



SKI-DOO KIT - XC Cast Front Bumper

Product:	Ski-Doo
Project no:	487803783_rev2
Instruction Sheet P/N:	487803783
Revision no:	2
Revision date:	July, 2026
Item covered:	XC Cast Front Bumper

The following symbols may be used in this document:



WARNING

Indicates a hazardous situation which, if not avoided, could result in death or serious injury.

CAUTION: Indicates a hazard situation which, if not avoided, could result in minor or moderate injury.

NOTICE Indicates an instruction which, if not followed, could severely damage vehicle components or other property.



WARNING

- For safety reasons, this kit must be installed by an authorized BRP dealer.
- This kit is designed for specific applicable models only (authorized BRP dealers will confirm model(s)). It is not recommended for units other than the one (those) for which it was sold.
- Should removal of a locking device (e.g. lock tabs, self-locking fasteners, etc.) be required when undergoing disassembly/assembly, always replace with a new one.
- Torque wrench tightening specifications must strictly be adhered to.
- Unless otherwise specified, engine must be OFF when performing any operation on the vehicle.
- Always be aware of parts that can move, such as wheels, transmission components, etc.
- Always wear EYE PROTECTION AND APPROPRIATE GLOVES when using power tools.
- Some components may be HOT. Always wait for engine to cool down before performing work.



WARNING

Some important safety information and/or operating instructions dedicated to the end user might be included in this instruction sheet. Make sure to give the kit part number as well as the instruction sheet included with this kit to the customer. Verify that the customer has access to all the information required for proper use of the accessory.

NOTE: USE TIGHTENING TORQUES IN THE FOLLOWING TABLE IF NOT OTHERWISE SPECIFIED.

	GRADE			
	5.8	8.8	10.9	12.9
M4	1.8 ± 0.2 N•m (16 ± 2 lbf•in)	2.8 ± 0.2 N•m (25 ± 2 lbf•in)	3.8 ± 0.2 N•m (34 ± 2 lbf•in)	4.5 ± 0.5 N•m (40 ± 4 lbf•in)

M5	3.3 ± 0.2 N•m (29 ± 2 lbf•in)	5 ± 0.5 N•m (44 ± 4 lbf•in)	7.8 ± 0.7 N•m (69 ± 6 lbf•in)	9 ± 1 N•m (80 ± 9 lbf•in)
M6	7.5 ± 1 N•m (66 ± 9 lbf•in)	10 ± 2 N•m (89 ± 18 lbf•in)	12.8 ± 2.2 N•m (113 ± 19 lbf•in)	16 ± 2 N•m (142 ± 18 lbf•in)
M8	15.3 ± 1.7 N•m (135 ± 15 lbf•in)	24.5 ± 3.5 N•m (18 ± 3 lbf•ft)	31.5 ± 3.5 N•m (23 ± 3 lbf•ft)	40 ± 5 N•m (30 ± 4 lbf•ft)
M10	29 ± 3 N•m (21 ± 2 lbf•ft)	48 ± 6 N•m (35 ± 4 lbf•ft)	61 ± 9 N•m (45 ± 7 lbf•ft)	73 ± 7 N•m (54 ± 5 lbf•ft)
M12	52 ± 6 N•m (38 ± 4 lbf•ft)	85 ± 10 N•m (63 ± 7 lbf•ft)	105 ± 15 N•m (77 ± 11 lbf•ft)	128 ± 17 N•m (94 ± 13 lbf•ft)
M14	85 ± 10 N•m (63 ± 7 lbf•ft)	135 ± 15 N•m (100 ± 11 lbf•ft)	170 ± 20 N•m (125 ± 15 lbf•ft)	200 ± 25 N•m (148 ± 18 lbf•ft)
M16	126 ± 14 N•m (93 ± 10 lbf•ft)	205 ± 25 N•m (151 ± 18 lbf•ft)	255 ± 30 N•m (188 ± 22 lbf•ft)	305 ± 35 N•m (225 ± 26 lbf•ft)
M18	170 ± 20 N•m (125 ± 15 lbf•ft)	273 ± 32 N•m (201 ± 24 lbf•ft)	330 ± 25 N•m (243 ± 18 lbf•ft)	413 ± 47 N•m (305 ± 35 lbf•ft)

NOTE: The illustrations in this document show typical construction of the different assemblies and may not reproduce the full detail or exact shape of the parts; however, they represent parts that have the same or similar function.

Installation time is approximately **0.8** hours.

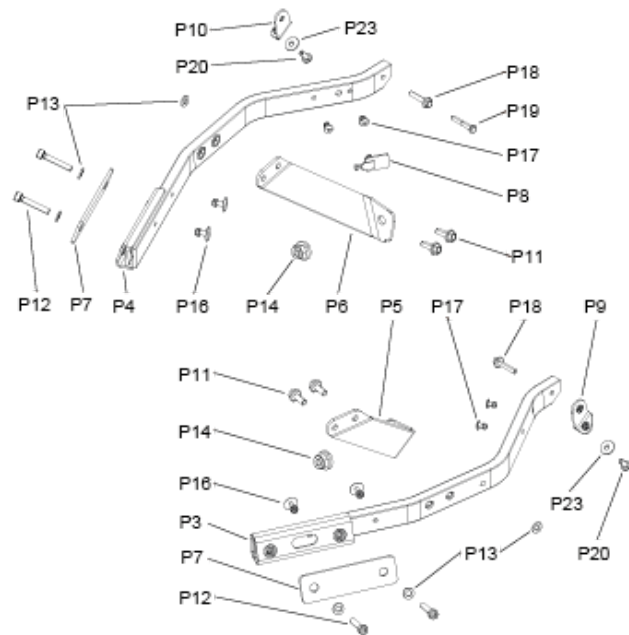
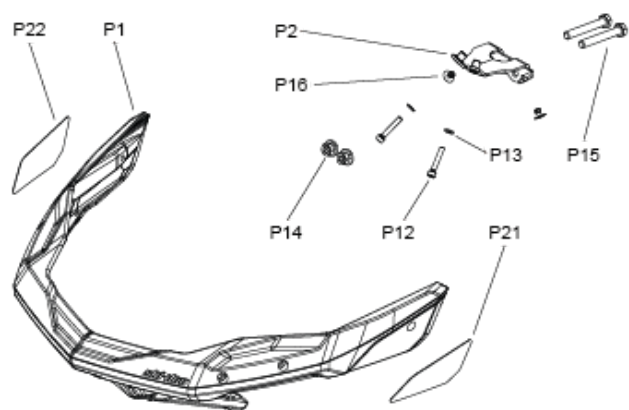
ICON LEGEND

ICON	INDICATES
	Parts to be discarded
	Parts kept for reinstallation

REQUIRED TOOLS

REQUIRED TOOL			USE
T1	Drill bit 5.5 mm (7/32 in)		To drill holes in the bottom pan
T2	Drill bit 5 mm (3/16 in)		To drill holes in the bottom pan
T3	Drill bit 10 mm (7/16 in)		To drill holes in the bottom pan
T4	Drill bit 12 mm (1/2 in)		To drill holes in the bottom pan (REV Gen4 Narrow models only)

