

**ROUGH COUNTRY**  
SUSPENSION SYSTEMS®

921107970



**10797BAG**

## 07-14 Chevy 2500 DIY Bumper

Thank you for choosing Rough Country for all of your suspension needs.

Rough Country recommends that a certified technician install this system. In addition to these instructions, professional knowledge of disassemble/reassembly procedures as well as post installation checks must be known. Attempts to install this system without this knowledge and expertise may jeopardize the integrity and/or operating safety of the vehicle. Please read all the instructions before beginning the installation. Check the kit hardware against the "Kit Contents" list below. If question exist, please call us @1-800-222-7023. We will be happy to answer any questions concerning this product. Check all fasteners for proper torque. Check to ensure for adequate clearance between all components. Check and retighten wheels at 50 miles and again at 500 miles. Periodically check all hardware for tightness. Be sure you have all the needed parts and understand where they go. Also, please review the "Tools Needed" list to be certain you have the necessary tools to complete the installation.

### PRODUCT USE INFORMATION

#### **▲WARNING**

As a general rule, the taller a vehicle is the easier it will roll. We strongly recommend that seat belts and shoulder harnesses be worn at all times. Braking performance and capabilities are decreased when significantly larger/heavier tires and wheels are used. Do not add, alter, or fabricate any factory or after-market parts which increase vehicle height over the intended height of the Rough Country product purchased. Rough Country makes no claims regarding lifting devices and excludes any and all implied claims. We will not be responsible for any product that is altered.

#### **▲NOTICE**

### NOTICE TO DEALER AND VEHICLE OWNER

Any vehicle equipped with any Rough country product must have the "Warning to Driver" decal installed on the sun visor or dash. The decal is to act as a constant reminder for whoever is operating the vehicle of its unique handling characteristics. **INSTALLING DEALER**—It is your responsibility to install the warning decal and to forward these installation instructions on too the vehicle owner for review and to be kept in the vehicle for its service life.



# 07-14 Chevy 2500 DIY Bumper

## TOOLS NEEDED:

Jack  
Safety Stands  
Wheel Chocks  
Pick  
Cut Off Tool  
Welder  
Grinder  
Sander  
Pry Tool  
Drain Bucket  
Pliers  
Measuring Tape  
Marker

## Metric Wrench/Socket

8mm  
10mm  
15mm  
18mm  
19mm  
21mm

## Bumper Skin Contents:

Center Skin (1)  
Winch Chin (1)  
Driver Wing 1 (1)  
Pass Wing 1 (1)  
Driver Wing 2 (1)  
Pass Wing 2 (1)  
Driver Wing 3 (1)  
Pass Wing 3 (1)  
Driver Bottom Wing (1)  
Pass Bottom Wing (1)  
Grill End Cap (2)  
Wing End Cap (2)  
10" Light Mount (2)  
30" Light Mount (1)  
Skin Support (4)  
Mount Plate (2)  
Bottom Brace (2)  
D-Ring Mount (2)  
Fairlead Mount Plate (1)  
Fairlead Spacer (1)

## Frame Mount Contents:

Driver Frame Mount (1)  
Pass Frame Mount (1)  
Frame Mount Brace (2)  
Front Plate (2)

## Winch Tray Contents:

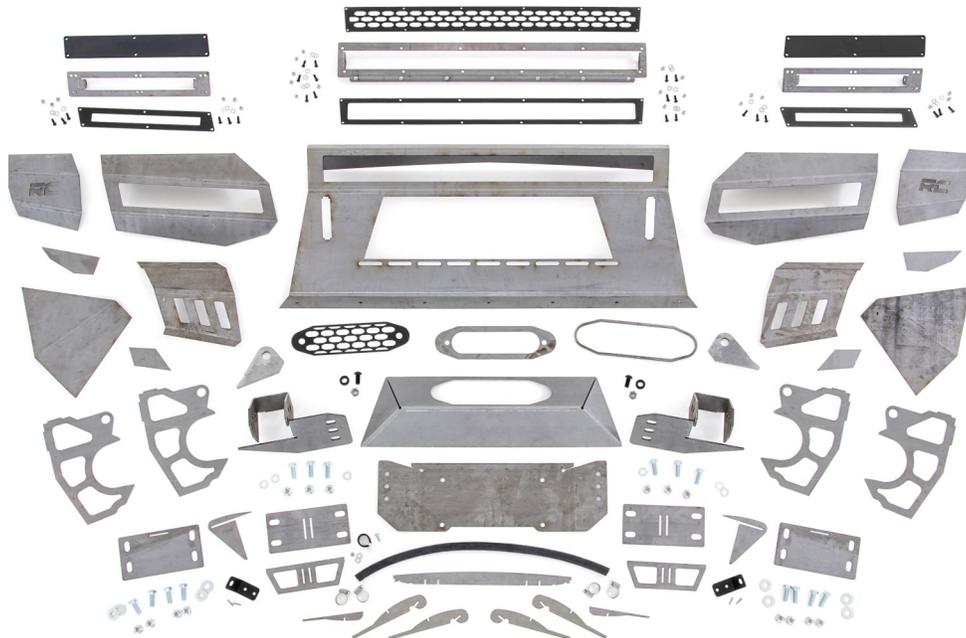
Winch Tray (1)  
Cross Rib (1)  
Outer Rib (2)  
Inner Rib (4)

## Extras:

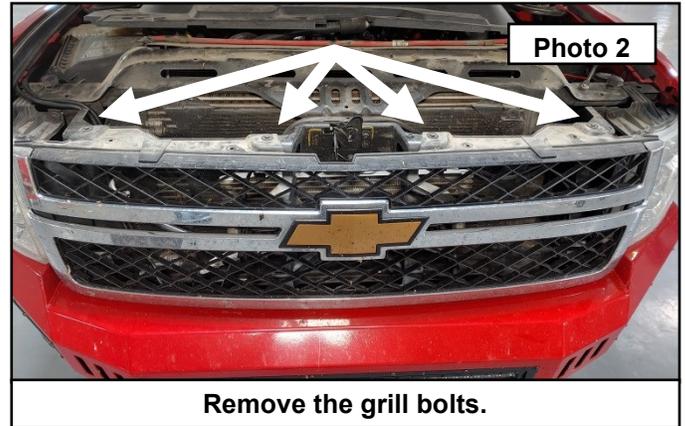
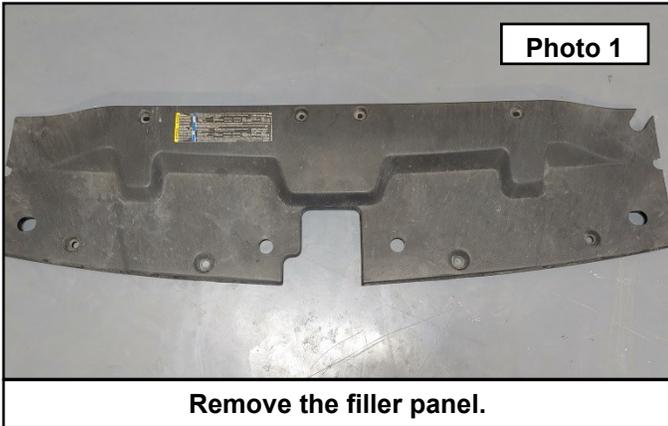
10" Light Trim Ring (2)  
10" Light Block Off Panel (2)  
30" Light Trim Ring (1)  
30" Light Block Off Grill (1)  
Fairlead Block Off Grill (1)  
Transmission Hose (2')  
Transmission Cooler Mount (2)

## HARDWARE INCLUDED:

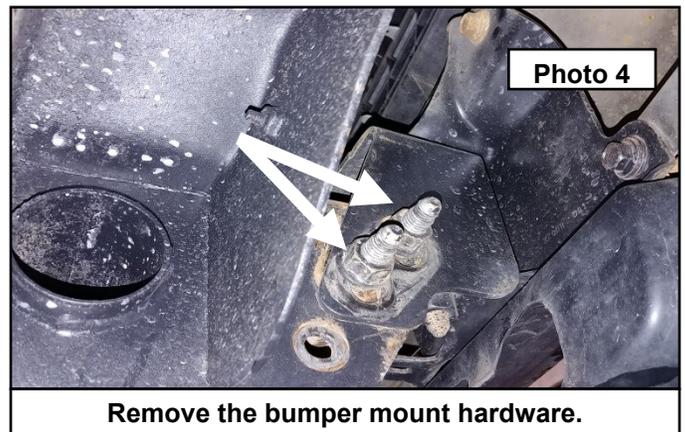
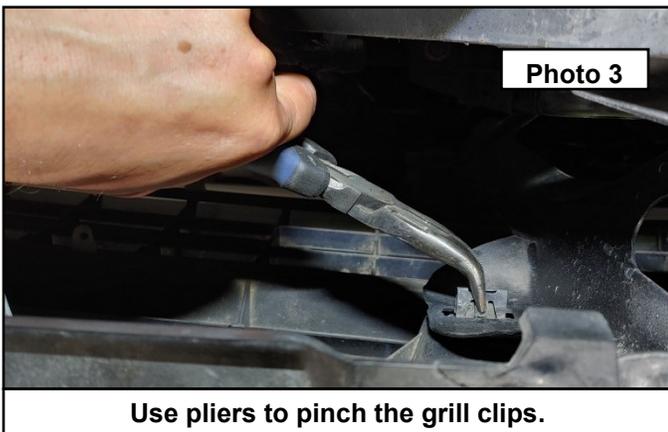
12mm x 35mm Bolt (14)  
12mm Flat Washer (6)  
12mm x 25mm Button Head Bolt (2)  
12mm Raw Nut (2)  
12mm Flange Nut (14)  
12mm Heavy Washer (8)  
1/4" x .75" Button Head Bolt (24)  
1/4" x .75 Black Button Head Bolt (24)  
1/4" Raw Nut (7)  
1/4" Nut (25)  
1/4" Washer (26)  
Phillips Head Screw (4)  
1" Adel Clamp (1)  
Hose Clamp (4)



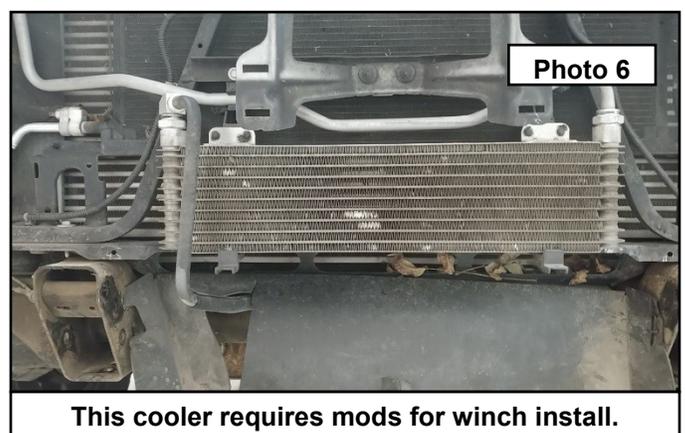
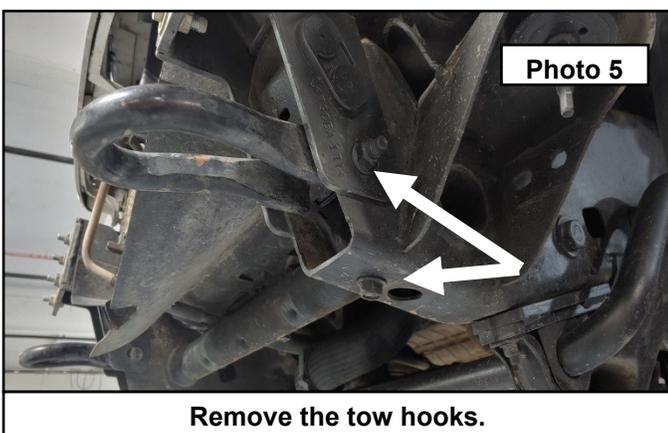
1. Park your vehicle on a clean flat surface, engage the parking brake and block the rear tires.
2. **Save all hardware removed from the vehicle unless otherwise noted.**
3. Open the hood and disconnect the negative terminal on the battery. Disconnect any auxiliary light harnesses in the bumper.
4. Remove the core support filler panel by prying out the plastic clips. **Photo 1**
5. Remove the 4 grill bolts using a 10mm socket. **Photo 2**



