



INSTALLATION INSTRUCTIONS

Trans4mer Mounting System

Dodge Ram Kit No. 65220, 73132, 75525, 76253 (black) or
65221, 73133, 75530, 76254 (stainless)

As you read these instructions, you will see **NOTES**, **CAUTIONS** and **WARNINGS**. Each message has a specific purpose. **NOTES** are additional information to help you complete a procedure. **CAUTIONS** are safety messages that indicate a potentially hazardous situation which, if not avoided, may result in minor or moderate injury. A **CAUTION** may also be used to alert against unsafe practice. **WARNINGS** are safety messages that indicate a potentially hazardous situation, which, if not avoided could result in serious injury. **CAUTIONS** and **WARNINGS** identify the hazard, indicate how to avoid the hazard, and advise of the probable consequence of not avoiding the hazard. **PLEASE WORK SAFELY!**

PARTS LIST

PART NO.	QUANTITY	DESCRIPTION
65207	2 (black kit only)	SIDE MEMBER, BLACK
65208	2 (stainless kit only)	SIDE MEMBER, STAINLESS
65210	1	SIDE MEMBER BRKT, RH
65209	1	SIDE MEMBER BRKT, LH
65218	1	FRAME EXTENSION, RH
65217	1	FRAME EXTENSION, LH
65352	1	UPPER BRACE, RH
65351	1	UPPER BRACE, LH
65354	1	LOWER BRACE, RH
65353	1	LOWER BRACE, LH
65358	2	DIAGONAL BRACE
63688	1 (stainless kit only)	1-1/2" TUBE, STAINLESS
29365	1 (black kit only)	1-1/2" TUBE, BLACK
73745	1 (75525 black kit only)	Light Bar Kit, Black
73753	1 (75530 stainless kit only)	Light Bar Kit, stainless
60326	1 (stainless kit only)	2-1/2" TUBE, STAINLESS
29366	1 (black kit only)	2-1/2" TUBE, BLACK

TORQUE SPECIFICATIONS

3/8 INCH	30 lb. ft. (40.7 N-M)
7/16 INCH	50 lb. ft. (67.8 N-M)

Note: Do not securely tighten any fasteners until directed later.

This **WARN Trans4mer system** can be customized to give your Dodge Ram a wide variety of looks, front-end protection and winch mounting capability. The system starts with this strong two-tube Grille Guard that attaches to the truck's frame with brackets designed by Warn engineers to handle up to a 16,500 lb. winch. It is durable and good-looking, even as a stand-alone Grille Guard, but can be easily upgraded with some great options! You can add a third large size tube (Light Bar) that adds even more protection and includes tabs for mounting auxiliary lights. The tubes can be mounted in a variety of positions to achieve the look and function that you desire. You can mount a Winch Carrier Bracket that provides a permanent mount for a Warn winch. An accent cover is available to dress up the winch carrier. You may also add a Receiver Bracket that will handle the Warn Multi-mount winch system, a draw bar or any other accessory that fits the standard 2-inch receiver tube. Finally, Brush Guards that protect the headlights and front corners of the truck that can be easily added to any of the options above.

NOTES: PLEASE READ THESE INSTRUCTIONS THOROUGHLY BEFORE STARTING THE INSTALLATION OF THIS KIT. MINOR MODIFICATIONS MAY BE REQUIRED DUE TO VARIATIONS BETWEEN VEHICLES. STAINLESS STEEL KITS WILL BE SLIGHTLY DIFFERENT AND MAY CONTAIN DIFFERENT HARDWARE.

1. Review all illustrations to become familiar with the kit components.
2. Remove the gray plastic insert(s) from the center of the bumper, if so equipped. Unscrew the fasteners and remove. The insert(s) will not be reinstalled. Note the spacing between the headlights and the top of the bumper. You will want to return the bumper to this spacing after installation. If the vehicle is equipped with factory tow loops, remove them now. They will not be used with the Grille Guard.



Figure 1 Bolts attaching bumper brackets to frame (viewed from center of vehicle, looking outward)

3. Remove bumper with brackets. Unplug the factory fog lamps if so equipped. Support the bumper then remove the “paired bolts” attaching the bumper brackets to the frame. See **Figure 1**

Vehicles with diesel engines might require removal of the upper intercooler mounting bolts. Remove the bolts then lift the intercooler enough to clear and remove the “paired” bolts (about 3/4”). Temporarily slide the intercooler back in place. See **Figure 2**