PARTS TO BE INSTALLED



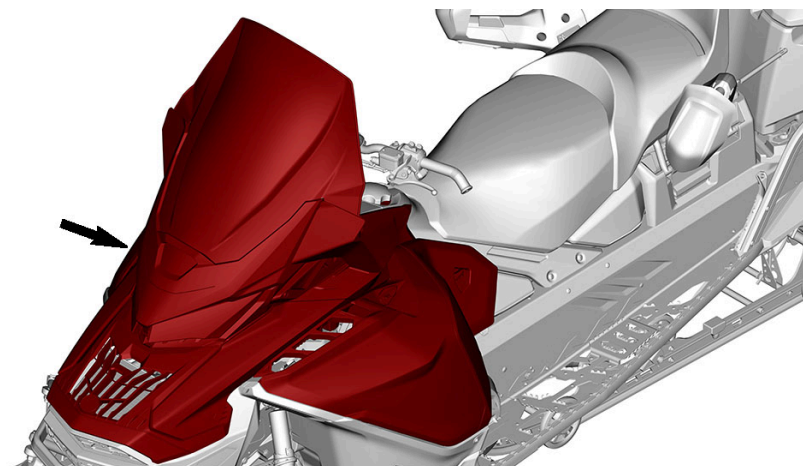
ITEM	DESCRIPTION	PART NUMBER	QTY
P1	Front Bumper	Not available separately	1

ITEM	DESCRIPTION	PART NUMBER	QTY
P2	Wear Plate	505074320	1
P3	LH Front Sectional Tube	502008367	1
P4	RH Front Sectional Tube	502008368	1
P5	LH Bumper Reinforcement	502008969	1
P6	RH Bumper Reinforcement	502008968	1
P7	Spacer	Not available separately	2
P8	Module Support	514056265	1
P9	LH Rear Bumper Reinforcement	Not available separately	1
P10	RH Rear Bumper Reinforcement	Not available separately	1
P11	M6 x 16 Hex. Flanged screw	207661646	4
P12	M6 x 35 socket head screw with Scotch Grip	250000288	6
P13	M6 Flat Washer	234061600	8
P14	M10 Elastic hex. Flanged nut	250100165	4
P15	M10 x 70 Hex. Screw	250001024	2
P16	Pop Rivet 3/16	293150292	6
P17	Avex Rivet 3/16	390909100	4
P18	M5 x 25 Hex. Flanged screw	207652544	2
P19	M5 x 30 Hex. Screw	207053044	1
P20	M5 x 14 Round head Torx screw	250000763	2
P21	LH Amber Reflector	520002717	1
P22	RH Amber Reflector	520002718	1
P23	M5 Washer	250200025	2

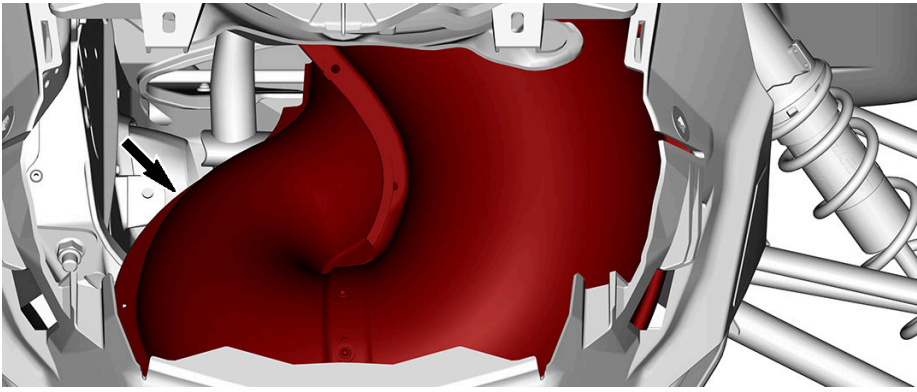
VEHICLE PREPARATION

E-TEC Models

Remove the following parts. Refer to the appropriate *SERVICE MANUAL* for procedure.