6. Locate the clips behind the grill holding it to the vehicle. Use a pair of pliers to pinch the clips while gently pulling up and out on the grill. There are a number of these. Use of a helper to keep pressure on the grill will aid in removal. **Photo 3**
7. Under the vehicle, locate the bumper side supports at the body mount and remove using a 15mm socket and discard. Locate the main frame mounts. Remove the nuts using a 21mm socket. **Photo 4**



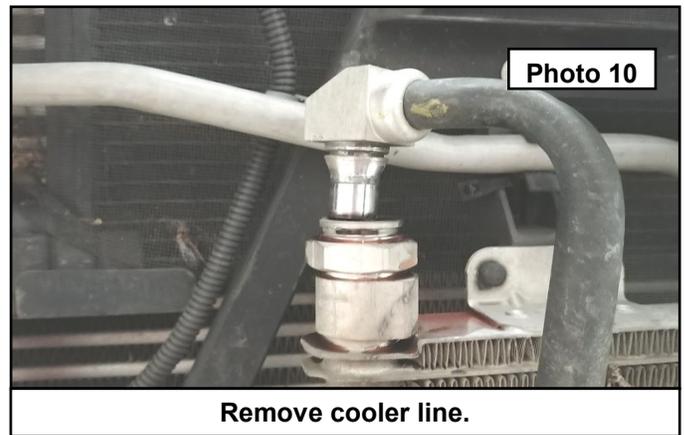
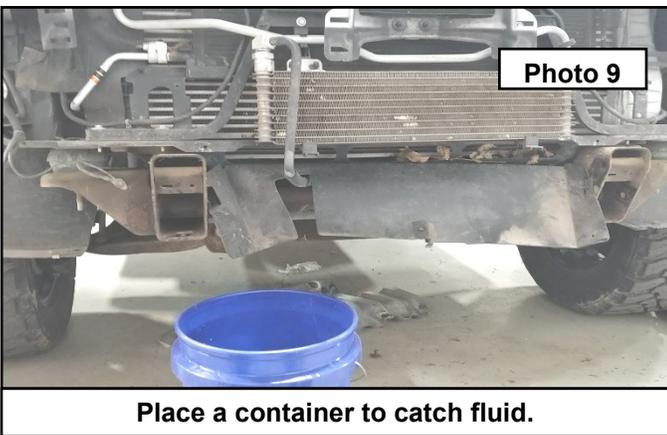
8. Use an assistant to help hold the bumper, remove the bolt tabs. Pull the bumper out and off the frame. Set aside. Remove the factory tow hooks if they are installed using a 18mm socket. **Photo 5**
9. On vehicles with the factory heavy duty transmission cooler, you will need to relocate this using the following steps if you plan on installing a winch. **Photo 6**



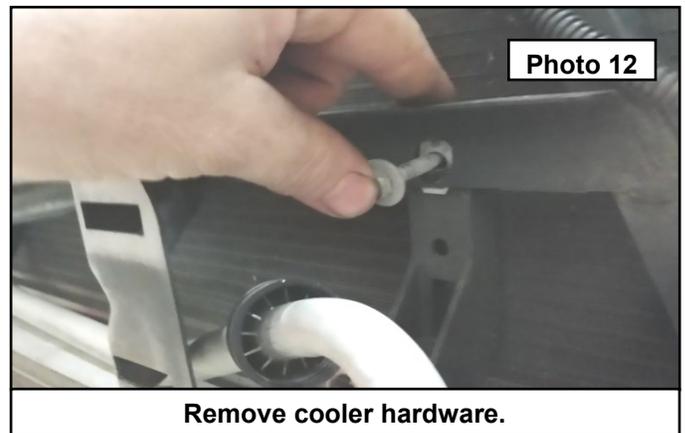
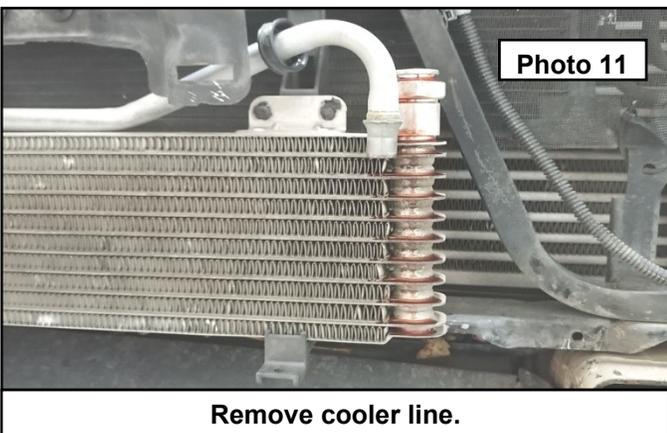
10. On the driver side of the cooler, you will need to lift up the plastic safety cap to access the clip. **Photo 7**  
11. Remove the lines from the transmission cooler by using a pry tool to pull the speed clips out of the way. Do not lose these as they will need to be reinstalled. **Photo 8**



12. Use a suitable container to catch fluid once you remove the lines. **Photo 9**  
13. Pull up on the cooler lines to remove them from the cooler. Pass side shown. **Photo 10**

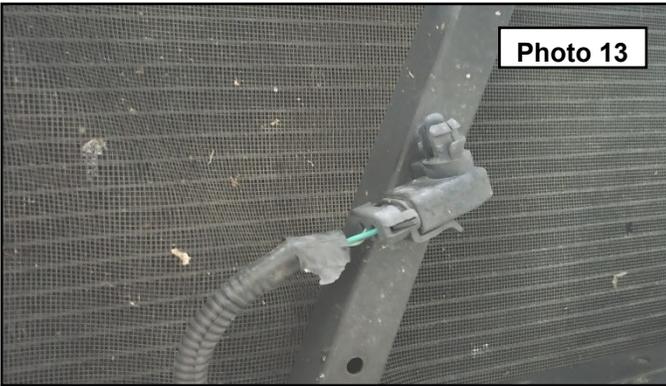


14. Repeat the process for the driver side. **Photo 11**  
15. Remove the cooler mounting hardware using a 10mm socket. **Photo 12**



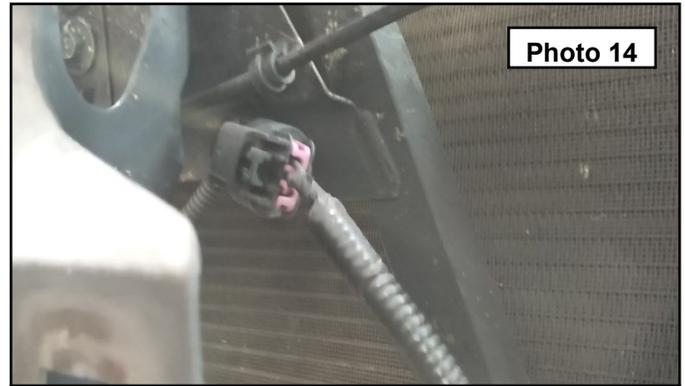
16. Remove the ambient temperature sensor by prying off the frame. **Photo 13**

17. Remove the hood latch safety switch harness by pressing the release tab and pulling out. **Photo 14**



**Photo 13**

**Remove the air temp sensor.**

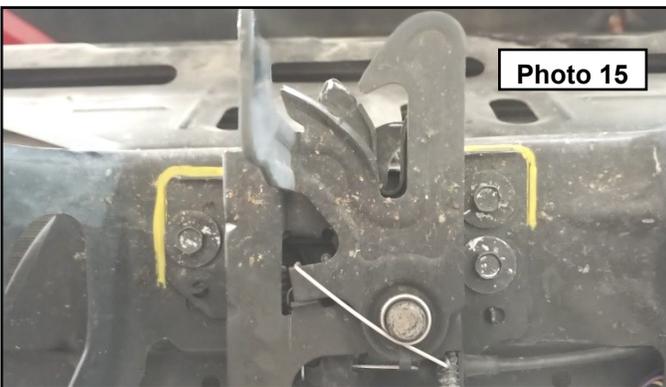


**Photo 14**

**Disconnect the hood latch connector.**

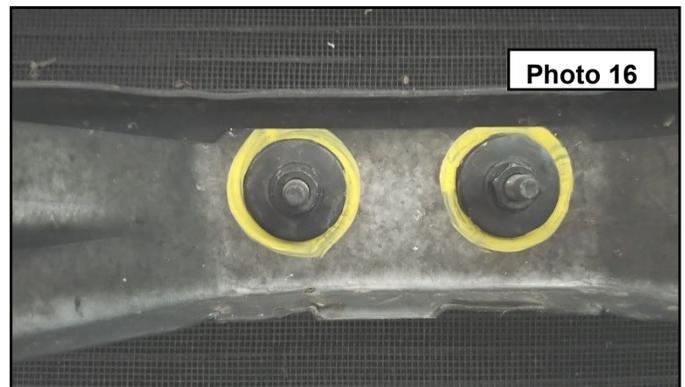
18. Mark around the hood latch so that you can reinstall in the same orientation later and remove using a 10mm socket. Let the latch hang out of the way. **Photo 15**

19. Mark around the lower frame grill mounting frame hardware so that you can reinstall in the same orientation later. Remove using a 10mm socket. **Photo 16**



**Photo 15**

**Mark the hood latch to frame.**



**Photo 16**

**Mark the frame mounting hardware.**

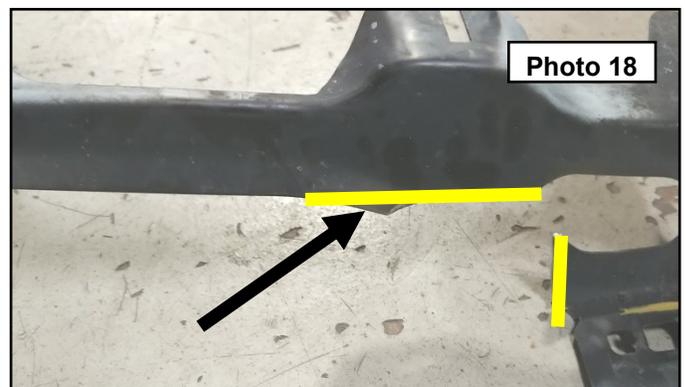
20. Mark the area that needs to be cut out in the grill mounting frame for the cooler to fit. Mark 3.5" down from the top for the horizontal line. Then from the vertical edge mark straight up. You are going to remove this kicker arm from the frame mount. **Photo 17**

21. Use a suitable cutting tool to remove the kicker. Sand any burrs and round off any sharp corners. **Photo 18**



**Photo 17**

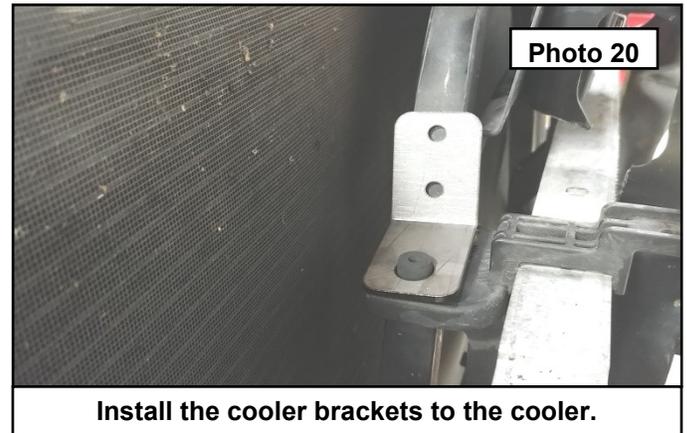
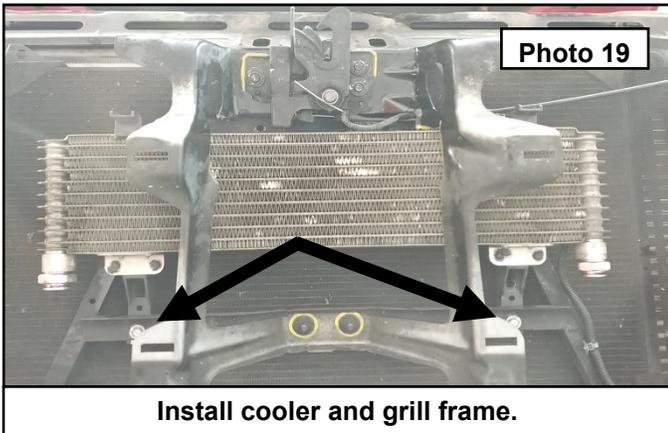
**Mark the grill mounting frame.**



