



A SPARTAN MOTORS COMPANY



Shock-Absorbing Bumper

Kits 01905433SK and 01905421SK

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NOTE: The information in this document is generic. Images and procedures may differ from those for vehicles you are servicing. Because Utilimaster manufactures customized vehicle solutions, this document cannot list and illustrate every possible option for every vehicle. The most common body options are described here. Use this information as a guideline.

Document Part Number: 03104592-N015EN

– Revision C –

Introduction

This document provides instructions for the installation of a rear shock-absorbing bumper onto the RAM ProMaster™ cargo van.

This manual contains drawings and photos to aid in servicing the vehicle. It may include maintenance information on some items installed but not manufactured by Utilimaster Corporation. Items such as drivetrain components and certain interior furnishings may be covered by separate manufacturer-supplied information. Information provided here is intended to assist Utilimaster customers and is in no way meant to replace or supersede instructions provided by other suppliers for their products.



*Rear step bumper
(White shown, reflective tape not included)*

Notes, Cautions, and Warnings

Reading through the procedures, you will see NOTES, CAUTIONS, and WARNINGS. Each is there for a specific purpose.

NOTES give additional information that will help you complete the procedure.

CAUTIONS warn against making an error that could damage the vehicle.

WARNINGS remind you to be careful when there is risk of personal injury.



When you see this symbol, read this statement first! This alert highlights information that may reduce the risk of personal injury or vehicle damage.

Below are some basic WARNINGS that you should heed when you work on the vehicle's body. They are not all-inclusive and common sense must be used when servicing vehicles.

- Always read and understand all instructions before starting.
- Always wear safety glasses and other appropriate protective equipment (gloves, steel-toed shoes, face shields, knee pads, hearing protection).
- Put the transmission in Park, and set the parking brake before working on the vehicle.
- Be sure that the ignition switch is Off unless otherwise required by the procedure.
- Keep your hair, clothing, and body away from all moving parts such as engine pulleys and power tools.
- Always remove rings, watches, hanging jewelry, and loose clothing before working in tight areas.
- Read and understand all warning labels.
- Always use proper ladders or scaffolding to perform required jobs.
- Always make sure tools are in proper working condition and have guards and safety devices in place.
- Use only the recommended tools for a specific job.
- If at any time you lack confidence in performing a specific repair procedure or in operating the tools safely to perform the repair, STOP! Call your local dealer or a Utilimaster representative.

Recommended Tools



WARNING: Always wear safety glasses and other proper protective equipment (gloves, steel-toed shoes, face shields, knee pads, hearing protection) as appropriate to the process.

Below are some tools that you will need for this process. There may be other commonly used hand tools required but not specifically mentioned.

- Grease gun and grease
- Black and/or white touch-up paint
- Right angle drill with 1/2" step bit
- Drill with H (or 1/4") bit
- Reciprocating saw
- Pneumatic air hammer
- Angle Grinder
- Standard and metric combination and ratchet wrench sets including swivel adapter and extensions
- Torque wrenches (ft•lb increments)

Kit Parts List

01905421SK PROMASTER-SHOCK-ABSORBING BUMPER BLACK		
QTY	PART NUMBER	DESCRIPTION
1	03104592-N015EN	REAR STEP BUMPER INSTRUCTIONS
1	01905421	BUMPER FITZPATRICK PROMASTER VAN BLACK

01905433SK PROMASTER-SHOCK-ABSORBING BUMPER WHITE		
QTY	PART NUMBER	DESCRIPTION
1	03104592-N015EN	REAR STEP BUMPER INSTRUCTIONS
1	01905433	BUMPER FITZPATRICK PROMASTER VAN WHITE

NOTE: Each kit includes:

- Step bumper (1)
- Bumper frame mounts (2)
- Shock-absorbing struts (2)
- Toe kick angle (1)
- 7/16 x 5" bolts, locknuts, and flat washers (2)
- 1/2" x 1.5" bolts, washers and nuts (14)
- 1/4-20 bolts, washers and nuts (3)
- M10 bolts, washers and nuts (6)

Installation Instructions

1. Read and understand all instructions before starting work.
2. Validate the packing slip with the list of parts in the instructions.