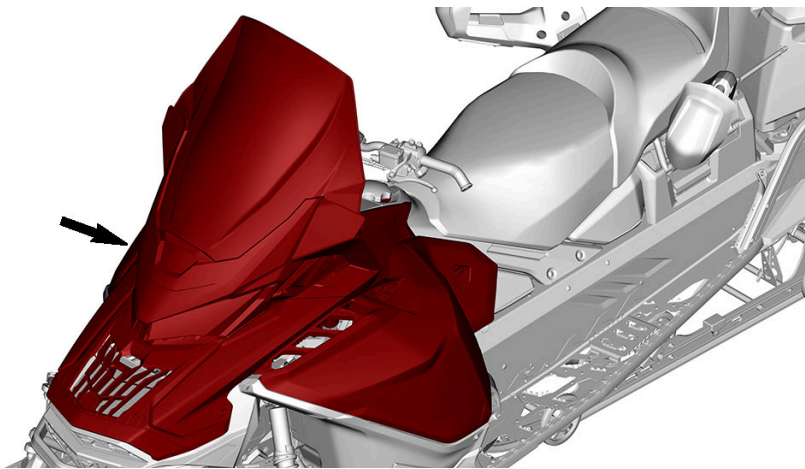
UPPER BODY MODULE



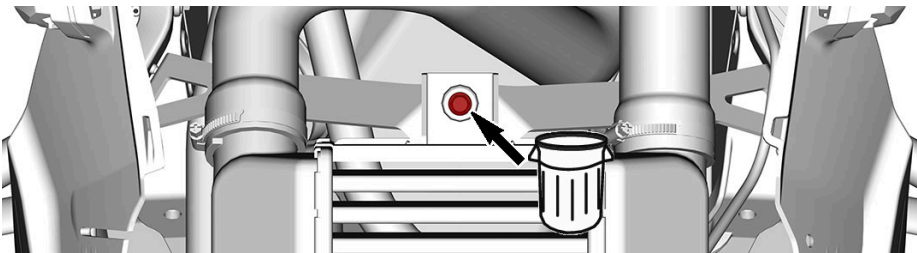
TUNED PIPE

ACE Models

1. Remove the following part. Refer to the appropriate *SERVICE MANUAL* for procedure.

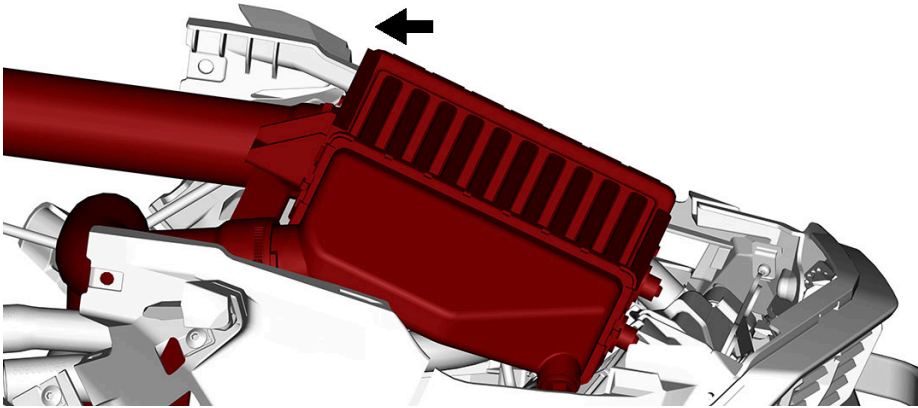


2. Remove and discard the following fastener on the intercooler.

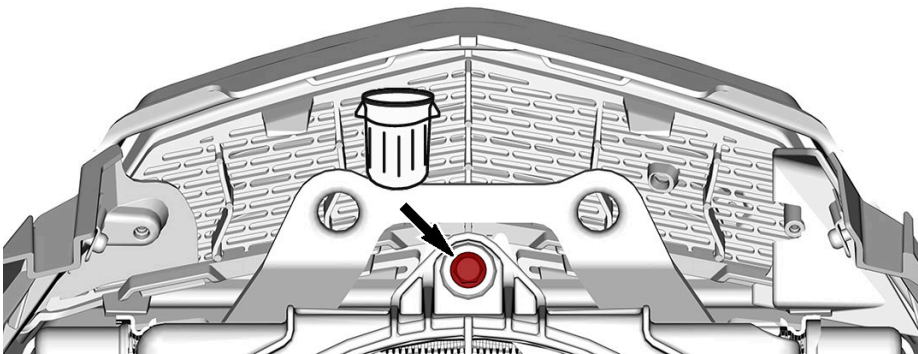


INTERCOOLER

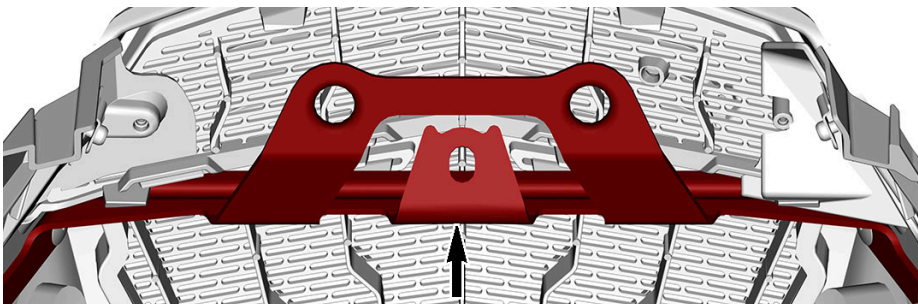
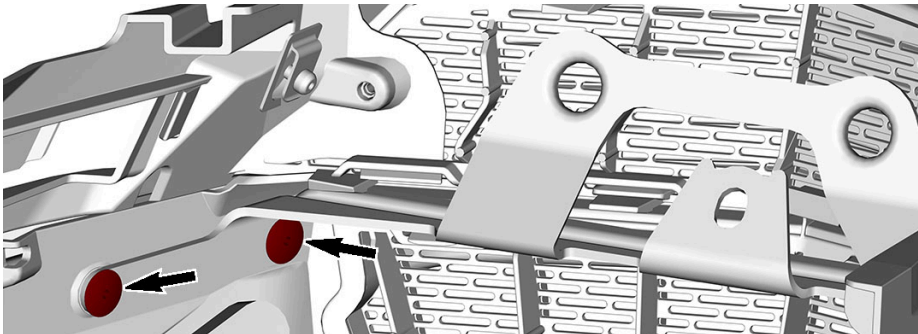
3. Move the intercooler rearward to make more room.



4. Remove and discard the following fastener.

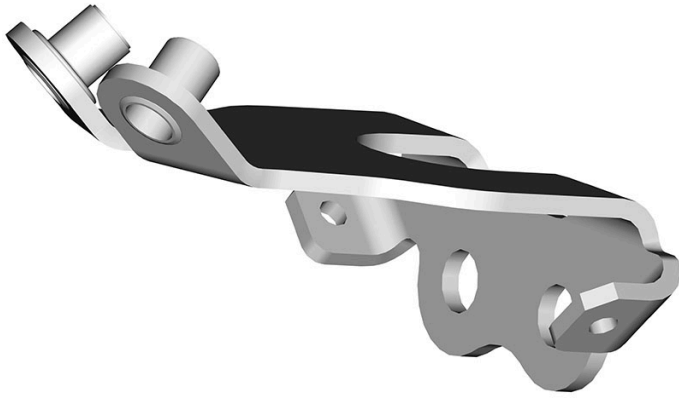


5. Remove the following rivets on both sides and the radiator support.



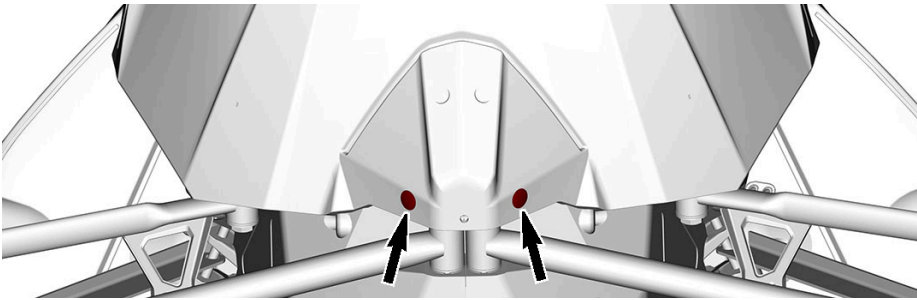
All Models

If the wear plate [P2] is already installed, proceed to step 3.

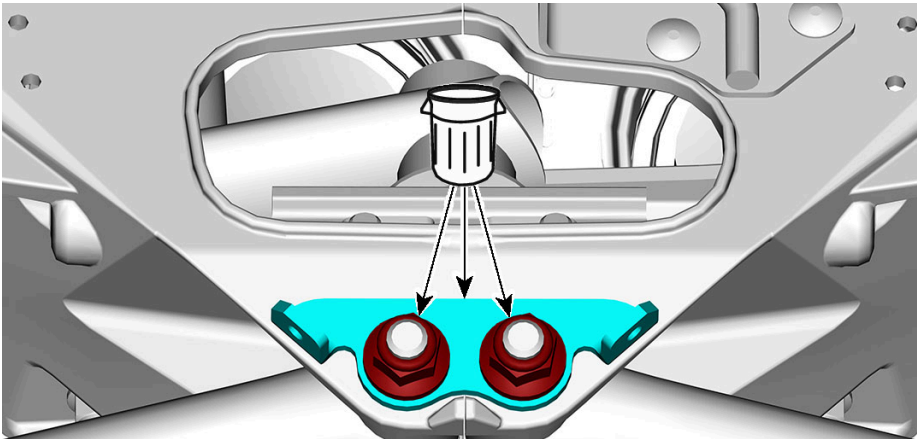


WEAR PLATE [P2]

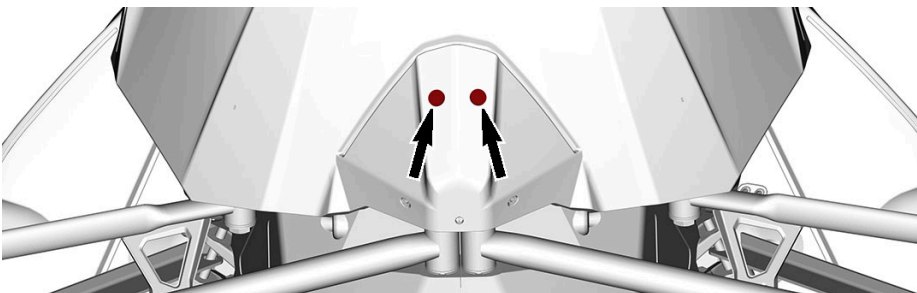
1. Remove the following rivets.



2. Remove and discard the following fasteners and the support.



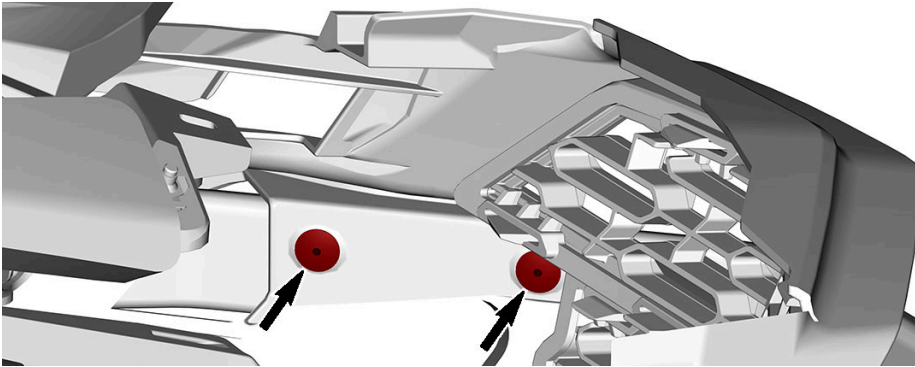
3. Remove the following plugs (if equipped).



