

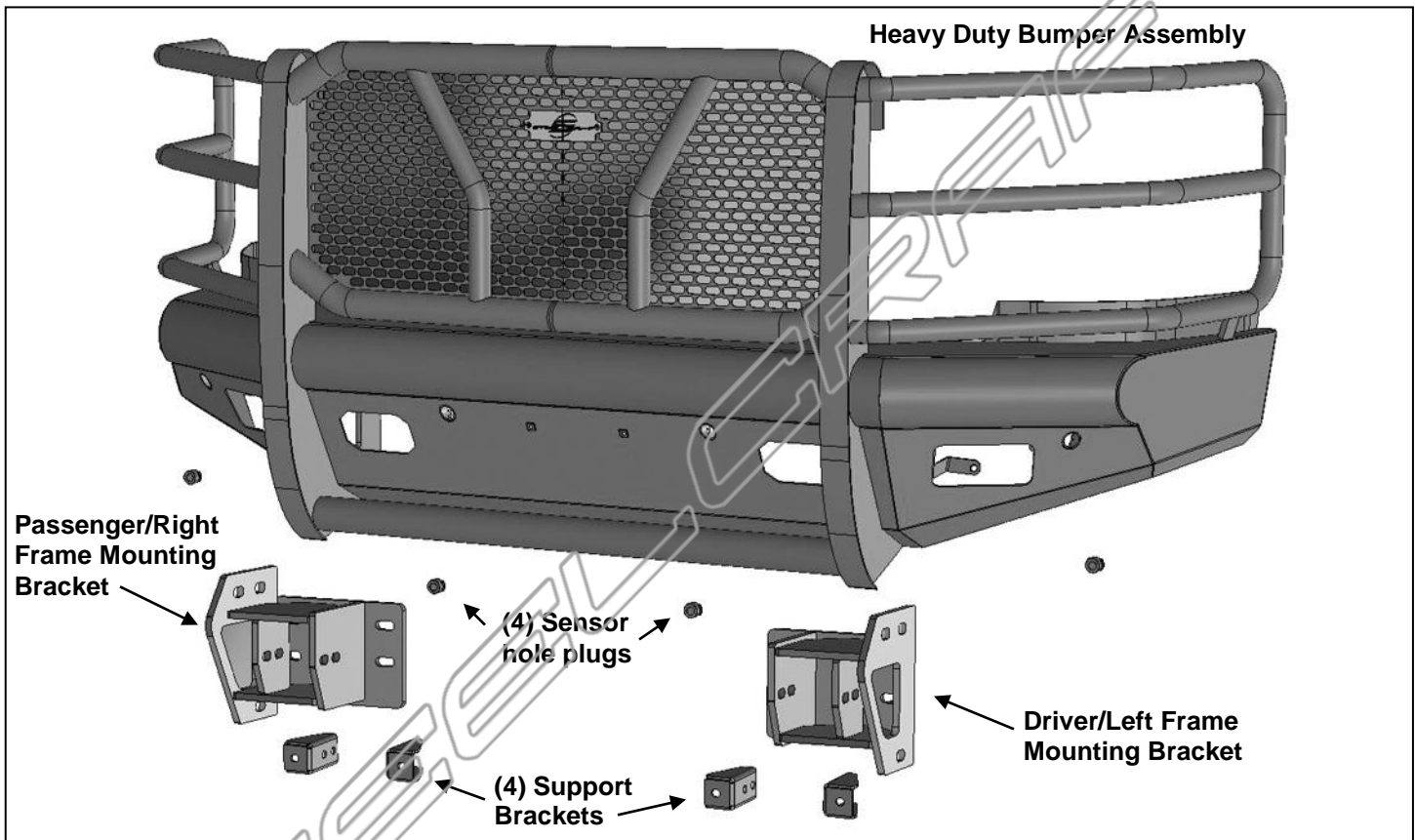
INSTALLATION INSTRUCTIONS

**HEAVY DUTY FRONT BUMPER
2014-15 CHEVY SILVERADO 1500**

STEELCRAFT

PARTS LIST:

