

INSTALLATION INSTRUCTIONS

HDX MAX Winch Tray



APPLICATION:

2023-2026 Ford F-250/350/450

2023-2025 Ford F-550

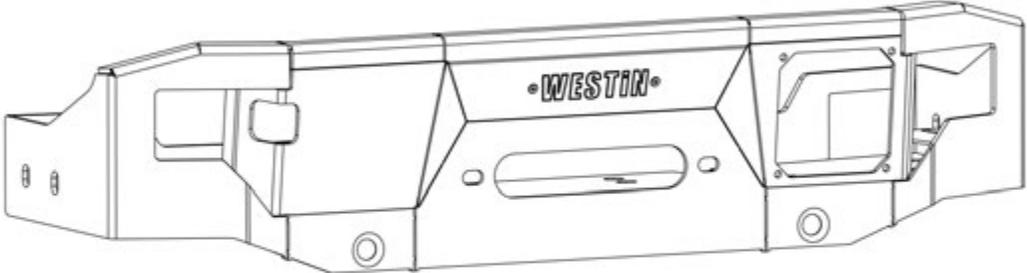
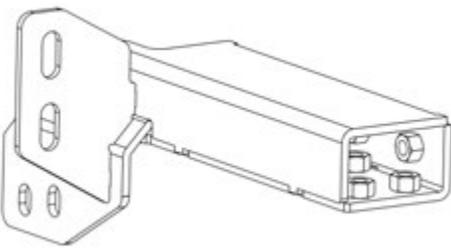
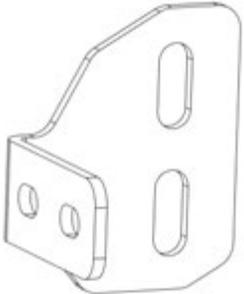
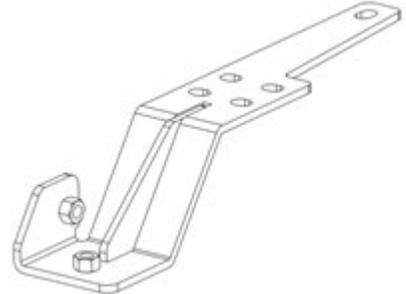
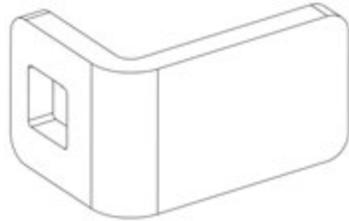
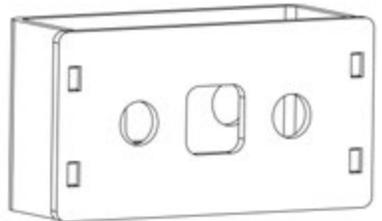
PART NUMBER:

48-23905

CONTENT			
ITEM	QUANTITY	DESCRIPTION	TOOLS NEEDED
1	1	WINCH TRAY	RATCHET
2	1	DRIVER BRACKET A	TORQUE WRENCH
3	1	PASSENGER BRACKET A	10MM SOCKET
4	1	DRIVER BRACKET B	10MM WRENCH
5	1	PASSENGER BRACKET B	18MM SOCKET
6	1	DRIVER BRACKET C	18MM WRENCH
7	1	PASSENGER BRACKET C	4MM HEX DRIVER
8	1	ACC COVER	8MM HEX DRIVER
9	2	PARKING SENSOR BRACKET	ALLEN WRENCH
10	1	DRIVER CUTTING TEMPLATE	UTILITY KNIFE
11	1	PASSENGER CUTTING TEMPLATE	PRY TOOL
12	14	50MM LONG M12 HEX HEAD BOLT (YELLOW ZINC)	
13	18	40MM LONG M12 HEX HEAD BOLT (YELLOW ZINC)	
14	4	35MM LONG M12 HEX HEAD BOLT (YELLOW ZINC)	
15	4	30MM LONG M12 HEX HEAD BOLT (YELLOW ZINC)	
16	40	M12 SPLIT LOCK WASHER (YELLOW ZINC)	
17	12	LARGE M12 FLAT WASHER (YELLOW ZINC)	
18	28	SMALL M12 FLAT WASHER (YELLOW ZINC)	
19	20	M12 SERRATED FLANGED HEX NUT (YELLOW ZINC)	
20	2	M6 HEX NUT (YELLOW ZINC)	
21	2	M6 SPLIT LOCK WASHER (YELLOW ZINC)	
22	2	M6 FLAT WASHER (YELLOW ZINC)	
23	2	M6 ROUND HEAD SQUARE NECK BOLT (BLACK ZINC)	
24	4	M6 BUTTON HEAD BOLT (BLACK ZINC)	
25	4	M6 SERRATED FLANGED HEX NUT (BLACK ZINC)	
26	4	40MM LONG M12 BUTTON HEAD BOLT (BLACK ZINC)	
27	4	M12 HEX HEAD BOLT (BLACK ZINC)	
28	8	M12 SPLIT LOCK WASHER (BLACK ZINC)	

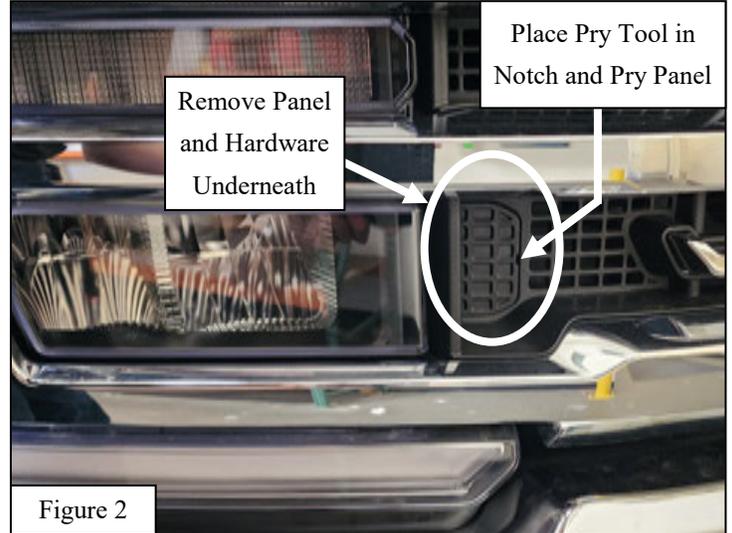
ANTI-SEIZE LUBRICANT MUST BE USED ON ALL STAINLESS STEEL FASTENERS TO PREVENT THREAD DAMAGE AND GALLING

