

INSTALLATION INSTRUCTIONS

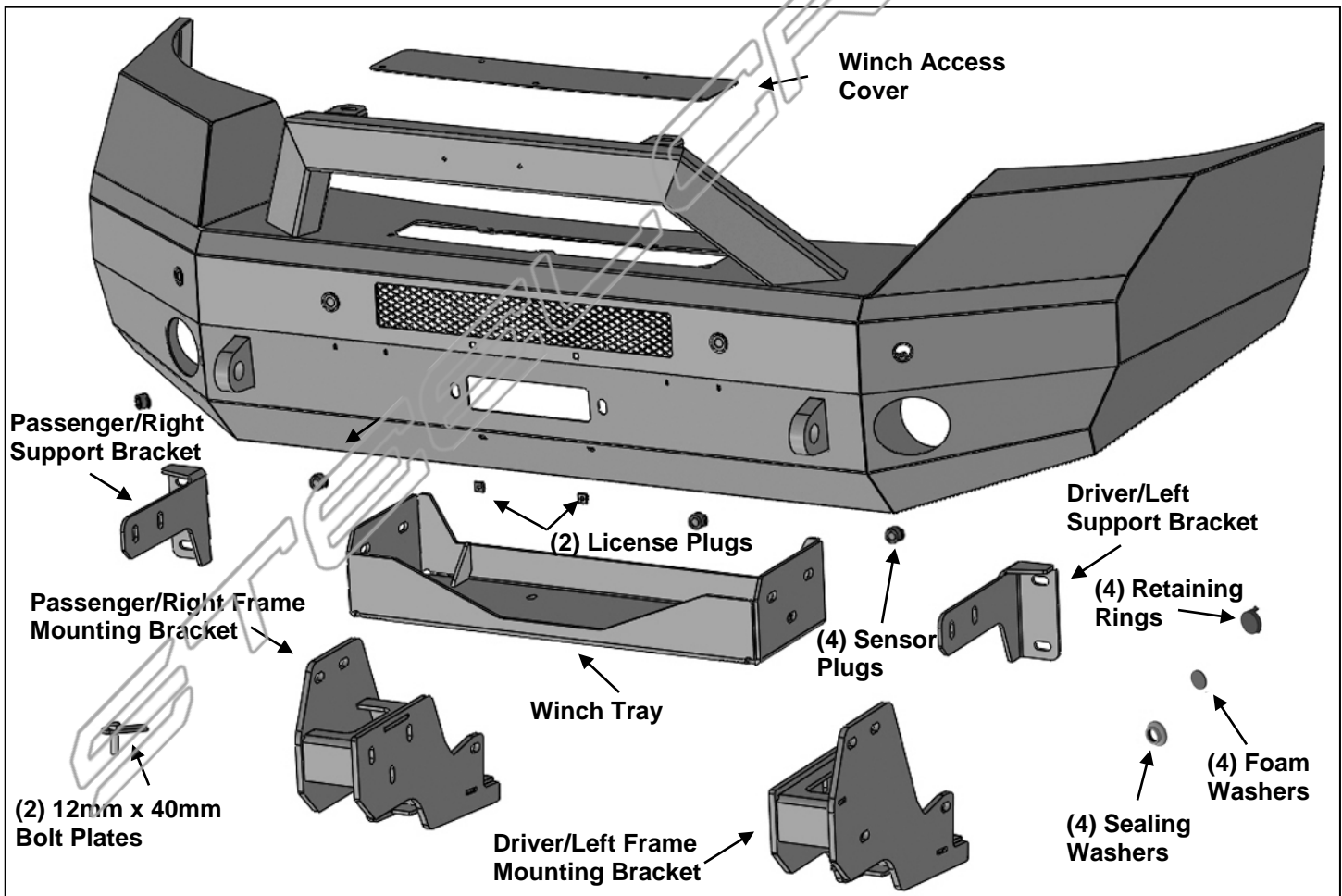
**ELEVATION BULL NOSE FRONT BUMPER
2015-17 GMC SIERRA 25-3500**