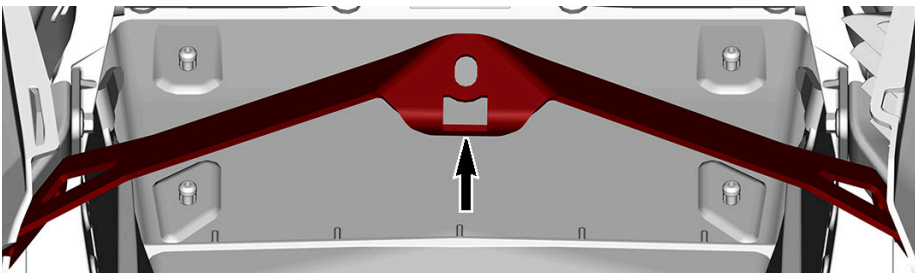
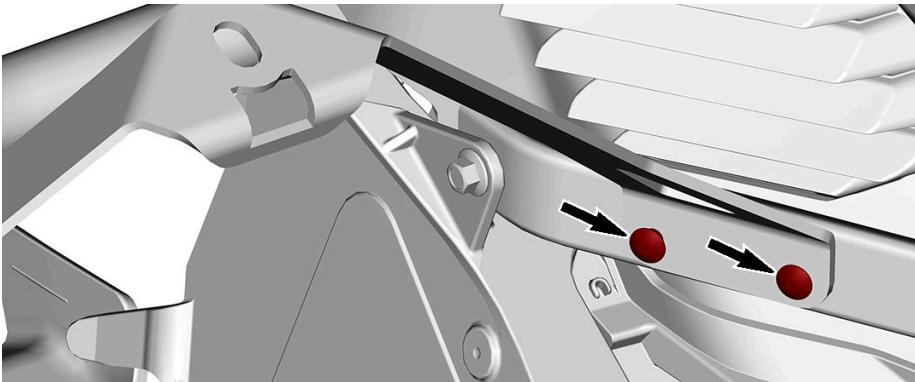
Removing the Original Bumper

Refer to the appropriate *SERVICE MANUAL* if required.

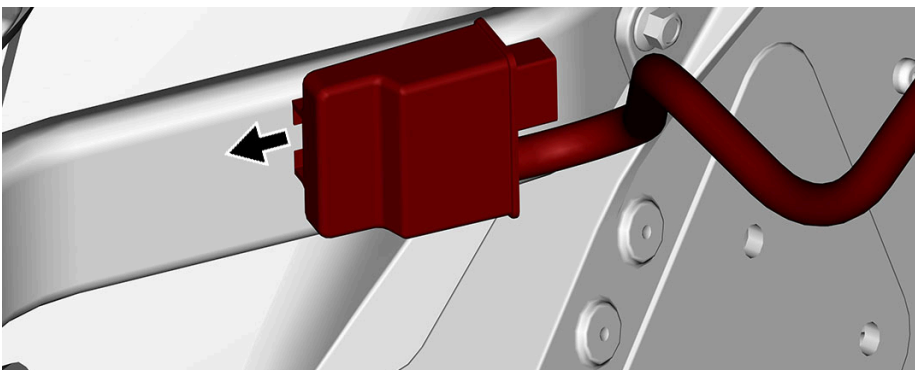
1. Remove the following rivets on both sides.



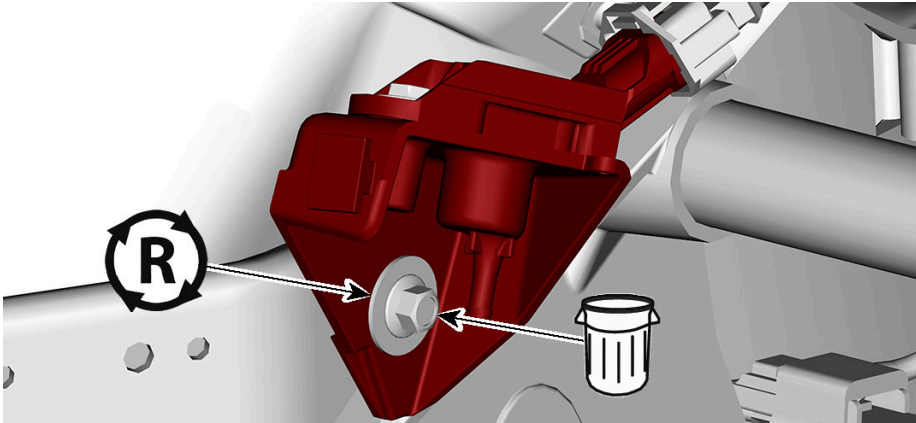
2. Remove the following rivets on both sides and the intercooler support (ACE only).



3. Remove the thermocouple module (E-TEC only).



4. Disconnect the following connector and remove the fasteners. Keep the washer and discard the screw (E-TEC only).



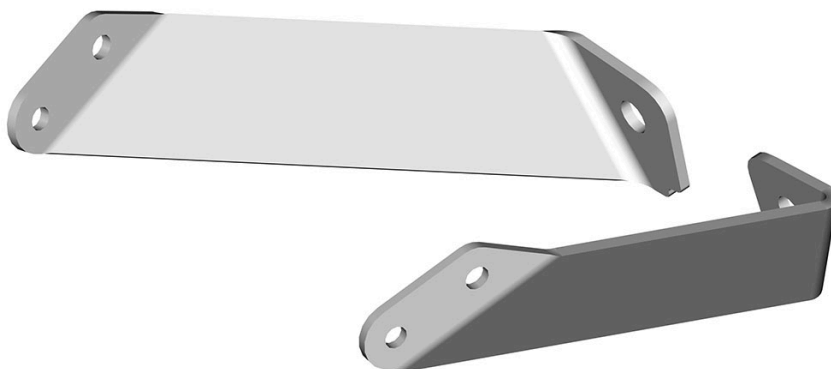
5. Remove the following fasteners and the bumper.



STEP 1. Remove fasteners

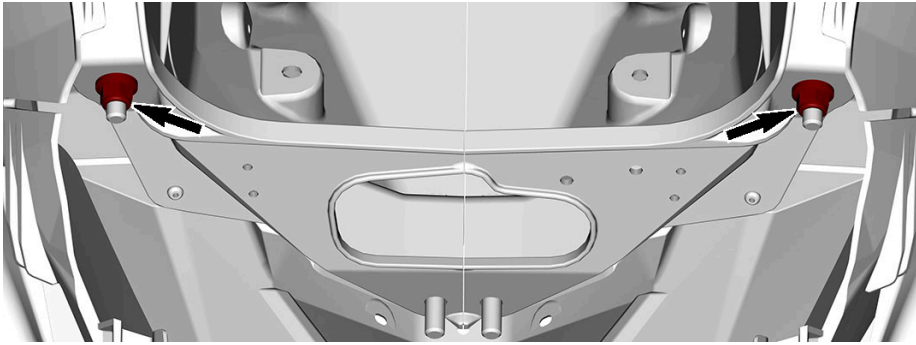
STEP 2. Remove bumper

6. If the bumper reinforcements [P5] and [P6] are already installed, proceed to step 8.

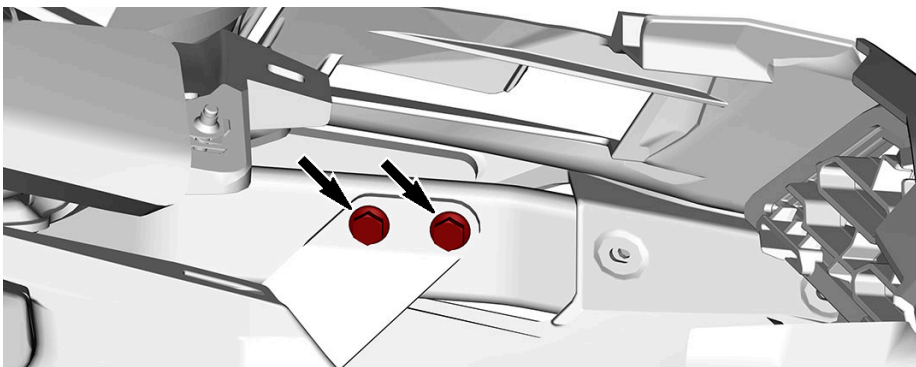


Bumper reinforcements [P5] and [P6]