CONTENT			
ITEM	QUANTITY	DESCRIPTION	TOOLS NEEDED
29	8	M12 FLAT WASHER (BLACK ZINC)	
30	6	ZIP TIE	
31	2	PARKING SENSOR EXTENSION	
32	2	DOUBLE SIDED TAPE	
33	2	SPACER	
34	4	35MM LONG M12 BUTTON HEAD BOLT (BLACK ZINC)	
35	4	M12 BELLEVILLE WASHER (BLACK ZINC)	
36	4	M12 SERRATED FLANGED HEX NUT (BLACK ZINC)	
ANTI-SEIZE LUBRICANT MUST BE USED ON ALL STAINLESS STEEL FASTENERS TO PREVENT THREAD DAMAGE AND GALLING			

ITEM 1		
		
ITEM 2 - Passenger Side Opposite	ITEM 4 - Passenger Side Opposite	ITEM 6 - Passenger Side Opposite
		
ITEM 8	ITEM 9	ITEM 33
		

PROCEDURE

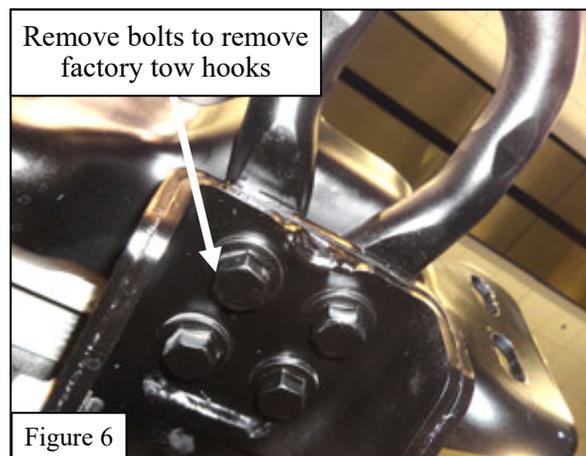
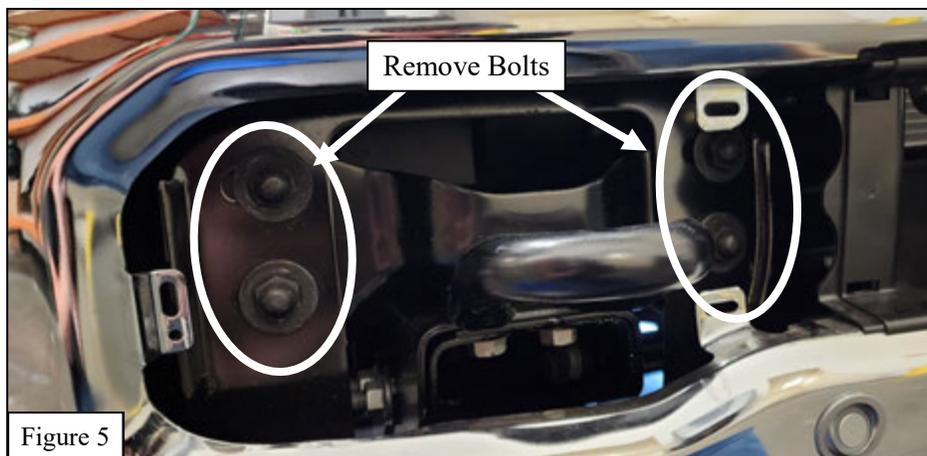
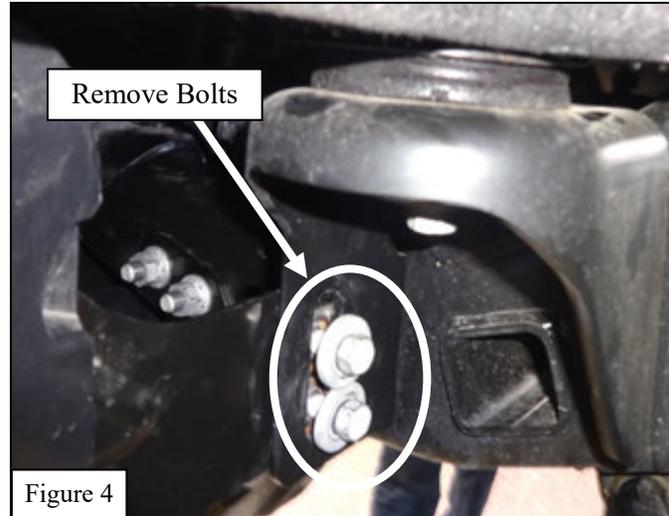
1. Remove contents from box, verify if all parts listed are present and free from damage. Carefully read and understand all instructions before attempting installation.
Failure to identify damage before installation could lead to a rejection of any claim.
2. Open the hood and remove the bolts attaching the top of the grille to the truck. See **Figure 1**.
3. On each side, remove the panel shown in **Figure 2** and remove the hardware underneath. Place the end of a pry tool in the rectangular notch on the side of the panel to pry the panel out.
4. Remove the (4) bolts attaching the bottom of the grille to the truck.



5. Remove the grille from the truck, disconnect any cables or tubes connected to the grille.
6. Remove the plastic panels circled in **Figure 3**.



7. On each side, remove (2) bolts attaching the front bumper to the body mounts. These bolts must be accessed from underneath the truck. They are located behind the bumper. See **Figure 4**.
8. Disconnect all cables from the front bumper.
9. On each side, remove the (4) bolts shown in **Figure 5**.
10. With assistance, remove the front bumper from the frame of the truck.
11. Remove the factory tow hooks. **Note:** Factory tow hooks will not be re-used. See **Figure 6**.



12. On each side of the truck, remove the factory bracket and hardware shown in **Figure 7**. The factory brackets will not be re-used.
13. Loosely install Driver Bracket C (**item 6**) into the frame using the M12 hardware (**items 13, 16, and 17**). See **Figure 8**.
14. Loosely install Driver Bracket A (**item 2**) onto the frame where the tow hooks were removed in step 11 using the M12 hardware (**items 12, 13, 16, 18, and 19**). See **Figure 9**.
15. Loosely install Passenger Bracket A (**item 3**) and Passenger Bracket C (**item 7**) on the passenger side of the vehicle.