STEEL CRAFT

**ELEVATION BULL NOSE FRONT BUMPER
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PARTS LIST:

1	Elevation Bull Nose Front Bumper	2	12mm x 40mm Bolt Plates
1	Driver/left side Mounting Bracket	2	12-1.75mm x 140mm Hex Bolts
1	Passenger/right side Mounting Bracket	12	12-1.75mm x 55mm Hex Bolts
1	Driver/left side Support Bracket	30	12mm x 37mm OD x 3mm Flat Washers
1	Passenger/right side Support Bracket	16	12mm Nylon Lock Nuts
1	Driver/left side Light Bracket	2	8mm x 25mm Hex Bolts
1	Passenger/right side Light Bracket	2	8mm x 16mm Hex Bolts
2	Plastic Plugs for License Plate	6	8mm x 24mm x 2mm Flat Washers
1	Winch Tray	4	8mm Lock Washers
1	Winch Access Cover	2	8mm Hex Nuts
4	Rubber Sensor Hole Block Offs	5	6mm Button Head Combo Bolts
1	Rubber Sensor Covers kit	1	4mm Wrench
4	Parking Sensor Sealing Washers	8	4mm x 10mm Button Head Screws
4	Parking Sensor Foam Washers	1	2.5mm Wrench
4	Parking Sensor Retaining Rings		



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. Open the hood and remove the plastic cover on top of the radiator and the grille, **(Figure 1)**. Carefully remove the grille. Remove the license plate and bracket. On models with factory fog lights, unplug both

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lights. On models with bumper mounted sensors, unplug all sensors. Release the wiring harnesses from the clips attached to the back of the bumper and move all wiring harnesses away from bumper.

2. Remove the outer bumper supports from each side of the frame, **(Figure 2)**.
3. Place blocks or jack stands under the front bumper to support it during mounting bolt removal. Once the bumper has been safely supported, from above the bumper, remove the (2) factory bumper bolts from each side, **(Figure 3)**. **WARNING!** Assistance is required to hold the bumper in place during bolt removal to prevent the bumper from falling. Remove the bumper assembly.
4. Remove the factory bumper brackets from the ends of frame and remove both tow hooks, **(Figure 4)**. **NOTE:** Frame Brackets will attach to the tow hook mounting holes.
5. Select a 12mm Bolt Plate. Insert the Bolt Plate into the end of the frame and down through the hole in the bottom of the frame, **(Figure 5)**. Select the driver side Mounting Bracket. Slide the Bracket over the end of the frame and over the Bolt Plate. Attach the Bracket to the Bolt Plate with the included 12mm Flat Washer and 12mm Nylon Lock Nut, **(Figures 6 & 7)**. Leave hardware loose at this time.
6. Next, line up the mounting tabs on the Mounting Bracket with the holes in the sides of the frame. Attach the Frame Bracket to the sides of the frame with (1) 12mm x 140mm Long Hex Bolt, (2) 12mm Flat Washers and (1) 12mm Nylon Lock Nut, **(Figures 6 & 7)**. Do not fully tighten hardware at this time.
7. Select the driver/left Support Bracket, **(Figure 8)**. Reuse (2) of the factory bumper bracket bolts to attach the Support Bracket to the outer holes in the bumper mounting flange on the end of the frame, **(Figures 8 & 9)**. Line up the mounting plate on the Support Bracket with the inside of the Frame Mounting Bracket. Do not tighten the Bracket hardware at this time.
8. Repeat **Steps 5—7** to attach the passenger/right Frame and Support Brackets, **(Figure 9)**.
9. **Optional Winch Tray and Winch installation (winch sold separately):**
 - a. Select the Winch Tray. With assistance, slide the Winch Tray between the Frame Brackets. Attach the Winch Tray to the Frame Brackets with (6) 12mm x 55mm Hex Bolts, (12) 12mm Flat Washers and (6) 12mm Nylon Lock Nuts, **(Figures 10 & 11)**. Snug but do not fully tighten all hardware. **I**
 - b. If installing winch, follow manufacturer's instructions to attach the winch to the Winch Tray. Winch must be installed before Bumper is placed in position against Brackets.
 - c. Attach winch cable guide, (not included), to Bumper assembly. Follow manufacturer's instructions to properly wire the winch to the electrical system.
10. **Optional Center LED light installation, (sold separately).** **NOTE:** Light must be installed in Bumper before Bumper Assembly is attached to Brackets.
 - a. Select the Driver side "L" Bracket. **NOTE:** "L" Brackets are offset for universal fitment for most LED bar style lights. Attach the Bracket to the top of the mounting tab on the back of the Bumper with the included (1) 8mm x 25mm Hex Bolt, (2) 8mm Flat Washers, (1) 8mm Lock Washer and (1) 8mm Hex Nut, **(Figure 12)**. Do not tighten hardware at this time.
 - b. Repeat Previous Step for Passenger side "L" Bracket installation.
 - c. Attach the LED Light Bar to the Brackets with (2) 8mm x 16mm Hex Bolts, (2) 8mm Lock Washers and (2) 8mm Flat Washers, **(Figure 12)**. Do not fully tighten hardware at this time.
 - d. Center and adjust light position and tighten hardware.
 - e. Follow light manufacturer's instructions to wire the light to the vehicle's electrical system once Bumper has been fully installed.
11. Sensors must be installed in Bumper, (if equipped), before installing Bumper Assembly.