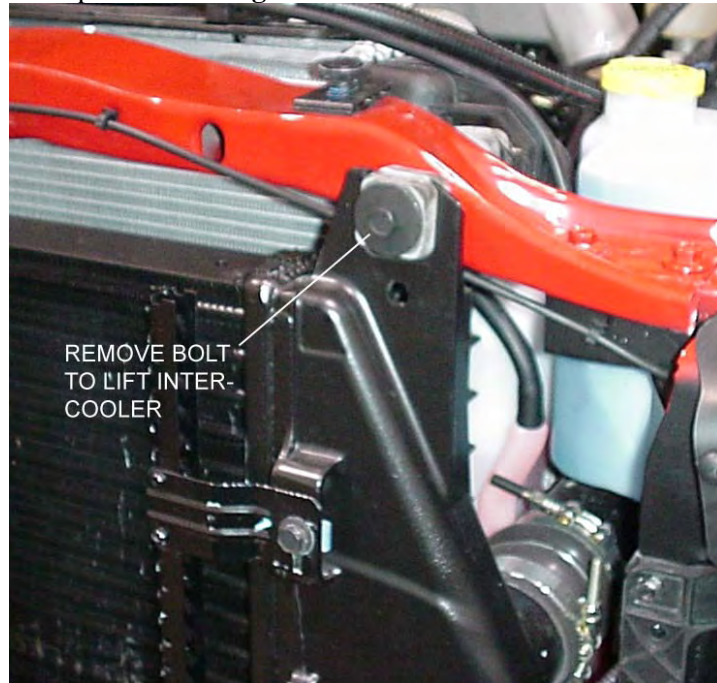


Figure 2 Left (driver side) diesel intercooler bolt

4. Remove the brackets from the bumper. Remove the three (3) nuts holding each bracket in place. Save the nuts to reattach the bumper later. The brackets will not be reinstalled.
5. Install the Template as shown in **Figure 3**. Temporarily install the factory “paired” bolts from outboard the frame. Install the nuts and tighten enough to prevent the Template from moving. Drill two (2) 7/16” holes through the remaining Template holes and both inner and outer frame walls. It is important that the holes be drilled straight across the frame in order to align with the brackets to be installed later. If the Template has more than one upper hole, drill the one that allows for the straightest drill angle through the frame. Later models typically use the lower of the (2) upper holes because of body mount interference. Repeat this step for the opposite side of the vehicle.



WARNING

Drilling operations can cause flying chips. **WEAR SAFETY GOGGLES.** Flying chips can cause eye injury.

When drilling, always make sure nothing can be damaged in the area where the drill will exit.

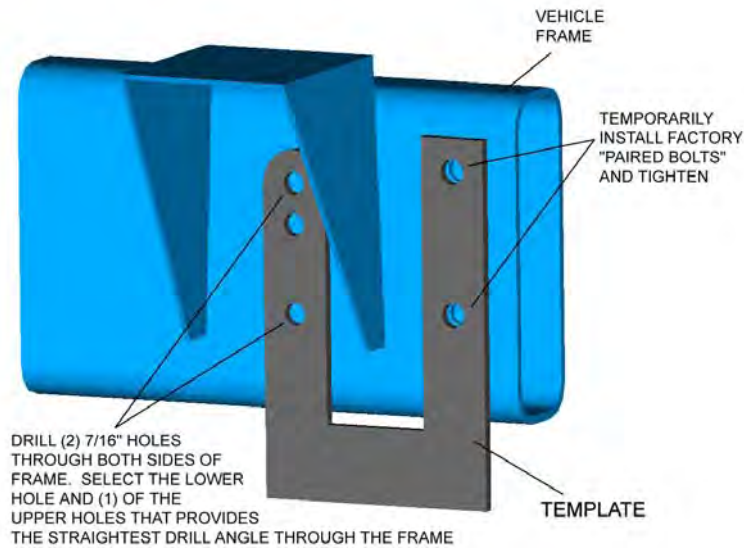


Figure 3 Template in place outside the right (passenger side) frame rail

6. Pry up the “anti-crush” brackets from the front of the left and right frame tubes. Use a large screwdriver or other suitable lever to pry the bottom tab from the hole in the frame. The spacers are welded at the top and it is not necessary to free them. If they do break loose, straighten and reinstall when instructed to do so. See **Figures 4 and 5**