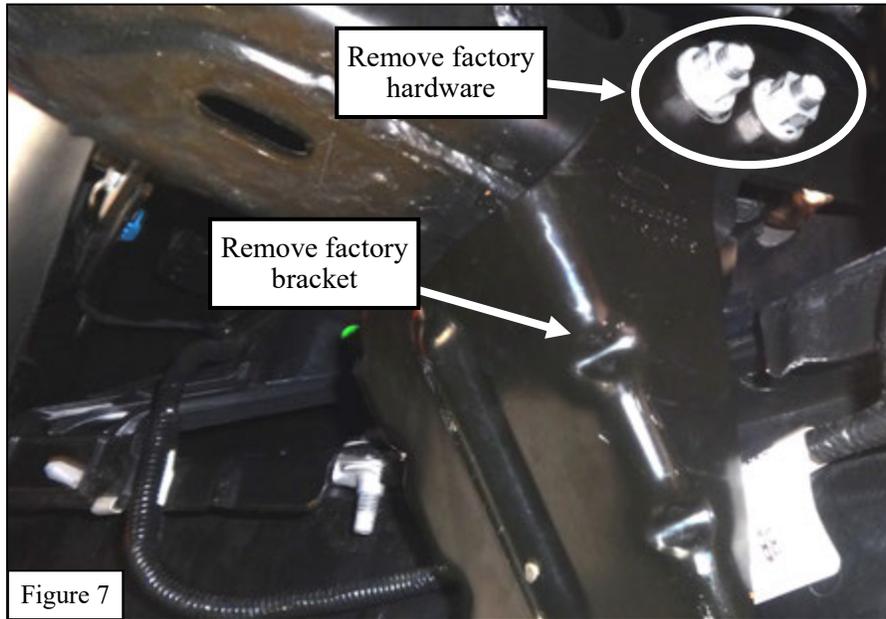


Figure 7

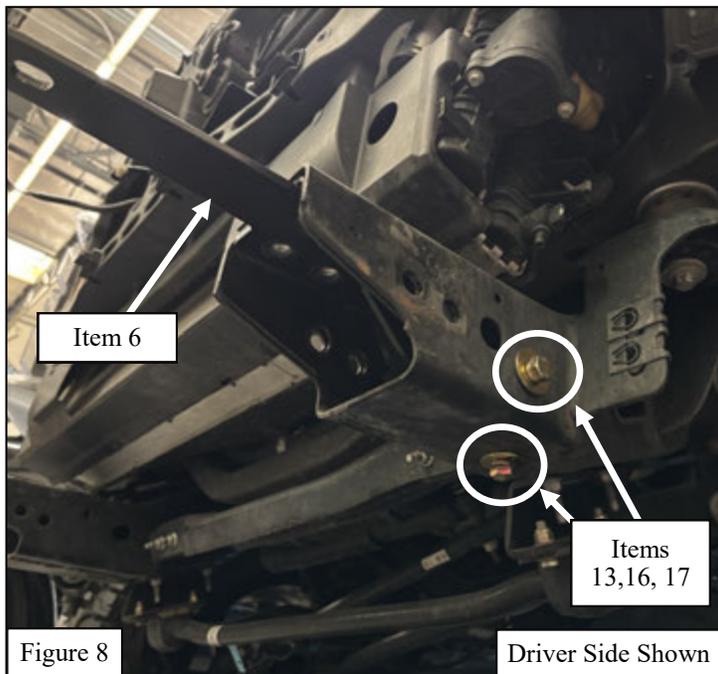


Figure 8

Driver Side Shown

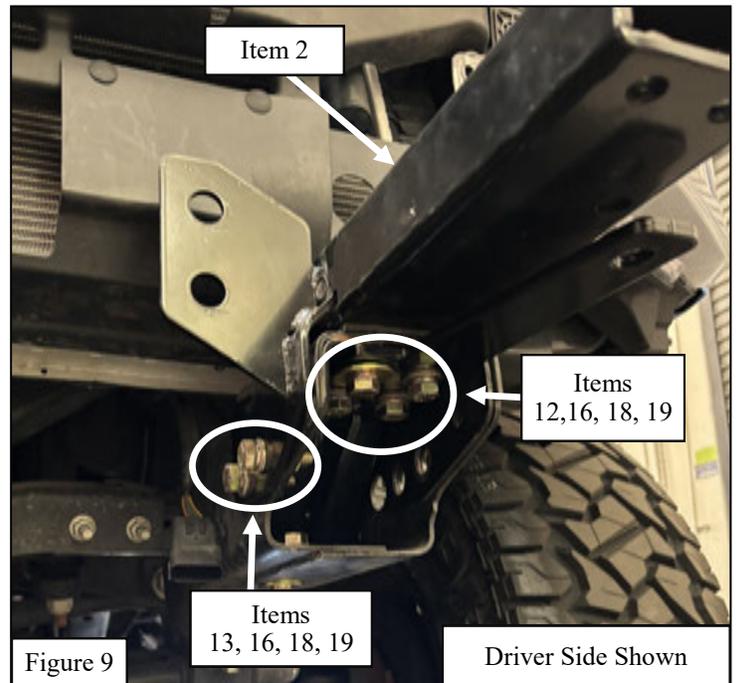
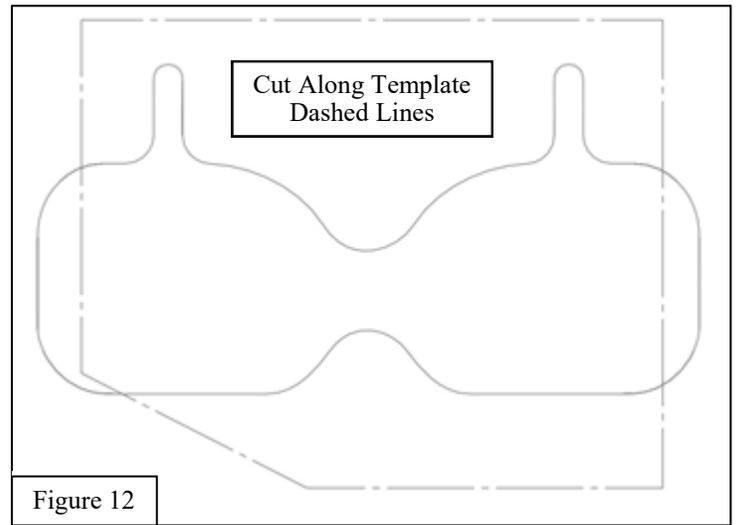
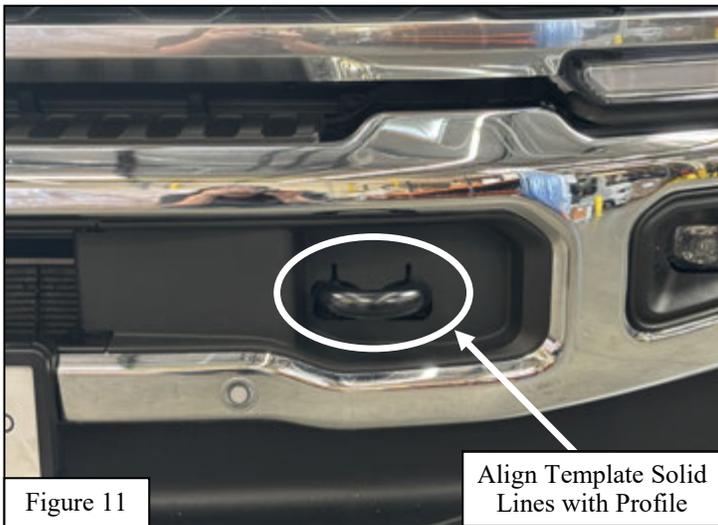
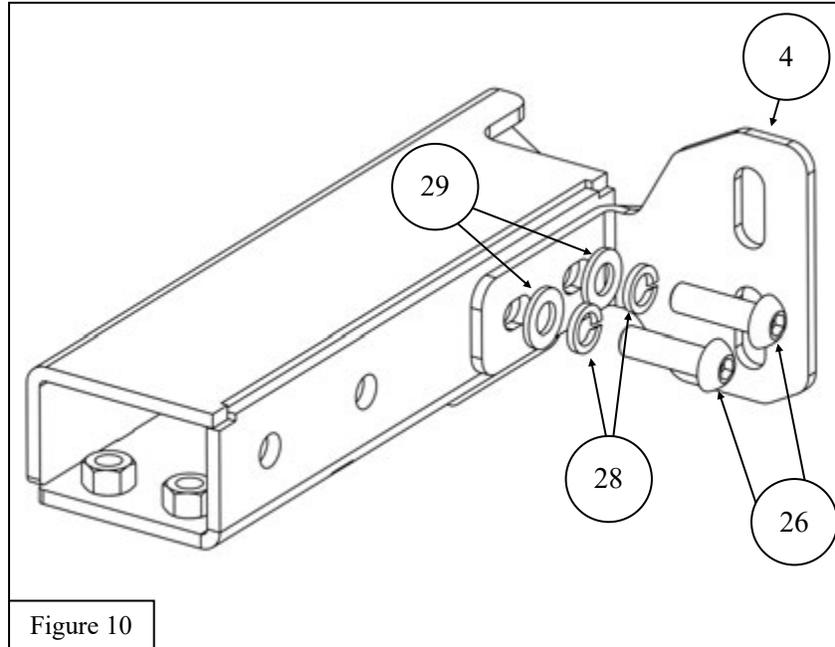


