

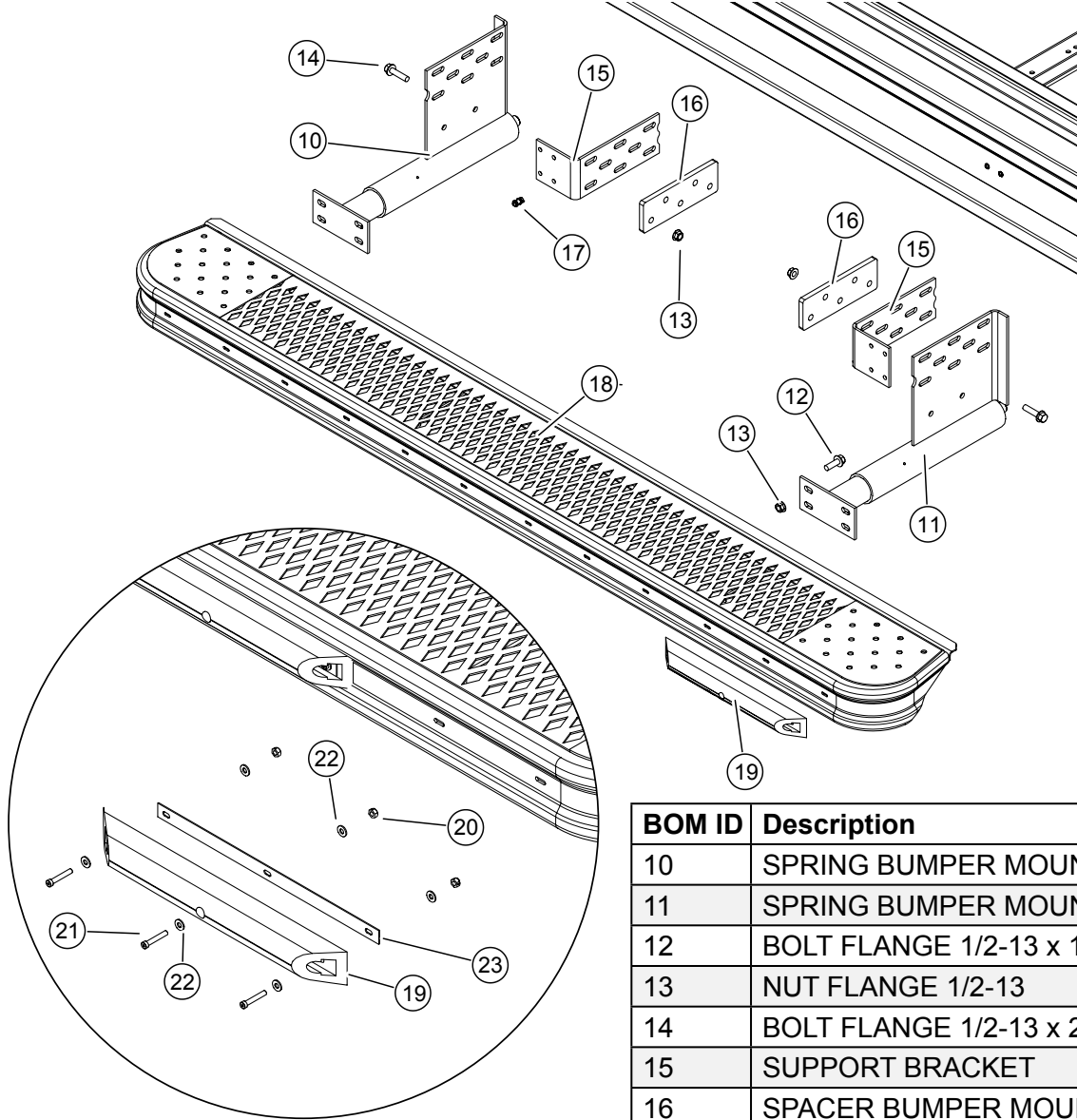


UTILIMASTER

Service Guide

A SPARTAN MOTORS COMPANY

Rear Shock Absorbing Bumper



BOM ID	Description
10	SPRING BUMPER MOUNT LH
11	SPRING BUMPER MOUNT RH
12	BOLT FLANGE 1/2-13 x 1.50
13	NUT FLANGE 1/2-13
14	BOLT FLANGE 1/2-13 x 2.00
15	SUPPORT BRACKET
16	SPACER BUMPER MOUNT
17	HUCK RIVET 3/8
18	BUMPER GRIPSTRUT ARM
19	BUMPER RUBBER DOCK
20	NUT HX 1/4-20
21	SCREW 1/4-20 X 1.50
22	WASHER 1/4"
23	RETAINER PLATE D-BUMPER

Bumper Removal



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

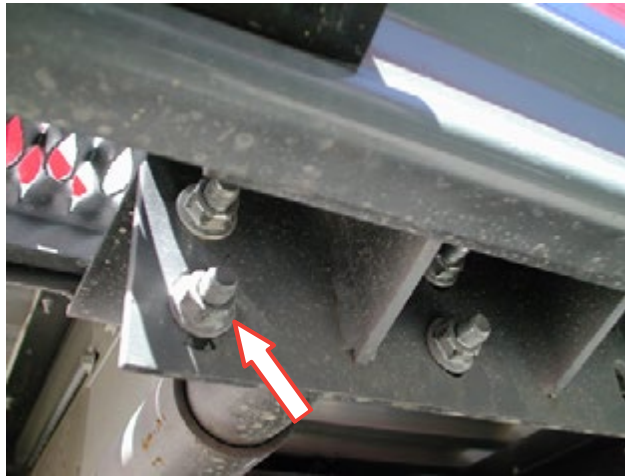
1. Remove fasteners securing the bumper to the shock-absorbing strut mount plate.
2. Remove strut fasteners on the frame rail.

