



## Installation Instructions

Dodge Ram HD

Product Number: T1650  
'94-02 Dodge Ram HD Trucks

# SAFETY

### Your safety and the safety of others is very important.

- In order to help you make informed decisions about safety, we have provided installation instructions and other information.
- These instructions alert you to potential hazards that could hurt you or others.
- Please do a job safety analysis (JSA) before each task to identify potential hazards for your situation and remove/protect against them.
- You must use your own good judgment, and take your time.

**Read and understand all safety precautions and instructions before installing this product.**

THIS PRODUCT IS FOR OFFROAD USE ONLY. ALL LIABILITY FOR INSTALLATION AND USE RESTS WITH THE OWNER.

**CARELESS INSTALLATION AND OPERATION CAN RESULT IN SERIOUS INJURY OR EQUIPMENT DAMAGE.**

## Injury hazard

### Failure to observe these instructions could lead to severe injury or death.

- Always** remove jewelry and wear eye protection.
- Always** use extreme caution when jacking up a vehicle for work. Set emergency brake and use tire blocks. Locate and use the vehicle manufacturers designated lifting points. Use jack stands.
- Always** use appropriate and adequate care in lifting components into place.
- Always** insure components will remain secure during installation and operation.
- Always** wear safety glasses when installing this kit. A drilling operation will cause flying metal chips. Flying chips can cause serious eye injury.
- Always** use extreme caution when drilling on a vehicle. Thoroughly inspect the area to be drilled (on both sides of material) prior to drilling, and relocate any objects that may be damaged.
- Always** use extreme caution when cutting and trimming during fitting.
- Always** tighten all nuts and bolts securely per installation instructions.
- Always** route electrical cables carefully. Avoid moving parts, components that become hot and rough or sharp edges.
- Always** insulate and protect all exposed wiring and electrical terminals.
- Always** perform regular inspections and maintenance on mounts and related hardware.





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### I. Parts List

- T1650 rear replacement bumper
- Tag Light
- 2 License plate mounting inserts
- 2 Reverse lights, mounting grommets, and wire pigtails
- 4 Backup sensor grommets and plugs
- Instruction Manual

### II. Tools Required

- Socket Wrench with Extension
- 18mm Socket
- 18mm Box End Wrench
- T20 Torx Driver
- Phillips & Flat Head Screwdriver

### III. Vehicle Preparation

1. Using an 18mm socket, loosen the three nuts per side holding the factory bumper brackets to the frame. Do Not Fully Remove bumper until it is supported.
2. With Bumper supported by others remove the fasteners completely and remove bumper by lowering and pulling out towards the back of the truck.
3. Using A #T20 Torx driver, remove the screws holding the license plate lights to the plastic license plate support. Disconnect the wiring for the lights from the factory harness.
4. Remove the license plate.
5. Using a Phillips Head screw driver remove the 3 sheet metal screws holding the plastic license plate support from the truck.





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### I. Installation

1. Replace OEM bumper with the Black Steel rear bumper assembly. Reuse the OEM fasteners. Do not fully tighten
2. Level and align the bumper in relation to the truck bed. Fully tighten all fasteners.
3. Slowly lower the tailgate to ensure there will be no interference. If required, loosen the frame bolts / hitch bolts and adjust alignment of the bumper.
4. Install tag light into the 1 ¼" hole provided in the center section. The powder coating may need to be removed from the hole for proper grounding. Connect wire into the hot wire of OEM tag light circuit. Verify operation.
5. Reinstall license plate with provided plastic inserts
6. Install grommets into sensor holes. If equipped, insert sensors from the back side. If not equipped, install provided plugs into the grommets.
7. Insert light grommets into oval cut-outs and press lights in from the front. Wire as desired.
8. Secure all loose wiring and harnesses to the frame or bumper with zip ties.





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### II. Maintenance/Care

- Periodically check and tighten all fasteners.
- Stripped, fractured, or bent bolts or nuts need to be replaced.



More than expected... Better than expected