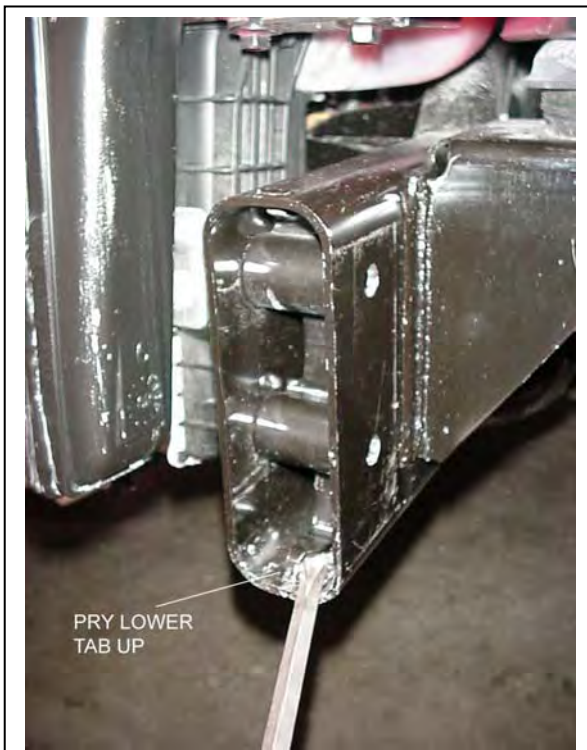


Figure 4 Left frame tube with “anti-crush” brackets in place



Figure 5 Left frame tube “anti-crush” brackets pried up for access inside the frame tube

7. Clamp the Right Hand (RH) Lower Brace onto the bottom of the frame. Position the 3-1/4" leg against the frame and the 2-1/2" leg vertical to the inside of the frame. The slots on the 2-1/2" leg are positioned forward. The front end of the bracket should be exactly 2" from the end of the frame. Note there is a Right Hand (RH) Brace and a Left Hand (LH) Brace. They are opposites and are not interchangeable. The slots in the 2-1/2" leg will align with the bottom holes of the Side Member. Drill a 7/16" hole through each slot into the center bottom of the frame. Repeat this step for the left side. See **Figure 6**

8. Insert a 7/16" Nut Plate into the frame (long leg first, towards rear of vehicle) and install the correct Lower Brace. Use a 7/16" x 1-1/2" bolt, lock washer and flat washer through the Brace and frame, into the Nut Plate. Repeat for each Brace slot. Do not tighten at this time. See **Figure 7**

