

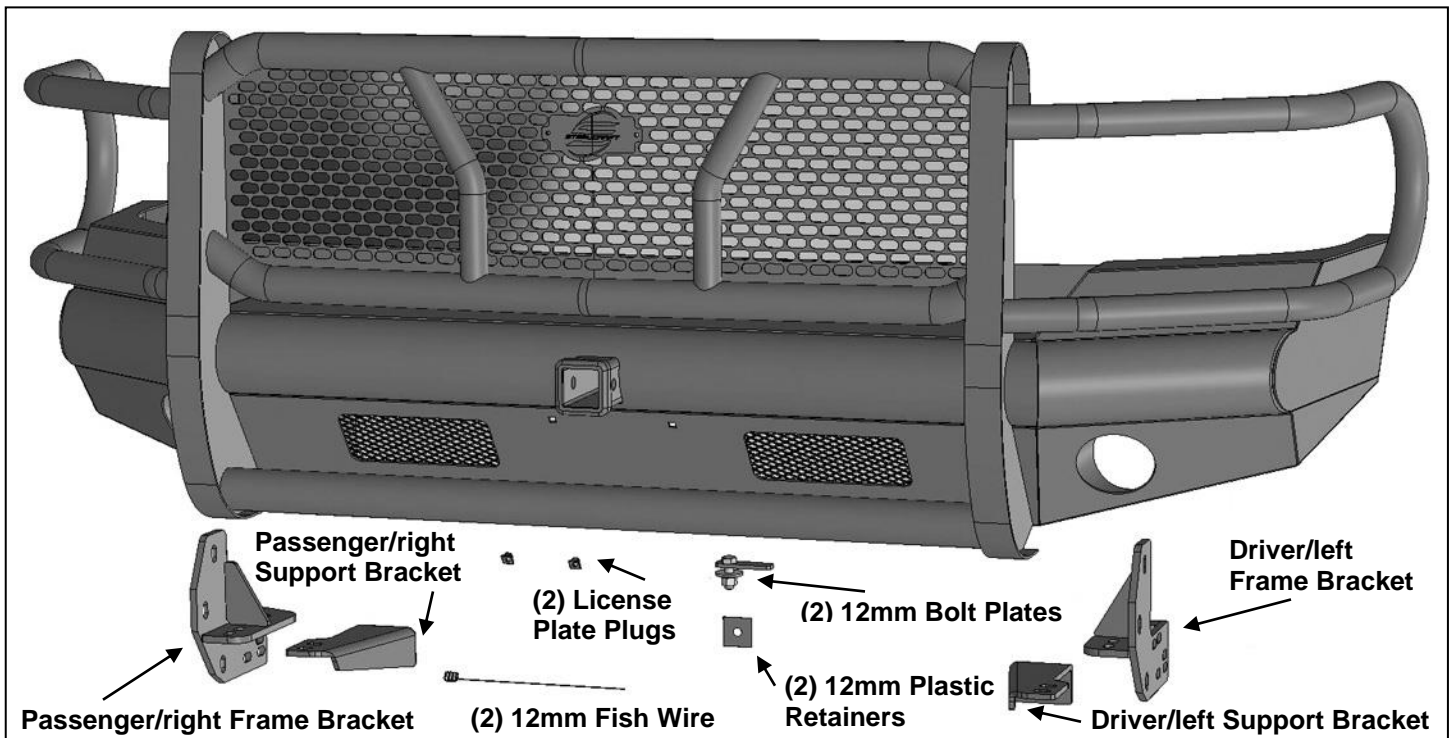
INSTALLATION INSTRUCTIONS

**HD REPLACEMENT FRONT BUMPER
1994-02 DODGE RAM 2500-3500**

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PARTS LIST:

1	HD Replacement Front Bumper Assembly	16	12-1.75mm x 45mm Hex Bolts
1	Driver/left Frame Mounting Bracket	14	12mm x 37mm x 3mm Large Flat Washers
1	Passenger/right Frame Mounting Bracket	20	12mm x 24mm x 3mm STD Flat Washers
1	Driver/left Support Bracket	18	12mm Lock Washers
1	Passenger/right Support Bracket	18	12mm Hex Nuts
2	License Plate Mounting Plugs	4	6mm x 20mm Hex Bolts
2	12mm Fish Wire	8	6mm Flat Washers
2	12mm Plastic Retainer	4	6mm Nylon Lock Nuts
2	12mm Bolt Plates		



PROCEDURE:

