

# IRON CROSS AUTOMOTIVE INC.

INSTALLATION INSTRUCTIONS REAR BUMPER  
**07-10 CHEVROLET HD 2500/3500**

**PART # 21-525-07 / 21-515-07**

**PART # 21-325-07 / 21-315-07**



## PARTS LIST

| QTY | HARDWARE          |
|-----|-------------------|
| 12  | 1/2" flat washers |
| 6   | 1/2" lock washers |
| 6   | 1/2" hex nuts     |
| 6   | 1/2" hex bolts    |
| 2   | Tag lights        |

## OEM BUMPER REMOVAL

A. Remove license plate and OEM license plate lights. If so equipped, unplug back-up sensors and seal OEM connector with tape; affix to frame..



B. Remove bottom bolt from hitch frame mount.



C. Remove bottom bolts from hitch frame mount from bumper. One on each side.



D. Remove OEM bumper fasteners and OEM bumper. This requires removing the following from each side. Save fasteners.

1. One 22mm bolt from the bottom of the frame
2. Two 18mm bolts from the side of the frame
3. One 15mm bolt from the side.

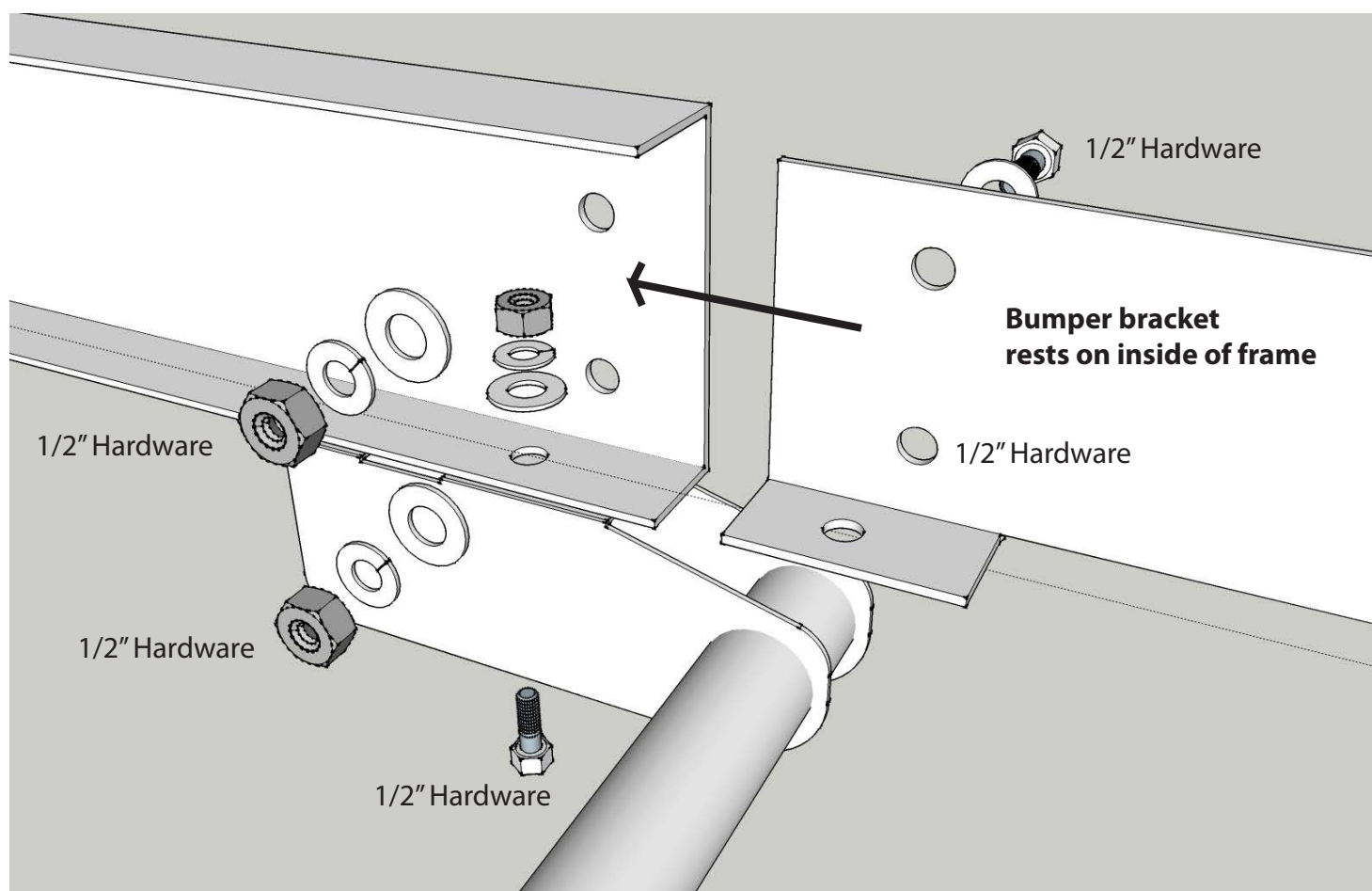


## REAR BUMPER INSTALLATION

- A. Remove the Rear Bumper from the shipping carton. Lay all items out on a blanket to prevent damage to the powder coating.
