



**INSTALLATION INSTRUCTIONS
KORE TACTICAL SERIES
BUMPER
2009-2013 Ram 1500 (DS) 4WD
PART NUMBER KTS0063**

INTRODUCTION

Installation requires a professional mechanic. Prior to beginning, inspect the vehicle's steering, driveline, and brake systems, paying close attention to the suspension link arms and bushings, stabilizer bars and bushings, tie rod ends, steering rack, ball joints and wheel bearings. Also check the steering and suspension-to-frame attaching points for stress cracks. The overall vehicle must be in excellent working condition; repair or replace all worn parts.

Read instructions several times before starting. Be sure you have all the needed parts and know where to install them. Read each step completely as you go.

NOTES:

- **Prior to beginning the installation, check all parts and hardware in the box with the parts listed on the next page. If you find a packaging error, contact KORE directly. Do not contact the dealer where the system was originally purchased. You will need the part number when calling: KTS0063.**
- Prior to attaching components, be sure all mating surfaces are free of grit, grease, excessive undercoating etc.
- A factory service manual should be on hand for reference.
- Use the check-off "found at each step to help you keep your place.



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Description **Number** **Part Number**

PARTS LIST. Identify and check off each part before beginning installation.

KTS0063

<input type="checkbox"/> Front Bumper	1	94-8197
<input type="checkbox"/> Bumper Mount Bracket, Passenger Side	1	96-7481
<input type="checkbox"/> Bumper Mount Bracket, Driver Side	1	96-7482
<input type="checkbox"/> Bumper Shim	6	97-7560
<input type="checkbox"/> Nut Plate, Lower Frame Crossmember	1	90-7561
<input type="checkbox"/> Skid Plate, Upper	1	94-7563
<input type="checkbox"/> Skid Plate, Lower	1	94-7564
<input type="checkbox"/> Spacer, Frame Horn	4	90-8222
<input type="checkbox"/> Hardware Pack, Bumper and Skid Plates	1	90-6851
<input type="checkbox"/> 3/8"-16 X 1" Hex Bolt Gr. 8	16	37C100HCS8Y
<input type="checkbox"/> 3/8"-16 Nylock Nut	16	37CNNE5Z
<input type="checkbox"/> 3/8" Hardened Flat Washer	34	37NWHDY/SAE
<input type="checkbox"/> 3/8"-16 X 1 1/4" Hex Bolt Gr. 8	6	37C125HCS8Y
<input type="checkbox"/> 3/8" USS Hardened Flat Washer	4	37NWHDY/USS
<input type="checkbox"/> 1/2"-13 X 2" Hex Bolt Gr. 8	2	50C175HCS8Y
<input type="checkbox"/> 1/2"-13 X 4 1/4" Hex Bolt Gr. 8	4	50C400HCS8Y
<input type="checkbox"/> 1/2"-13 Stover Nut Gr. C	6	50CNUCZ
<input type="checkbox"/> 1/2"-13 SAE Hardened Flat Washer	12	50NWHDY/SAE

Optional Equipment Available from your Distributor!
Baja Designs Stealth 20" LED Light Bar: Part # 62-0272

Baja Designs Fuego HID Wide Driving: Part # 61-3281

Baja Designs, Inc
www.bajadesigns.com
800-422-5292

FRONT BUMPER INSTALLATION

- Open the hood and disconnect the negative cable from the battery.
- Remove the black plastic cover over the radiator.
- Unbolt and remove the grill and body filler panel, under headlights. Save the **OE** hardware for reinstallation.
- Remove the front bumper from the vehicle. (Image 1)



Image 1

- Using a razor knife, carefully remove and cut the front wind skirt below the transmission cooler. (Image 2)

