

# **INSTALLATION INSTRUCTIONS**

**HEAVY DUTY REAR BUMPER**

**2010-15 RAM 25-3500**

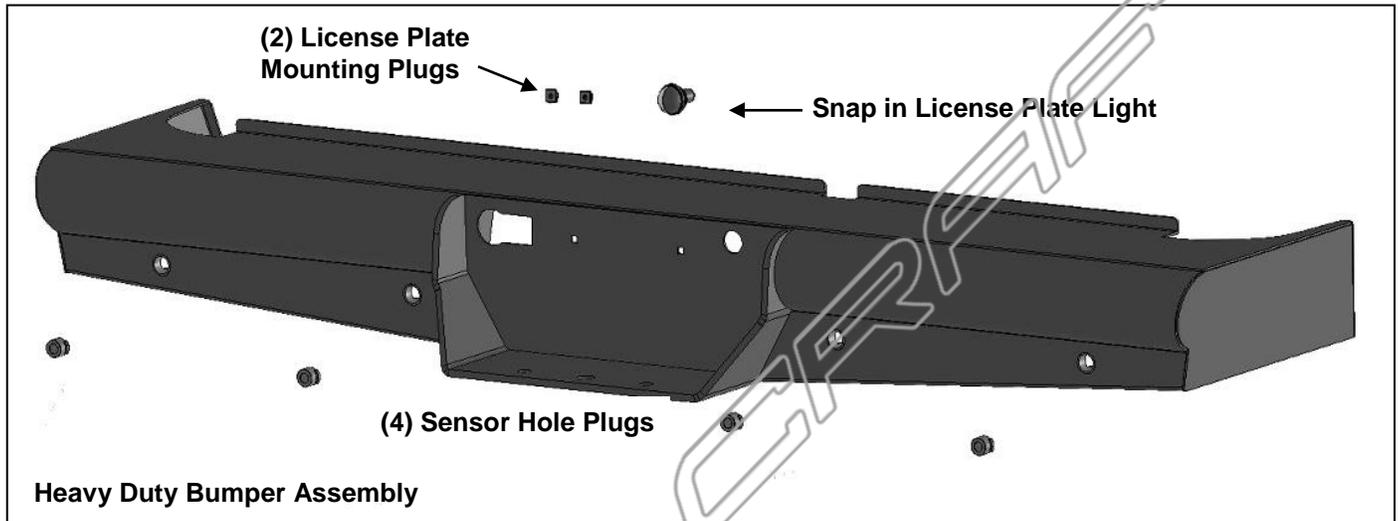
**#PW015856**

STEELCRAFT

**HEAVY DUTY REAR BUMPER  
2010-15 RAM 25-3500**

**PARTS LIST:**

1	Heavy Duty Rear Bumper Assembly	4	8mm x 40mm Hex Bolts
1	Universal License Plate Light	4	8mm x 28mm x 3mm Flat Washers
10	12-1.75mm x 50mm Hex Bolts	4	8mm Lock Washers
20	12mm x 37mm x 3mm Flat Washers	4	Sensor Hole Plugs
10	12mm Nylon Lock Nuts	8	4mm x 10mm Button Head Screws
2	License Plate Mounting Plugs	1	Allen Wrench



**PROCEDURE:**

**REMOVE CONTENTS FROM BOX. VERIFY ALL PARTS ARE PRESENT. READ INSTRUCTIONS CAREFULLY BEFORE STARTING INSTALLATION. BUMPER IS HEAVY, ASSISTANCE IS HIGHLY RECOMMENDED TO AVOID POSSIBLE INJURY OR DAMAGE TO THE VEHICLE.**