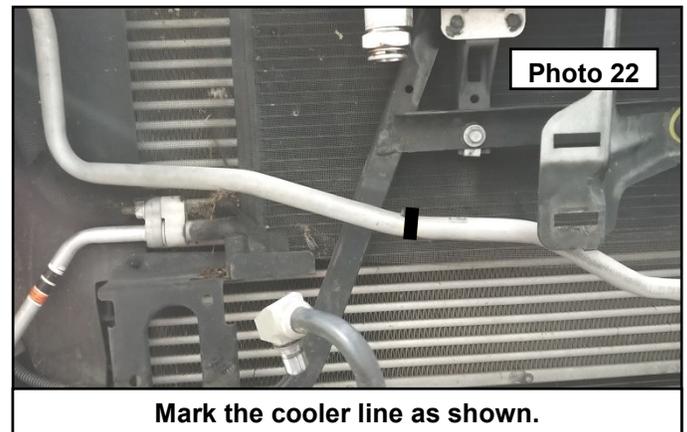
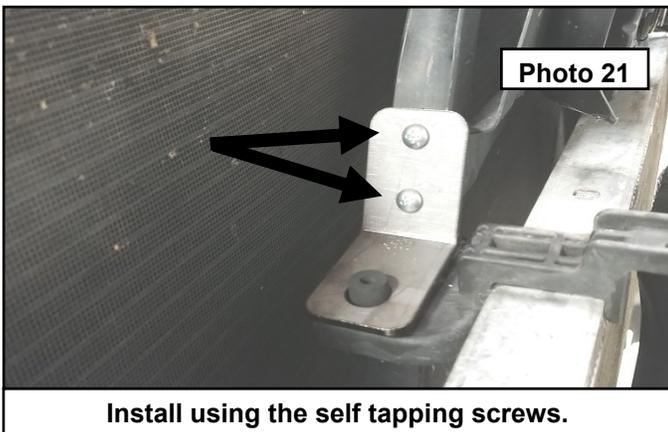
**Photo 18**

**Cut the grill mounting frame.**

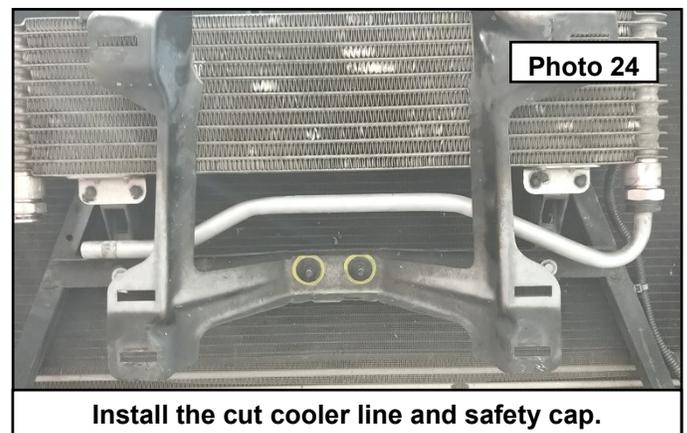
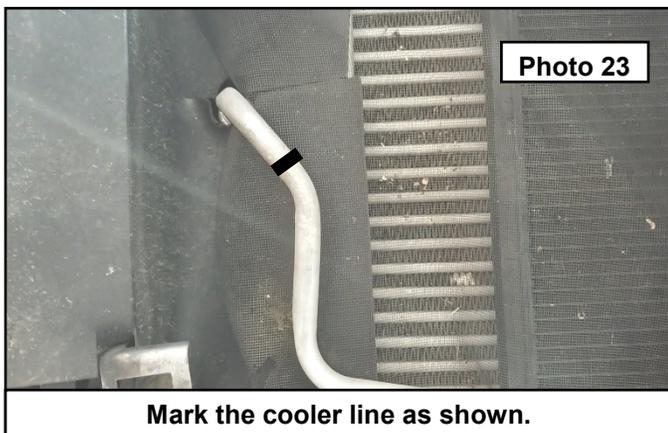
22. Install the transmission cooler upside down in the original holes using the factory hardware. Reinstall the grill mounting frame and hood latch using the previously made marks and hardware. Check to see if you have any edges that could damage the cooler, and if so remove. **Photo 19**
23. Locate the cooler brackets from the bumper kit. Install onto the cooler rubber feet. Push the cooler back towards the radiator until the brackets line up with core support frame. **Photo 20**



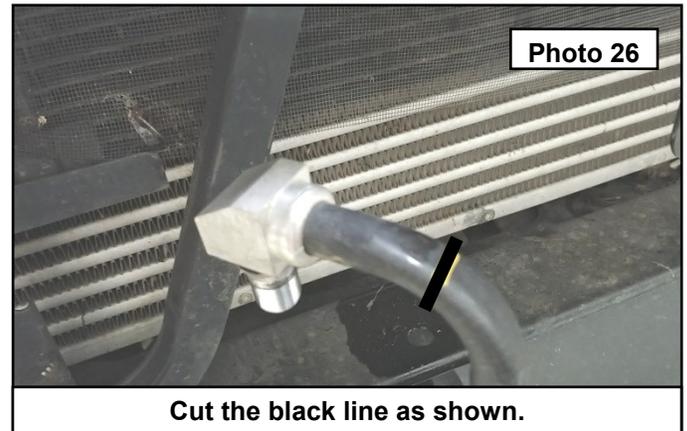
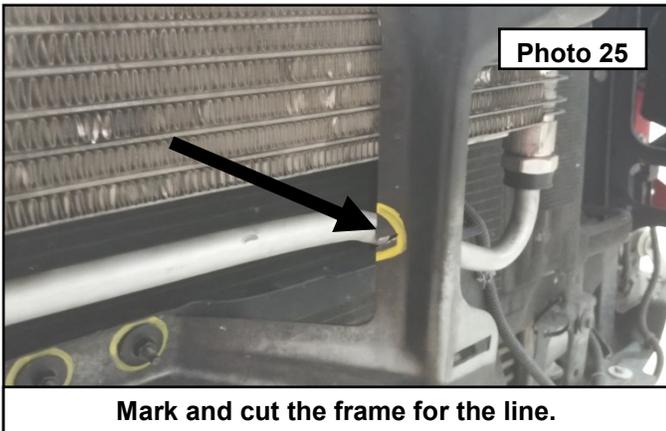
24. Mount the brackets to the frame using the provided self tapping screws. Do not strip out the threads. **Photo 21**
25. Mark the silver cooler line on the passenger side of the vehicle right after the bend as shown. **Photo 22**



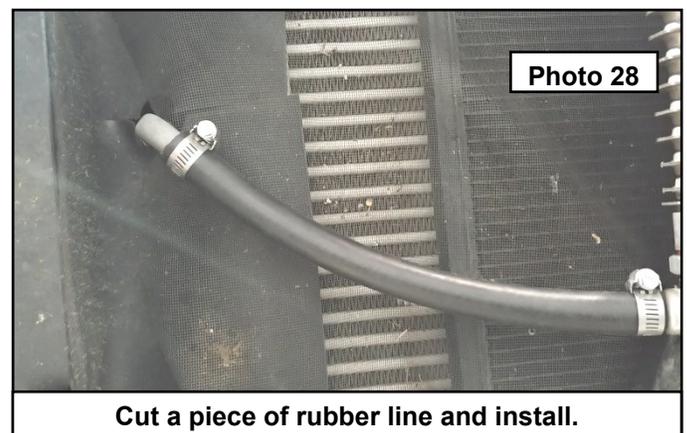
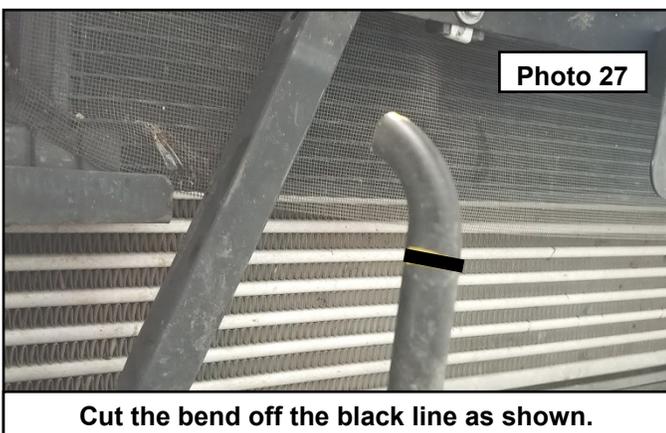
26. Mark the silver cooler line as shown right before the bend near the radiator. Use a suitable cutting tool, cut the line. Make sure to sand any burrs off the inside and outside of the tubing. Blow the line out using compressed air to make sure any shavings are not in the line. **Photo 23**
27. Install the cut line into the driver side of the inverted cooler. Reinstall the quick clip and the safety cap. **Photo 24**



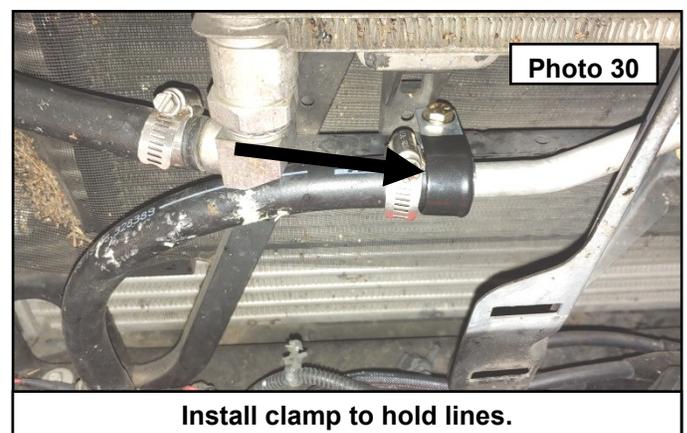
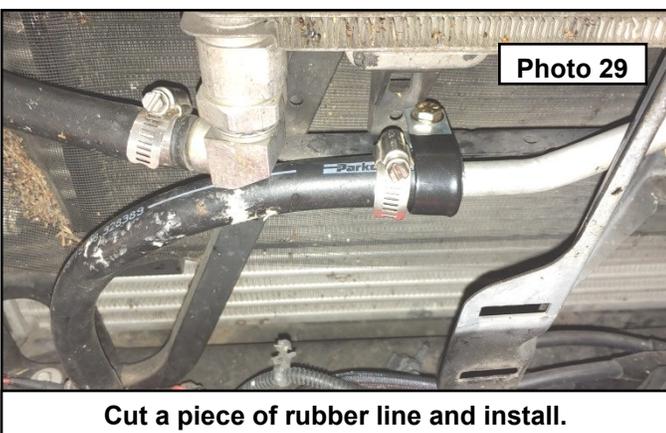
28. Rotate the silver line to the front of the vehicle. Mark onto the grill mounting frame where this line can make contact. Remove the frame and cut to provide clearance for the tubing. Sand any burrs and paint all exposed metal with a quality rust preventative paint. **Photo 25**
29. Mark and cut the black cooler line as shown. Sand any burrs off the inside and outside of the line. Blow the line out to clear out any shavings. **Photo 26**