1	Heavy Duty Front Bumper Assembly	16	12mm Nylon Lock Nuts
1	Driver Mounting Bracket	8	4mm x 10mm Socket Head Screws
1	Passenger Mounting Bracket	4	Sensor Plugs
4	Support Brackets	2	Plastic Plugs for License Plate
16	12-1.75mm x 50mm Hex Bolts	1	Wrench
32	12mm x 32mm OD x 3mm Flat Washers		



PROCEDURE:

REMOVE CONTENTS FROM BOX. VERIFY ALL PARTS ARE PRESENT. READ INSTRUCTIONS CAREFULLY BEFORE STARTING INSTALLATION. BUMPER IS HEAVY, ASSISTANCE IS HIGHLY RECOMMENDED TO AVOID POSSIBLE INJURY OR DAMAGE TO THE VEHICLE.

1. Remove the license plate and bracket. On models with factory fog lights, unplug both lights. On models with front bumper mounted sensors, unplug sensors and remove from bumper, **(Figure 1)**. Move all wiring harnesses away from bumper.
2. Next, from behind the bumper, release the clips and hardware to remove the plastic body panel, (facia), on top of the bumper, between the bottom of the grille and the top of the bumper, **(Figure 2)**. Open the hood and remove the cover between the top of the radiator and the grille, **(Figure 3)**. Remove the bolts attaching the bottom of the grille to the cross member and remove the grille. Remove the outer bumper supports on each side of the frame.
3. Place blocks or jack stands under the front bumper to support it during mounting bolt removal. Once the bumper has been safely supported, remove the factory bumper bolts attaching the bumper to the inner bumper bracket bolted to the end of the frame, **(Figure 4A & 4B)**.

WARNING! Assistance is required to hold the bumper in place during bolt removal to prevent the bumper from falling. Carefully slide the bumper assembly with brackets off of the ends of the frame.

4. Reinstall the grille and top cover removed in **Step 2**.
5. Remove both bumper brackets and tow hooks from the ends of the frame, (**Figure 4A & 4B**).
6. Select (1) Bumper Bracket Support. Starting on the driver side, attach the Support Bracket to the inner facing side of the frame with (2) 12mm x 50mm Hex Bolts, (4) 12mm Flat Washers and (2) 12mm Nylon Lock Nuts, (**Figures 5 & 6A**). Next, attach (1) Support Bracket to the outer facing side of the frame with (1) 12mm x 50mm Hex Bolt, (2) 12mm Flat Washers and (1) 12mm Nylon Lock Nut, (**Figures 5 & 6B**). Do not tighten hardware at this time.
7. Select the driver side Frame Mounting Bracket. Reuse (2) factory bumper bolts to attach the top mounting holes on the Frame Bracket to the threaded bumper mount, (**Figures 7 & 9**). Attach the (2) lower holes in the Frame Bracket to the Support Brackets with (2) 12mm x 50mm Hex Bolts, (4) 12mm Flat Washers and (2) 12mm Nylon Lock Nuts, (**Figures 8 & 9**). Snug but do not fully tighten hardware at this time.
8. Repeat **Steps 6 & 7** to install the passenger side Support Brackets and Frame Bracket.
9. With assistance, position the Bumper Assembly up to and over the Brackets. Temporarily support the weight of the Bumper. **WARNING:** To avoid possible injury or damage to the vehicle, do not proceed until the Bumper is fully and safely supported.
10. Line up the (3) holes in the driver side mounting plate on the inside of the Bumper with the (3) slots in the Frame Bracket. Attach the Bumper to the Bracket with the included (3) 12mm x 50mm Hex Bolts, (6) 12mm Flat Washers and (3) 12mm Nylon Lock Nuts, (**Figure 10**). Do not fully tighten hardware at this time. Repeat this **Step** to attach the passenger side of the Bumper to the Frame Bracket.
11. Level and adjust the bumper and fully tighten all hardware to 65-70ft-lbs.
12. Reuse the factory hardware to attach the tow hooks to the inside of the Frame Brackets, (**Figure 11A & 11B**).