- B. Install license plate inserts in provided locations.
- C. Install the Factory Trailer Plug into the cutout in provided location.



- F. Bolt bumper to frame using supplied hardware: bolts, washers, and nuts. Use the 1/2" Hardware in the 3 larger holes per side. Repeat for other side. Verify that Bumper Mount rests on INSIDE of frame rail as shown. Align Spare Tire Access Cover with guide tube. See Image Below.

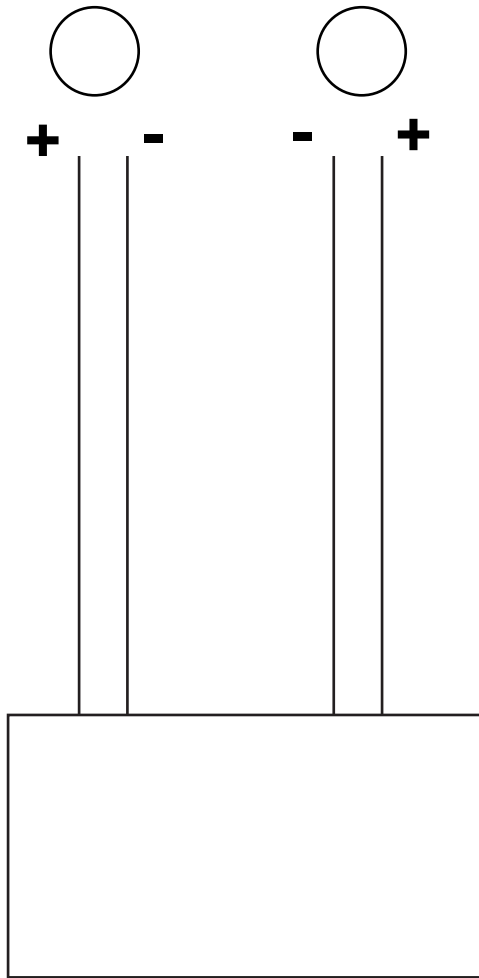


- G. Align bumper front to back and snug tighten frame mount fasteners.
- H. Align bumper height side-to-side, verify tailgate clears while lowered, and tighten bumper mounting fasteners using 3/4" socket and wrench.
- I. Plug in license plate light harness and trailer harness, secure to frame rails Remove the Rock Slider from the vehicle.
- J. Re-install License Plate.

# TAG LIGHT WIRING

FACTORY TAG LIGHTS MUST BE CUT AND REPLACED WITH REPLACEMENT TAG LIGHTS

FACTORY TAG LIGHTS



REPLACEMENT TAG LIGHTS