Figure 9

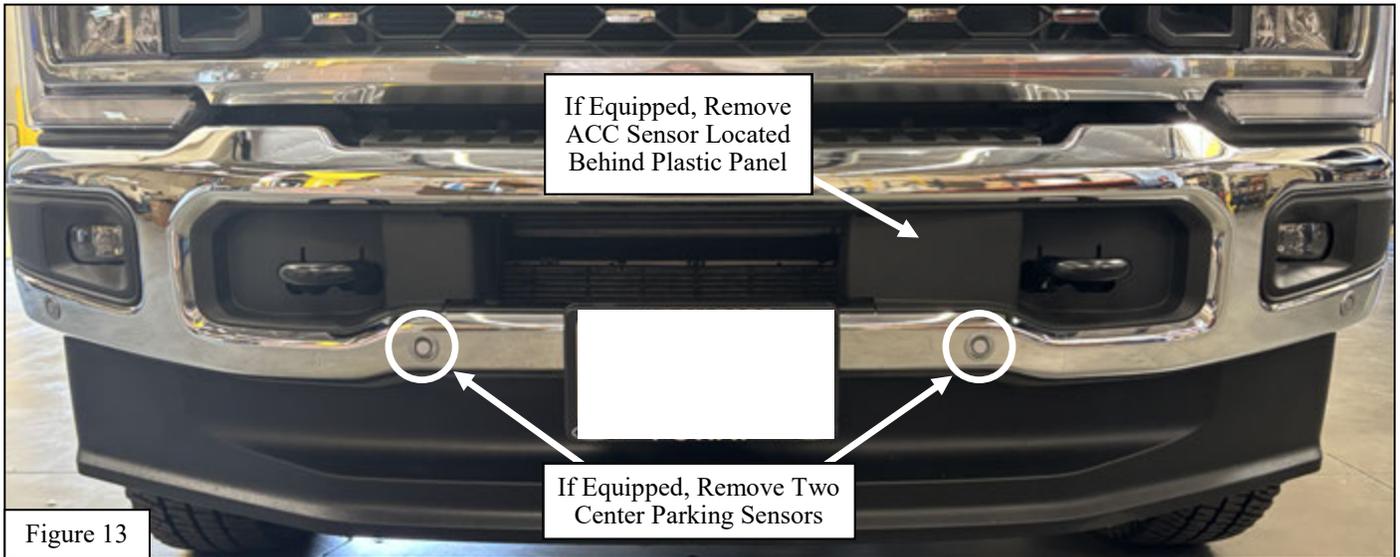
Driver Side Shown

16. Install the Driver Bracket B (item 4) onto the previously installed Driver Bracket A using the M12 hardware (items 26, 28, and 29). See Figure 10.
17. Install Passenger Bracket B (item 5) on the passenger side.
18. Trim the plastic panels removed in step 6 using the Driver and Passenger Cutting Templates (items 10 and 11). Align the template solid lines with the profile shown in Figure 11 and tape the template in place. Use a utility knife to trace the template dashed lines onto the plastic. Trim the panel along the traced lines using a utility knife. See Figures 11 and 12.