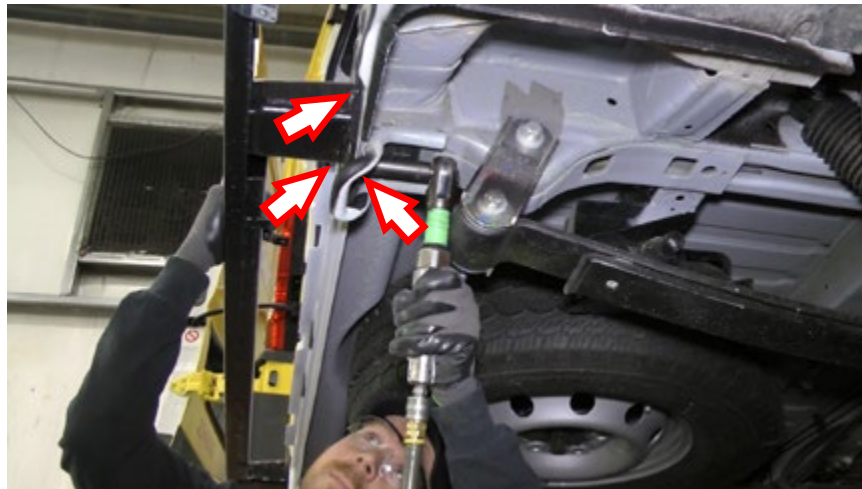
NOTE: Keep all hardware and fasteners for reuse unless noted otherwise.

3. Remove (8) screws from the bumper cladding and set aside.



Bumper cladding

4. Remove (4) bolts and (2) nuts from the bumper.



Bumper bolts located behind rear crossbar

5. Use an angle grinder and pneumatic air hammer to remove (2) weldbolts in the bumper.



Bumper weldbolt removal

6. If needed, use a reciprocating saw to remove stud on the LH frame rail.
7. Use a reciprocating saw to remove tow hook on the RH rear crossbar and discard.



Stud on LH frame rail



RH tow hook removal

8. Deburr and paint exposed steel surfaces.
9. If needed, use a 1/2" step bit and a right-angle drill to enlarge the hole in the chassis frame rails for the bumper frame mounts.



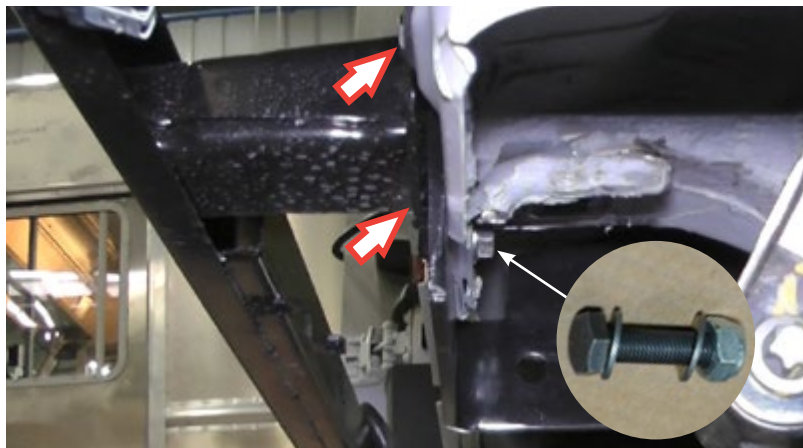
Enlarge hole in frame rail if necessary

- Secure each bumper frame mount on the **inboard** side of the chassis frame rail using (1) 7/16 x 5" bolts, locknuts, and flat washers. Do NOT tighten at this time.



*Position bumper frame mounts on the **inboard** side of chassis frame rails (RH shown)*

- Install the bumper to the bumper frame mounts using (6) M10 bolts with (4) washers and nuts on lower holes.



M10 fasteners for lower holes

- Torque bolts to 48 ft•lb.
- Secure (8) screws in the bumper cladding.



Bumper cladding

14. Install each shock absorbing strut on the inboard side of the bumper frame mounts with (3) 1/2-13 x 1.5" bolts, flat washers, and locknuts. Do NOT tighten at this time.

