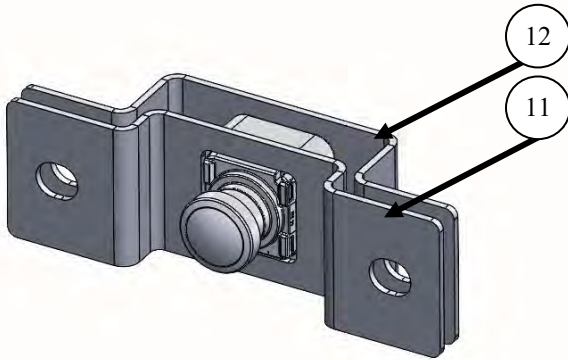


Figure 9

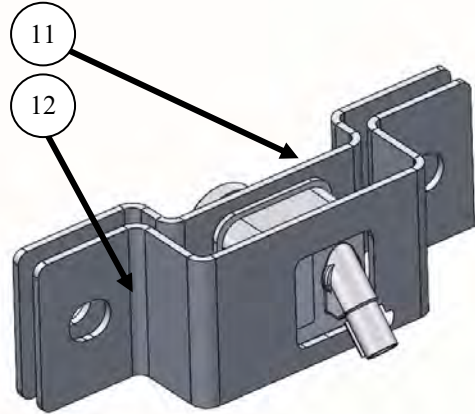


Figure 10

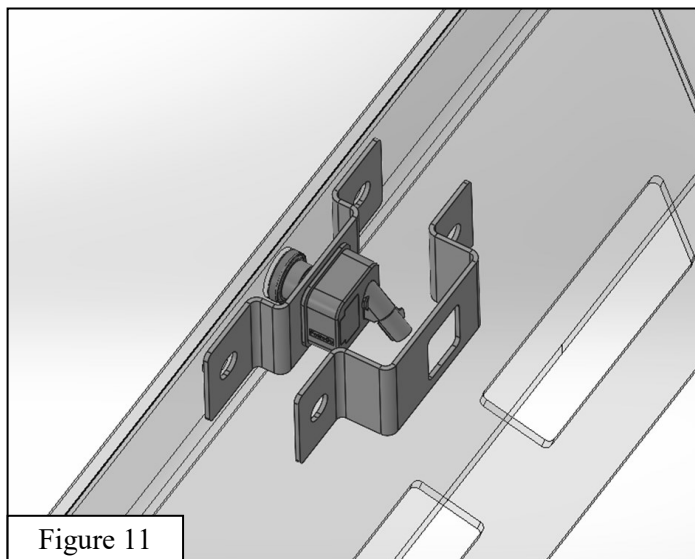
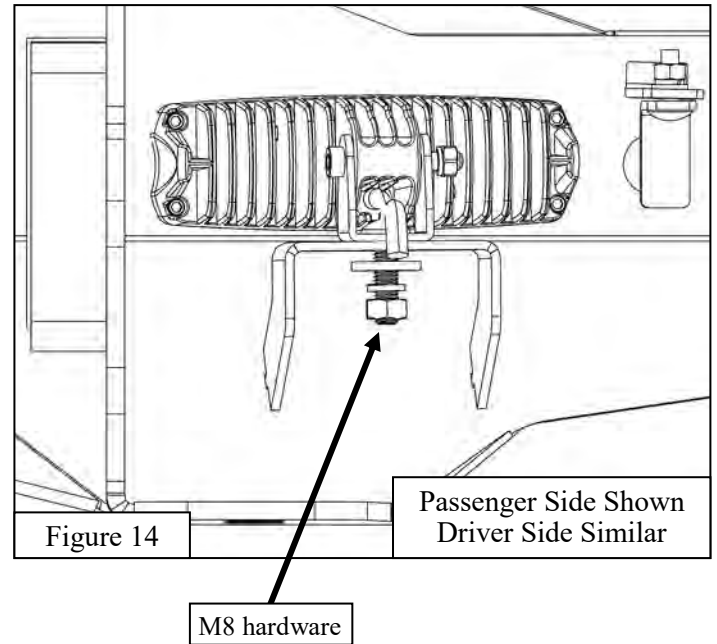
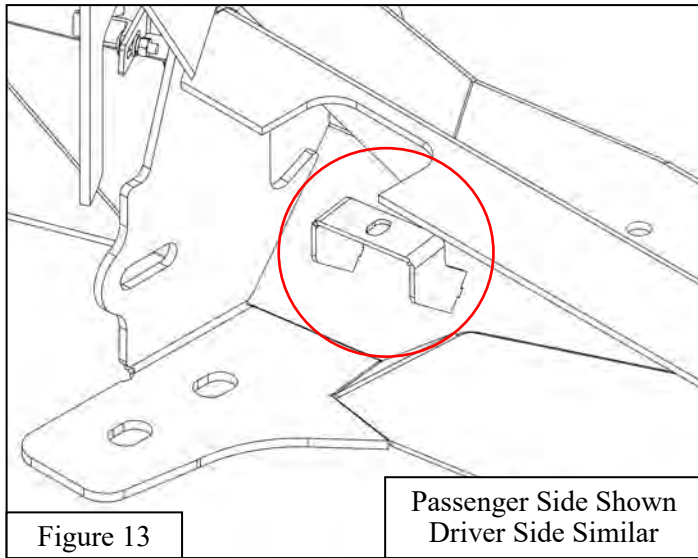
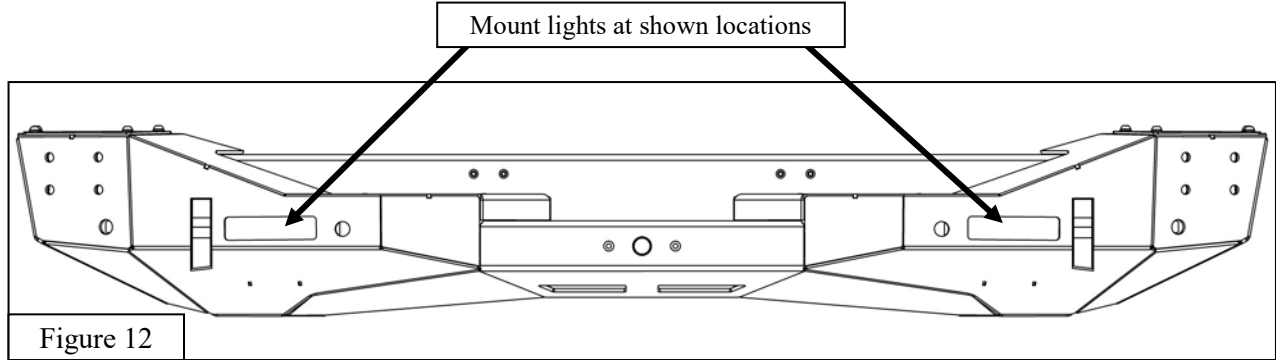