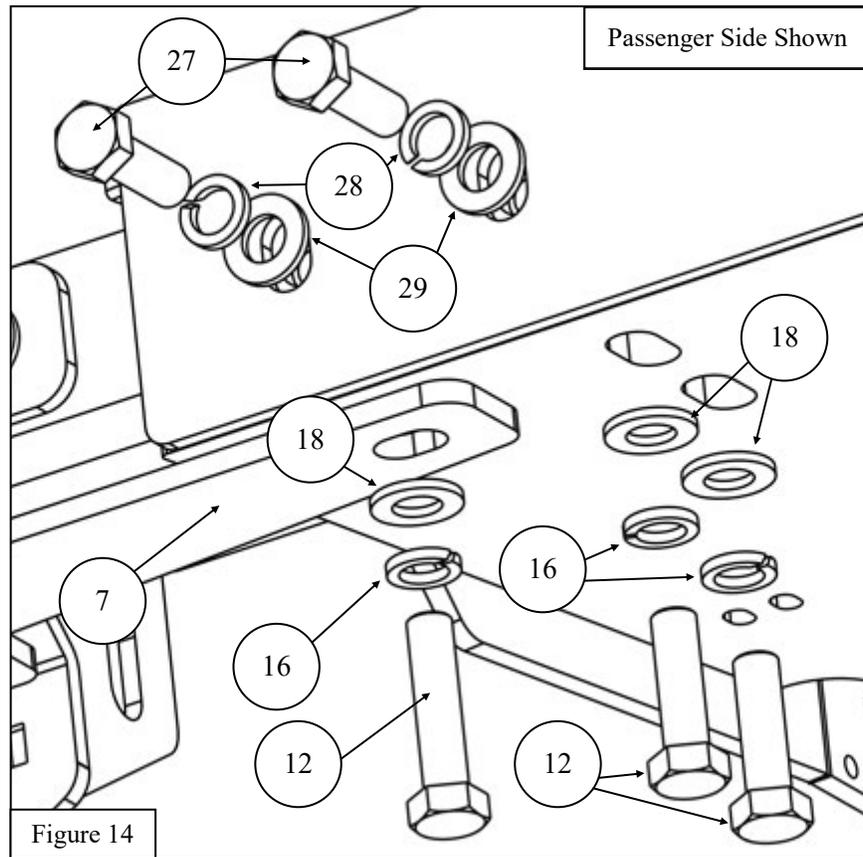


19. If equipped, remove the two center parking sensors from the front bumper. See **Figure 13**.
 - Disconnect each sensor from the bumper wiring harness. Press the red locking tab on the sensor connector and pull the connector away from the sensor.
 - Remove each sensor from the clips holding them in place. Release the sensors by prying each side of the clip away from the sensor using a pry tool while pushing the sensor from the outside of the bumper.
20. If parking sensors are equipped, connect a Parking Sensor Extension (**item 31**) where each parking sensor was plugged into the bumper wiring harness. See **Figure 13**.
21. If equipped, remove the active cruise control (ACC) sensor from the front bumper.
 - The ACC sensor is located in the front bumper behind the driver side panel removed in step 6.
 - Disconnect the sensor from the bumper wiring harness. Press the locking tab on the sensor connector and pull the connector away from the sensor.
 - Remove the sensor from the bumper by removing the bolts attaching it to the bumper.

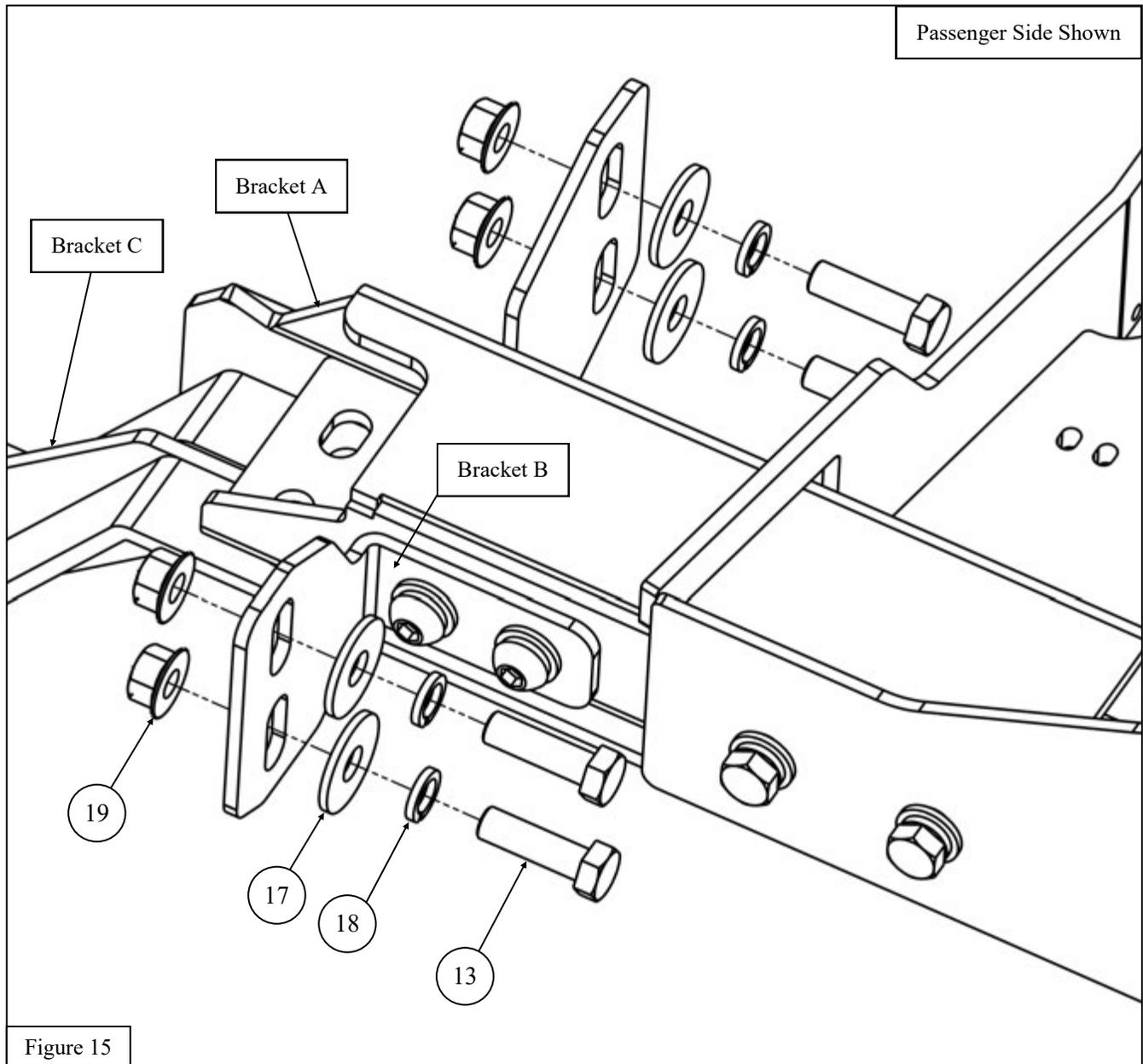
Note: The ACC sensor will be relocated to the winch tray using the ACC Relocation Kit (part number **48-25905**).
22. If ACC sensor is equipped, attach the ACC extension cable from the ACC Relocation Kit where the ACC sensor was plugged into the bumper wiring harness. See **Figure 13**.