Models with fog lights:

- a. Slide the light into place through the opening in the bumper. Push the attaching posts into the tabs on the bumper, (**Figure 12**). Repeat this Step to install remaining light.
- b. Reattach the factory wiring harness to both lights.

Models without bumper sensors:

- a. Select the included (4) Rubber Plugs.
- b. From behind bumper, push plugs into sensor mounting holes, (**Figure 13**).

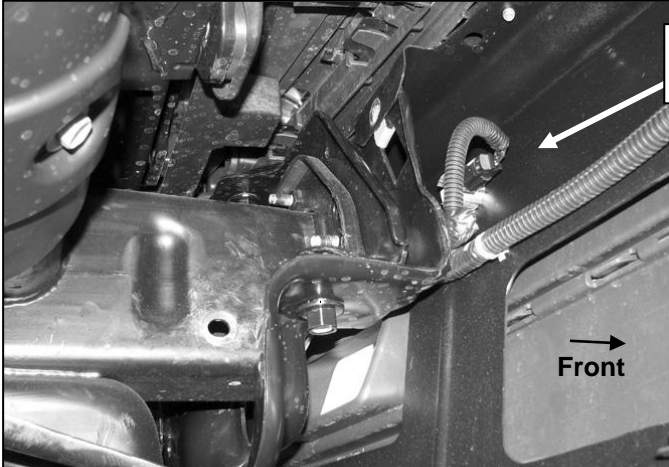
Models with bumper mounted sensors:

- a. Push the sensor into the mounting socket in the back of the bumper.
- b. Secure each sensor to the socket with (2) 4mm x 10mm Button Head Screws, (**Figure 14**). **IMPORTANT:** Sensors fit snug in sockets. The 4mm Screws are used to apply slight pressure to lock the sensors in place. Tighten both screws evenly until they touch the sensor body only. Do not overtighten screws or damage to sensors will result.

13. Use the included (2) push-in Plastic Nuts to attach the front license plate, (if required), to the (2) holes in the front of the Bumper, (**Figure 15**).
14. Do periodic inspections to the installation to make sure that all hardware is secure and tight.

To protect your investment, wax this product after installing. Regular waxing is recommended to add a protective layer over the finish. Do not use any type of polish or wax that may contain abrasives that could damage the finish. Mild soap may be used to clean the Heavy Duty Front Bumper assembly.

Driver Side Installation Pictured



Unplug sensors and fog lights if equipped

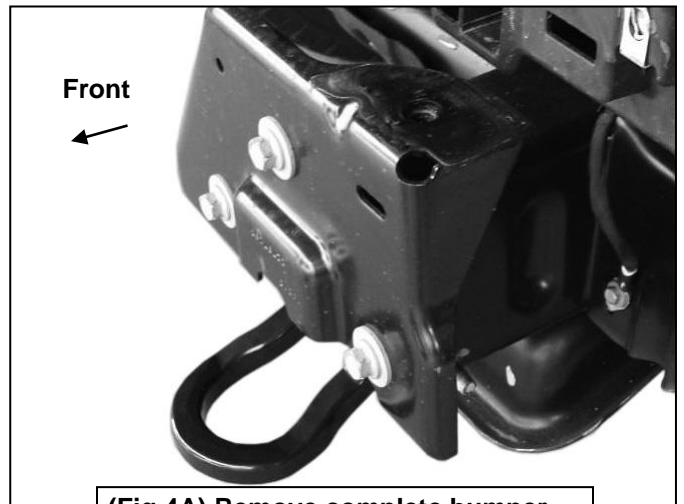
(Fig 1) Unplug sensors, fog lights and move wiring harness away from bumper before removal