- REMOVE CONTENTS FROM BOX. VERIFY ALL PARTS ARE PRESENT. READ INSTRUCTIONS CAREFULLY BEFORE STARTING INSTALLATION. BUMPER IS HEAVY, ASSISTANCE IS HIGHLY RECOMMENDED **DRILLING MAY BE REQUIRED****
- Start installation from under the driver/left front of the vehicle. Remove the outer bumper brace from the outside of the frame to the end of the bumper. Repeat to remove the passenger/right bumper brace.
- Models with factory fog lights:** Unplug the wiring harness from the back of the bumper. Move the wiring harness out of the way.
- Support the bumper with stands or blocks. Locate the factory bumper bolts attaching the bumper brackets to the end of the frame. Remove hex bolts and with assistance, remove the bumper assembly, **(Figure 1)**.
- Select the driver/left Frame Mounting Bracket, **(Figure 2)**. Line up (3) of the slots in the Bracket with the corresponding mounting holes for the factory bumper bracket. **NOTE:** Frame Mounting Bracket is equipped with several slots to allow fitment on multiple model years. Attach the Mounting Bracket to the frame with (3) 12mm x 45mm Hex Bolts, (6) 12mm x 24mm STD Flat Washers, (3) 12mm Lock Washers and (3) 12mm Hex Nuts, **(Figure 2)**. Leave hardware loose at this time.

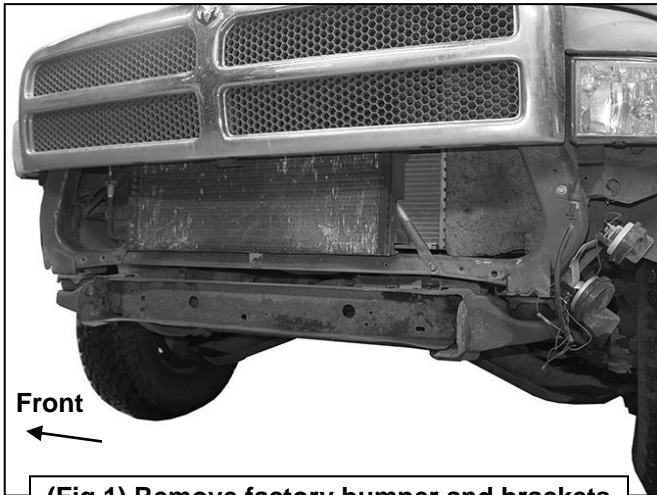
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6. Next, select the driver/left Support Bracket, **(Figure 3)**. Hold the Bracket up in position against the front of the cross member. Line up the mounting slot in the back of the Bracket with the correct hole in the cross member. Insert (1) 12mm Bolt Plate through the back of the cross member, **(Figure 3)**. Attach the Bracket to the Bolt Plate with (1) 12mm x 37mm Large Flat Washer, (1) 12mm Lock Washer and (1) 12mm Hex Nut. Leave loose at this time.
IMPORTANT: On some models or model years, the cross member is reinforced, and the Bolt Plate cannot be inserted through the back of the crossmember. On these models, select (1) 12mm Fish Wire, **(Figure 4)**. Insert the coiled end of the Fish Wire through the hole in the cross member for the Support Bracket. Feed the Fish Wire either down through the slot in the bottom or back out through the larger hole toward the center of the cross member if equipped. Thread the Bolt Plate into the coiled end. Pull the straight end of the Fish Wire back through the cross member until the threaded end of the Bolt Plate extends out of the smaller hole in the cross member. Hold the Bolt Plate and remove the Fish Wire. Thread (1) 12mm Plastic Retainer onto the Bolt Plate to help hold it in place, **(Figure 4)**. Repeat the previous Step to attach the Support Bracket to the Bolt Plate.
7. Line up the top of the Support Bracket with the mounting flange on the Frame Mounting Bracket. Attach the Support Bracket to the Frame Bracket with (2) 12mm x 45mm Hex Bolts, (4) 12mm x 24mm STD Flat Washers, (2) 12mm Lock Washers and (2) 12mm Hex Nuts, **(Figure 5)**. Tighten the (2) Hex Bolts attaching the Support Bracket to the Frame Bracket, then only snug tighten the Bolt Plate and the Frame Bracket hardware.
8. Repeat **Steps 5—7** to install the passenger/right Frame Mounting Bracket and Support Bracket.
9. **Models with factory fog lights:**
 - a. Carefully remove the driver/left light assembly from the bracket on the back of the bumper.
 - b. Attach the light assembly to the mounting tab on the back of the HD Bumper with the included (2) 6mm x 20mm Hex Bolts, (4) 6mm Flat Washers and (2) 6mm Nylon Lock Nuts, **(Figure 6)**. Do not overtighten 6mm hardware or damage to the light assembly may result.
 - c. Repeat to install the passenger/right fog light assembly.
 - d. Remove wiring harness from factory bumper. Attach the wiring harness to the back of the HD Bumper and fog lights.
10. With assistance, carefully position the Bumper Assembly up to the Brackets, **(Figure 7)**. Temporarily support the weight of the Bumper. **WARNING:** To avoid possible injury or damage to the vehicle, do not proceed until the bumper is fully and safely supported.
11. Line up the (3) holes in the driver/left side of the Bumper with the (3) holes in the Frame Bracket. Attach the Bumper to the Bracket with the included (3) 12mm x 45mm Hex Bolts, (6) 12mm x 37mm Large Flat Washers, (3) 12mm Lock Washers and (3) 12mm Hex Nuts, **(Figure 7)**. Do not fully tighten hardware at this time. Repeat to attach the passenger/right side of the Bumper to the Bracket.
12. Level and adjust the bumper to the vehicle and fully tighten all 12mm hardware to 65-70ft-lbs.
13. Use the included (2) push-in Plastic Nuts to attach the front license plate, (if required), to the (2) holes in the front bumper, **(Figure 8)**.
14. Reattach the wiring harness for the fog lights if equipped.
15. Do periodic inspections to the installation to make sure that all hardware is secure and tight.