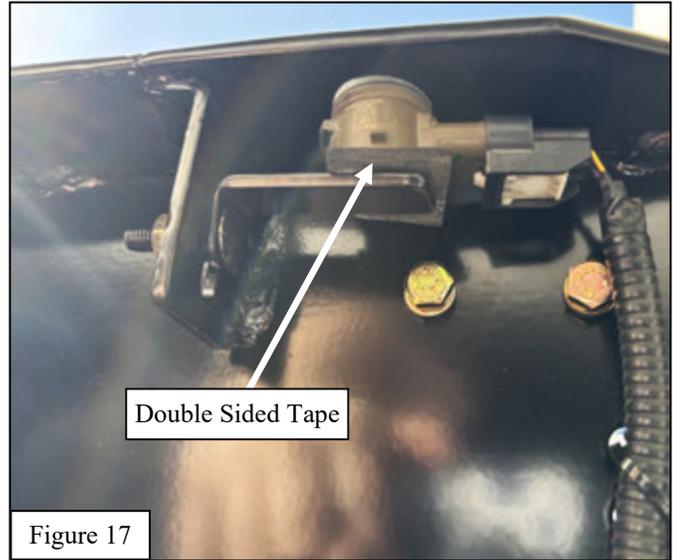
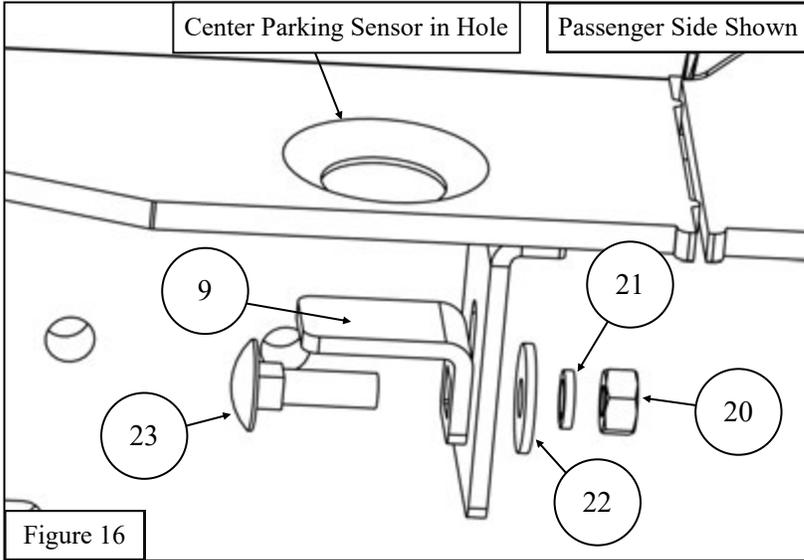
22. Slide the Winch Tray (**item 1**) so it sits between Brackets C and Brackets A. Loosely attach the winch tray to Brackets C and A using the M12 hardware (**items 12, 16, 18, 27, 28, and 29**). See **Figure 14**.



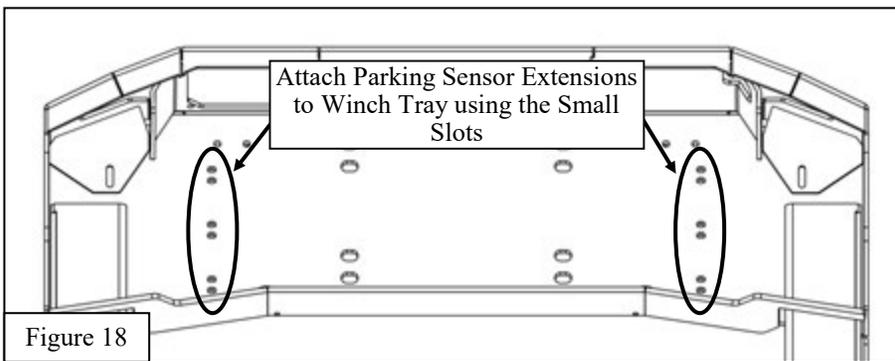
24. Adjust and align the brackets, then tighten the M12 bracket hardware to 60 ft-lb.
 - Adjust and align the brackets and winch tray. The winch tray will be used to properly align the brackets.
 - Temporarily hand tighten the M12 hardware attaching the winch tray to the brackets.
 - Tighten and torque the M12 hardware attaching the brackets to the truck.
25. Remove the winch tray from the brackets.
26. Reinstall the front bumper onto Mount Brackets A and Mount Brackets B using the M12 hardware (**items 13, 16, 17, and 19**). Reconnect the front bumper wiring harness. Tighten the M12 hardware attaching the brackets to the vehicle to 60 ft-lb. See **Figure 15**.
27. Reinstall the winch tray onto Mount Brackets A and C. See **Figure 14**.



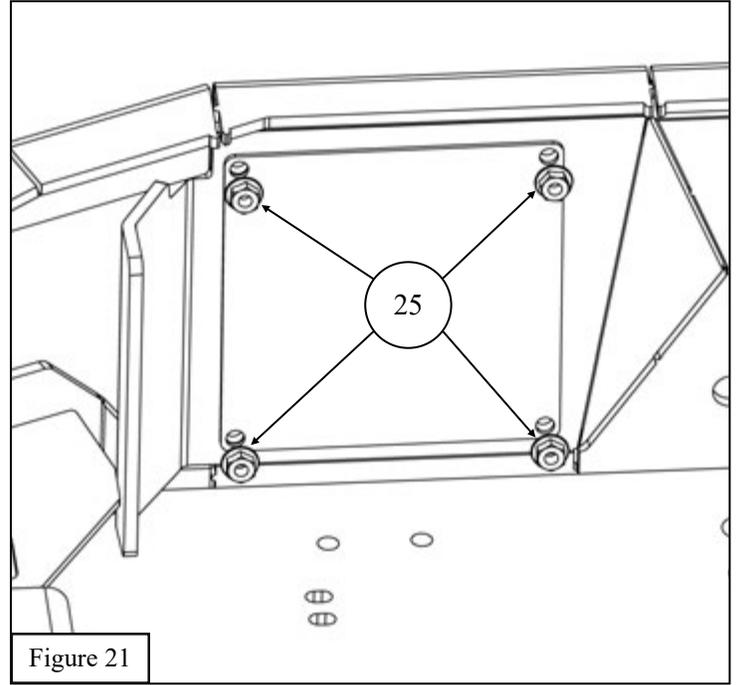
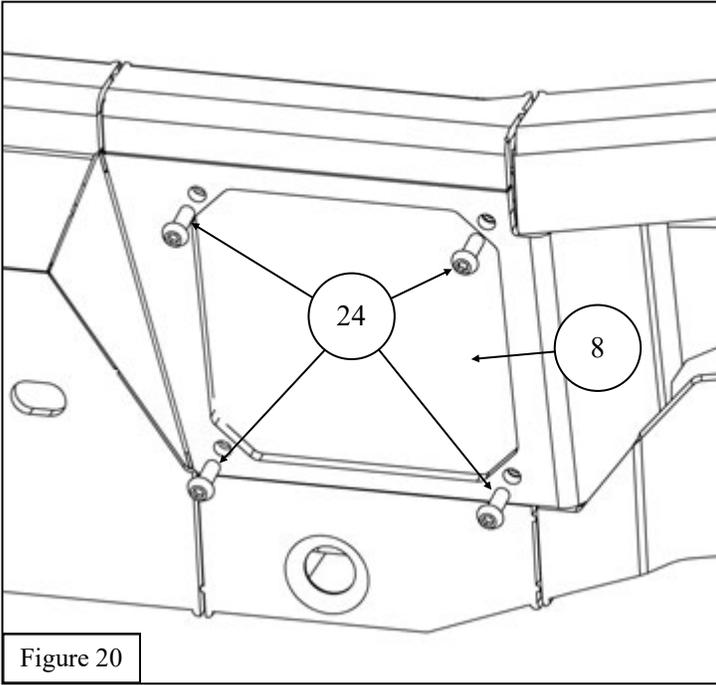
28. If installing parking sensors, loosely install the Parking Sensor Brackets (**item 9**) onto the front of the winch tray using the M6 hardware (**items 20-23**). See **Figure 16**.
29. If installing parking sensors, install the parking sensors removed in step 19. Make sure the factory sensor grommet is in place before installing each sensor. The factory grommet should surround the part of the sensor that will be placed in the sensor hole. Place a piece of double sided tape on the back of the parking sensor. Place the parking sensors in the holes near the bottom of the winch tray. Center the parking sensors in the holes and hold them in place by pressing the parking sensor brackets against the back of the parking sensors. Tighten the M6 hardware to 7-8 ft-lbs. See **Figure 17**.