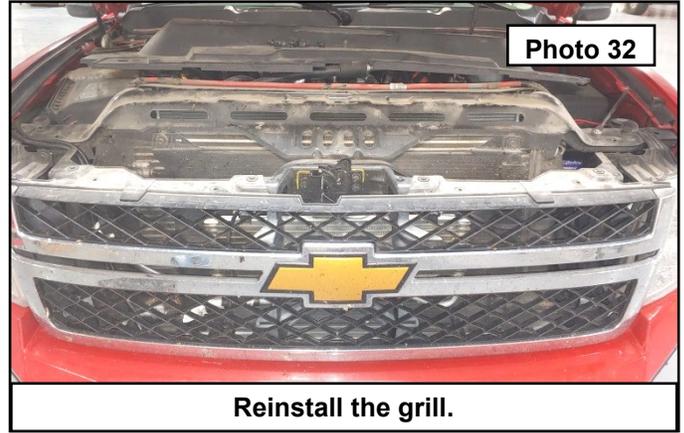
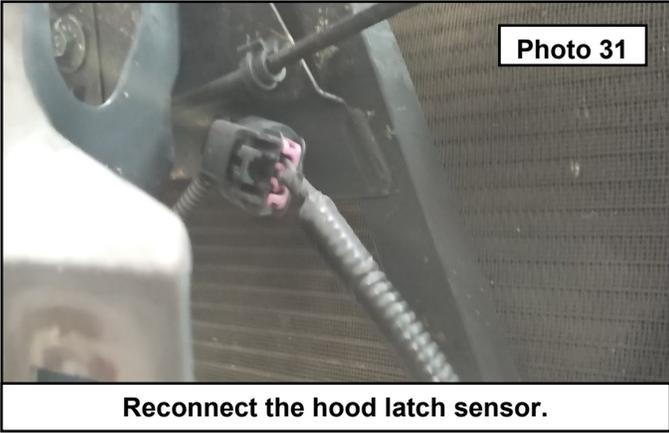
30. Mark and cut the black cooler line right after the bend. As with the other cuts, sand any burrs off the line. **Photo 27**
31. Install the cut black end into the passenger side of the cooler using the quick clip. Measure and cut a section of the provided hose and attach this end to the silver line next to the radiator using the provided non marring hose clamps. **Photo 28**



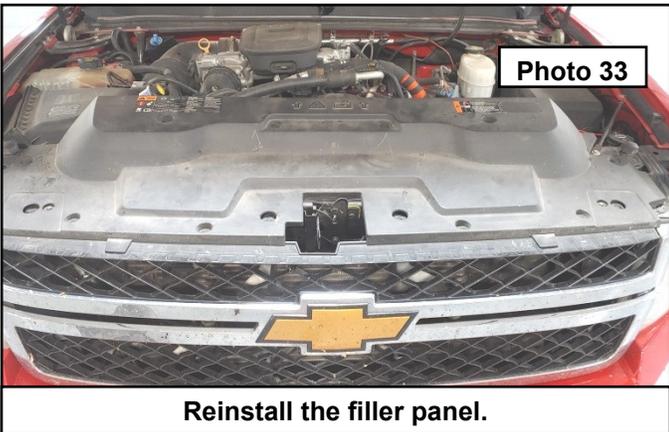
32. Do the same for the silver line to the black line under the radiator. Run the hose long so that extra can hang past the hose clamp. You will use this area to place the Adel clamp in the next step. **Photo 29**
33. Install the provided Adel clamp using the provided 1/4" hardware into the square hole in the support frame. **Photo 30**



34. Reinstall the ambient temp sensor into the hole on the side of the grill frame. Reconnect the hood latch sensor harness. **Photo 31**  
 35. Reinstall the grill. **Photo 32**



36. Reinstall the filler panel. **Photo 33**  
 37. The instructions from here on out will be more of a guide and proper welding, clamping and measurements techniques are on the assembler for the assembly of the bumper.  
 38. Lay out the skin parts. 07-10 model bumpers slightly vary from the pictured 11-14 model. **Photo 34**



39. Lay out the inner bracket parts. **Photo 35**  
 40. Starting with the bumper frame brackets. Locate the pieces required to build these. There is the main mount, the front plate and the brace. **Photo 36**



41. Install the front plate to the main mount using the tab and slot. Make sure this is square to the main mount and tack in place on the inside. **Photo 37**
42. Install the brace by sliding the slot onto the lower plate. This piece will get corner welded to the front plate. **Photo 38**



**Photo 37**

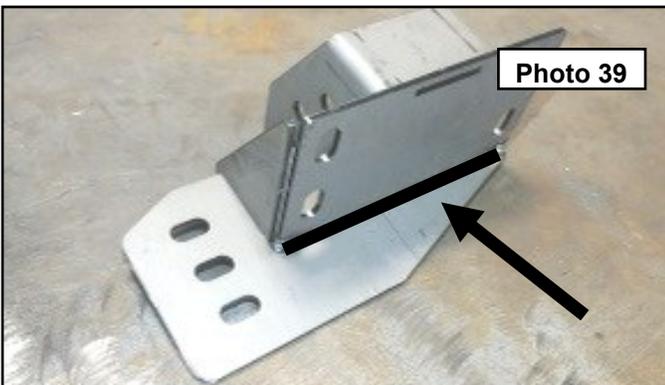
**Install the front plate.**



**Photo 38**

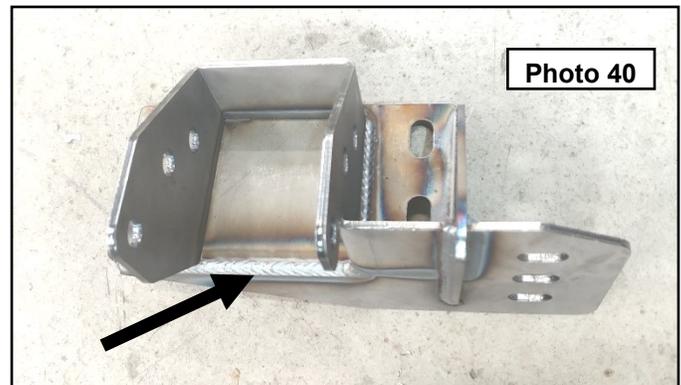
**Install the side brace.**

43. Square this piece to the front plate and tack weld in place as shown. DO NOT weld where the line is shown as this can cause interference with the bumper adjustment. **Photo 39**
44. Once you are satisfied with the fit, fully weld the corner joints as shown. You can weld the front plate bottom edge from the under side of the main bracket. DO NOT weld the front corner shown above. **Photo 40**



**Photo 39**

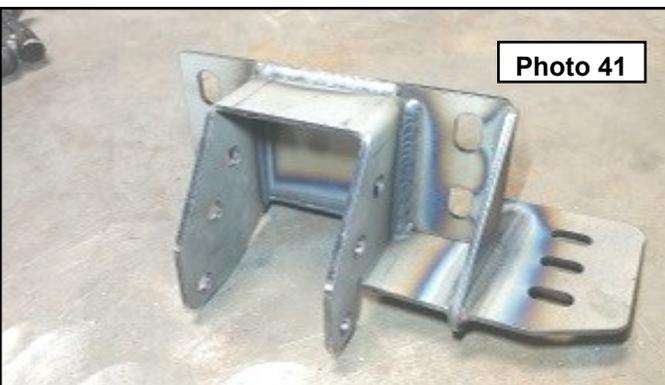
**DO NOT weld here.**



**Photo 40**

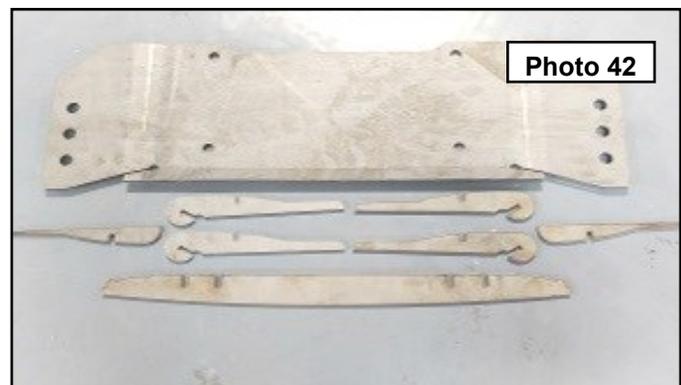
**Weld the front plate here.**

45. Weld the brace on both sides of the main bracket. Repeat for the opposite hand side parts. **Photo 41**
46. Locate the winch tray parts. Even if you are not installing a winch, assemble these parts as they act as a brace for the bumper internals when all is done. **Photo 42**



**Photo 41**

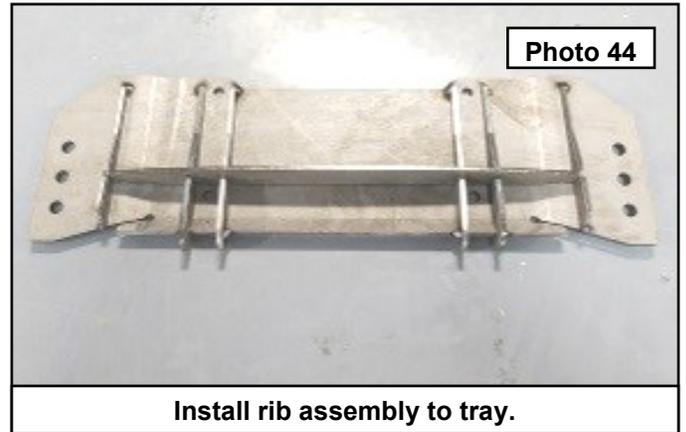
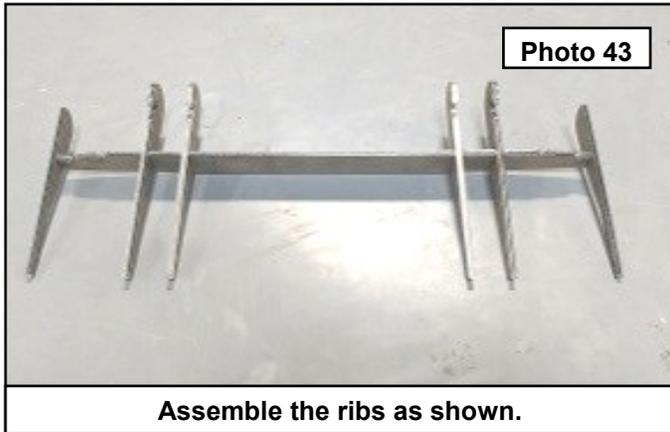
**Weld the corner joints.**



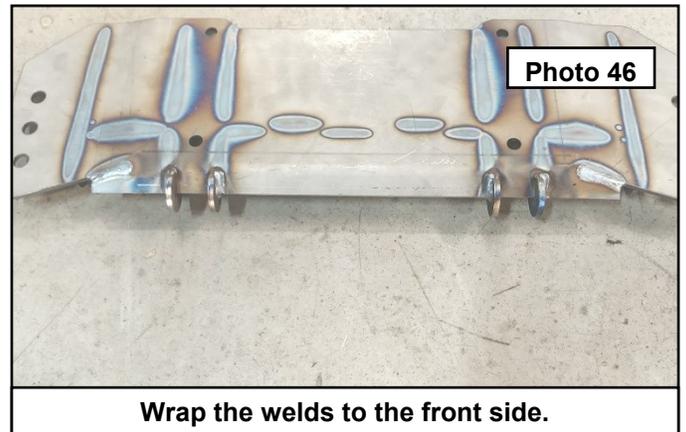
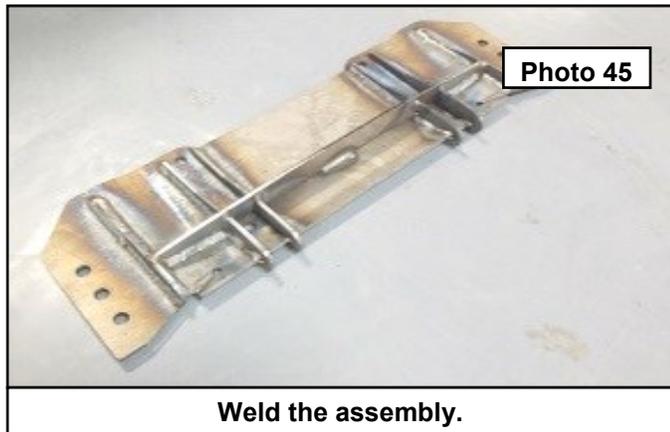
**Photo 42**