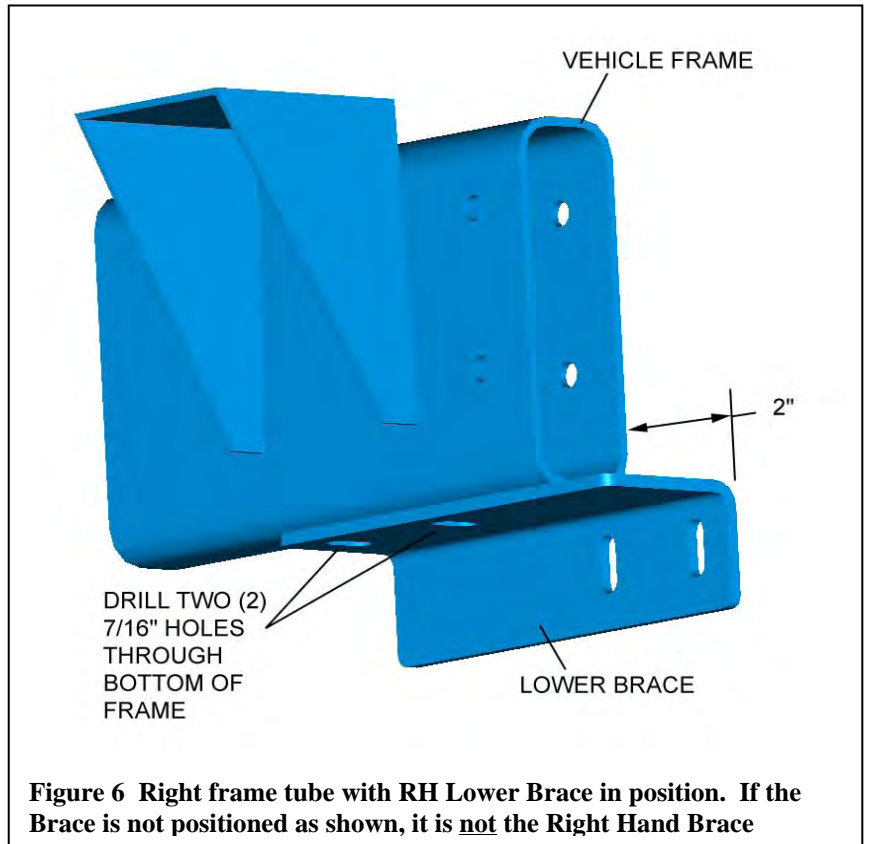
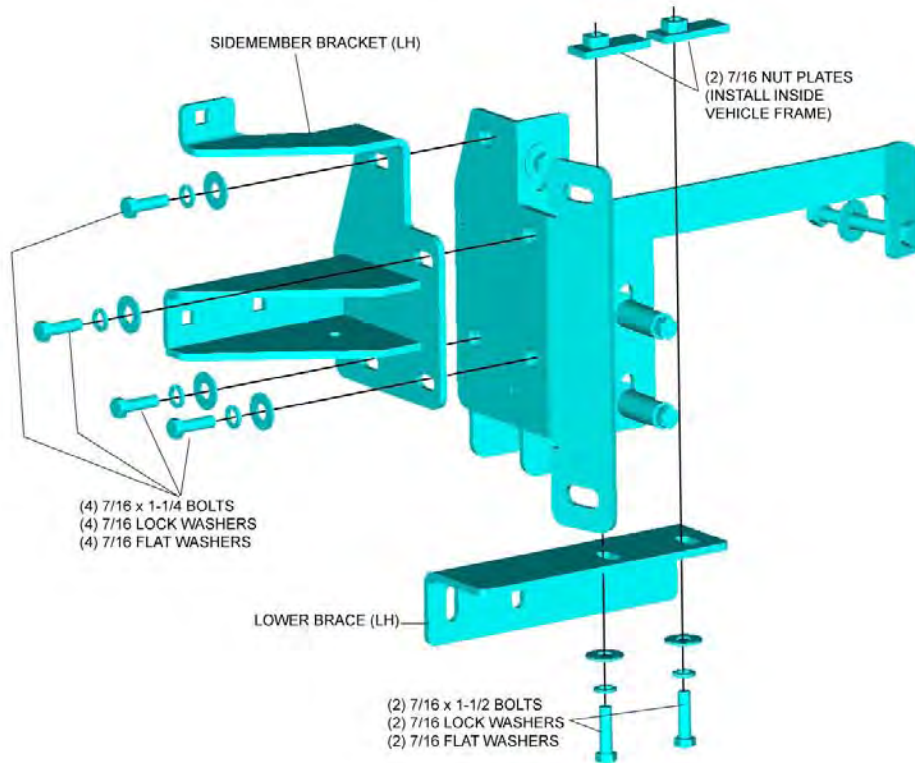
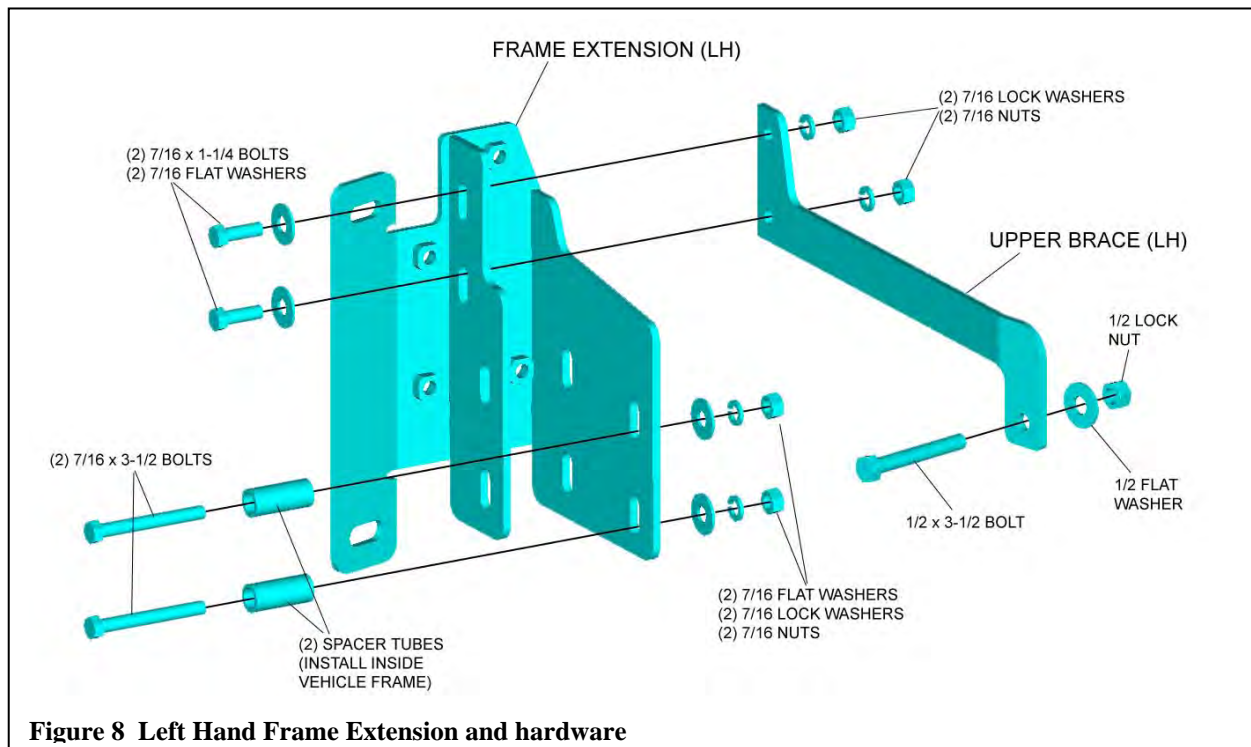