Models without bumper sensors:

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

Models with bumper mounted sensors:

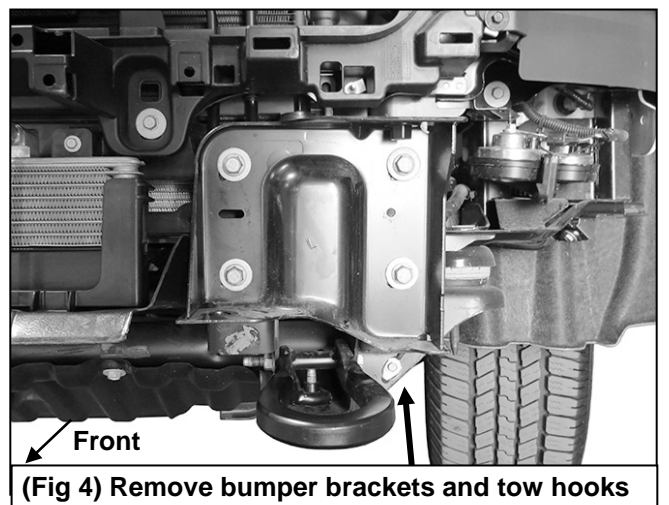
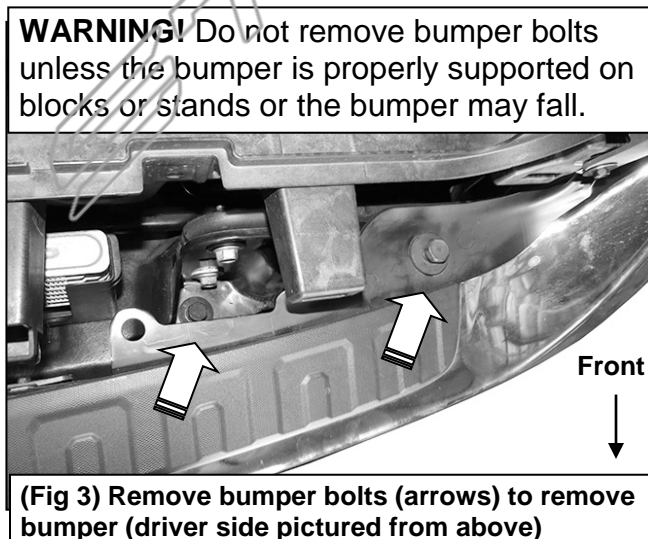
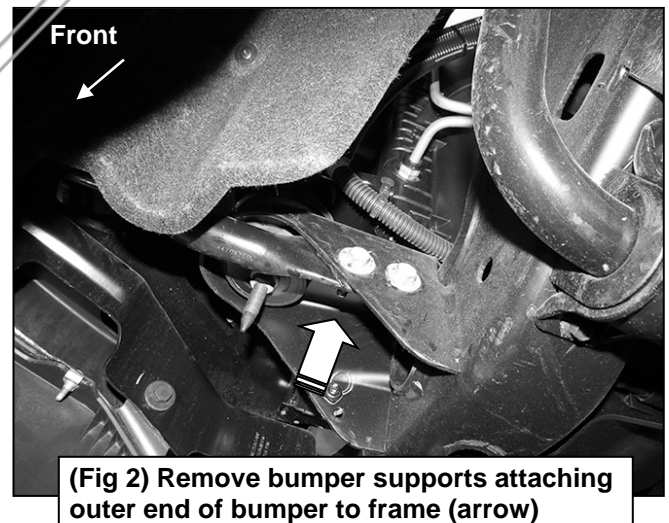
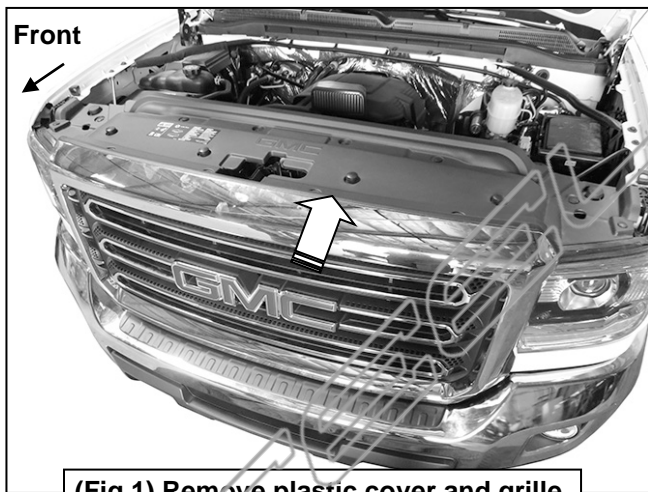
- a. Trim off the plastic tabs on the sensor to make sure the sensor fits snug inside the sensor sleeve. Remove the small factory sealing washer from the sensor. Attach the provided larger (1) Sealing Washer onto the front of the sensor, **(Figure 13)**.
- b. Push the sensor in from the back of the Bumper until it is flush with the sensor sleeve. Attach (1) 20mm x 2mm Adhesive Foam Washer to (1) Retaining Ring. Push the Retaining Ring into the sensor sleeve to secure sensor in place, **(Figures 13 & 14)**. **NOTE:** Make sure the tabs on the Retaining Ring fit into the holes on the sensor sleeve.
- c. Repeat the Previous Steps to install each sensor to the back of the Bumper.