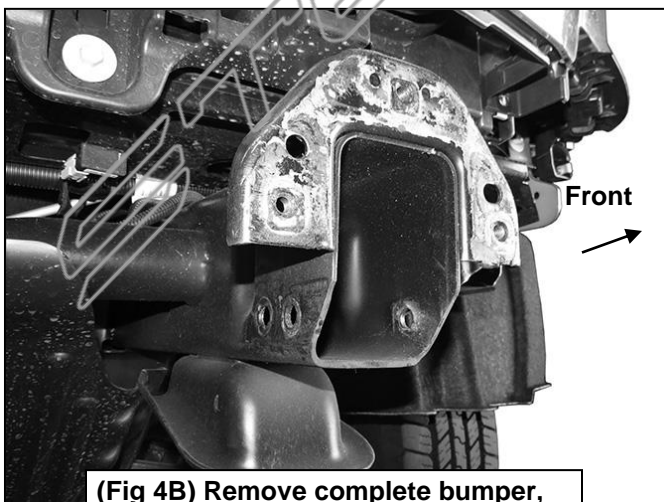
(Fig 2) From behind bumper, release clips and hardware attaching plastic fascia panel (arrow) to top of bumper. Remove fascia panel to access bumper hardware



(Fig 3) Remove plastic cover from top of radiator (arrow). Temporarily remove grille



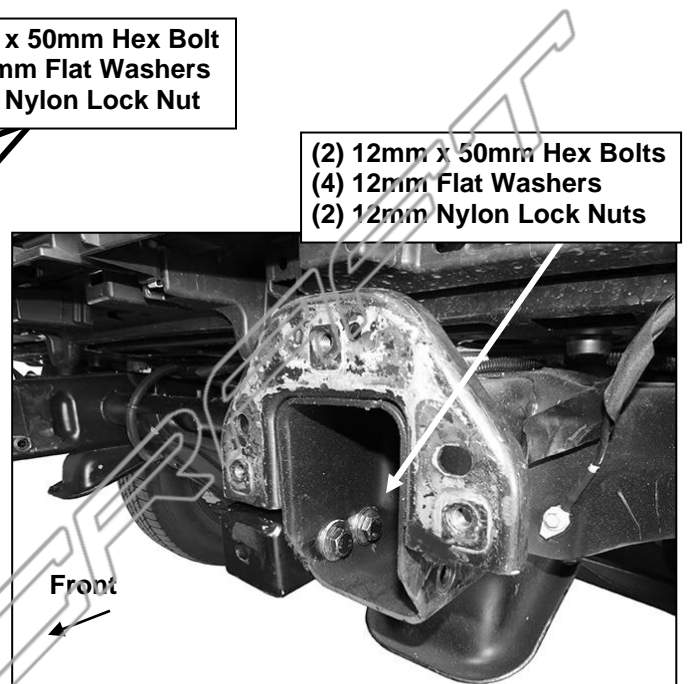
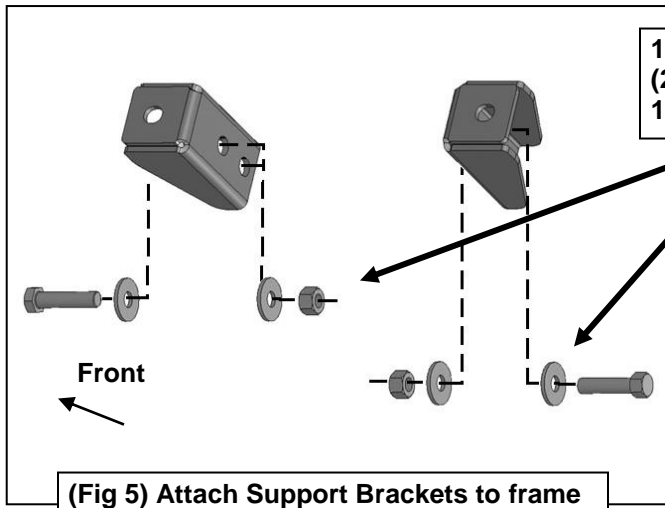
(Fig 4A) Remove complete bumper, inner bumper bracket and tow hooks