Figure 6 Right frame tube with RH Lower Brace in position. If the Brace is not positioned as shown, it is not the Right Hand Brace



9. Hold a spacer tube inside the frame and insert a 7/16 x 3-1/2" bolt through one of the holes drilled with the Template and the spacer from outside the frame. These spacers will prevent frame distortion when the bolts are tightened. Do not push the bolt through the inside frame wall yet. Repeat this step for each hole drilled with the template. See **Figure 8**
10. Push the "anti-crush" brackets back into the original positions. Do not let the spacer tubes drop off the bolts inside the frame.
11. Position the appropriate Upper Brace above the frame so the leg with the single hole is towards the rear of the vehicle, outboard of the frame. Do not install hardware yet.
12. Install the appropriate Frame Extension. Push the 7/16" x 3-1/2" bolts through the Frame Extension and install a 7/16" flat washer, lock washer and nut on each. Lift the intercooler and reinstall the factory "paired" bolts from the inside, through the Frame Extension. Install the factory nuts. Do not tighten any hardware yet. Repeat for the opposite side. See **Figure 8**



13. Attach the RH Upper Brace to the inside of the Frame Extension. Use (2) 7/16 x 1-1/4" bolts and flat washers through the Frame Extension into the Upper Brace. Note the Upper Brace is positioned inside the outboard Frame Extension plate. Install a 7/16" lock washer and nut on each bolt. Repeat the procedure for the LH Upper Brace. Push the intercooler back into position. Install and tighten hardware. See **Figure 8**
14. Install a 1/2 x 3-1/2" bolt through the rear hole in the RH Upper Brace into the existing large hole in the frame. Insert the bolt through both frame walls and install a 1/2" flat washer and nylon lock nut. See **Figure 8**

15. Carefully drill a 1/2" hole through the rear hole in the LH Upper Brace through both walls of the frame. **NOTE: Avoid drilling into the steering box inboard of the frame.** Install a 1/2 x 3-1/2" bolt through the LH Upper Brace into the frame. Insert the bolt through both frame walls and install a 1/2" flat washer and nylon lock nut.
16. Install the LH and RH Side Member Brackets. Use 7/16 x 1-1/4" bolts, lock washers and flat washers through the Side Member Brackets into the threaded holes in the Frame Extensions. Center the Brackets on the vehicle and adjust them so there is 32-1/2" between the inner faces (where the Side Members will be installed). Tighten the hardware before proceeding. See **Figure 7**