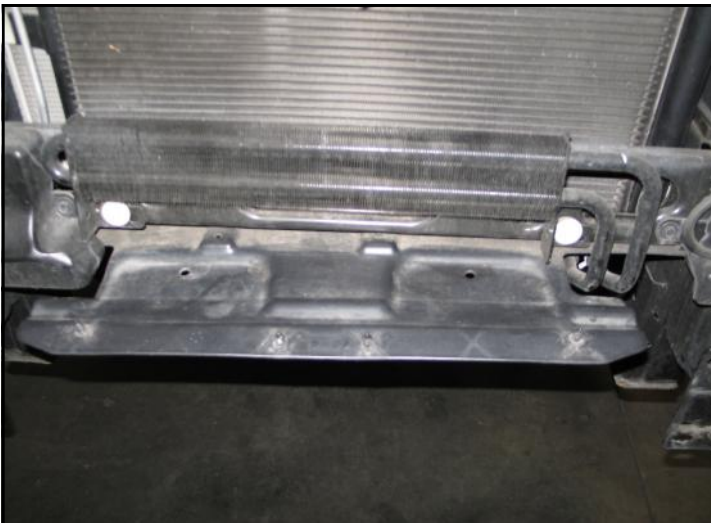


Image 2

- Mark the **OE** bumper mount flange on the frame where it is welded. (Image 3)

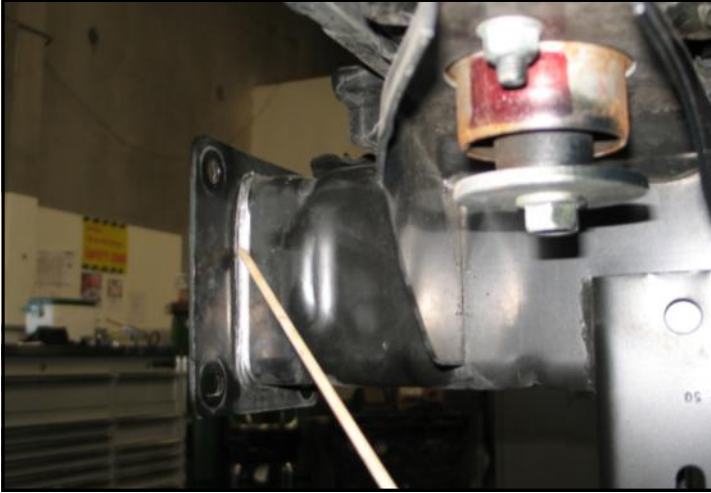


Image 3

- Using a cut-off wheel, plasma cutter, Sawzall or another suitable cutting tool, cut off the **OE** bumper mount flange. (Image 4)



Image 4

- Test fit new frame mount bracket (96-7482 Drvr and 96-7481 Pass) in place. Center the window in the frame mount bracket over the bump in the frame. (Image 5) Once the bracket is in the proper position clamp it in place using a C-clamp. **IMPORTANT!: Be sure the frame mount bracket is properly located over the bump in the frame and the bracket sits flush against the top and sides of the frame.**



Image 5

- Mark and center punch the (2) holes in the frame mount bracket (96-7482 Drvr and 96-7481 Pass) for drilling. Mark the outer perimeter of the frame mount bracket, on the frame, where the paint will need to be removed prior to welding. (Image 6)



Image 6

- First, unclamp the frame mount bracket and drill the previously marked holes, through both the inner and outer frame rails using a $17/32$ " drill bit. (Image 7) Second, drill out the hole in the outer frame rail ***ONLY*** to $7/8$ ". ***IMPORTANT!: It is imperative that the holes be drilled straight through or the crush sleeve will fit properly into place.***



Image 7

- Prep the previously marked and trimmed areas for welding by cleaning and removing any paint. (Image 56)
- Insert the (2 per side) frame horn spacers (90-8222) into the frame and install the frame mount bracket (96-7482 Drvr and 96-7481 Pass) using the (2) provided $1/2$ " X $4 1/4$ " bolts and hardware. (Image 8) ***IMPORTANT!: Be sure the frame mount bracket is properly located over the bump in the frame and the bracket sits flush against the top and sides of the frame.***



Image 8

- On both sides, tack weld the frame mount bracket (**96-7482 Drvr and 96-7481 Pass**) to the frame. Weld inside the window and around the perimeter of the new frame mount bracket by alternating welding areas to avoid warping the metal. (Image 9) Remove the **1/2"** bolts and hardware from the frame mount brackets.