**Locate the winch tray parts.**

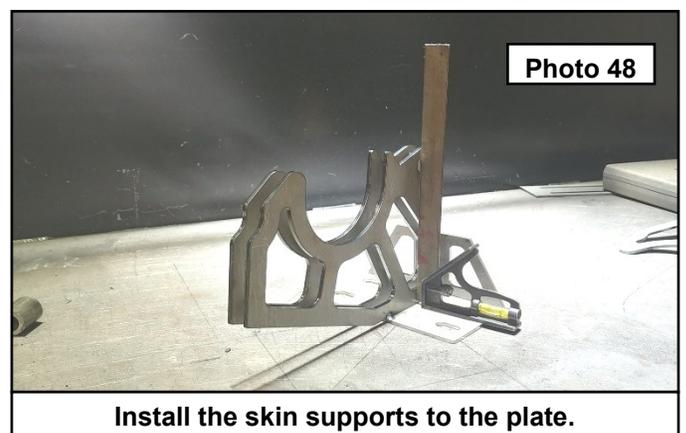
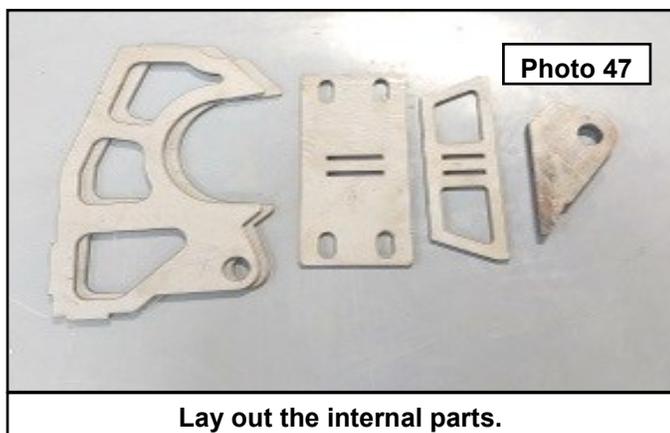
47. Notice the ribs all are slotted. There are internal and external ribs as well as a middle rib. Install the 4 internal and 2 external ribs as shown to the middle rib using the slots. **Photo 43**
48. Turn the winch tray so that the main mounting surface is face down on the table. Slide the rib assembly onto the back edge of the winch tray using the remaining slots in the internal ribs. Adjust the assembly until the ribs are evenly spaced around the winch mounting holes. Once this has been done, square the ribs to the middle rib and tack weld in place. **Photo 44**



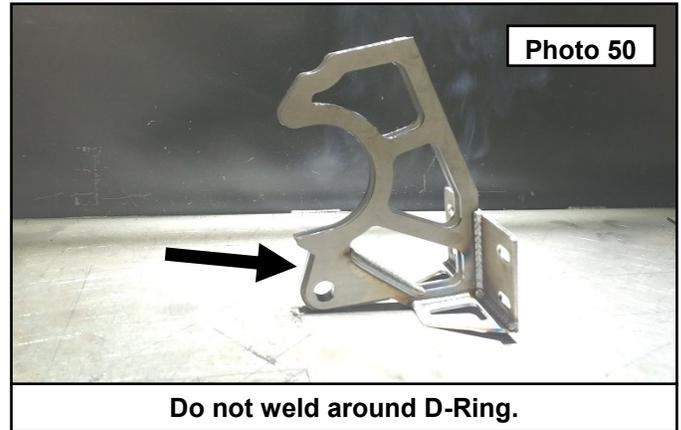
49. Weld the internal ribs to the winch tray on the outside edge away from the mounting holes. Weld the outer ribs along both sides. Stitch weld the middle rib on alternating sides in the middle. **Photo 45**
50. Wrap the welds to the front side of the winch tray around the internal ribs. Weld the corner joints on the tray. **Photo 46**



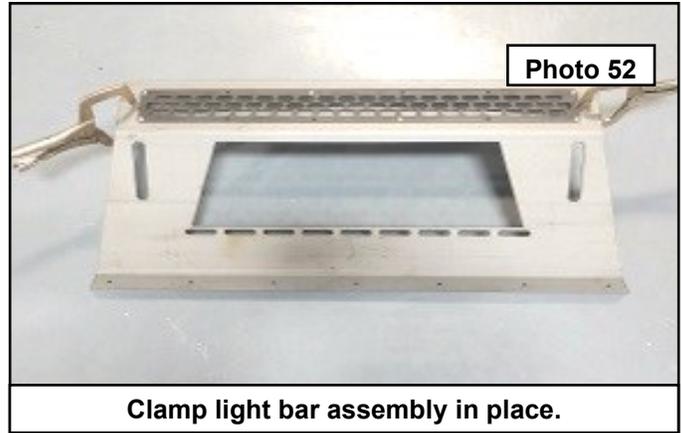
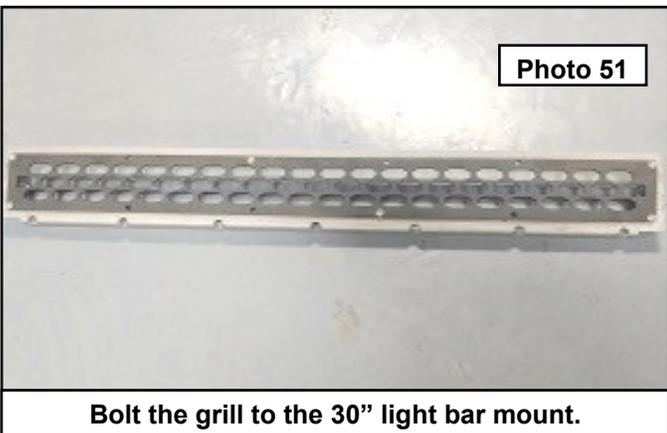
51. Locate the internal skin support, mounting plates, brace plate and D-Ring mount. **Photo 47**
52. Install two of the skin supports into the mounting plate and bottom brace as shown using the tabs and slots. Square the parts together and tack weld in place. **Photo 48**



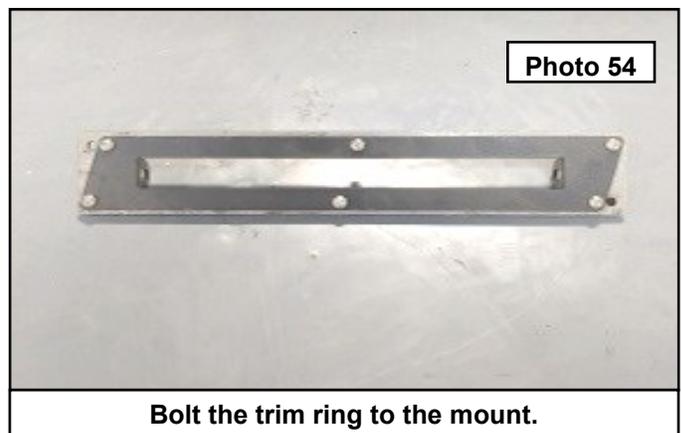
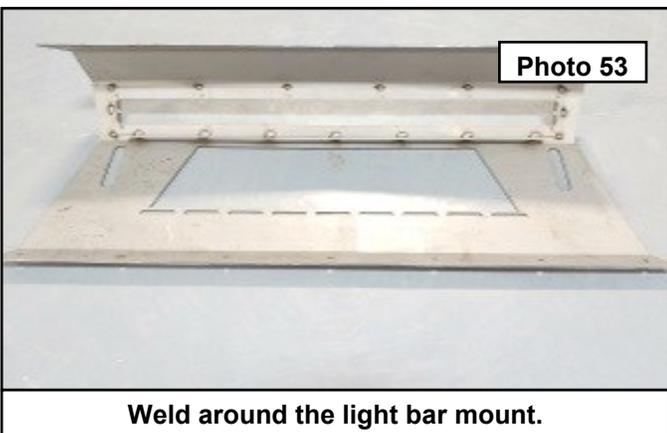
53. Install two of the skin supports into the mounting plate and bottom brace as shown using the tabs and slots. Square the parts together and tack weld in place. **Photo 49**
54. Install the D-Ring mount into the skin supports. Center the mounting hole. Make sure the D-Ring has an even spacing around the outer perimeter of the skin supports. Clamp together. Fully weld the corner joints of the skin support, the bottom brace and the mounting plate. Weld the D-Ring back edge to the skin supports. DO NOT weld around the outside of the D-Ring mount. This will interfere with assembly into the main skin. **Photo 50**



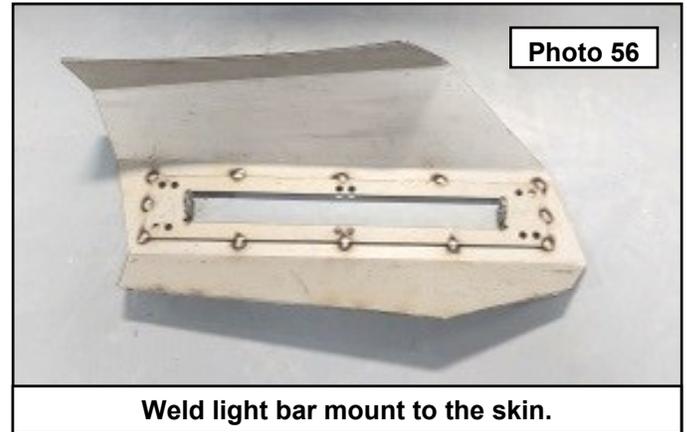
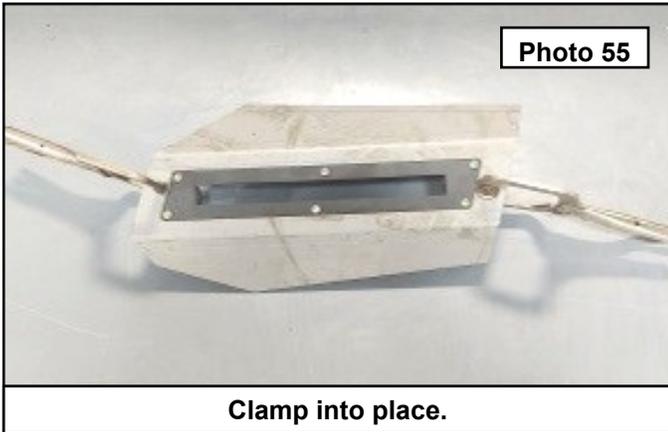
55. Locate the 30" light bar mount, and grill plate. Bolt the grill panel to the light bar mount using the provided 1/4" button head bolts and nuts. **Photo 51**
56. Install the light bar assembly behind the center skin. Center this assembly in the hole and clamp in place. **Photo 52**