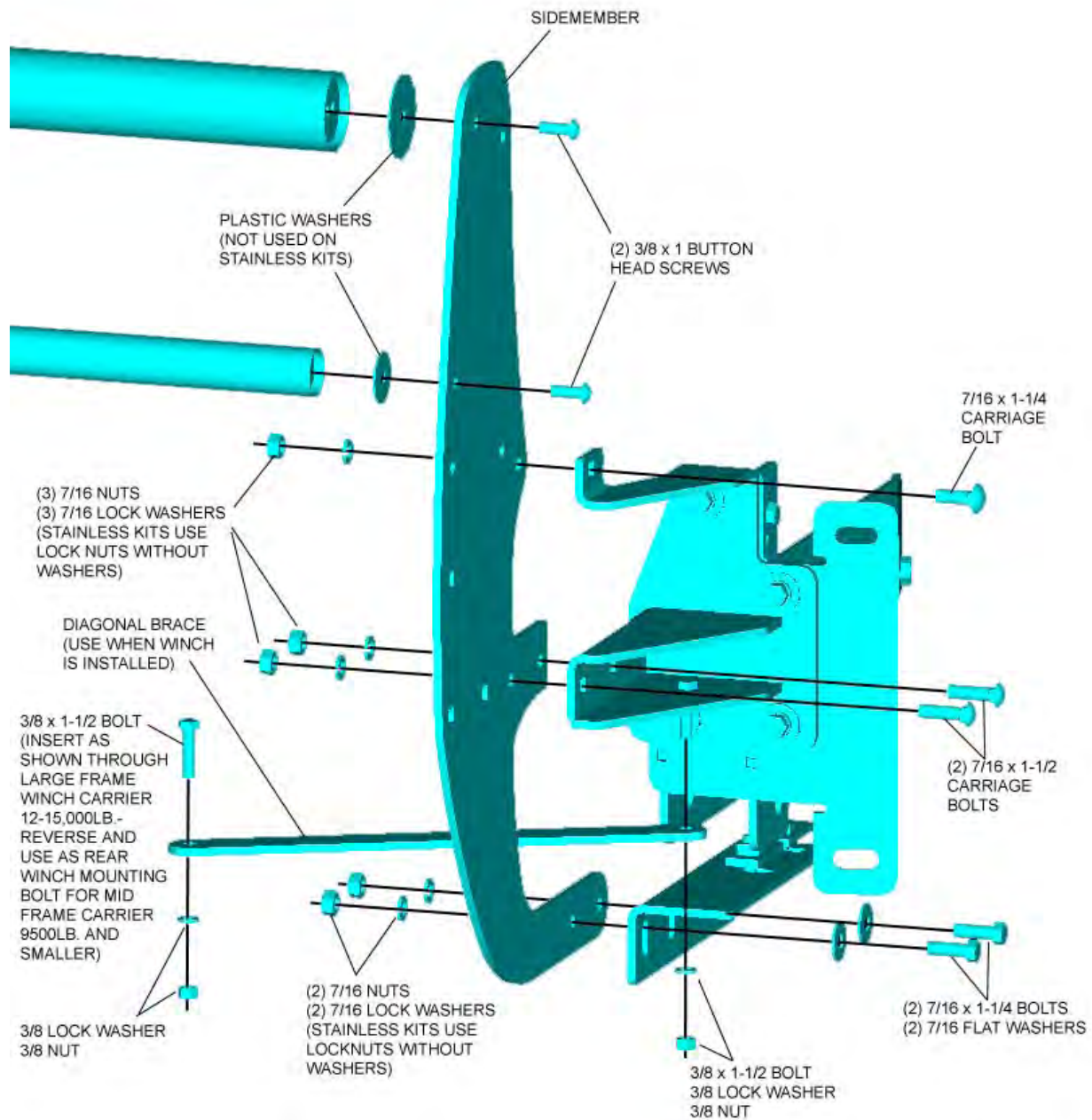


Figure 9 Side Member, Diagonal Brace and Center Tubes

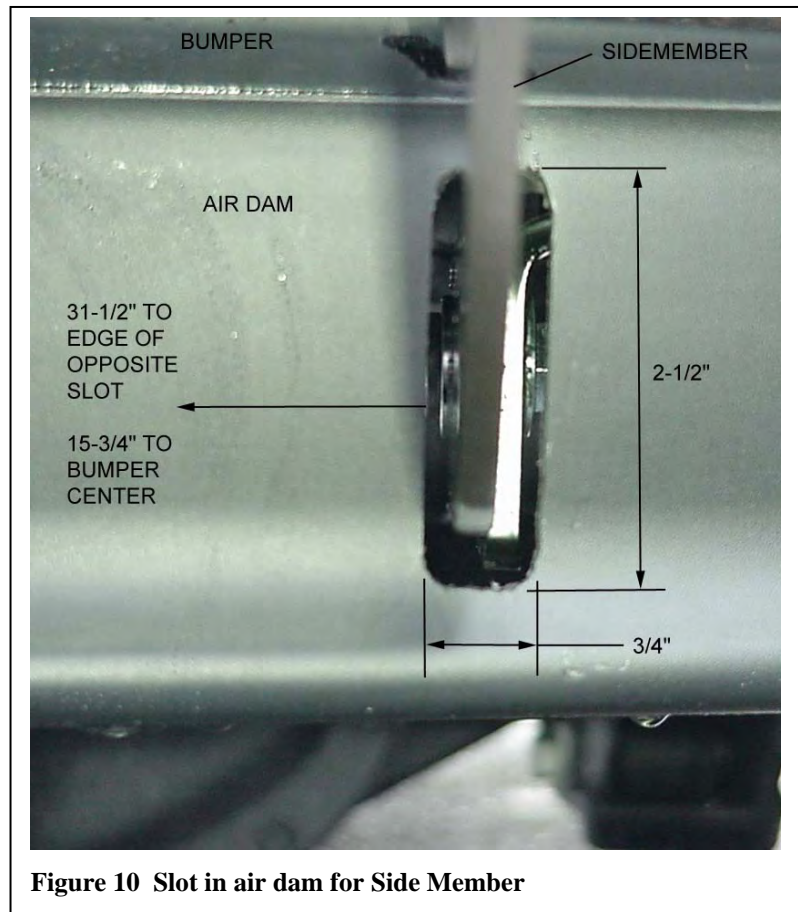
Diesel Application Note: Maintain at least 1/4" clearance between the Side Member Brackets and the intercooler when the hardware is tight.