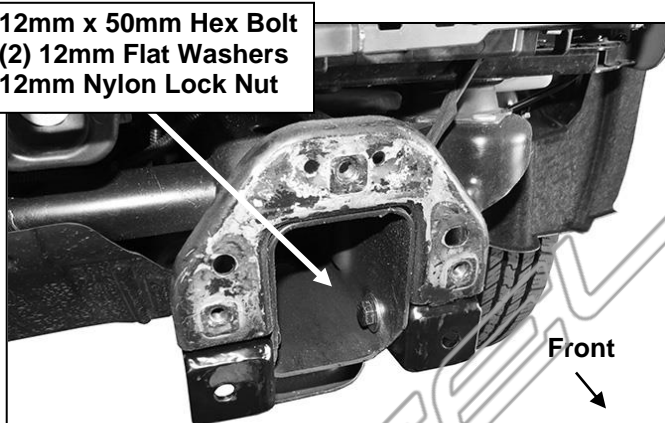
(Fig 4B) Remove complete bumper, inner bumper bracket and tow hooks

WARNING! Do not crawl under bumper unless the bumper is properly supported on blocks or stands or the bumper may fall.

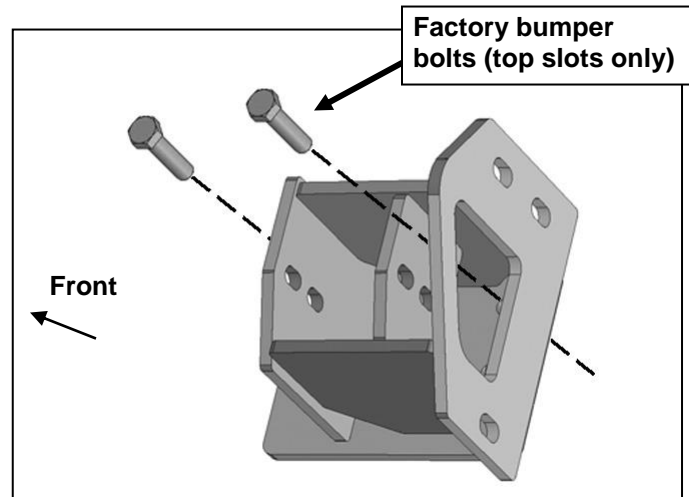
Driver Side Installation Pictured



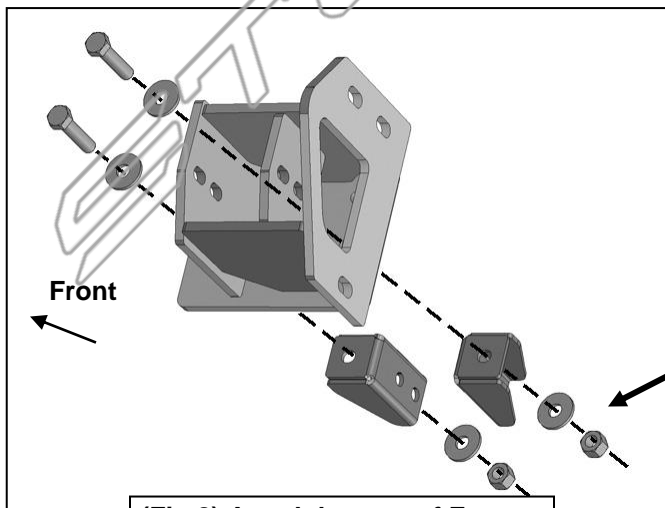
(Fig 6A) Attach Support Brackets to frame using factory holes for tow hooks. Driver side pictured



(Fig 6B) Attach Support Brackets to frame using factory holes for tow hooks. Driver side pictured



(Fig 7) Reuse factory bumper bolts to attach top of Frame Bracket to bumper mount on frame