30. If installing parking sensors, connect the parking sensor extensions to the parking sensors and attach the parking sensor extensions to the bottom of the winch tray using the provided zip ties (**item 30**). Route the parking sensor extensions through the bumper, underneath the winch tray and to the parking sensors. On each side, attach the zip ties to the pairs of small slots in the winch tray and the parking sensor extensions.



31. Install the ACC Cover (**item 8**) to the winch tray using the provided M6 hardware (**items 24 and 25**) Tighten the M6 hardware to 7-8 ft-lbs.
32. If equipped, reinstall the ACC sensor using the ACC Relocation Kit (part number 48-25905). Reference the ACC Relocation Kit installation sheet.



33. Install the winch into the tray. If installing a Superwinch Tiger Shark 18,000 winch, use the M12 hardware (**items 14-18**). See **Figures 22 and 23**.
34. Adjust the winch tray and winch as needed. Tighten all remaining M12 hardware to 60 ft-lb.

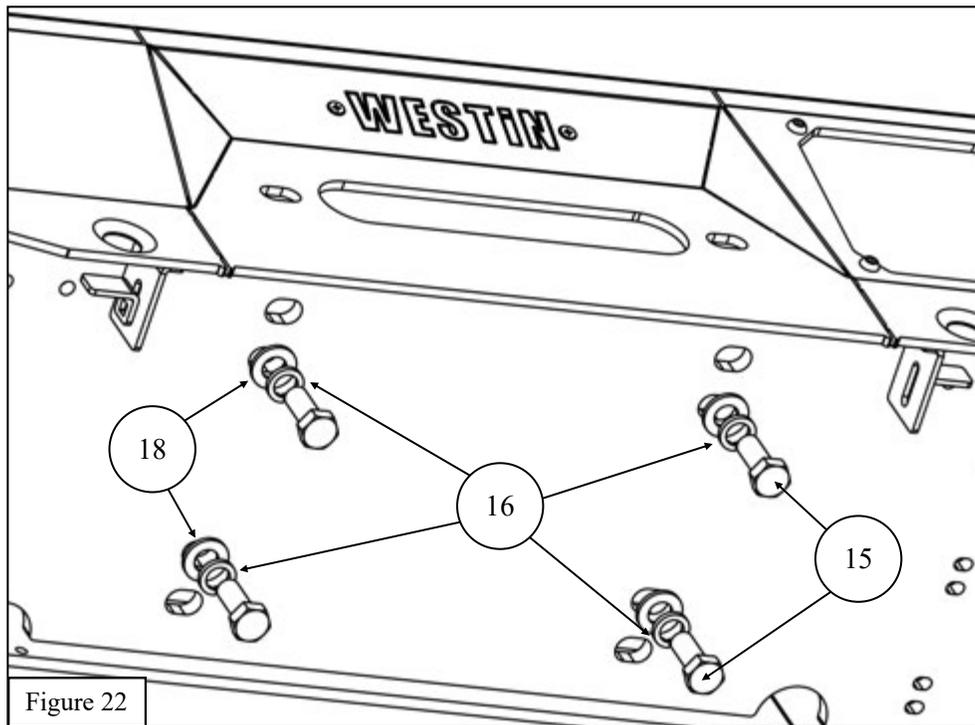


Figure 22