17. If the Trans4mer is being installed as a Grille Guard and a winch is not being mounted at this time, skip step 18 and install the tubes in any desired position as shown in **Figure 9**. If a winch is to be installed proceed with step 19.

18. Install the Diagonal Braces. Use 3/8 x 1-1/2" bolts through the hole in each Side Member Bracket into the Diagonal Brace. Install 3/8" lock washers and nuts. Do not tighten yet. The other end of the brace will be attached to the Winch Carrier. For a Large Frame Winch Carrier 12,000 to 16,500 lbs, install 3/8 x 1-1/2" bolts from the top of the Carrier Base (before the winch is installed) and secure with lock washers and nuts. For a Mid Frame Winch Carrier, 9500 lbs and below, use the 3/8 x 1-1/2" bolts with lock washers as rear winch mounting bolts, installed from the bottom of the Carrier Base.

Brush Guard Note: If Brush Guards are to be installed refer to those instructions at this time. It is easier to install the stabilizing brackets for the Brush Guards before the bumper is reinstalled.

19. Install the bumper. Slide the bumper mounting studs through the slots in the Frame Extensions. Only the four (4) outboard studs are used. Install the original nuts, center the bumper and tighten. See **Figure 10**



20. Adjust the bumper to the desired vertical position and tighten the 'paired bolts' and the 7/16 x 3-1/2 bolts through the Frame Extensions first. Next, tighten the 7/16 x 1-1/4" Upper Brace bolts, then the 1/2 x 3-1/2" through Upper Brace and frame bolts. Do not tighten the Lower Brace hardware or the Side Member Bracket hardware yet.

21. Cut two (2) slots in the front air dam for the Side Members. See **Figure 10** for slot dimensions. The top of the slot should be 6-1/4" down from the bottom of the Side Member Bracket (where the Diagonal Brace is attached). Drill 3/8" holes for the corners of the slot then cut between the holes with a saw or knife.

22. Attach the Side Members to the insides of the Side Member Brackets. Use 7/16 x 1-1/4" carriage bolts, lock washers and nuts (use nylon lock nuts without washers for Stainless Side Members). Insert two (2) 7/16 x 1-1/4" bolts and flat washers through each Lower Brace and Side Member. Install 7/16" lock washers and nuts (use nylon lock nuts without washers for Stainless Side Members). See **Figure 9**
23. If the Winch Carrier or Receiver Kit is being added, install a tube only in the top position and then refer to the specific instructions packaged with those items. If this kit came with an angled light bar install it now in place of the lower Grill Guard Tube by following the directions provided in the kit.
24. The plastic washers are not used when installing Stainless Steel Tubes.
25. If a Winch Carrier is being installed in a Stainless Kit, use the 7/16" button head bolts from this Hardware Kit to secure it (replacing the carriage bolts supplied in the Carrier Kit.)