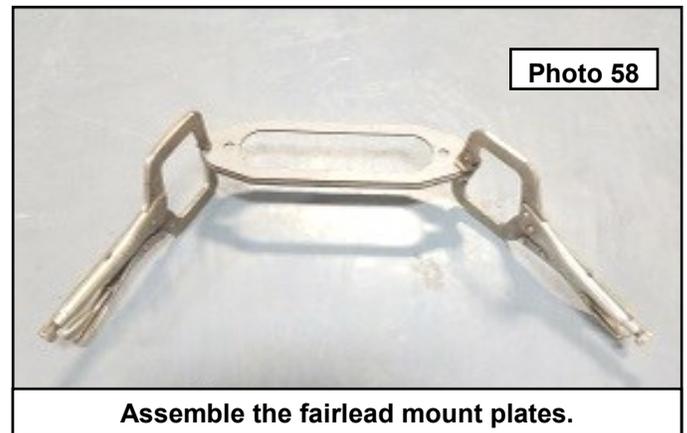
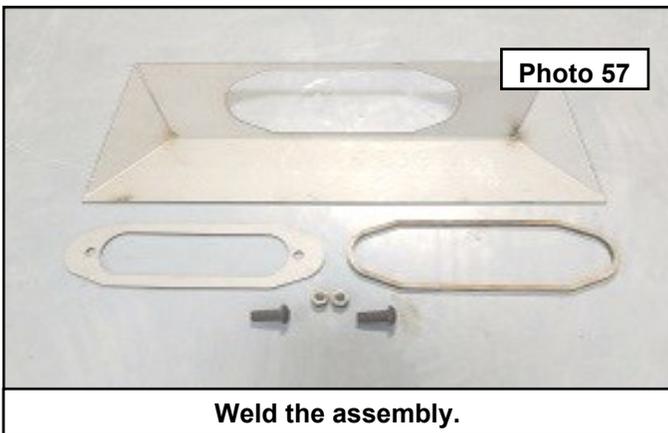
57. Unbolt the grill and set aside. Tack weld around the light bar mount using the bolt hole locations as your guide for the up and sides. Use the openings in the mount to plug weld the bottom edge in place. **Photo 53**
58. Locate the 10" light bar mount and one of the trim rings. Bolt the trim ring to the light bar mount using the provided 1/4" button head bolts and nuts. The light bar mounts are universal for either side but will only use one of the bolt hole patterns. **Photo 54**



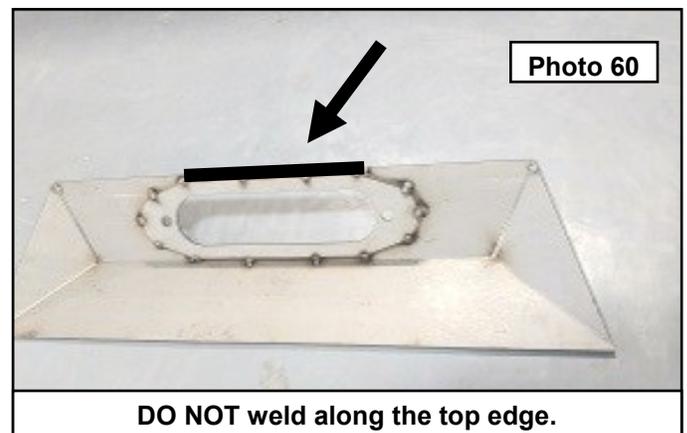
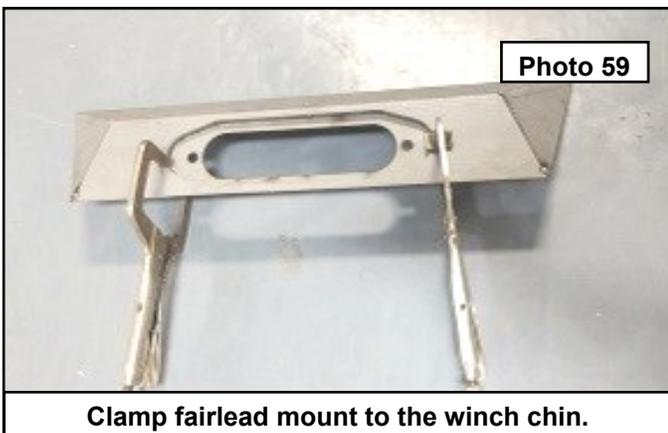
59. Install the light bar assembly behind the wing skin piece. Center this assembly in the hole and clamp in place. Repeat for the opposite side. **Photo 55**
60. Unbolt the trim ring and set aside. Tack weld around the light bar mount as shown. Repeat for the opposite side. **Photo 56**



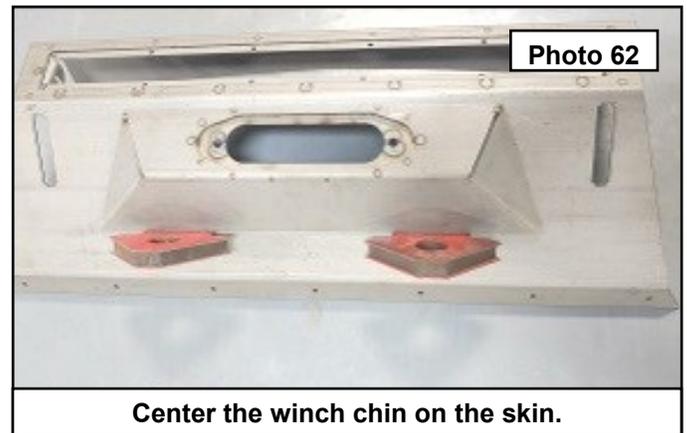
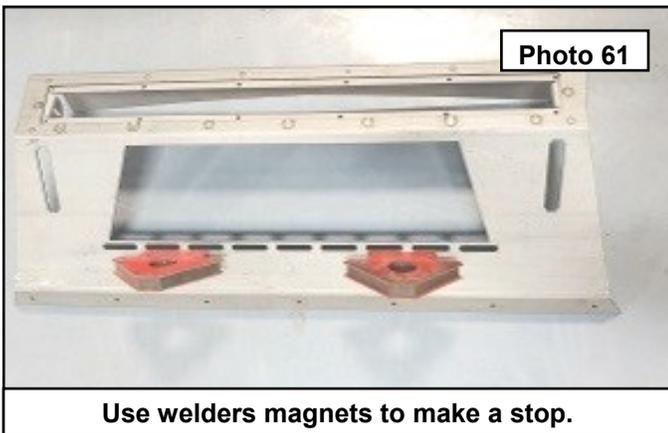
61. Locate the winch chin parts. **Photo 57**
62. Center the fairlead mount plate to the spacer ring. Clamp in place. Tack weld these pieces together around the perimeter of the mount plate. **Photo 58**



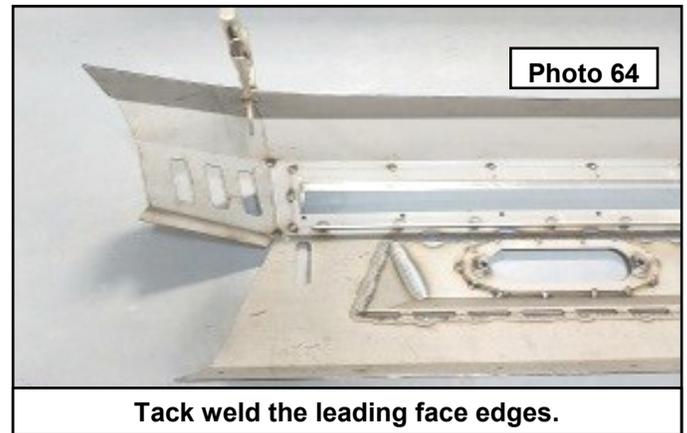
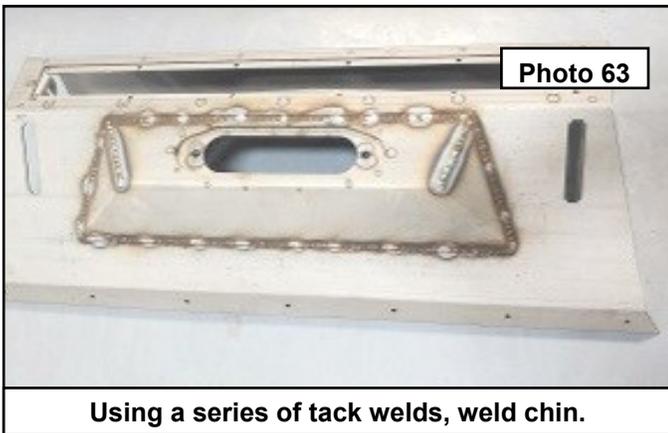
63. Center the fairlead mount assembly behind the winch chin and clamp into place. **Photo 59**
64. Tack weld the fairlead mount assembly to the winch chin around its perimeter. DO NOT weld to the top edge of the chin. This will cause interference with the next step. **Photo 60**



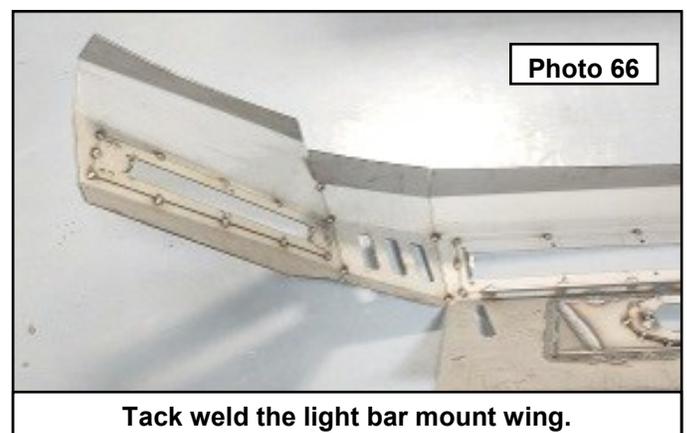
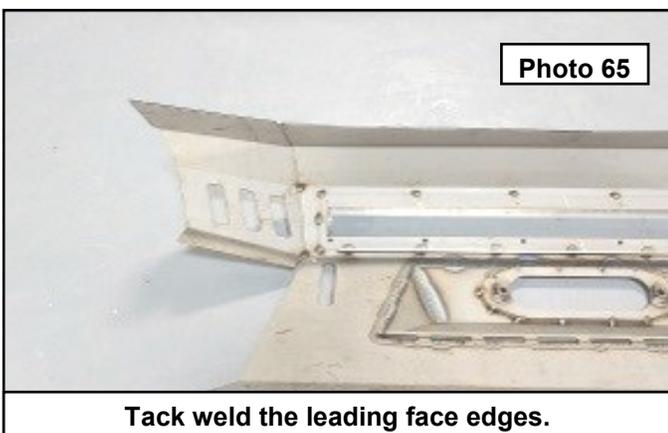
65. Use a pair of welders magnets or clamp a straight edge under the drain hole cut outs in the center skin. **Photo 61**
66. Lay the winch chin onto the center skin. Use the magnets or straight edge to line up the chin with the bottom edge of the drain holes. Center the winch chin. You will see the lower corners of the winch chin will line up with the outer edges of the first and last drain hole. **Photo 62**



67. Tack weld around the perimeter of the winch chin. You will want to weld this piece in place using a series of tack welds to avoid warping the center skin. Tack, skip a few inches, tack, and let cool down. It is a slow process, but taking time now insures little to no warping of the center skin. **Photo 63**
68. You will repeat the wing installation process for both sides. Only one side will be shown. Locate the slotted wing piece. Line up the leading face and bend lines. Do not worry about the top or bottom at this time. Tack weld the wing in place at the leading faces bend lines leaving a small gap between the parts so that you can bury the weld later for clean up sanding. **Photo 64**