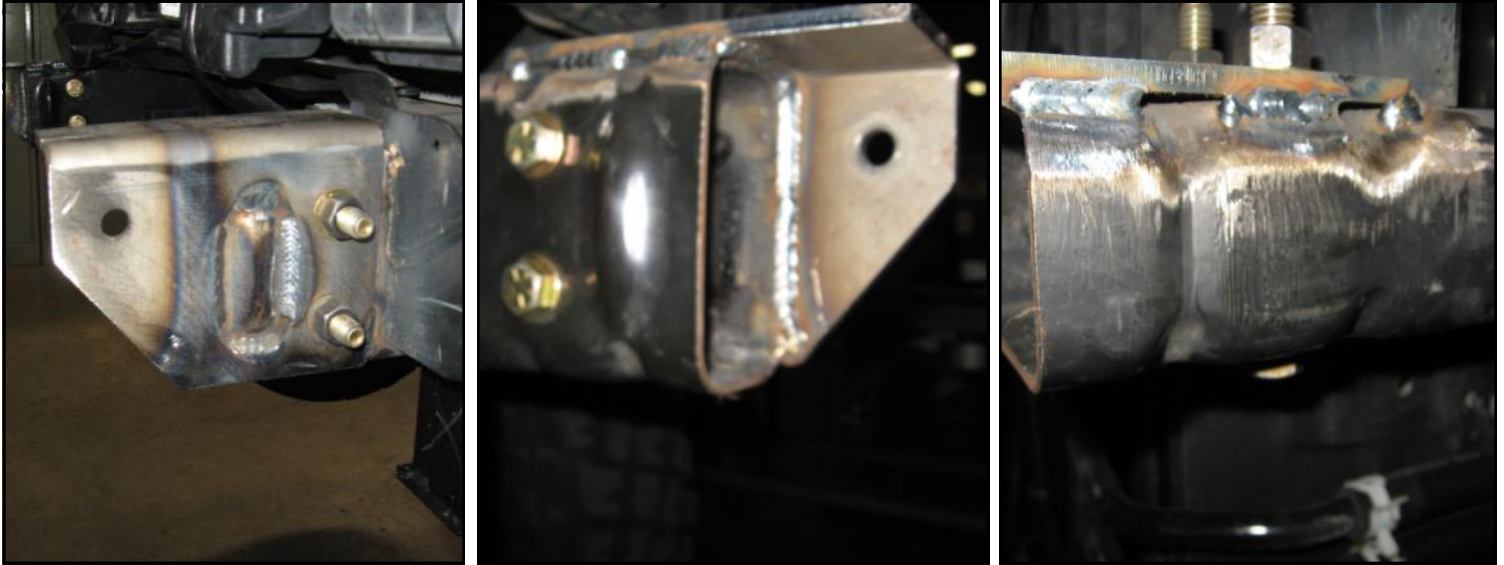


Image 9

- Measure the distance from the outside of the frame rail bracket on the driver side to the outside of the frame rail bracket on the passenger side. Record the measurement. _____
- Measure the distance between the inside of the mounts on the new front bumper (**94-8197**). Record measurement. _____
- Reinstall the **OE** grill and body filler panel, under headlights, using the previously removed **OE** hardware. Using a piece of masking tape, find and mark the center of the grill.
- Find and mark the center between the frame rails mounts.
- Using the previous measurements as a guide, install the provided shims (**97-7650**) as necessary, in order to align the center marks of the frame rails and the grill. (Image 10)