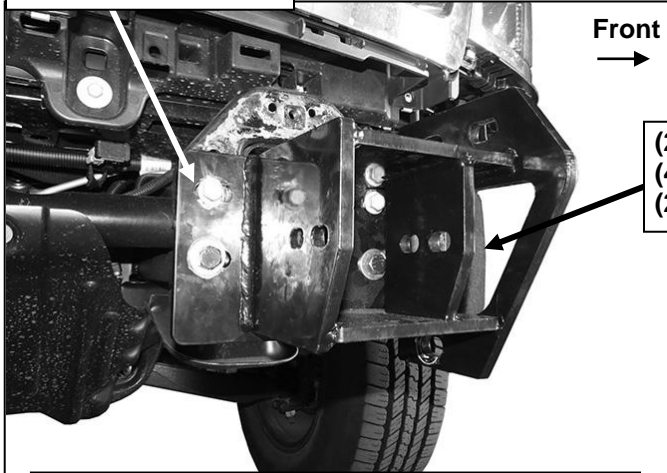


(Fig 8) Attach bottom of Frame Bracket to Support Brackets

WARNING! Do not crawl under bumper unless the bumper is properly supported on blocks or stands or the bumper may fall.

Driver Side Installation Pictured

Factory bumper bolts (top slots only)

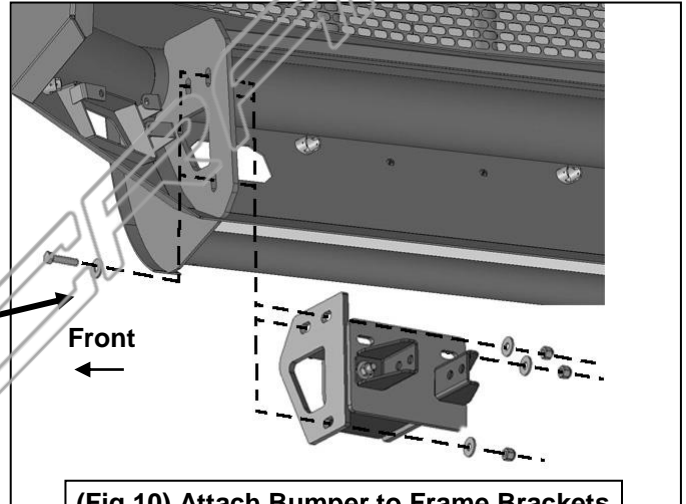


Front
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WARNING! Do not crawl under bumper unless the bumper is properly supported on blocks or stands or the bumper may fall.

- (2) 12mm x 50mm Hex Bolts
- (4) 12mm Flat Washers
- (2) 12mm Nylon Lock Nuts

(Fig 9) Complete installation of Frame Bracket



Front
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- (3) 12mm x 50mm Hex Bolts
- (6) 12mm Flat Washers
- (3) 12mm Nylon Lock Nuts