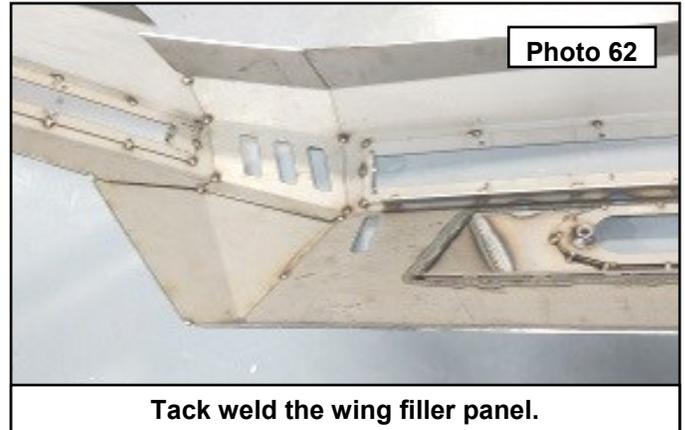
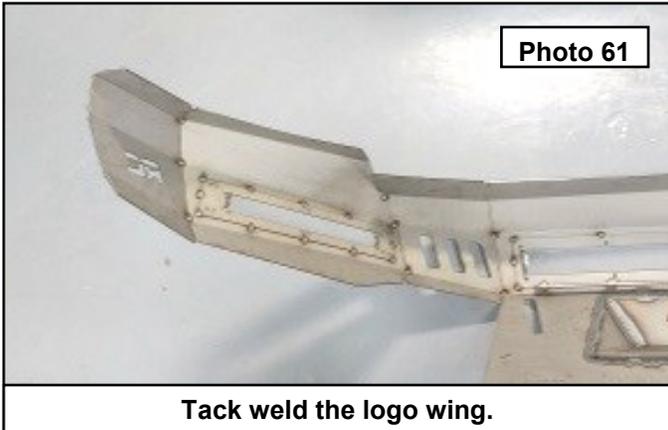


69. Adjust the wing as necessary and clamp the top edge. Once you are satisfied with the fit, finish tack welding the wing in place. **Photo 65**
70. Repeat the process for the slotted wing piece with the light bar wing piece. Again rely on getting the main face edge lined up first and then adjust the rest of the face / edges. You will see that the very top edge doesn't line up with the top edge of the others. This is a recess for the grill in the vehicle. There is a filler panel that will be installed in a later step. **Photo 66**



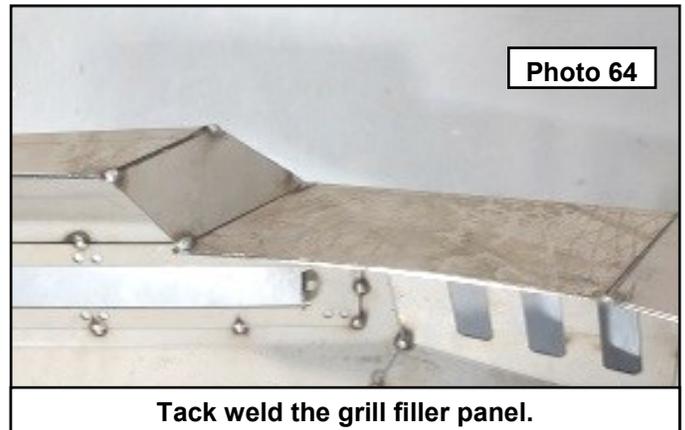
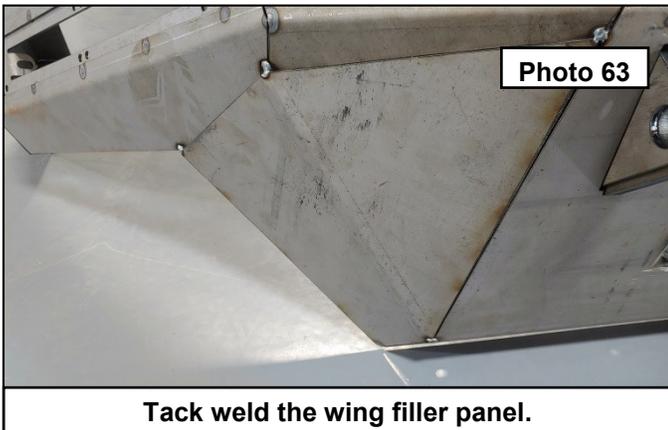
71. Continue the process for the end wing with the RC logo. **Photo 61**

72. When getting ready to install the lower wing filler panel. Make sure the bumper has turned out square. You will be able to twist the wings up or down before this piece is fully tacked in. Line up the bottom wing filler with the main center skin. Again leaving a small gap for welding. The filler panel will go in front of the wing skins, leaving a bent edge from these pieces floating off the filler. This was done intentionally for adjusting and looks from the front of the bumper. **Photo 62**



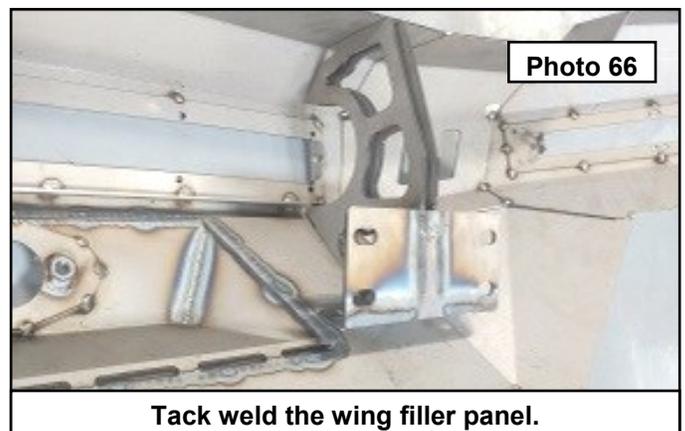
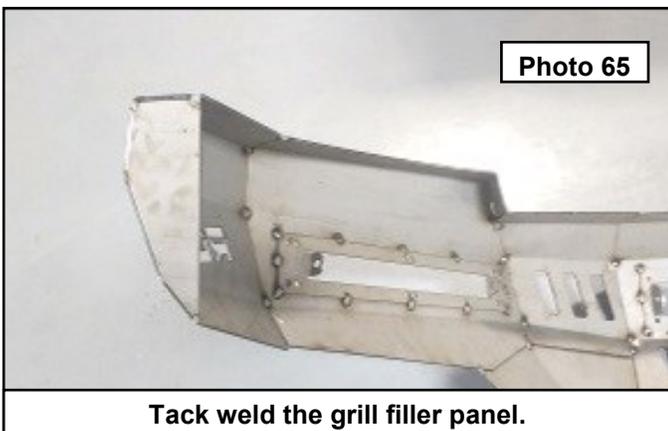
73. Once you are satisfied with the fitment, tack weld the filler panel to the slotted and light bar wing pieces. **Photo 63**

74. Locate the grill filler panel. Line this up with the leading edges on the light bar wing. It will sit at an angle over the top of the slotted wing piece. This is intentional and will not be welded corner to corner on the slotted wing. You may need to bend or pry the light bar wing top edge to line up properly. **Photo 64**

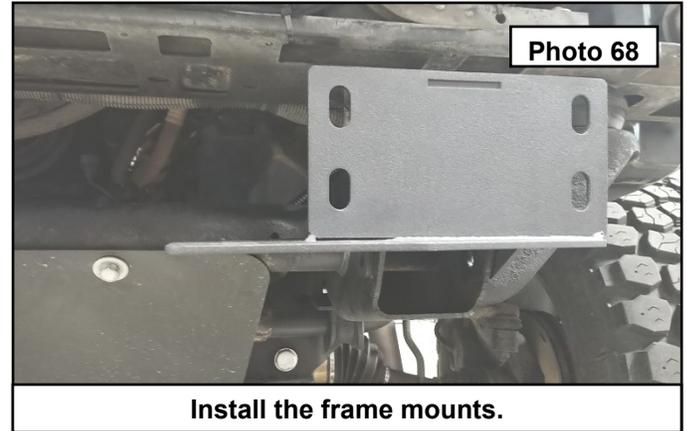


75. Locate the wing filler panels. Line up with the edges and tack weld in place. **Photo 65**

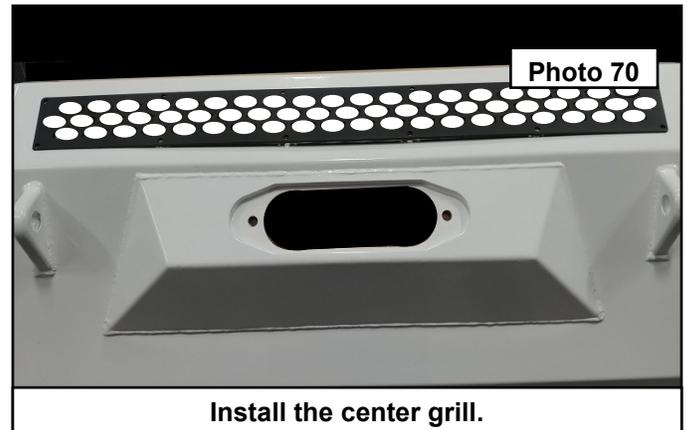
76. Install the previously assembled skin support / bumper mounts into the center skin using the holes for the D-Ring mounts. Make sure that the faces are touching the skin supports and that the mounts are square to the bumper. Tack weld into place. **Photo 66**



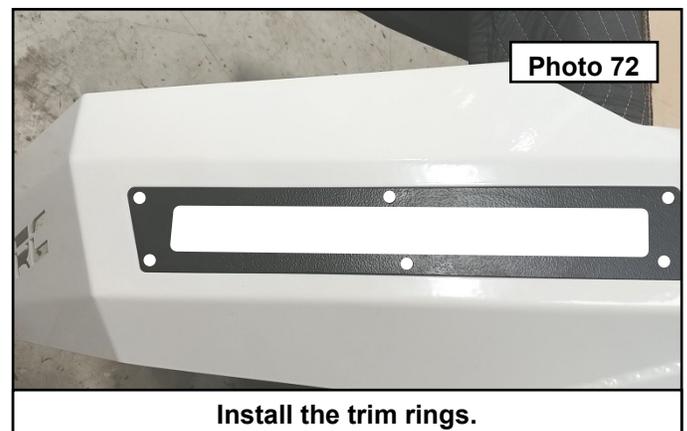
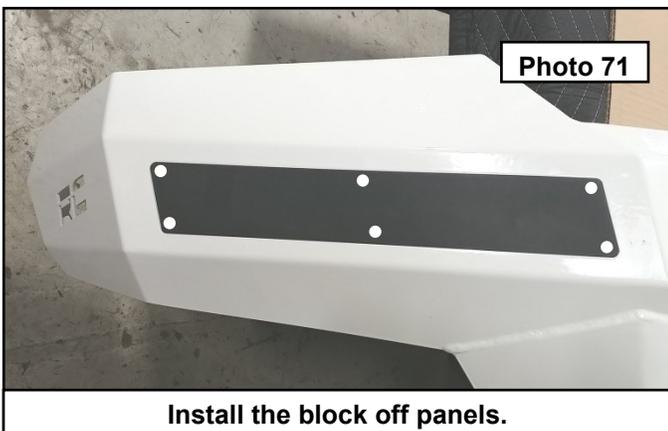
77. Now with the bumper tacked altogether, you will want to test fit the bumper onto the vehicle to insure everything is lining up the way it should. This is the time to adjust any issues before fully welding. **Photo 67**
78. Install the frame mounts to the frame using the factory hardware. DO NOT fully tighten. **Photo 68**



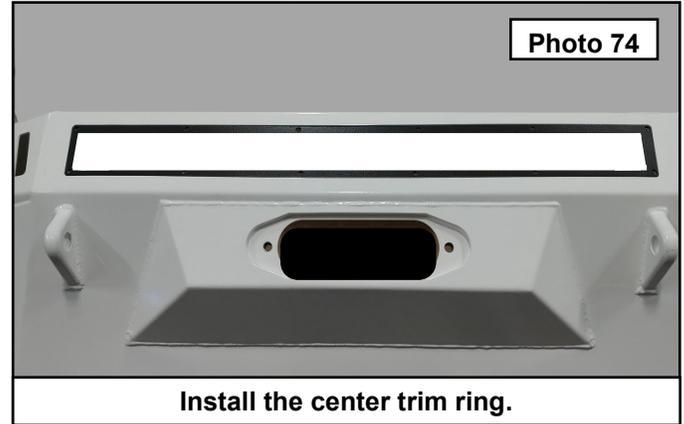
79. Install the bumper to the frame mounts using the provided 12mm bolts, washers, and nuts. Adjust until the gaps are satisfactory. Make sure the wings are level and gaps are even. If you need to adjust, break a tack weld and set the piece where you need it and tack weld again. **Photo 69**
80. Once you are satisfied with the fitment, remove the bumper and fully weld all the joints. Sand the bumper smooth and have coated in your choice of powder coat, paint, bed liner, etc.
81. If you did not purchase any lights to go into the bumper, you have block off panels and a grill to fill the holes. Install the center grill using the provided 1/4" stainless bolts. You have a choice of black or silver bolts for accents. **Photo 70**