To protect your investment, wax this product after installing. Regular waxing is recommended to add a protective layer over the finish. Do not use any type of polish or wax that may contain abrasives that could damage the finish. Mild soap may be used to clean the Bumper Assembly.

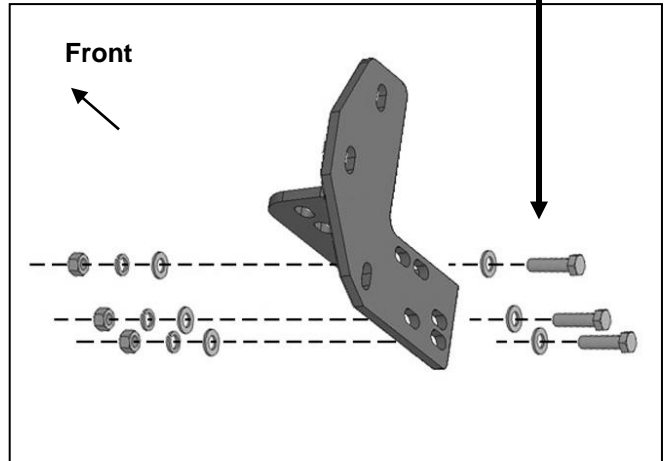
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Driver Side Installation Pictured



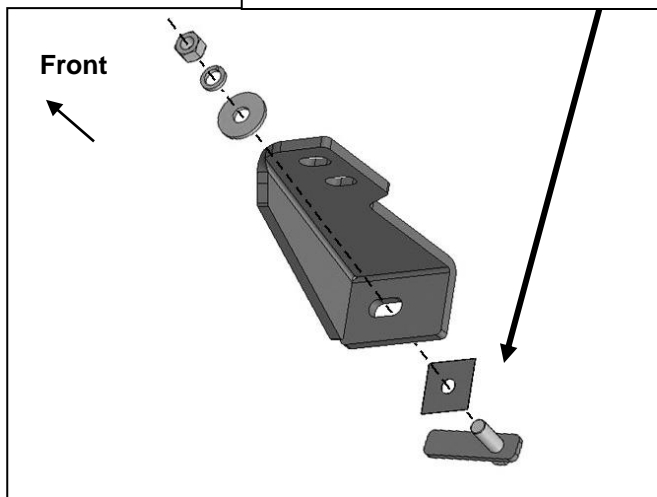
(Fig 1) Remove factory bumper and brackets

- (3) 12mm x 45mm Hex Bolts
- (6) 12mm STD Flat Washers
- (3) 12mm Lock Washers
- (3) 12mm Hex Nuts

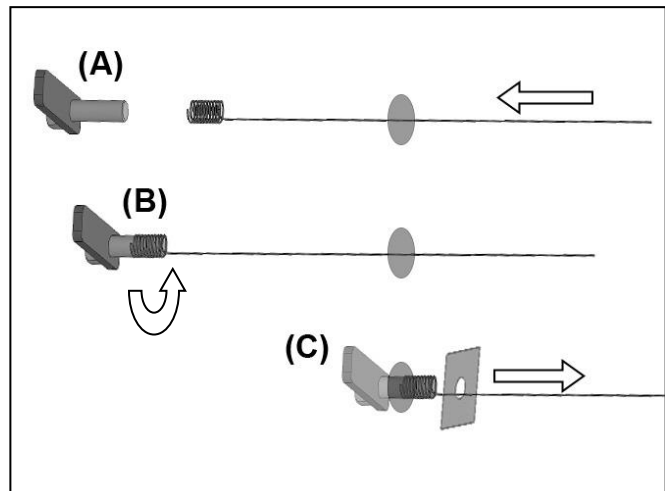


(Fig 2) Attach driver/left Frame Bracket to inside of end of frame. Line up correct slots in Bracket with mounting holes for factory bumper bracket

- 12mm Bolt Plate
- 12mm Plastic Retainer
- 12mm x 37mm Large Flat Washer
- 12mm Lock Washer
- 12mm Hex Nut



(Fig 3) Insert 12mm Bolt Plate through hole in cross member if accessible. Attach driver/left Support Bracket to Bolt Plate



(Fig 4) On models with reinforced cross member, insert coiled end of Fish Wire through hole in front of cross member (A). Feed the Fish Wire either down through slot in bottom of cross member or to large round hole toward center of cross member (if equipped). Thread Bolt Plate into coiled end of Fish Wire (B). Pull Bolt Plate back through cross member and out hole (C). Remove Fish Wire and thread 12mm Plastic Retainer onto Bolt Plate to help hold in place (C)