1. Remove the license plate. On models with back up sensors, unplug the sensors and move the wiring harness away from the bumper, **(Figure 1)**. Next, remove the sensors from the plastic sleeves and remove the sleeves from the bumper, **(Figure 2)**.
2. Unplug the factory license plate lights. Next, unplug the wiring harness from the back of the trailer plug and remove the plug from the bumper, **(Figure 3)**. Move all wiring harnesses away from the bumper.
3. Place blocks or jack stands under the bumper to support it during bumper bolt removal. Once the bumper has been safely supported, remove the factory bumper bolts and slide the rear bumper off of the end of the frame, **(Figures 4—6)**. **WARNING!** Assistance is required to hold the bumper in place during hardware removal to prevent the bumper from falling.
4. With assistance, position the HD Bumper Assembly up and over the bumper brackets on the ends of the frame and factory tow hitch, **(Figures 6 & 7)**. Temporarily support the weight of the Bumper Assembly. **WARNING:** To avoid possible injury or damage to the vehicle, do not proceed until the Bumper is fully and safely supported.
5. Line up the (2) outer holes in the passenger side frame mounting bracket with the (2) holes in the HD Bumper Mounting Plate. Attach the HD Bumper to the frame bracket with (2) 12mm Hex Bolts, (4) 12mm Flat Washers and (2) 12mm Nylon Lock Nuts, **(Figure 7)**. Leave hardware loose at this time. Repeat to attach the driver side of the Bumper to the bracket.
6. Next, line up the (2) inner holes on the passenger side frame bracket to the mounting plate on the HD Bumper. Select the correct installation.

**Models with 8mm hex nuts welded onto the back of the frame bracket:**

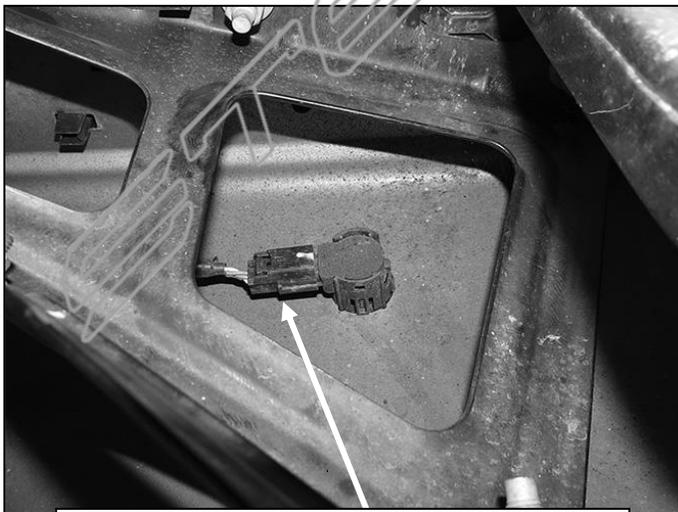
- a. Use (2) 8mm Hex Bolts, (2) 8mm Lock Washers and (2) 8mm Flat Washers to attach the passenger side of the HD Bumper to the frame bracket, **(Figures 4 & 7)**. Repeat

this Step to attach the driver side of the HD bumper to the frame bracket. Do not fully tighten hardware at this time.

**Models without 8mm welded hex nuts (open holes):**

- b.** Use (2) 12mm Hex Bolts, (4) 12mm Flat Washers and (2) 12mm Nylon Lock Nuts to attach the passenger side of the HD Bumper to the frame bracket. Repeat this Step to attach the driver side of the HD Bumper to the frame bracket. Leave hardware loose at this time.
- c. NOTE:** On some models/years, the frame bracket may only be equipped with outer mounting holes. Adjust installation accordingly, **(Figure 5)**.
- 7.** Line up the (2) holes in the center mounting plate with the (2) holes in the top of the tow hitch. Attach the HD Bumper to the tow hitch with (2) 12mm Hex Bolts, (4) 12mm Flat Washers and (2) 12mm Nylon Lock Nuts, **(Figure 8)**. Leave hardware loose at this time.
- 8.** Level and adjust the HD Bumper. Fully tighten all 12mm hardware to 65-70ft-lbs and 8mm hardware to 20-22ft-lbs.
- 9.** Snap the plug for the trailer harness into the opening in the HD Bumper. Plug the wiring harness into the back of the plug.
- 10.** On models with bumper mounted sensors, remove the rubber plugs from the sockets in the bumper assembly. Push the sensor in from the back of the bumper. Secure each sensor to the socket with (2) 4mm x 10mm Button Head Screws. **IMPORTANT:** Sensors fit snug in sockets. The 4mm Screws are used to apply slight pressure to lock the sensors in place. Tighten both screws evenly until they touch the sensor body only. Do not overtighten screws or damage to sensors will result. Reattach the factory wiring harness to sensors.
- 11.** Select the included snap in Universal License Plate Light. Insert the Light into the mounting hole in the bumper. Connect the wire harness to the License Plate Light. Tie down all wiring harnesses and seal off any open wiring connection.
- 12.** 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 Heavy Duty Bumper assembly.

