

IRON CROSS AUTOMOTIVE INC.

INSTALLATION INSTRUCTIONS REAR BUMPER 94-02 DODGE RAM 1500/2500/3500 PART # 21-615-94



PARTS LIST

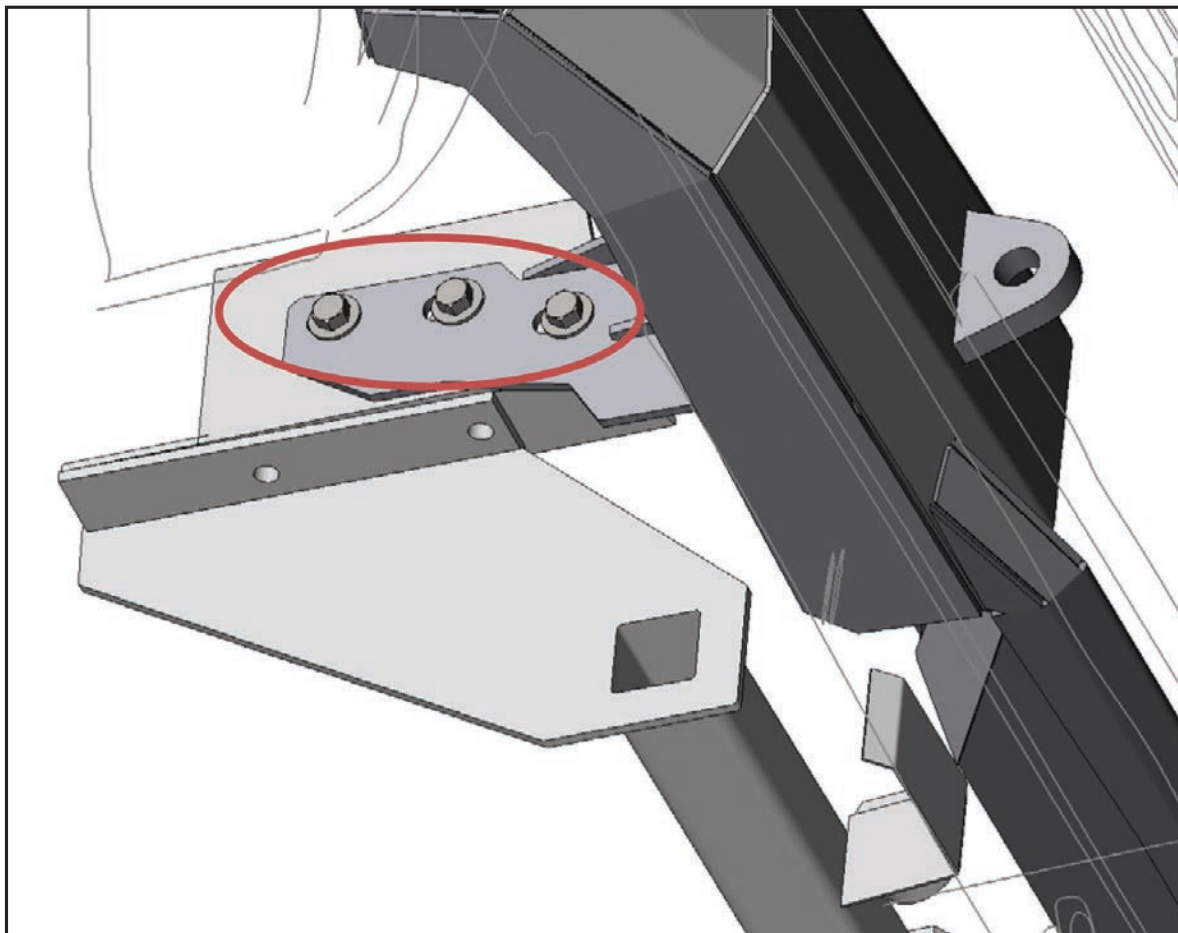
QTY	HARDWARE
12	1/2" flat washers
6	1/2" lock washers
6	1/2" hex nuts
6	1/2" hex bolts
2	Tag lights

Removal of Stock Bumper

- A. Using a 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.
- B. With Bumper supported by others, remove the fasteners completely and remove bumper by lowering and pulling out toward the back of the truck.
- C. Using A #T20 Torx bit, remove the screws holding the license plate lights to the plastic license plate support. Disconnect the wiring for the lights from the factory harness.
- D. Remove the license plate.
- E. Using a Phillips Head screw driver, remove the 3 sheet metal screws holding the plastic license plate support from the truck.
- F. Your Truck is Now Ready for Installation of new bumper.

Bumper Install.

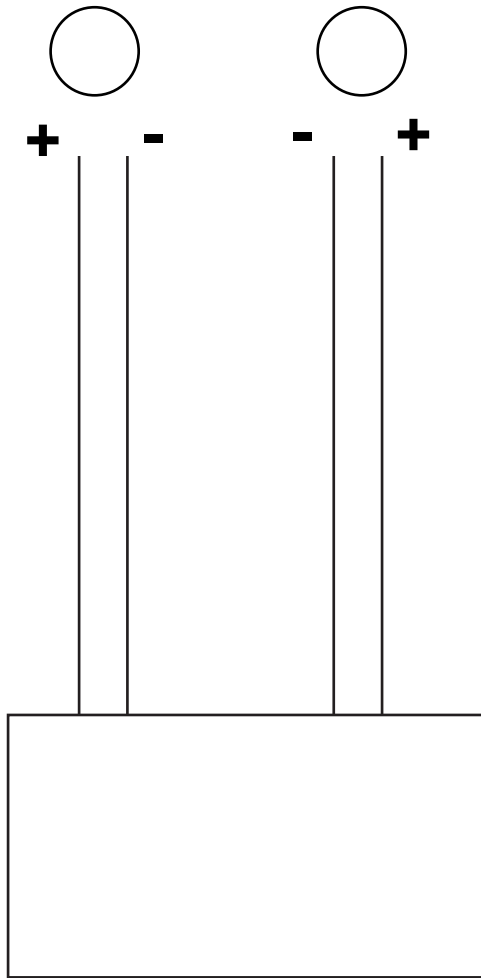
- A. Using the supplied $\frac{1}{2}$ " Hardware, install the Bumper tower brackets to the frame as shown in the picture below, using flat washers on the bolt and nut side in addition to the lock washer on the nut side. Do Not Fully Tighten!
- B. With the help of a couple friends and/or a floor jack raise the Rear Bumper up into place against the mounts.
- C. With the bumper held into place insert the supplied $\frac{1}{2}$ " fasteners through the bumper and into the front side of the frame mount. Do Not Fully Tighten. See Image Below.
- D. Align the bumper side to side and top to bottom to ensure a perfect fit to the truck. Allow for a 0.5" clearance to all painted surfaces if possible to allow for frame flex.
- E. Check that the tailgate does not interfere with the bumper by opening it very carefully and lowering it into place. If tailgate is too close to the bumper, adjust bumper lower.
- F. Fully tighten all fasteners between bumper and brackets and brackets and frame.
- G. Install OEM license plate lights using supplied black machine screws and install light and plug back into the factory harness.



TAG LIGHT WIRING

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

FACTORY TAG LIGHTS



REPLACEMENT TAG LIGHTS