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12. 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.
13. 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 55mm Hex Bolts, (6) 12mm Flat Washers and (3) 12mm Nylon Lock Nuts, **(Figures 15 & 16)**. Do not fully tighten hardware at this time. Repeat to attach the passenger side mounting plate to the Frame Bracket.
14. Level and adjust the bumper and fully tighten all 12mm hardware to 65-70ft-lbs.
15. **Models with factory fog lights:**
 - a. Slide the driver side fog light into place through the opening in the bumper, **(Figures 17 & 18)**. Carefully push the attaching posts into the tabs on the bumper. Repeat this **Step** to install passenger side light.
16. Reattach the factory wiring harness to both lights and/or sensors if equipped.
17. Use the included (2) push-in Plastic Nuts to attach the front license plate, (if required), to the (2) holes in the front Bumper, **(Figure 19)**.
18. Do periodic inspections to the installation to make sure that all hardware is secure and tight.

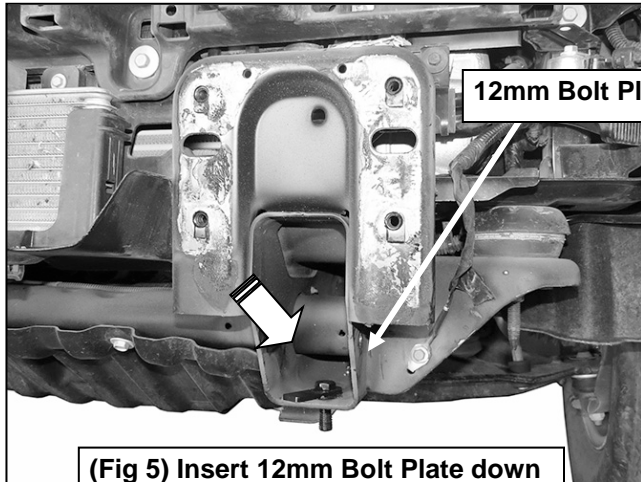
To protect your investment, wax this product after installing. Regular waxing is recommended to add a protective layer over the finish. Do not use any type of polish or wax that may contain abrasives that could damage the finish. Mild soap may be used to clean the Bumper assembly.

