

IRON CROSS AUTOMOTIVE INC.

INSTALLATION INSTRUCTIONS FRONT WINCH BUMPER

20/22/24- 615 - 97

97-02 DODGE RAM 2500

PARTS LIST

12	1/2" FLAT WASHERS
6	1/2" LOCK WASHERS
6	1/2" HEX BOLTS
6	1/2" HEX NUTS
1	BUMPER

BUMPER REMOVAL

A. Disconnect the factory fog light harness and tie up out of harm's way.

B. If you factory bumper has the horn or other items fastened to the Factory Bumper Corner Stiffeners, please remove these and relocate them to the frame.

C. Loosen the fastener on the bumper side of the corner supports and fully remove the fastener on the frame side of the corner support allowing it to rotate down and out of the way.

D. Loosen the 3 bolts (Per side) holding the bumper bracket to the frame rail, using an 18mm socket. See Image Below. Do Not Fully Remove Until Bumper is Supported!

E. With Bumper Supported remove the fasteners and remove by pulling down and out away from the truck.



BUMPER INSTALL

A. CAREFULLY ALIGN BUMPER MOUNT TOWERS WITH FRAME MOUNTS AND SLIDE BUMPER INTO PLACE. INSTALL THE SUPPLIED 1/2" MOUNTING BOLTS BUT DO NOT TIGHTEN FULLY. IT MAY BE HELPFUL TO SUPPORT BUMPER WITH A FLOOR JACKS DURING INSTALL. REPEAT FOR OTHER SIDE. THIS WILL AT MINIMUM REQUIRE TWO PEOPLE TO HOLD THE BUMPER AND A THIRD PERSON TO INSTALL THE SUPPLIED HARDWARE.

B. ADJUST THE BUMPER TO ACHIEVE GOOD VISUAL ALIGNMENT AS FOLLOWS:

1. ADJUST "CASTOR" WITH MOUNTING BRACKET BOLTS.
2. ADJUST IN/OUT, UP/DOWN, AND LEFT/RIGHT WITH THE INTERMEDIATE MOUNT BOLTS. ALLOW 0.5" GAP FROM ALL PAINTED SURFACES FOR FRAME FLEX.

C. TIGHTEN ALL FASTENERS.

PASSENGER SIDE



1/2" hex bolt
1/2" flat washers (x2)
1/2" lock washers
1/2" hex nut