Bumper Installation



CAUTION: Always use new bolts and two-way Grade 8 locknuts. Do NOT reuse locknuts or bolts when replacing bumpers.

1. Mount bumper to struts using flange nuts and bolts. Do NOT tighten at this time.
2. Align and level the bumper side to side and front to back.



Bumper mounting fasteners

3. Secure all flange nuts.
4. Torque nuts at the strut mount to 75–95 ft•lb.

Strut Removal

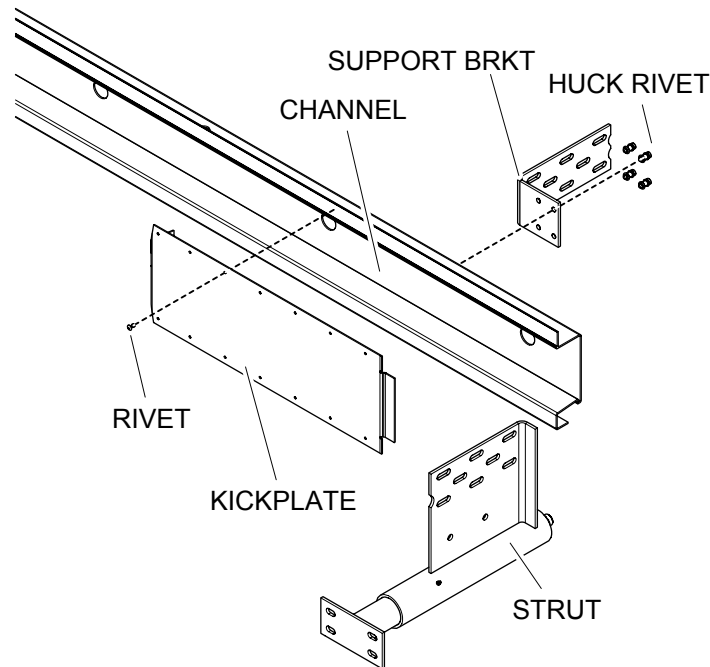
1. Remove the bumper.
2. Remove fasteners securing strut to frame rail.
3. Remove spacers and carefully remove bracket.

Strut Installation

NOTE: Some bumper struts do NOT use spacer plates.

1. If necessary, carefully pry the rear structure support bracket away from the chassis rail. Align the spacer plate and bracket with holes in the frame rail.
2. Install new 1/2-13 flange head nuts and bolts into the upper holes and lower holes. Do NOT tighten at this time.
3. Torque nuts at frame rail to 75–95 ft•lb.
4. Mount bumper to struts.

Support Bracket Removal



Overview of rear structure support bracket

1. Remove the rear kickplate under the rear door by drilling out the buck rivets.
2. Remove the Huck rivets. This will free the bumper support brackets and spacers.

Support Bracket Installation

NOTE: If locknuts are not available, use lock washers and a thread adhesive like Loctite.®

1. If strut uses a spacer plate, align with existing frame rail holes.
2. Secure the support brackets using existing fasteners holes. If the Huck riveter is not available, use new 3/8" Grade 8 locknuts, bolts, and flat washers. Do NOT tighten at this time.
3. Reinstall the kickplate with aluminum POP rivets.

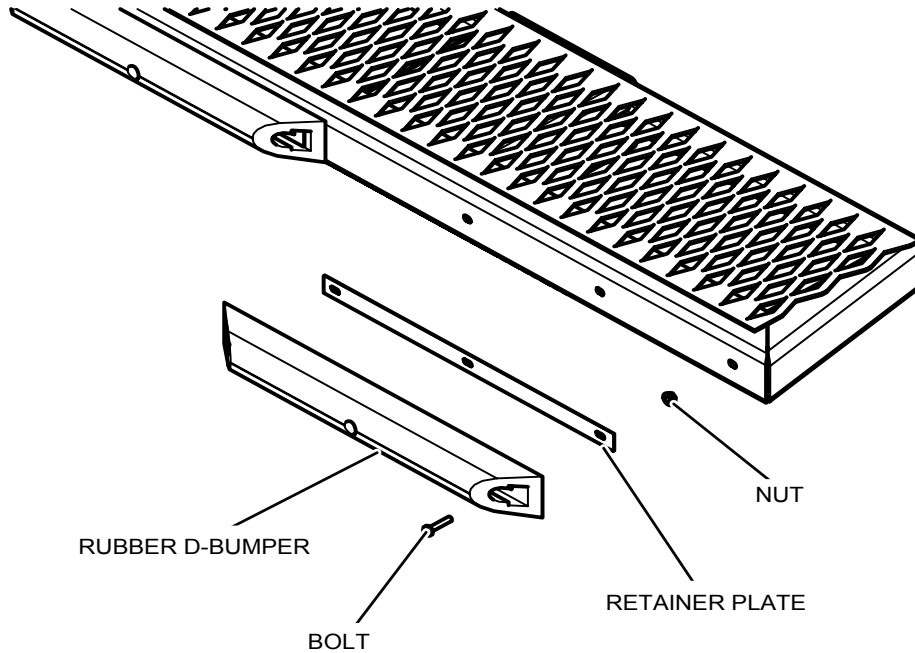
Rubber D-Style Bumpers



CAUTION: Discard ALL used fasteners and replace with new. If using a fastener that does NOT have preapplied thread lock, apply a medium-grade liquid thread lock.

Removal

1. Remove bolts, washers and nuts from D-bumper through access holes.
2. Set D-bumper and retainer plate aside.



Rubber dock bumper overview

Installation

1. Insert retainer plate into D-bumper.
2. Secure D-bumper with new bolts, washers and nuts.
3. Tighten nuts.

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