(Fig 10) Attach Bumper to Frame Brackets

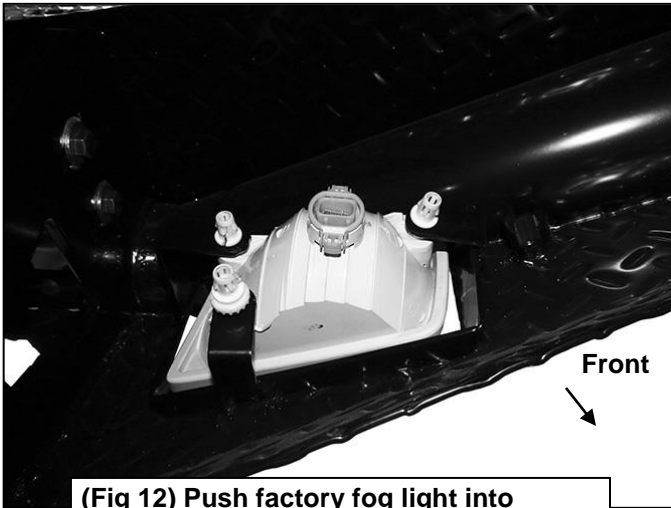


Front
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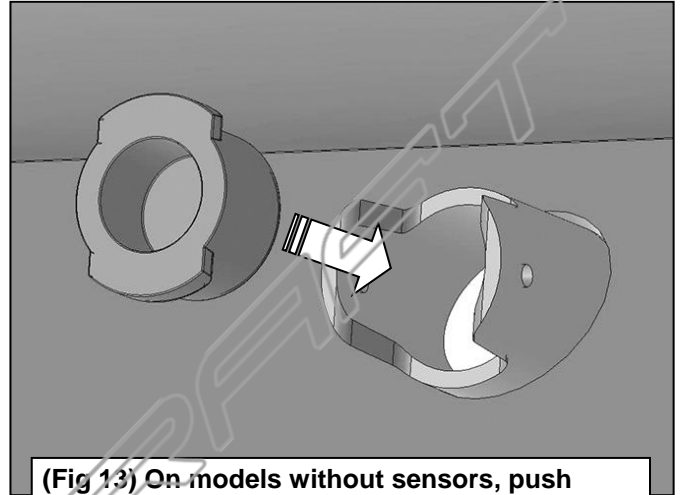
(Fig 11A) Reinstall tow hooks with factory hardware



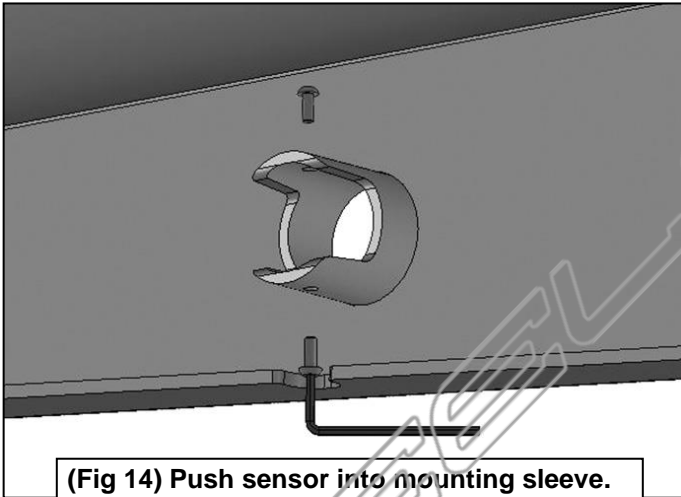
(Fig 11B) Reinstall tow hooks with factory hardware



(Fig 12) Push factory fog light into mounting tabs (passenger side pictured)

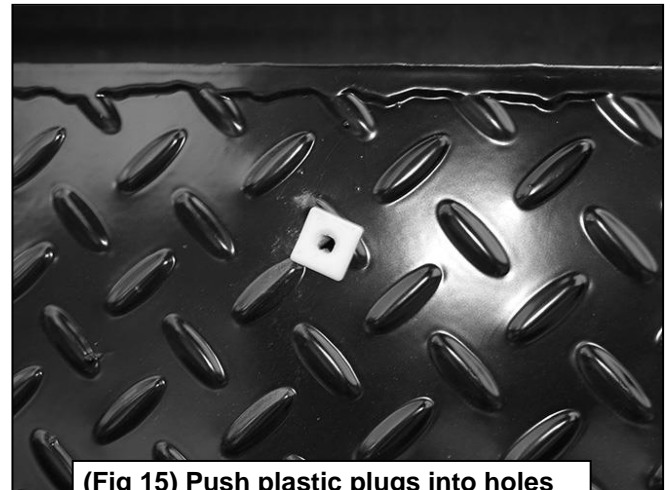


(Fig 13) On models without sensors, push included rubber plugs into mounting sleeves



(Fig 14) Push sensor into mounting sleeve. Use 4mm Screws to lock sensor in place.

IMPORTANT: Sensors fit snug in sockets. The 4mm Screws are only used to apply slight pressure to lock the sensors in place. Tighten both screws evenly until they touch the sensor body only. Do not overtighten screws or damage to sensors will result.



(Fig 15) Push plastic plugs into holes in Bumper for license plate if required



Complete Installation