Driver Side Installation Pictured

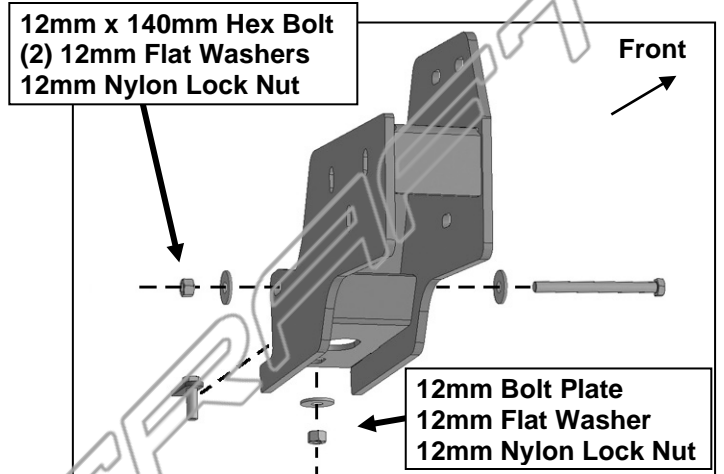


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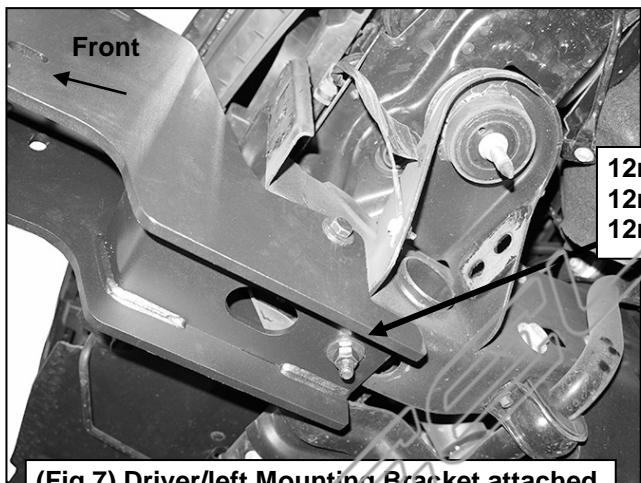
Driver Side Installation Pictured



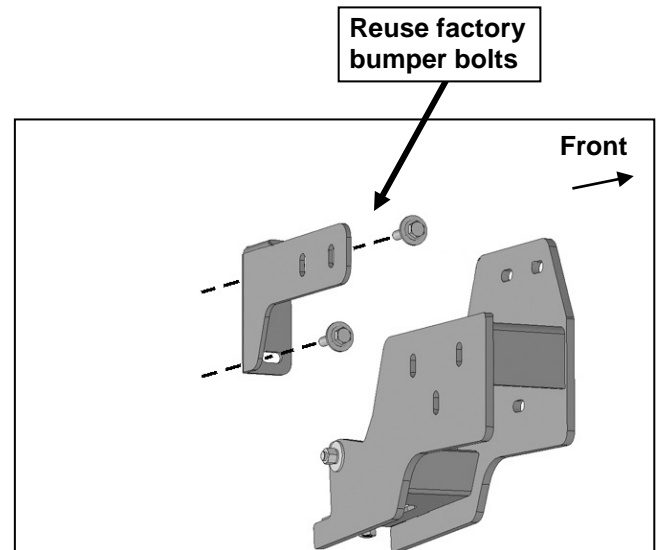
(Fig 5) Insert 12mm Bolt Plate down through hole in bottom of the frame



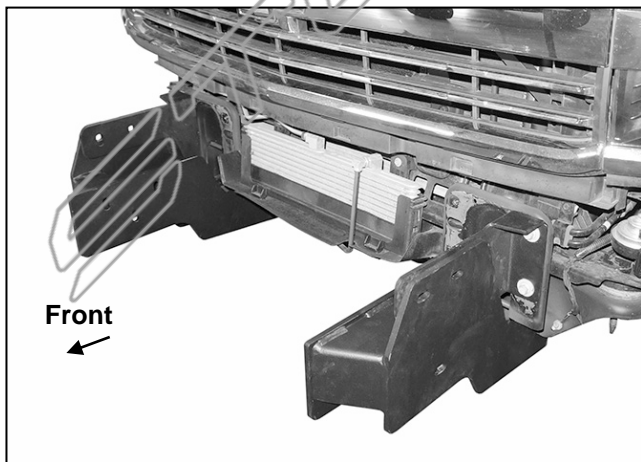
(Fig 6) Attach driver/left Mounting Bracket to frame