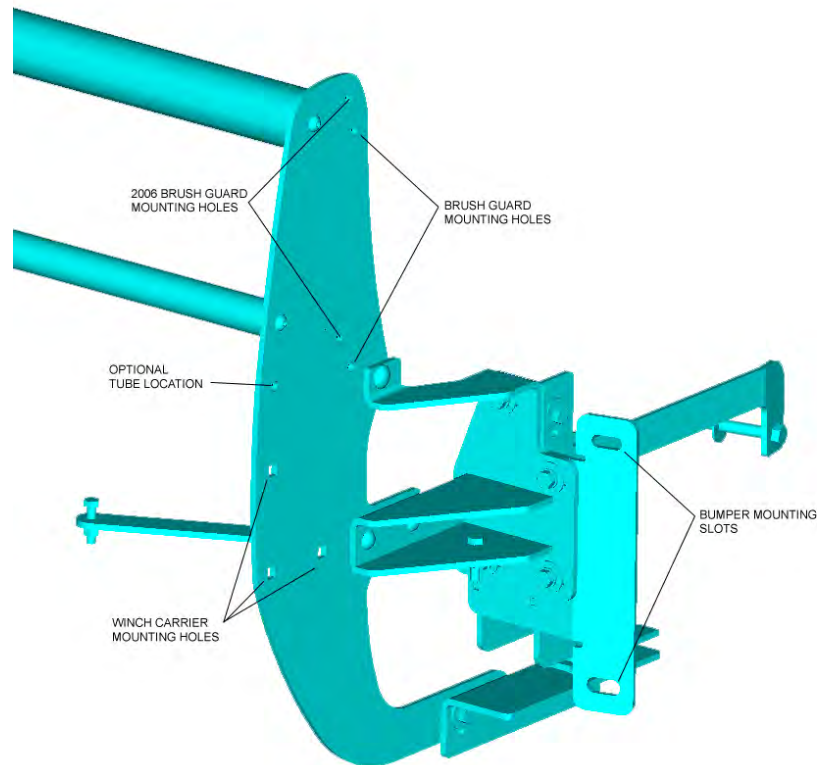
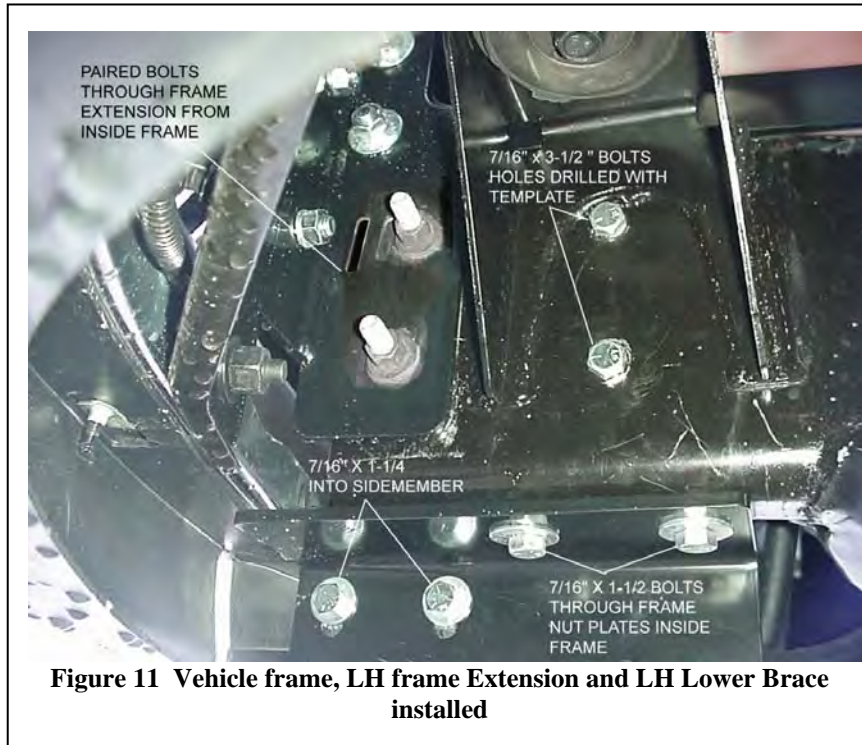


Figure 10 Left Hand Assembly complete

26. Tighten the remaining fasteners securely. Start with the Side Member and Winch Carrier hardware first, then work towards the vehicle.



Stainless Steel Truck Accessories

What to expect:

Polished stainless steel combines the beauty of a chrome-like appearance with extreme durability and corrosion resistance. With a minimum amount of care, the appearance will last almost indefinitely. Unlike platings or coatings, there is nothing to peel off or wear away that would allow corrosion underneath.

The actual appearance may not be exactly like new chrome in either the degree of luster or color. There may be fine polishing lines visible up close and small differences between mating parts of an assembly. A grille guard, for instance, may have small differences between the round tubing and the flat plate. The backside of a part may not be as highly polished as the front. However, part of the beauty and appeal of stainless actually lies in the smooth “hand-worked” appearance.

There also is a possibility that small rust spots can appear on stainless products. They are usually due to minor iron contamination on the surface as a result of normal manufacturing and handling processes. This minor rust, if it occurs at all, is easy to remove and will not tend to spread.

Recommended care:

Regular washing with fresh water and mild car wash detergents followed by rinsing and drying with a soft towel is the best minimum care. Beyond that, any cleaner/wax recommended for automotive finishes will work well to remove minor stains and scuffs, enhance the shine and provide protection. Always use clean soft cotton cloths. In most cases, this will be all that is required for many years. For more serious blemishes or a rust spot, use a cream metal polish recommended for stainless, aluminum, etc. Try to rub in the direction of the original polishing lines. Ultimately, any stainless part can be restored to a brilliant shine with power buffing processes.

Caution:

Do not use steel wool or any type of metal scraper. Do not use “Scotch Brite” pads or abrasive powdered cleaners. Do not try to clean with muriatic acid or any other acid.

Stainless Fasteners

Stainless steel fasteners are included in many of the stainless kits. These fasteners provide similar corrosion resistance and appearance as the rest of the kit. However, stainless fasteners are prone to galling when installed in similar stainless material. It is a good idea to apply a small amount of anti-seize compound to the threads when installing them. Care should also be taken when tightening the fasteners to prevent rounding or deforming the corners of the bolts. Make sure the wrenches are the correct size and fit properly. In the case of socket heads, the wrench should have sharp, un-worn edges. With a few precautions during assembly the products should provide years of service.