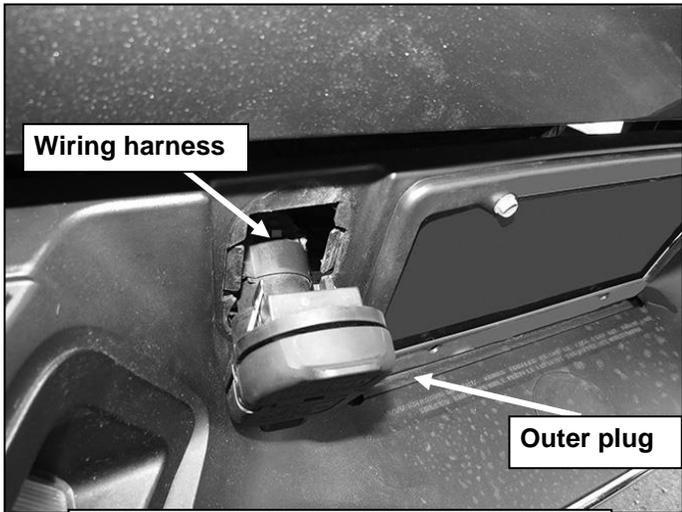


**(Fig 1) Unplug the sensor first then remove the sensor from the mounting sleeve**



**(Fig 2) Remove the mounting sleeve (right) from each sensor location in bumper**

Passenger side installation pictured

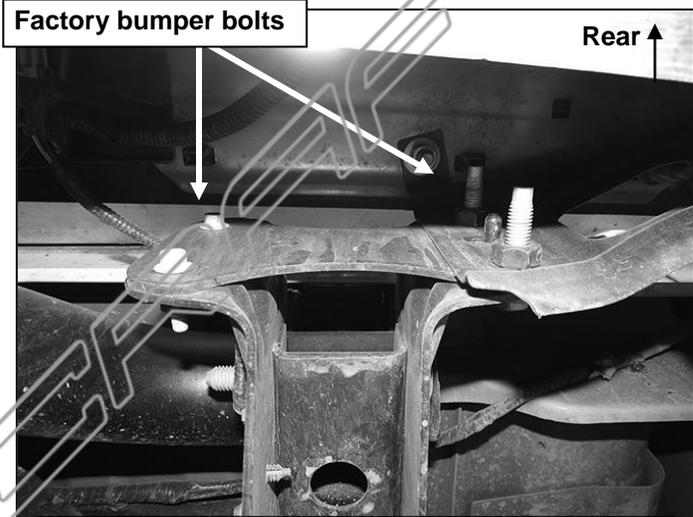


Wiring harness

Outer plug

(Fig 3) Unplug harness from back of trailer connector then remove outer plug

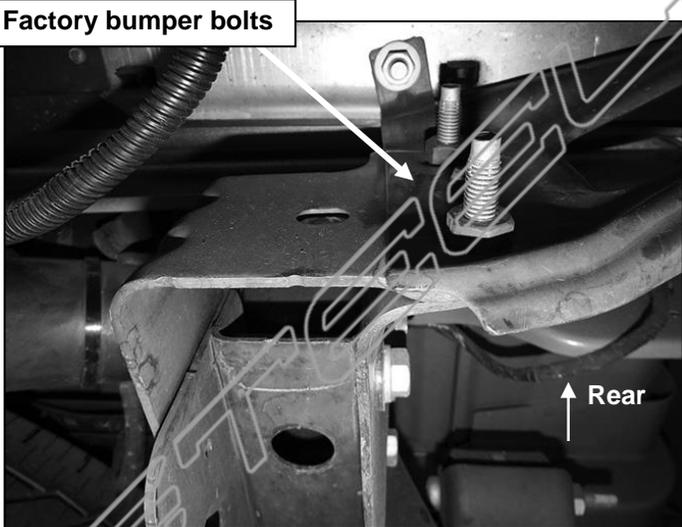
**WARNING!** Do not remove bumper bolts unless the bumper is properly supported on blocks or stands or the bumper may fall.