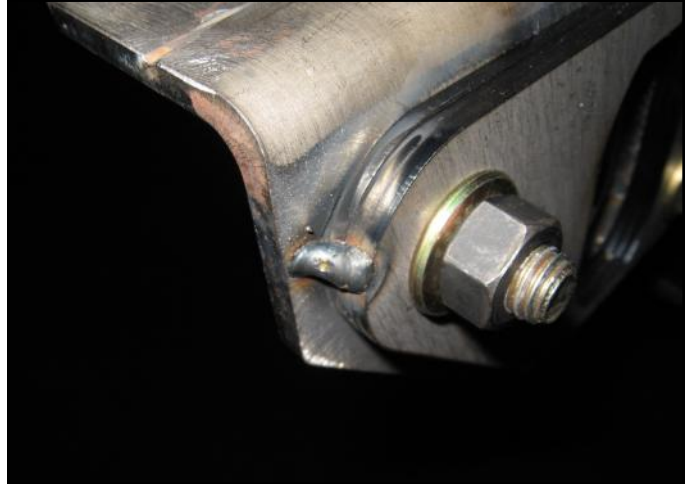


Image 10

- Once the proper shim configuration has been determined, bolt the shims in place using the provided $1/2'' \times 4 1/4''$, $1/2'' \times 2''$ bolts and hardware. Tack weld the shims (**97-7560**) in place on the frame using at least (3) good tack welds. Be sure to only tack around the edges so the shim will sit flat on the frame. (Image 10) **NOTE: Be sure not to over-shim the frame because it will make it hard to install the front bumper.**

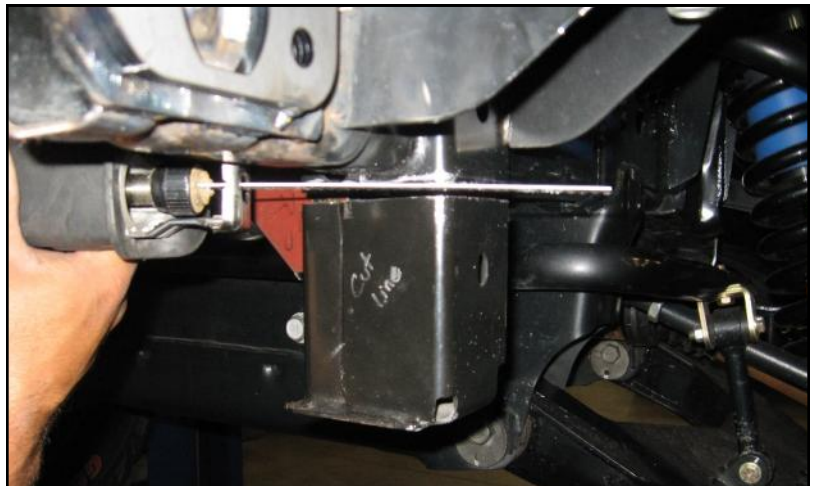
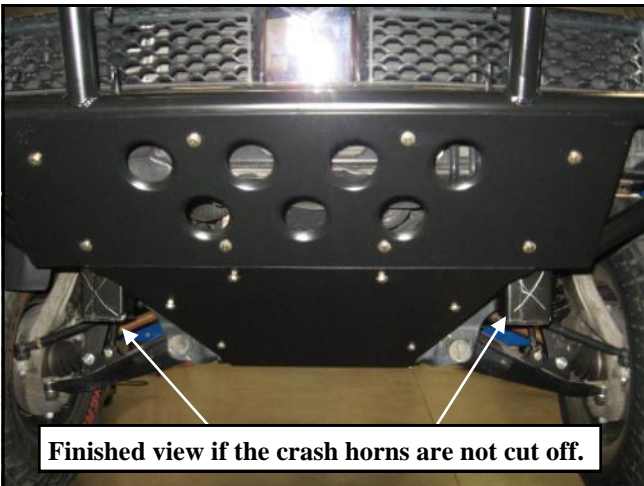