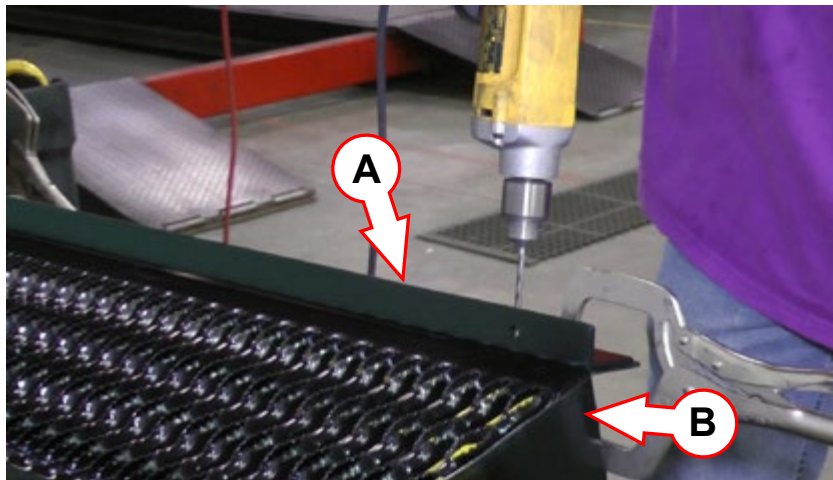


Shock absorbing strut fasteners (RH shown)



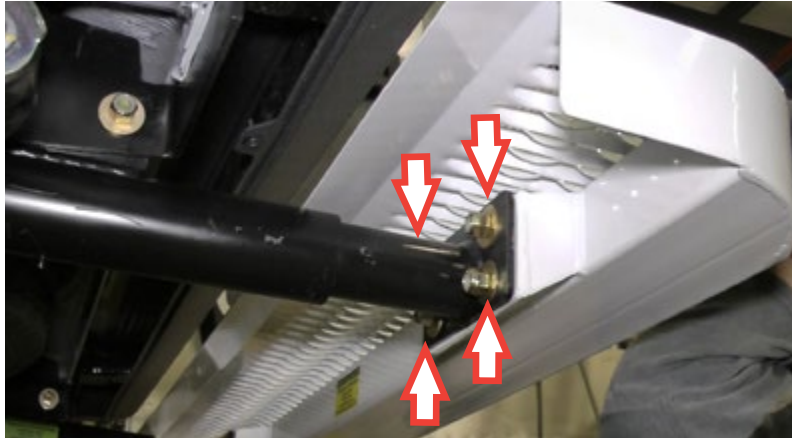
WARNING: Always support the bumper to keep it from falling.

15. Use an H-bit to drill (3) holes spaced evenly across the width of the toe kick angle and bumper.
16. Deburr and paint holes.
17. Secure toe kick angle with (3) 1/4-20 bolts, washers and nuts.



Toe kick angle (A) and bumper (B)

18. Secure rear step bumper to shock absorbing struts with (8) 1/2-13 x 1.5" bolts, washers and nuts.



Bumper to shock absorber fasteners

19. Use a tape measure to align bumper with bumper cladding.



Align bumper

20. Torque all 1/2" nuts on shock absorbing struts to 85 ft•lb.

21. Lubricate struts using approximately 6.5–7.5 grams (or five hand pumps) of #2 grease.



Strut grease fittings

Load Carrying Modification Label

NOTICE: Load Carrying Modification Label may be required to satisfy the statutory requirements for labeling contained in Title 49 of the United States Code, Chapter 5 (Motor Vehicle Safety) and regulatory requirements contained in 49 CFR Parts 567 (Certification) and 568 (Vehicles Manufactured in Two or More Stages). A person who alters a vehicle that previously has been certified in accordance with 49 CFR 571.110 may require an altered certification obligation. Altered certification regulations cover all manufacturing performed after the vehicle has been certified in the final stage and before the first purchase of the vehicle in good faith for purpose other than resale.

If you have any questions regarding labeling requirements or need to order labels, call NTEA at 1-800-441-6832.

1. Fill out and apply the Load Carrying Modification Label as required.

Revision Control

Document Part Number: 03104592-N015EN

Revision: A
Revision: B
Revision: C

April 2014
September 2014
June 2016

Important Notices

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Title: *ProMaster—Shock-Absorbing Bumper*

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