Factory bumper bolts

Rear ↑

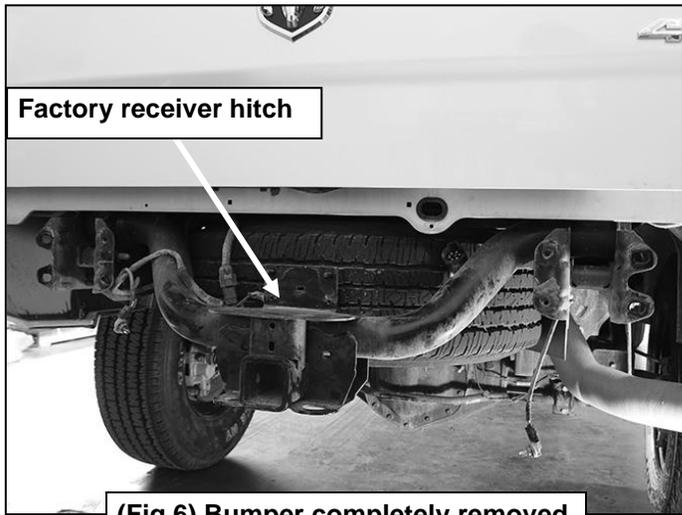
(Fig 4) Example of factory bumper bracket with 8mm hex nuts (left) welded onto back of bracket



Factory bumper bolts

Rear ↑

(Fig 5) Example of factory bumper bracket with (2) hex bolts only (right) pictured from below bumper



Factory receiver hitch

(Fig 6) Bumper completely removed

**WARNING!** Do not crawl under bumper unless the bumper is properly supported on blocks or stands or the bumper may fall.

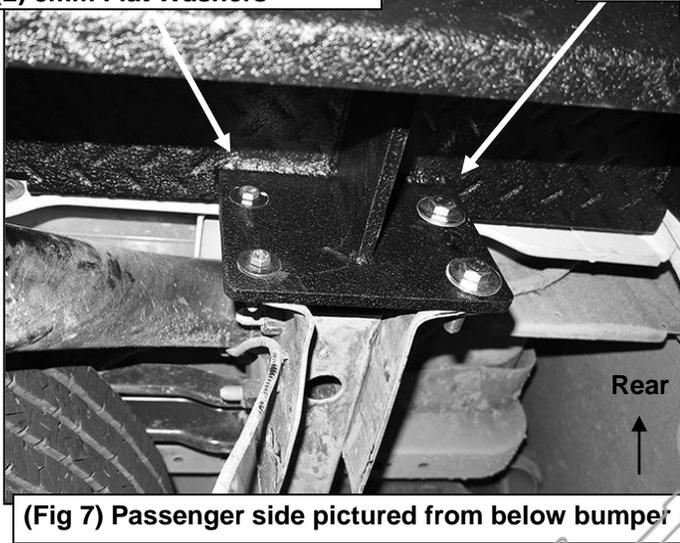
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**Passenger side installation pictured**

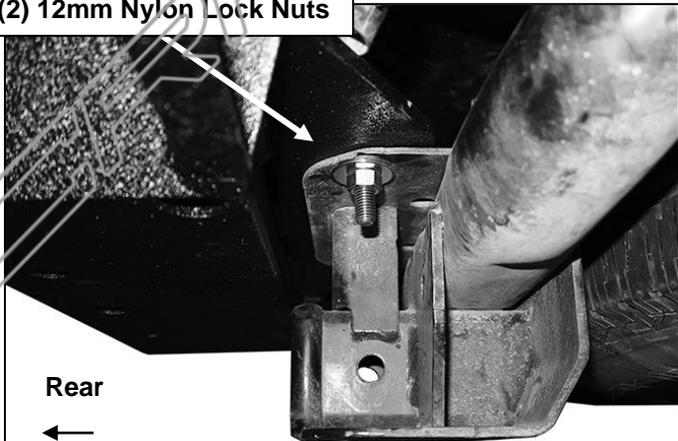
On inner side of bracket, use:  
(2) 12mm Hex Bolts  
(4) 12mm Flat Washers  
(2) 12mm Nylon Lock Nuts  
or  
(2) 8mm Hex Bolts  
(2) 8mm Lock Washers  
(2) 8mm Flat Washers

**WARNING!** Do not crawl under bumper unless the bumper is properly supported on blocks or stands or the bumper may fall.

(2) 12mm Hex Bolts  
(4) 12mm Flat Washers  
(2) 12mm Nylon Lock Nuts



(2) 12mm Hex Bolts  
(4) 12mm Flat Washers  
(2) 12mm Nylon Lock Nuts



(2) 4mm Socket Head Screws