Image 11

- The crash horns may be cut off and removed from the vehicle at this time if so desired. (Image 11)

- Carefully, test fit the front bumper (**94-8197**) to verify proper shim (**97-7560**) configuration. (Image 13) **NOTE: If the bumper is not aligned properly, reconfigure the shims as needed to achieve proper alignment. Repeat this process until the bumper fits correctly.**

- Once the welds have cooled, sand, prime and paint the welded areas with a quality paint. (Image 12)



Image 12

- Carefully raise the front bumper (94-8197) into place and secure to the frame mount bracket (96-7482 Drvr and 96-7481 Pass) using the provided 1/2" X 4 1/4", 1/2" X 2" bolts and hardware. (Image 13) **NOTE: The 2" long bolts go in the forward most hole. Do Not torque hardware at this time.**

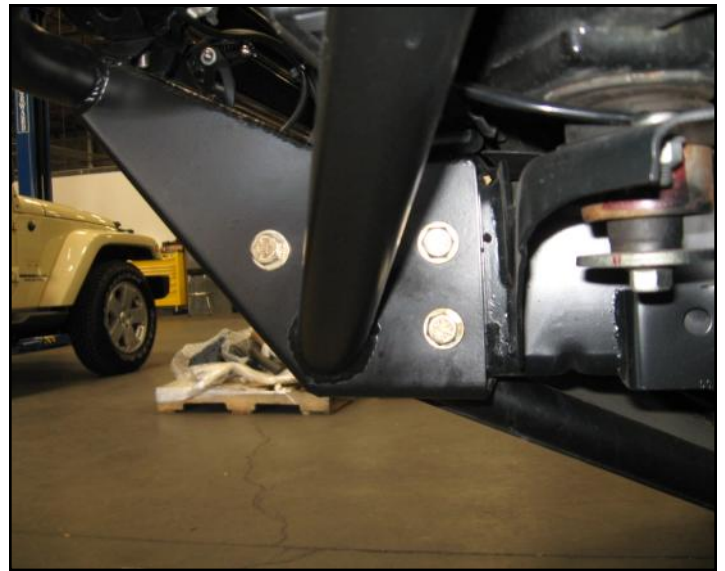


Image 13

- Using a floor jack, raise the lower lip of the front bumper (94-8197) to contact the lower frame crossmember. Using the front bumper as a guide, mark and center punch the (2) the front holes in the lower frame crossmember for drilling. Drill the (2) holes out using a 3/8" drill bit. Secure using the (2) supplied 3/8" X 1 1/4" bolts and hardware. (Image 14) Torque the 3/8" bolts and hardware to 30 ft./lbs.



Image 14

- Install the lower skid plate using the (8) supplied 3/8" X 1" bolts and hardware. (Image 15) Leave bolts hand tight only at this time.

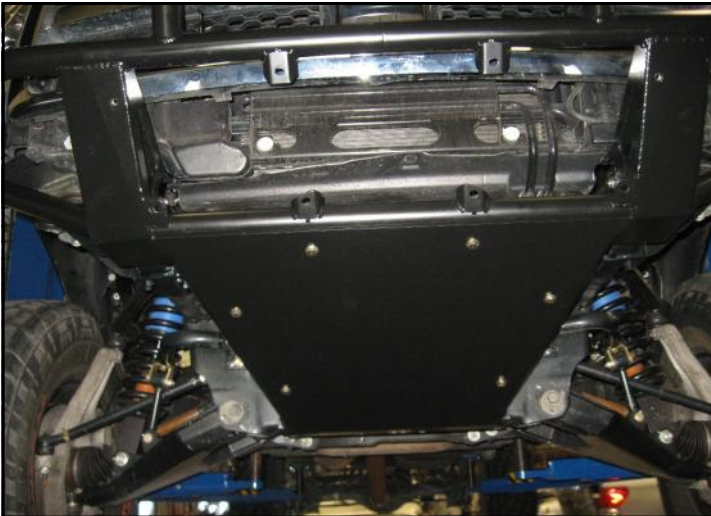


Image 15

- Install the upper skid plate using the (8) supplied 3/8" X 1" bolts and hardware. (Image 15) Align the outer edges of the upper and lower skid plates. Once they are in alignment, Torque the 3/8" mounting hardware to 30 ft./lbs. . **NOTE: All gaps should be even after tightening the hardware.**