Figure 11

### OPTIONAL REAR LIGHT INSTSALLATION

- Locate the mounting brackets on the inside of the bumper shown below in **Figures 12 & 13**.
- Use appropriate M8 hardware (not included) to mount the lights to the mounting brackets. Align the lights as required and tighten hardware to secure the light to the inside of the bumper. See **Figure 14** for hardware placement.



**Note:** XTS rear bumper is designed to accommodate the Westin Fusion5 EF Flex Beam Light Bar (**Part No. 09-12232-PR**), as shown above. Please verify compatibility and fitment if using other aftermarket lights.



11. Use (8) M12 Button Head hardware (Items 23-26) to cover up holes. See **Figure 15**.

*Note: Bolt s can be used for swingouts , which are purchased separately*



Figure 15

12. Install steel cover and rubberized corner step (Items 6-9) onto the rear bumper assembly (Item 1) as seen on **Figure 16 & 17** using (8) M8 hardware (items 27-30).

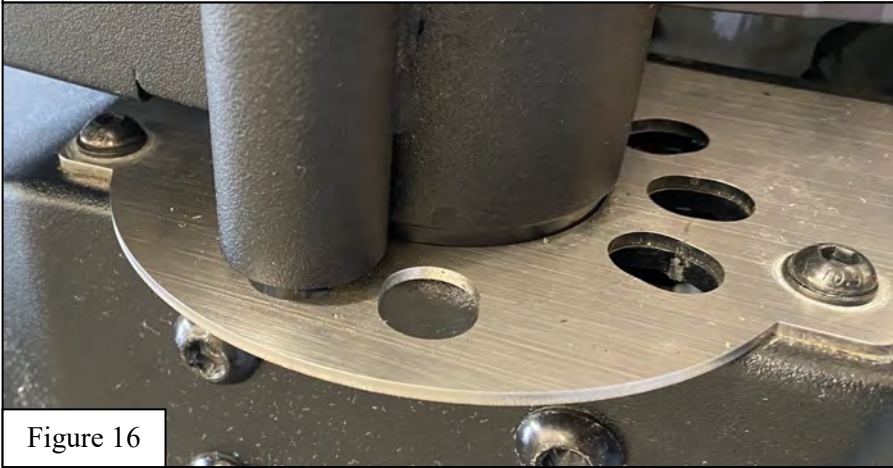


Figure 16

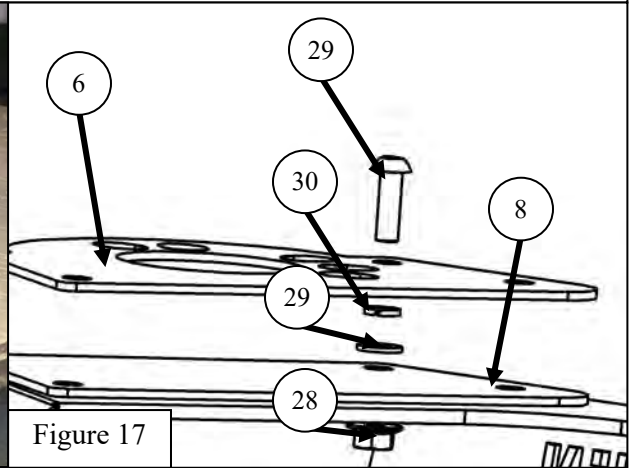


Figure 17

13. Install any bumper accessories prior to installing the bumper onto the vehicle.
14. Using the OEM hardware, loosely secure the XTS rear bumper assembly to the OEM mounting locations. See **Figure 18** for reference. **Note:** Assistance may be needed to lift the bumper onto the vehicle.
15. Using the supplied M12 bolt plate and M12 hardware (Items 4, 18-20), loosely secure the XTS rear bumper assembly to the OEM upper mounting locations on both sides of the bumper. See **Figure 19** for reference.