(Fig 7) Driver/left Mounting Bracket attached to frame and pictured from below



(Fig 8) Reuse (2) factory bumper bolts to attach Support Bracket to mounting plate on frame

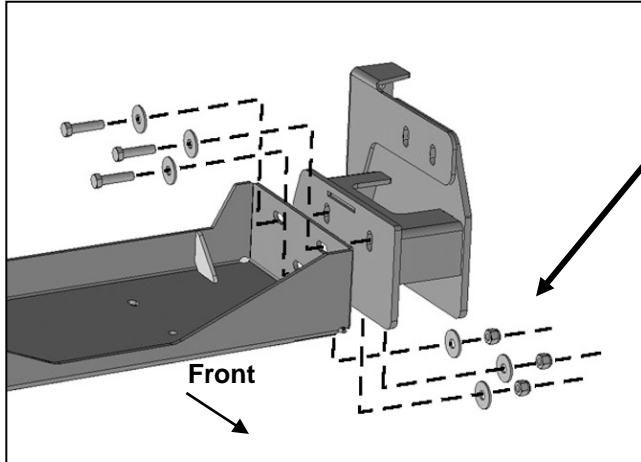


(Fig 9) Frame Brackets installed (vehicle pictured for example only-actual model may differ slightly)

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

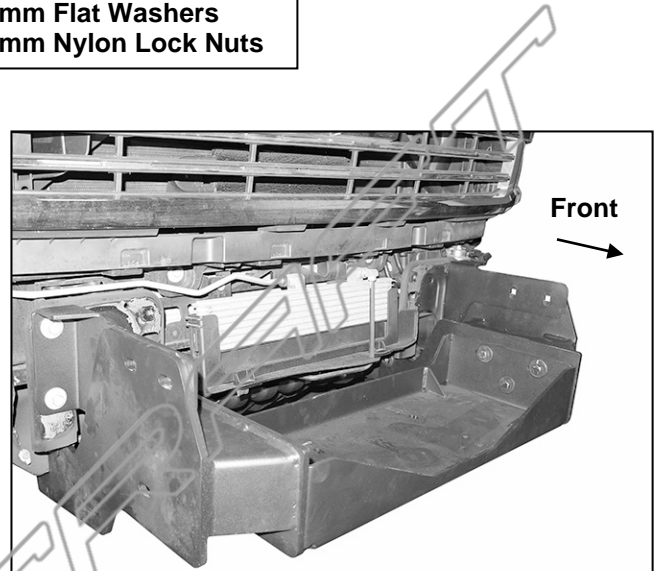
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Driver side installation pictured

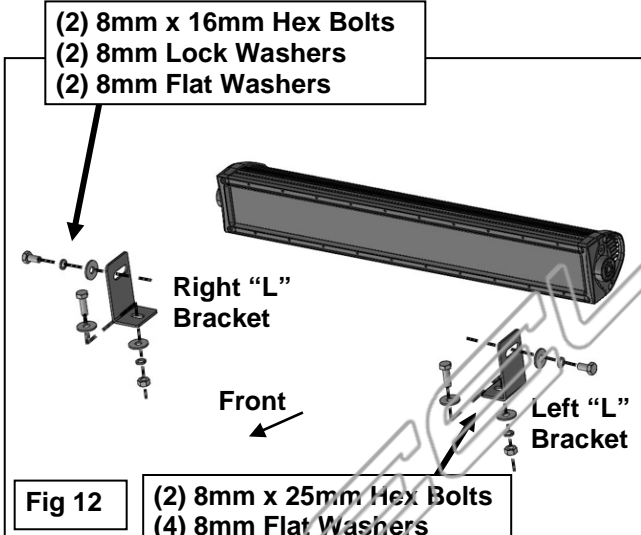


- (3) 12mm x 55mm Hex Bolts
- (6) 12mm Flat Washers
- (3) 12mm Nylon Lock Nuts

(Fig 10) Attach Winch Tray to inside of Brackets



(Fig 11) Winch Tray and Brackets (vehicle pictured for example only-actual model may differ slightly)