7. Remove the following fasteners.

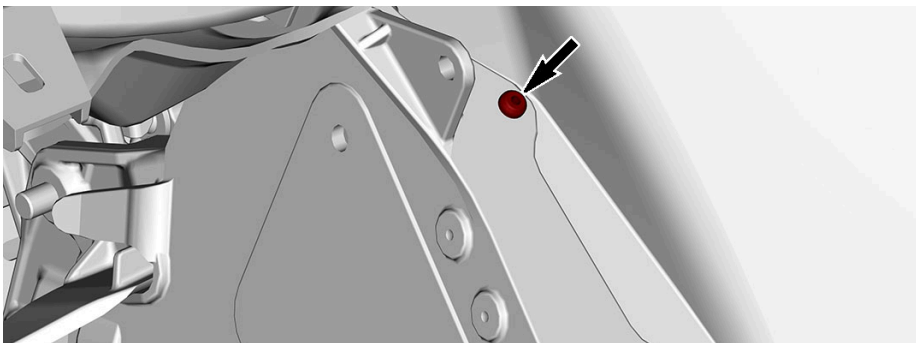


8. Remove the following fasteners.



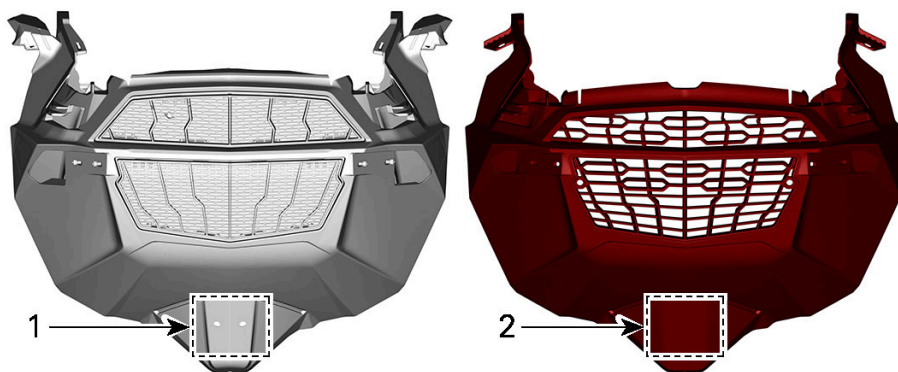
Drilling the Bottom Pan

1. Remove the following rivet on both sides.



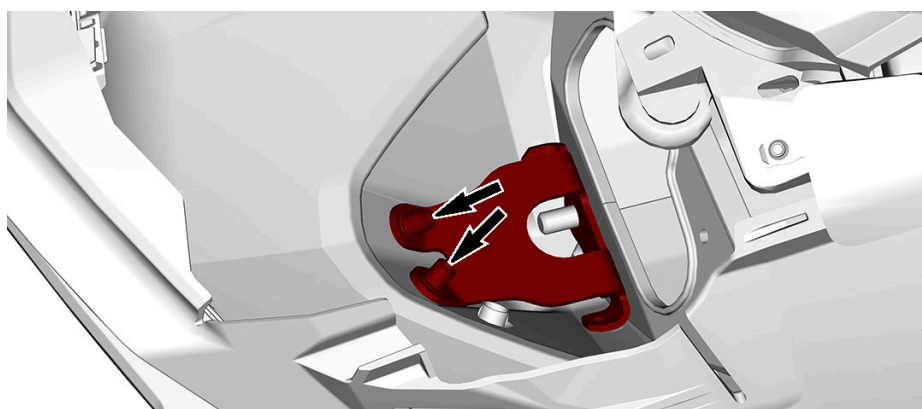
2. Drill the rivet holes using drill bit 5.5 mm (7/32 in) [T1] on both sides.

NOTE: If the vehicle is a REV Gen4 Narrow model (without holes in the lower section of the bottom pan), proceed to step 3. Otherwise, proceed to step 5.



1. All models except REV Gen4 Narrow
2. REV Gen4 Narrow

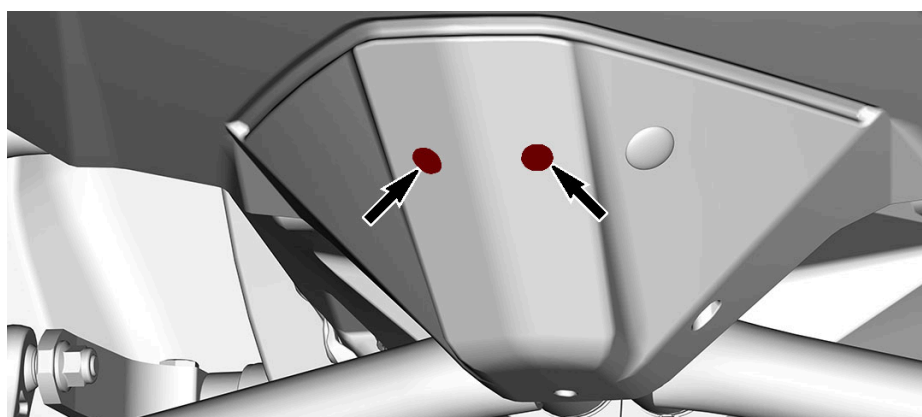
3. Use the wear plate [P2] as a template and mark the holes to drill.



INSIDE VIEW

NOTICE Make sure to not damage the threads

4. Remove the wear plate and drill the bottom pan using drill bit 5 mm (3/16 in) [T2]. If there are two layers of sheet metal, drill through all.
5. From outside the vehicle, drill the bottom pan using drill bit 10 mm (7/16 in) [T3] except REV Gen4 Narrow models.
6. For REV Gen4 Narrow models, drill the bottom pan using drill bit 12 mm (1/2 in) [T4]. If there are two layers of sheet metal, drill through all.

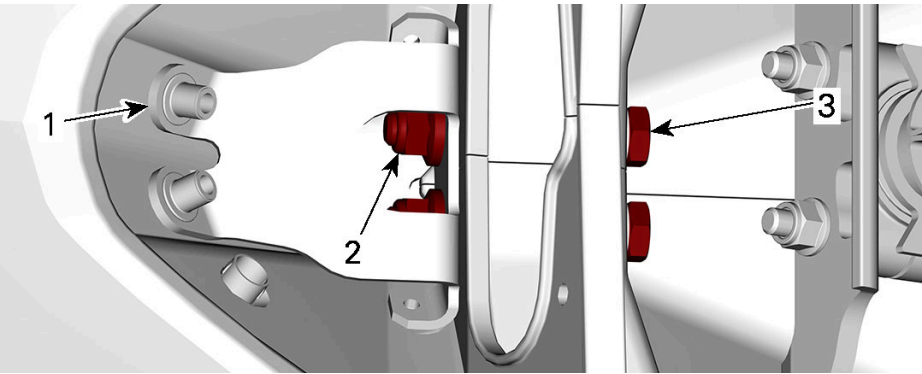


OUTSIDE VIEW

INSTALLATION INSTRUCTIONS

NOTE: LH side installation shown. Repeat on RH side.