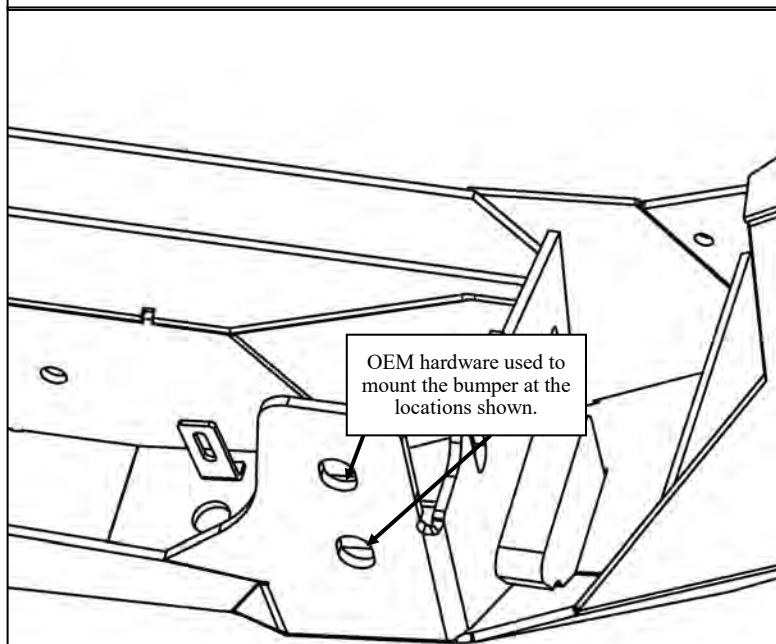


Figure 18

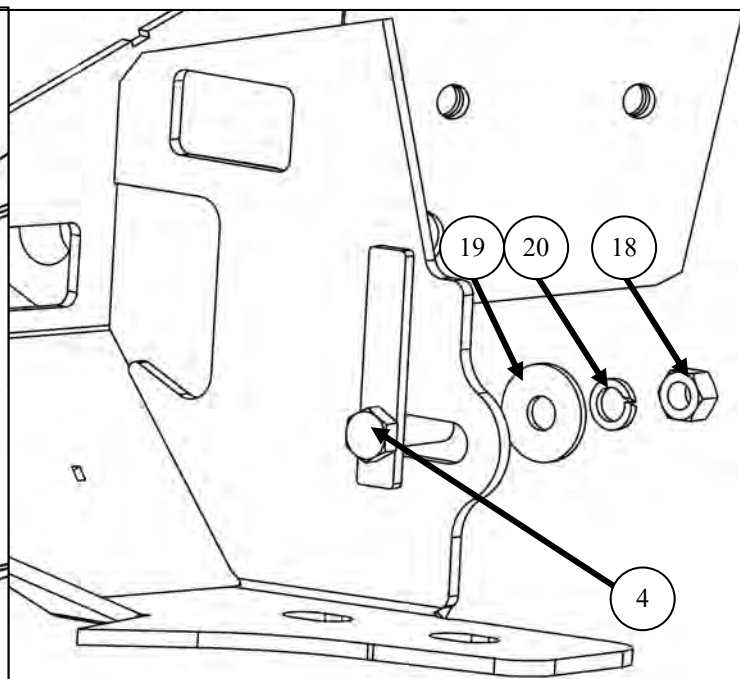


Figure 19

#### OPTIONAL HITCH DELETE

- When not using a hitch install the hitch delete spacer (Item 10) using (4) M12 Hex head hardware (Items 19, 22, and 23). See **Figure 20** for reference.

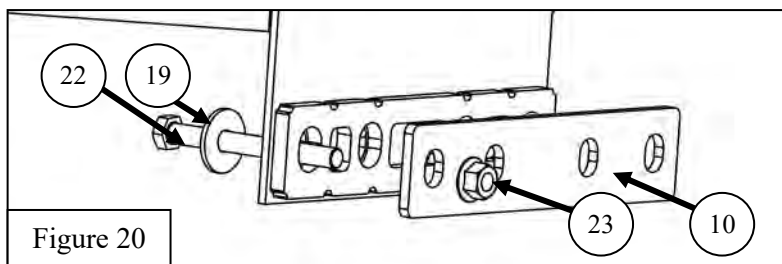


Figure 20

16. Mount bumper onto the frame of vehicle using (4) M12 Hex head hardware (item 19, 22, & 23). Hardware will go into the frame, pointing towards the back of the vehicle. See **Figure 20** for reference in direction.  
*Note: This bumper is compatible with OE hitch, and most after market hitches as well.*



## INSTALLATION COMPLETE



Shown with optional swing outs.

### CARE INSTRUCTIONS

- REGULAR WAXING IS RECOMMENDED. DO NOT USE ANY TYPE OF POLISH OR WAX THAT MAY CONTAIN ABRASIVES.
- STAINLESS STEEL PRODUCTS CAN BE CLEANED WITH MILD SOAP AND WATER. STAINLESS STEEL POLISH SHOULD BE USED TO POLISH SMALL SCRATCHES.
- GLOSS BLACK FINISHES SHOULD BE CLEANED WITH MILD SOAP AND WATER.

**WESTIN**

Westin Automotive Products, Inc.  
320 W. Covina Blvd  
San Dimas, Ca. 91773

Thank you for choosing Westin products  
for additional installation assistance please call  
Customer Service (800) 793-7846  
[www.westinautomotive.com](http://www.westinautomotive.com)



## WARNING



Failure to follow these instructions could lead to death, personal injury, and / or property damage.

Failure to follow these instructions could lead to death, personal injury, and / or property damage.