- Torque the (3 per side) 1/2" bumper to frame mounting bolts and hardware to 65 ft./lbs.



Image 16

- Using the bottom of the front bumper (94-8197) as a guide, mark and center punch the (1) non-existing lower frame crossmember inner hole in the frame for drilling. Drill the previously marked hole out to 25/64". Drill out the other existing inner hole to 25/64". (Image 17) **NOTE: The (2) outer lower crossmember holes are existing and do not require modification.**



Image 17

- Attach the bottom of the bumper (94-8197) to the lower frame crossmember by inserting the nut plate (90-7561), with the nuts up and the extra hole facing the driver side, into the lower frame crossmember. Secure the (4) supplied 3/8" X 1 1/4" bolts and USS washers into the nut plate (90-7561). (Image 18) Torque the 3/8" bolts and hardware to 30 ft./lbs.



Image 18

- Reinstall the negative cable to the battery.
- If installing the Baja Designs Inc. lights, purchased separately, do so at this time following the manufacturers instructions.
Baja Designs Stealth 20" LED Light Bar: Part # 62-0272
and/or Baja Designs Fuego HID Wide Driving: Part # 61-3281
- Installation is now complete.

Important Maintenance Information

It is the ultimate buyer's responsibility to have all bolts / nuts checked for tightness after the first 100 miles and then every 1000 miles. The steering, suspension and driveline systems, plus wheel alignment should be inspected by a qualified professional mechanic at least every 3000 miles.



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KORE INC. USA LIMITED WARRANTY

KORE INC. warrants the listed products for the listed time period. This warranty does not apply to products which have been improperly applied or installed. The consumer will be responsible for removing from the vehicle and returning any items, shipping prepaid, and for the reinstallation of the part upon return. A copy of the sales receipt is required. KORE INC. will repair or replace at its option, defective products or components. Exclusions from this warranty are the finish, any condition(s) caused by abnormal use or service, and product-specific limitations, if any, listed below.

The loss of use of the product, loss of time, inconvenience, commercial loss or consequential damages are not covered. KORE INC. reserves the right to change the design of any product without assuming any obligation to modify any product already manufactured. This warranty gives you specific legal rights and you may also have other rights which may vary from state to state. There are no warranties, expressed or implied including any implied warranties of merchantability and fitness, which extend beyond this warranty period. There are no warranties that extend beyond the face hereof. Seller disclaims implied warranty of merchantability. This warranty shall not apply to any product sold by KORE INC. which has been modified, customized or improperly installed.

No warranty applies to any part that is designed to be sacrificial and periodically replaced. Examples of these parts are spherical bearings found in shock absorbers, rubber bushings found in control arms, and rod ends found in end links. KORE parts are the finest quality possible. But these are high-performance, race-derived parts and therefore have limited life spans that are, like brake pads and clutch surfaces, dependent upon use and environmental conditions.

LIMITED ONE YEAR WARRANTY ON PARTS MANUFACTURED BY KORE INC.

KORE INC. warrants any part it manufactures against defects in material and workmanship (except for finish or other cosmetic problems) for one year from the date of purchase.

RIGHTS RESERVED

KORE INC. reserves the right to make changes in design, material and specification or to make product changes as deemed necessary without prior notice. Obligations or liabilities will not be assumed with respect to similar products previously advertised.

**KORE TECH LINE
(760) 855-1219**