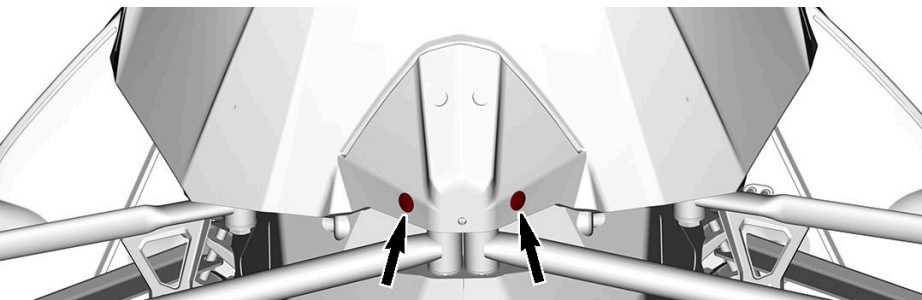
1. Install the wear plate [P2], if not already installed, using M10 x 70 Hex. Screw [P15] and M10 Elastic hex. Flanged nut [P14].



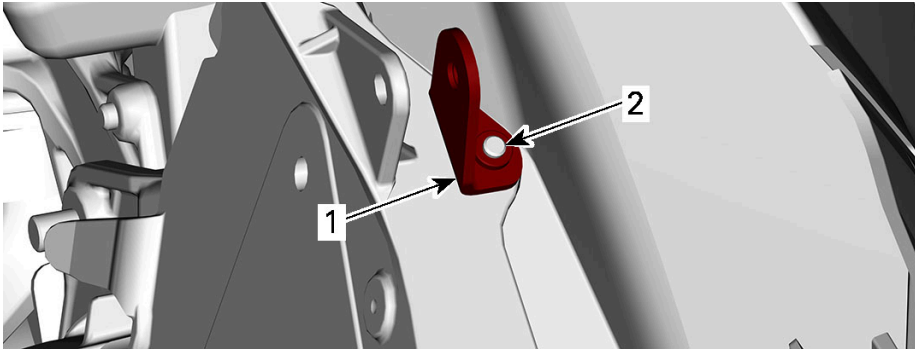
- 1. Wear plate [P2]
- 2. M10 Elastic hex. Flanged nut [P14]
- 3. M10 x 70 Hex. Screw [P15]

TIGHTENING TORQUE	
M10 x 70 Hex. Screw [P15]	48 ± 6 N•m (35.5 ± 4.5 lbf•ft)

2. Install pop rivet 3/16 [P16] as shown.

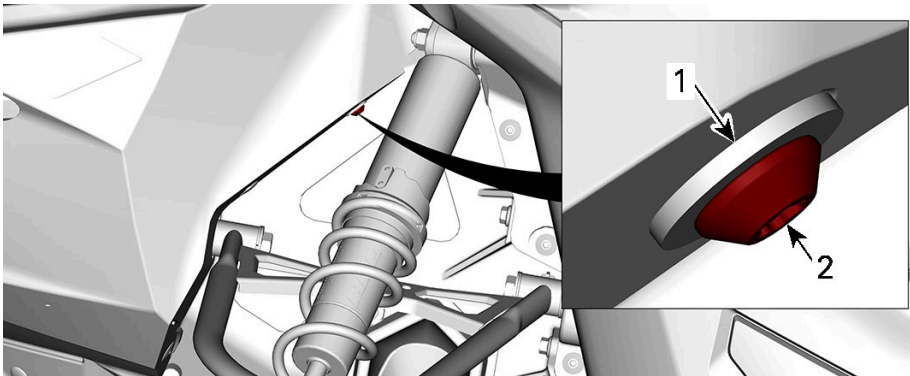


3. Install the LH Rear Bumper Reinforcement [P9] as shown using M5 x 14 Round head Torx screw [P20] and M5 Washer [P23]. Do not tighten yet. Repeat on the RH side with the RH Rear Bumper Reinforcement [P10].



INSIDE VIEW

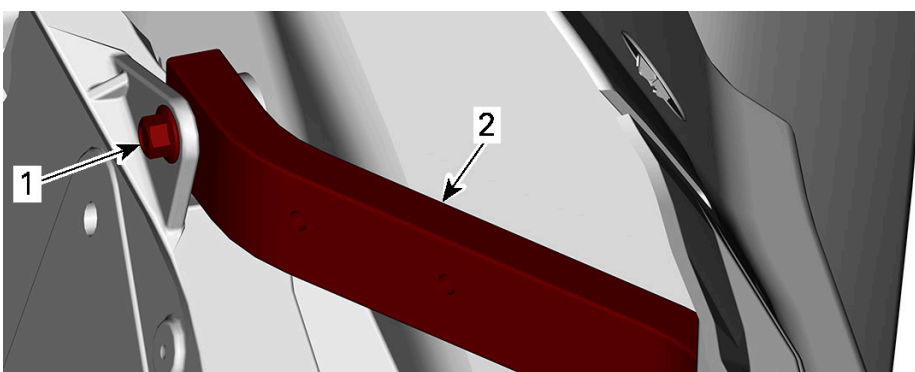
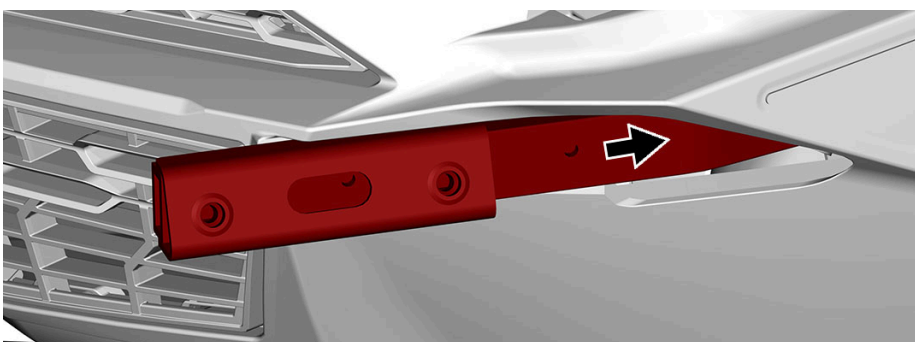
1. LH Rear Bumper Reinforcement [P9]
2. M5 x 14 Round head Torx screw [P20]



OUTSIDE VIEW

1. M5 Washer [P23]
2. M5 x 14 Round head Torx screw [P20]

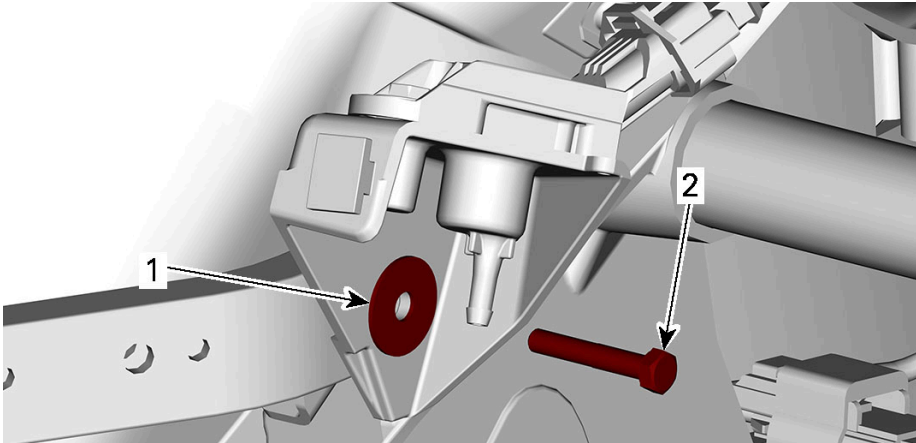
4. Install the LH Front Sectional Tube [P3] on the LH Rear Bumper Reinforcement as shown using M5 x 25 Hex. Flanged screw [P18].