### FASTENERS:

All Westin supplied fasteners must be utilized and installed in accordance with the installation instructions and apply torque to the specifications as defined. **DOUBLE CHECK ALL FASTENERS BEFORE INITIAL USE, AND PERIODICALLY IN THE FUTURE TO ENSURE PROPER FUNCTION AND SAFETY.**

### DRILLING:

Most Westin products do not require drilling for installation. If drilling is defined as required, use caution when drilling a vehicle. **FAILURE TO REVIEW AN AREA TO BE DRILLED MAY RESULT IN PERSONAL INJURY AND/OR INJURY TO OTHERS AS WELL AS VEHICLE DAMAGE.**

### EYE PROTECTION:

**ALWAYS WEAR SAFETY GLASSES OR GOGGLES DURING THE INSTALLATION PROCESS TO AVOID PERSONAL INJURY.**

### MAXIMUM TOWING/CARRYING CAPACITY: (if applicable)

The Westin Receiver Hitches will have a visible tow rating label affixed directly on the product. User should never exceed the vehicle manufacturers maximum tow and weight rating regardless of the capacity of the hitch. **FAILURE TO FOLLOW THESE GUIDELINES WILL VOID THE WESTIN WARRANTY AND MAY RESULT IN PERSONAL INJURY AND/OR INJURY TO OTHERS AS WELL AS VEHICLE DAMAGE.**

### FOR CALIFORNIA RESIDENTS ONLY-PROP 65 WARNING:

Some products may contain chemicals such as DEHP, which can cause cancer, birth defects or other reproductive harm. For more info go to [www.p65warnings.ca.gov](http://www.p65warnings.ca.gov)



Westin Automotive Products, Inc.  
320 W. Covina Blvd  
San Dimas, Ca. 91773