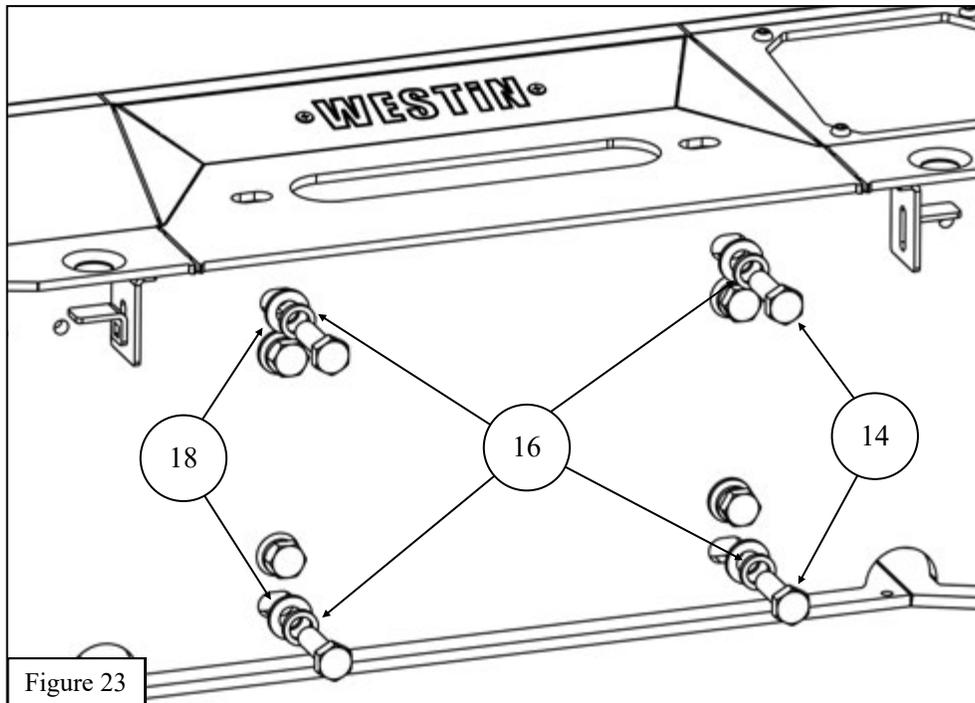
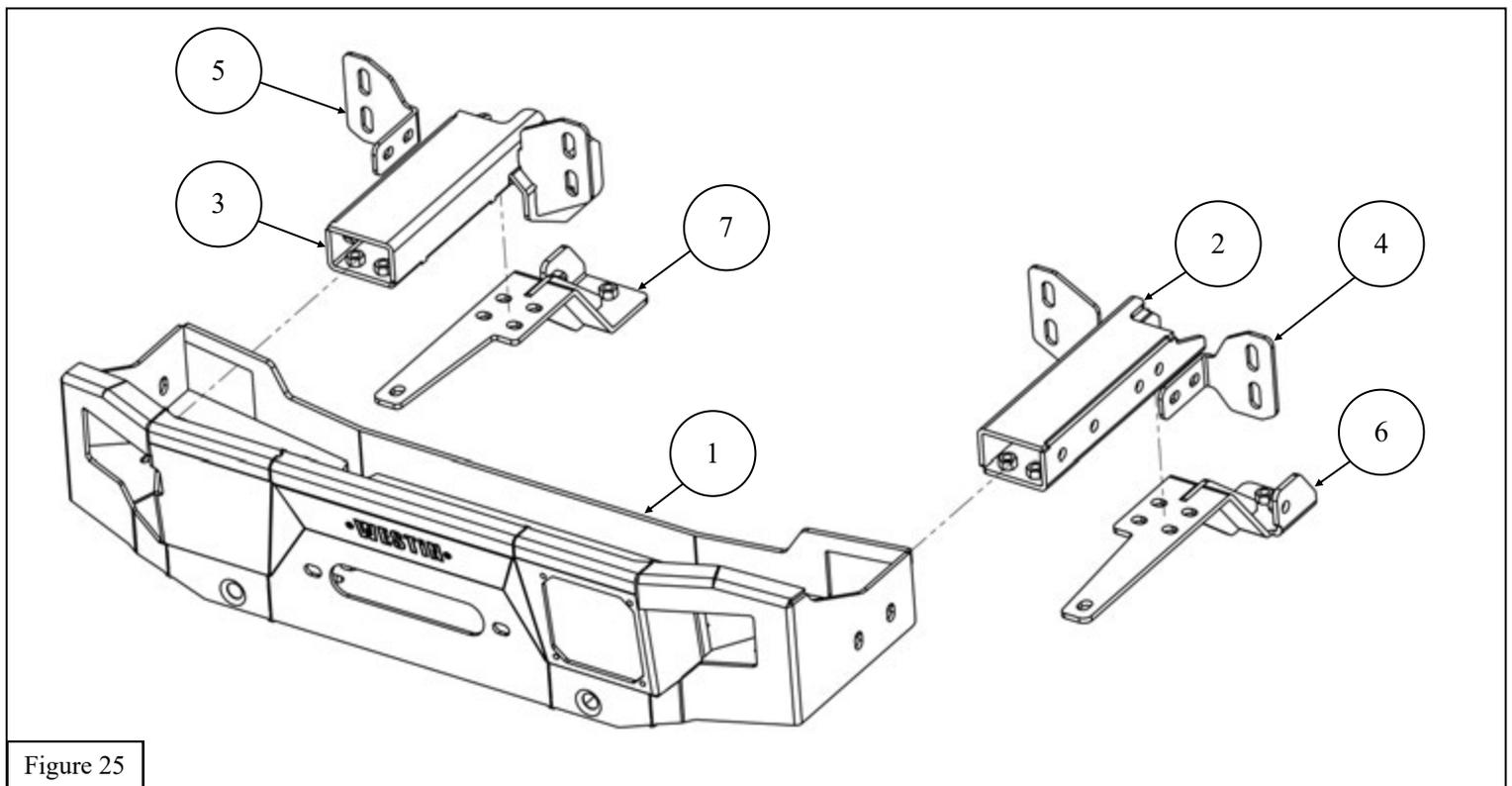
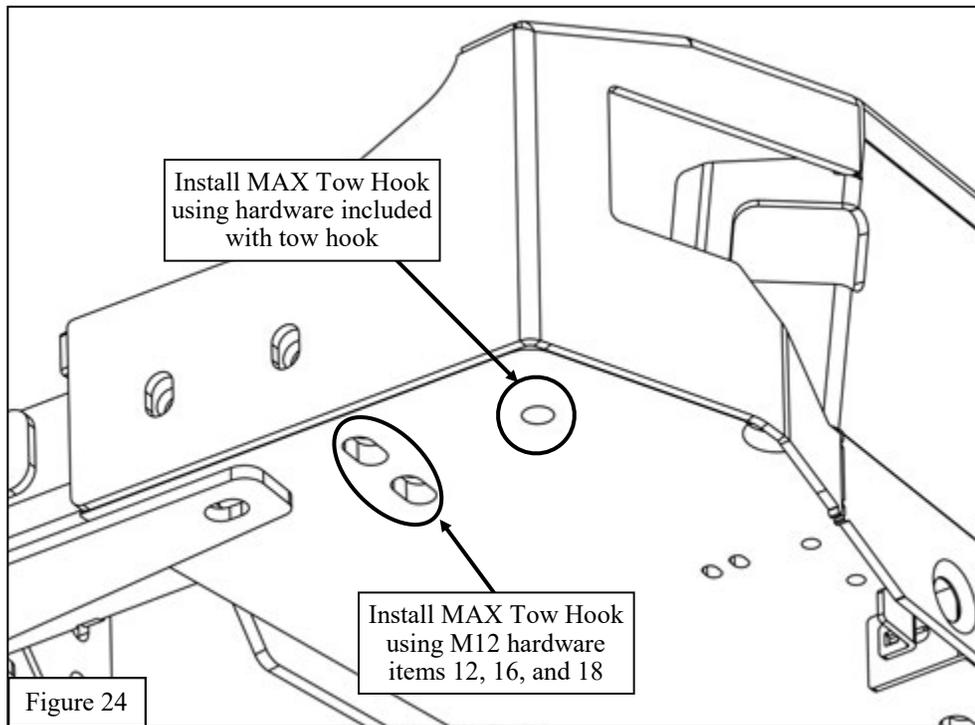


Figure 23

35. If installing MAX tow hooks (part number 46-3005), loosely install them to the bottom of the winch tray using the M12 hardware (items 12, 16, and 18) and the hardware included with the tow hooks. See **Figure 24**.

36. Adjust the tow hooks as needed. Tighten tow hook M12 hardware to 60 ft-lb.



INSTALLATION COMPLETE



CARE INSTRUCTIONS

- Texture Black Finishes should be cleaned with mild soap and water only (do not wax).
- Gloss Black Finishes should be cleaned with mild soap and water.
- Polished Stainless products should be cleaned with mild soap and water. Stainless Steel polish may be used to remove small scratches.
- Regular waxing is recommended for Gloss Black and Stainless Steel products. Do not use wax that may contain abrasives.

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



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



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