- (2) 8mm x 16mm Hex Bolts
- (2) 8mm Lock Washers
- (2) 8mm Flat Washers

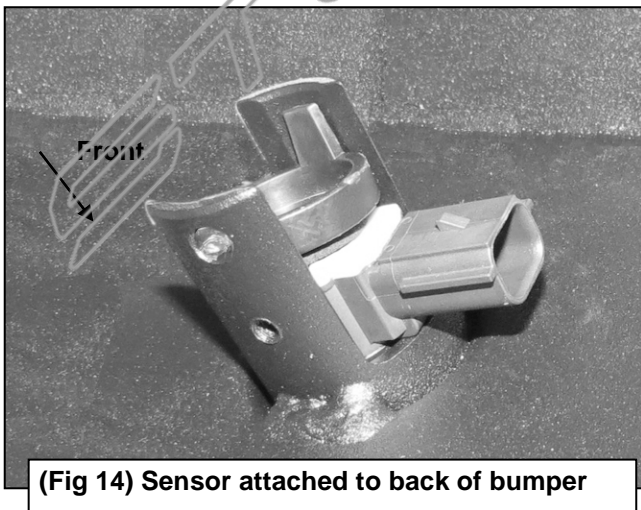
Right "L" Bracket

Left "L" Bracket

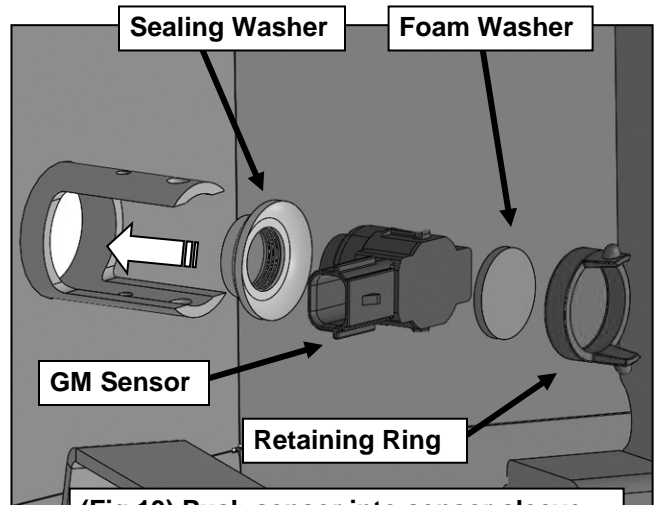
Front

Fig 12

- (2) 8mm x 25mm Hex Bolts
- (4) 8mm Flat Washers
- (2) 8mm Lock Washers
- (2) 8mm Hex Nuts



(Fig 14) Sensor attached to back of bumper

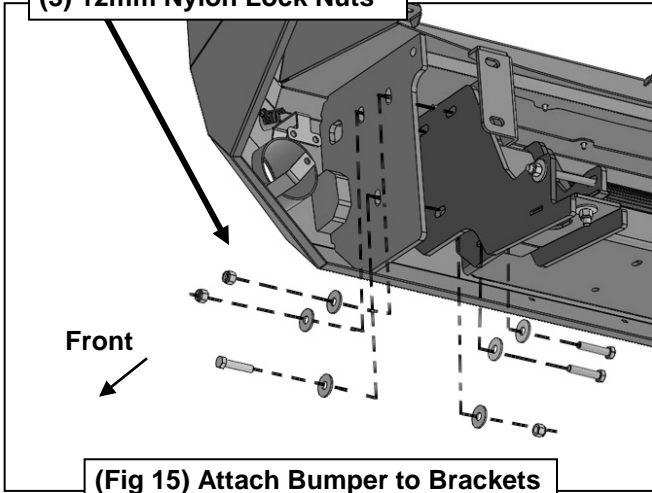


(Fig 13) Push sensor into sensor sleeve

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Driver side installation pictured

- (3) 12mm x 55mm Hex Bolts
- (6) 12mm Flat Washers
- (3) 12mm Nylon Lock Nuts



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

- (3) 12mm x 55mm Hex Bolts
- (6) 12mm Flat Washers
- (3) 12mm Nylon Lock Nuts