1. M5 x 25 Hex. Flanged screw [P18]
2. LH Front Sectional Tube [P3]

5. Repeat previous step on RH side with RH Front Sectional Tube [P4].

For Summit 850 Turbo models, use M5 x 30 Hex. Screw [P19] and the washer previously removed to secure the connector support. Reconnect the connector.



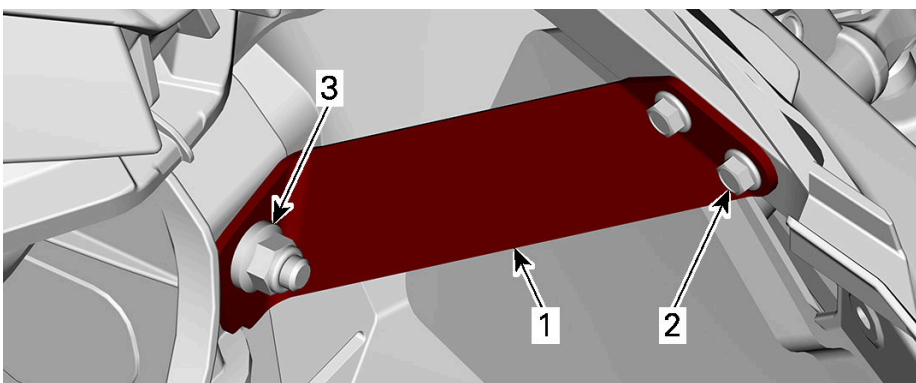
SUMMIT 850 TURBO SHOWN

1. Washer
2. M5 x 30 Hex. Screw [P19]

6. Tighten fasteners to specification.

TIGHTENING TORQUE	
M5 x 25 Hex. Flanged screw [P18] M5 x 30 Hex. Screw [P19] M5 x 14 Round head Torx screw [P20]	$5 \pm 0.5 \text{ N}\cdot\text{m}$ ($44.5 \pm 4.5 \text{ lbf}\cdot\text{in}$)

7. If the bumper reinforcements [P5] and [P6] are not already installed, install them using M10 Elastic hex. Flanged nut [P14] and M6 x 16 Hex. Flanged screw [P11] on both sides. Tighten to specification.

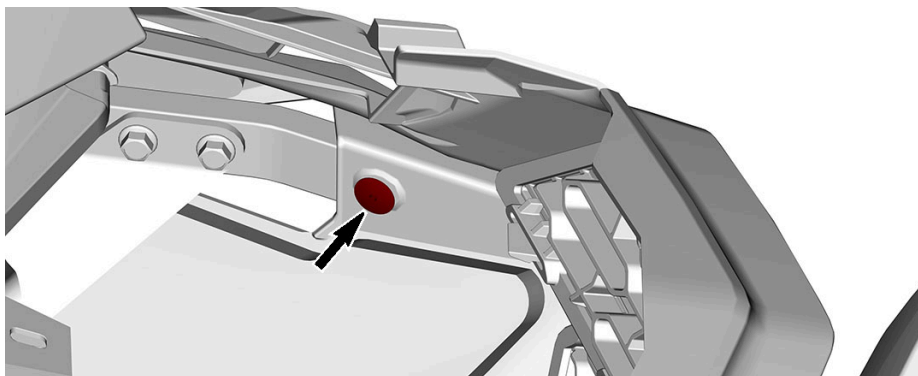


1. LH bumper reinforcements [P5]
2. M6 x 16 Hex. Flanged screw [P11]
3. M10 Elastic hex. Flanged nut [P14]

TIGHTENING TORQUE	
M6 x 16 Hex. Flanged screw [P11]	$10 \pm 2 \text{ N}\cdot\text{m}$ ($89 \pm 18 \text{ lbf}\cdot\text{in}$)
M10 Elastic hex. Flanged nut [P14]	$48 \pm 6 \text{ N}\cdot\text{m}$ ($35.5 \pm 4.5 \text{ lbf}\cdot\text{ft}$)

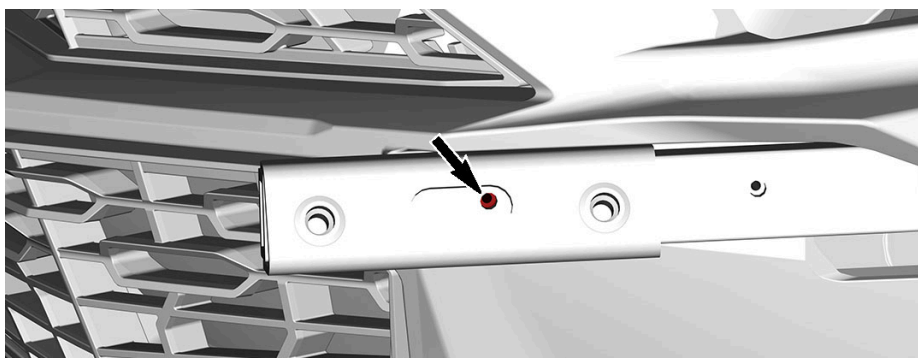
E-TEC Models

8. Install the first pop rivet 3/16 [P16] as shown.



INSIDE VIEW

9. Using the Front Sectional Tube as a template, drill with a drill bit 5 mm (3/16 in) [T2].

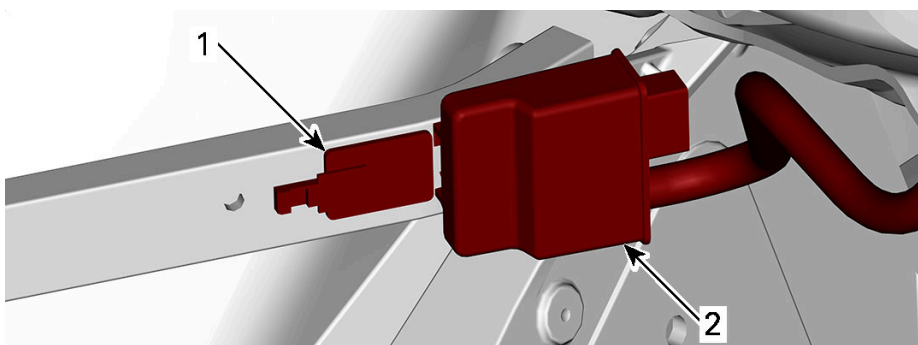


OUTSIDE VIEW

10. Install the second pop rivet 3/16 in the newly drilled hole from inside the vehicle.

11. Repeat on the other side.

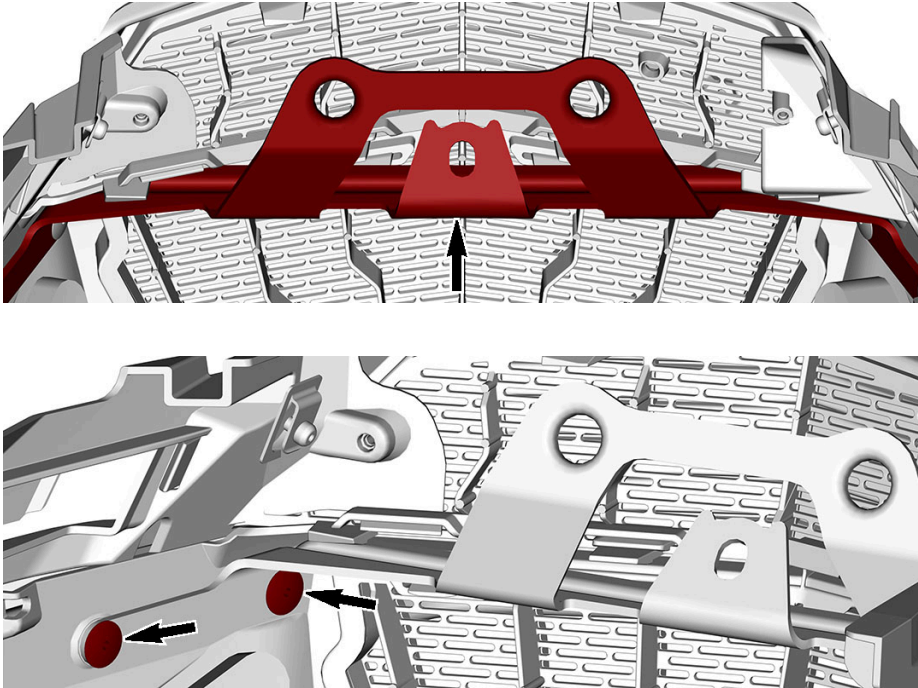
12. If the thermocouple module was previously removed, install the module support [P8] and reinstall the thermocouple module.