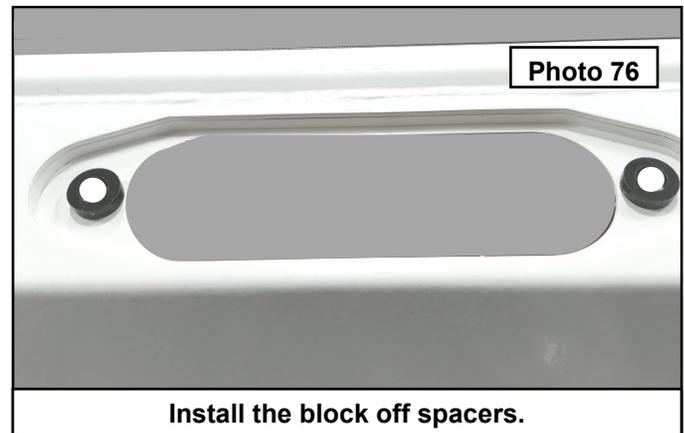
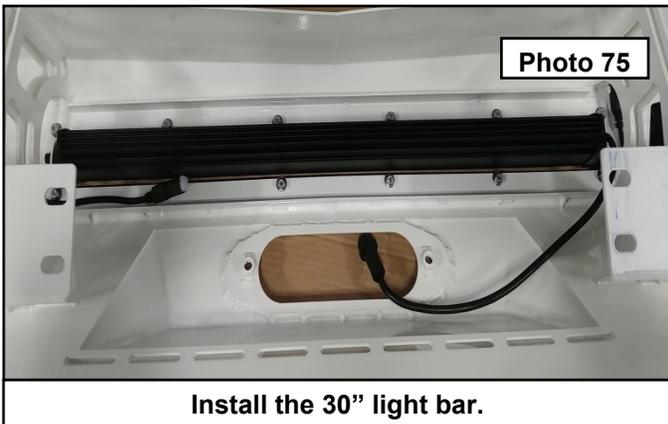
82. The side light openings will get the light block off panel. Install using your choice of the 1/4" stainless hardware. **Photo 71**
83. If you have purchased any of the lighting options, install using the provided hardware with the light kit. Some lights will require using the provided spacers as well. For the outside lights, install the trim rings using the 1/4" hardware. **Photo 72**



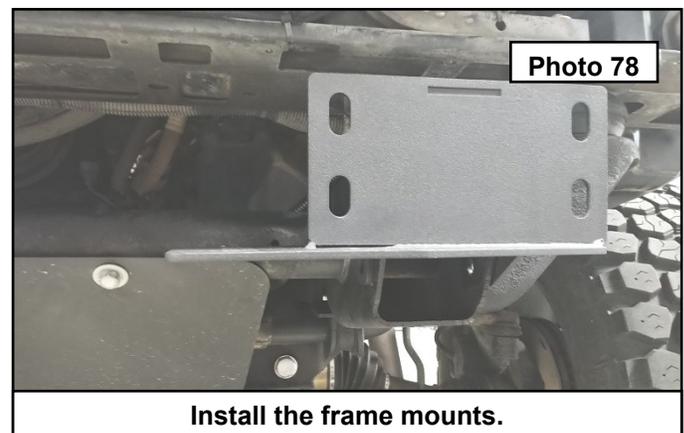
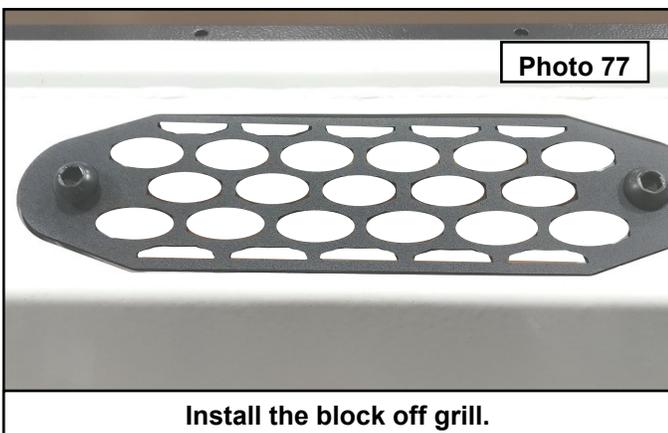
84. Install the 10" side lights using the hardware from the light kit. **Photo 73**
85. Install the center trim ring using the stainless 1/4" hardware. Though if you like, you can run the center light bar and the grill in front of it. **Photo 74**



86. Install the 30" light bar using the hardware from the light kit. This one may require the spacers in the box depending on the light you purchased. **Photo 75**
87. If you are not installing a winch, install the provided block off grill spacers. **Photo 74**

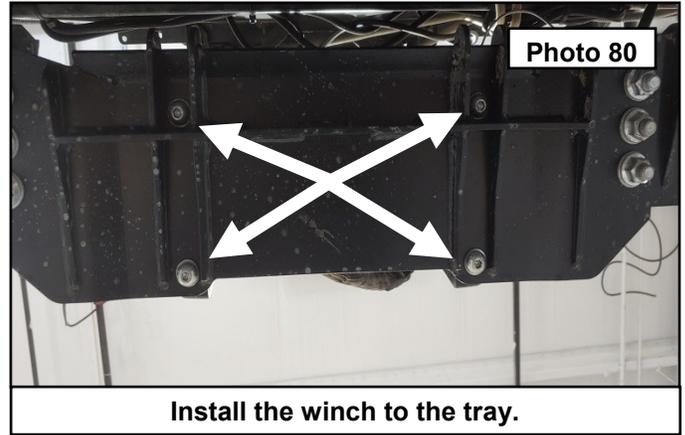
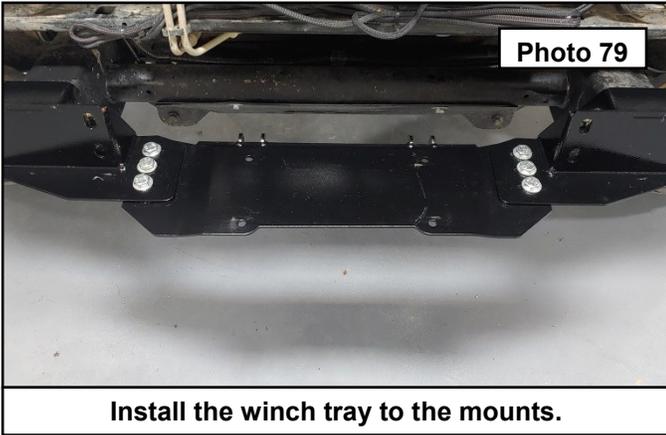


88. Install the block off grill using the provided 12mm button head bolts. Center the grill and then tighten the bolts. **Photo 75**
89. Install the bumper mounts to the frame using the stock hardware. The lower hole is for the stock tow hook bolt. **Photo 78**



90. Install the winch tray to the bottom of the frame mounts using the provided 12mm hardware. **Photo 79**

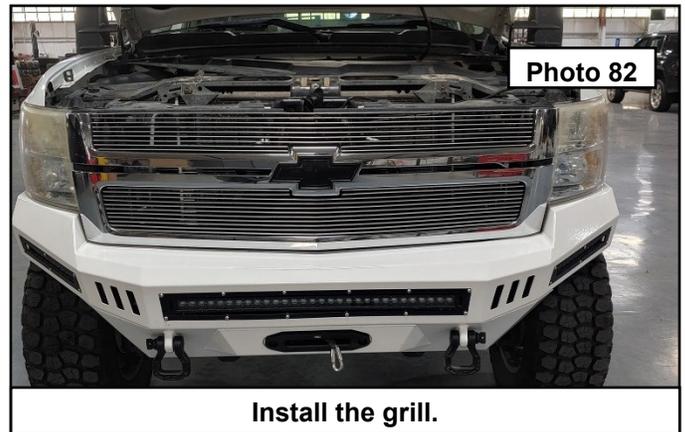
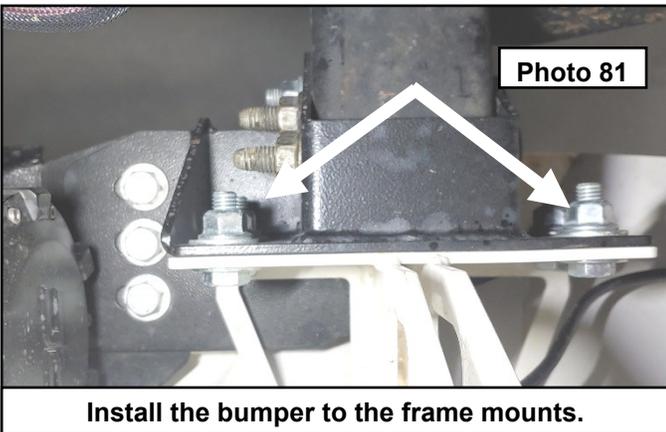
91. Install the winch to the tray using the provided 10mm button head bolts from the bumper kit, the flat washers, lock wash-



ers, and square nuts from the winch kit. **Photo 80**

92. Install the bumper to the frame mounts using the provided 12mm hardware from the bumper kit while fishing the winch cable through the hole if installed. Adjust until centered and level with a 1/2" gap between the headlights. Torque to 95 ft-lbs. **Photo 81**

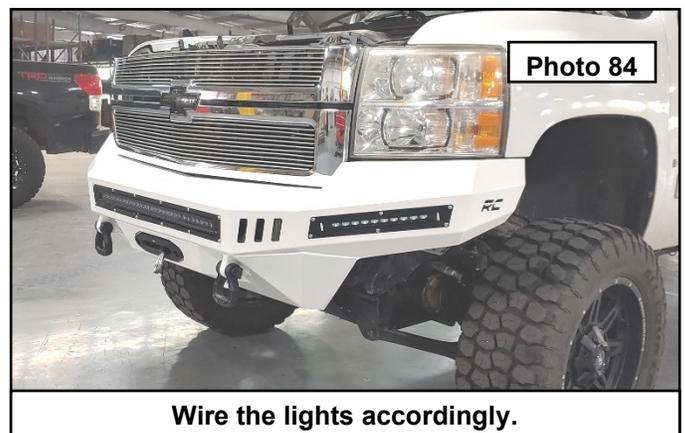
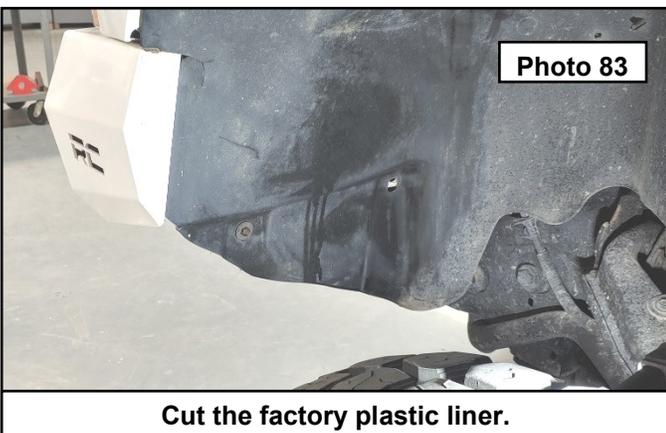
93. Install the Hawes fairlead provided with the winch using the button head bolts from the bumper kit.



94. Install the grill using the factory clips and hardware. Do not overtighten the bolts. The grill can crack easily. **Photo 82**

95. Trim the plastic wheel liner using a suitable cutting tool. Tuck the liner behind the bumper ends for a clean look. **Photo 83**

96. Wire the lights and winch accordingly if installed. **Photo 84**





If you have purchased the optional skid plate, install using the hardware and instructions included with the kit. Step back and enjoy all of your hard work.



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