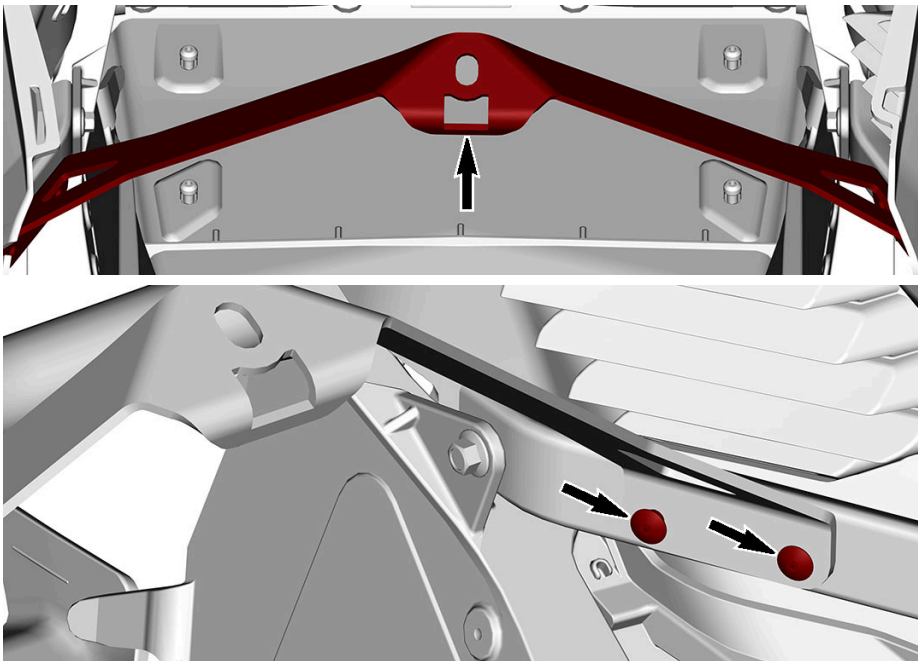
1. Module support [P8]
2. Thermocouple module

ACE Models

13. Install the radiator support and the pop rivet 3/16 [P16] as shown.



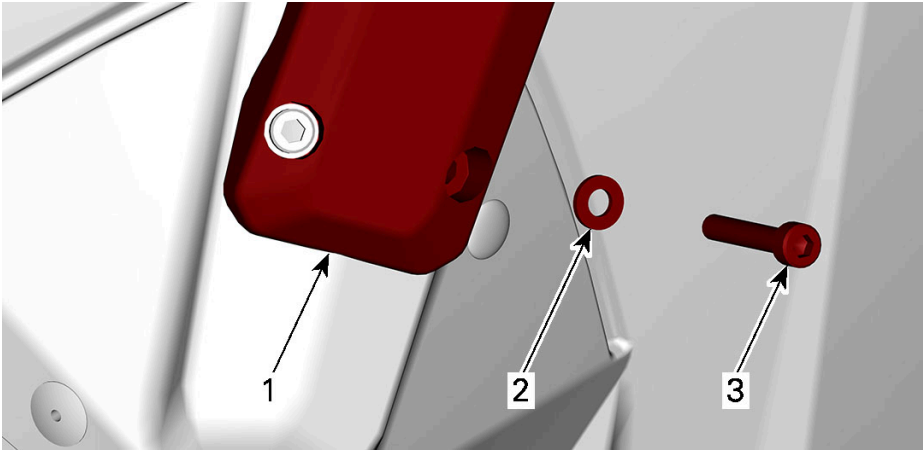
14. Install the intercooler support (ACE Turbo only) using Avex rivets 3/16 [P17].



For All Models

NOTE: If the Adventure Front Plate (P/N 860202328) is installed, refer to the instruction sheet P/N 487803784.

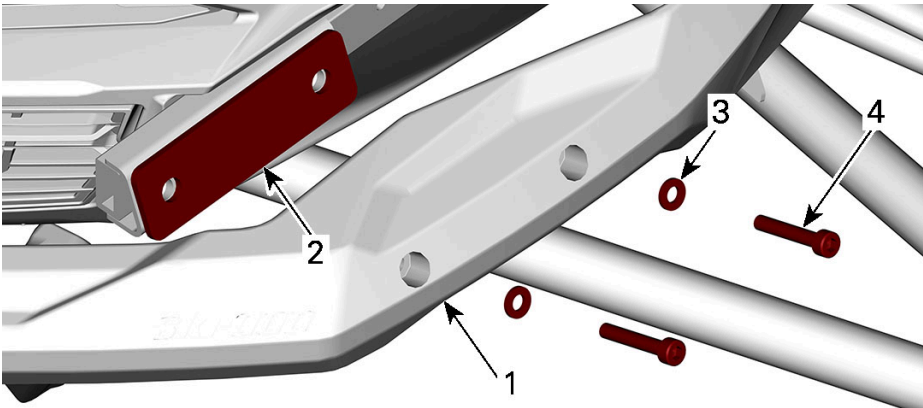
15. Install the front bumper [P1] using M6 x 35 socket head screw with Scotch Grip [P12] and M6 Flat Washer [P13]. Tighten to specification



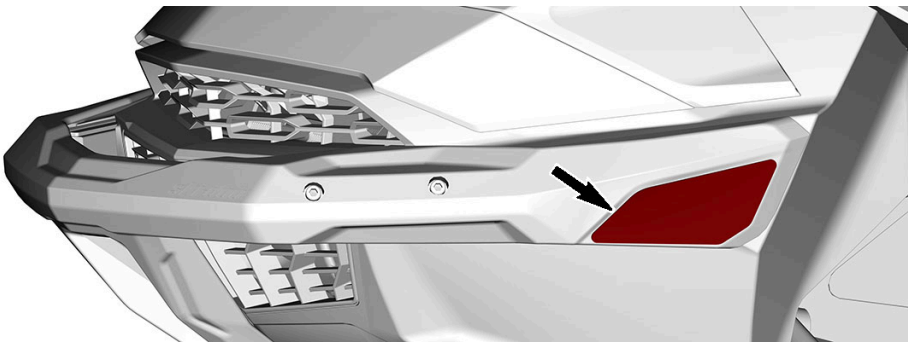
- 1. Front bumper [P1]
- 2. M6 Flat Washer [P13]
- 3. M6 x 35 socket head screw with Scotch Grip [P12]

TIGHTENING TORQUE	
M6 x 35 socket head screw with Scotch Grip [P12]	7 ± 1 N•m (62 ± 9 lbf•in)

NOTE: If only the front bumper [P1] is installed, install the spacer [P7].



16. Install the amber reflectors [P21] and [P22] on the front bumper.



17. Reinstall all previously removed parts. Refer to the appropriate *SERVICE MANUAL*.