

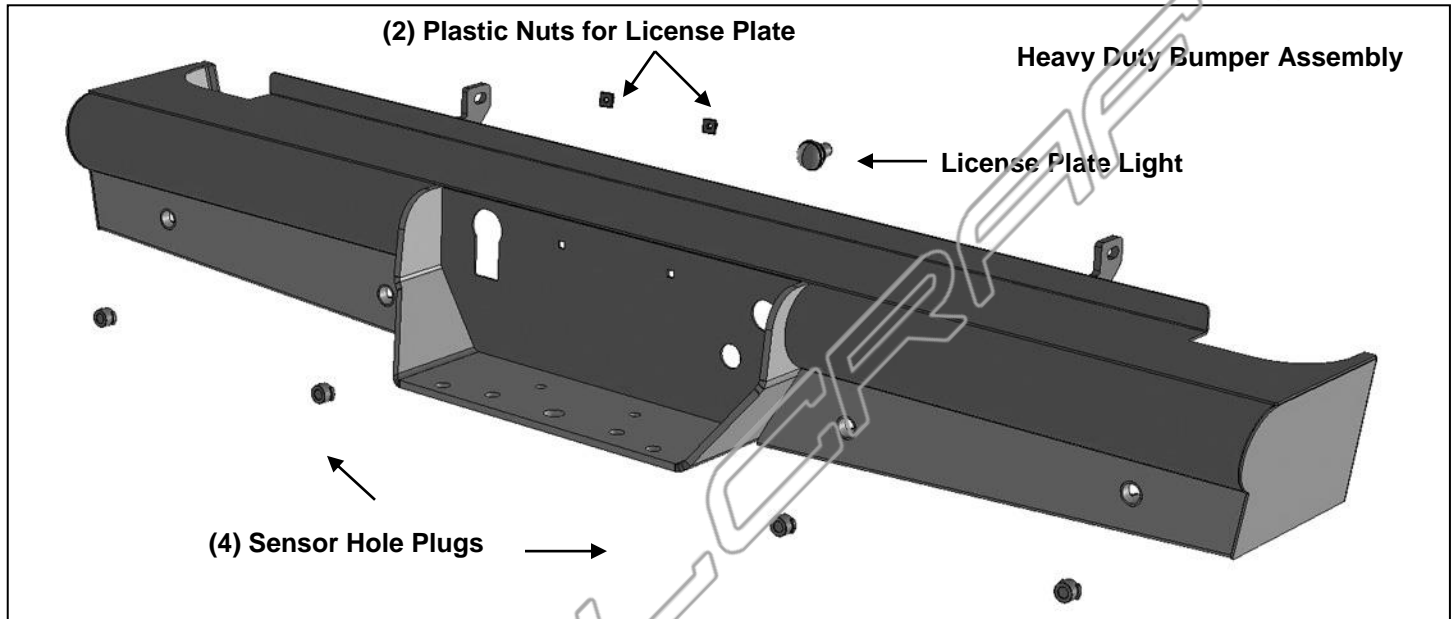
INSTALLATION INSTRUCTIONS

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

STEELCRAFT

PARTS LIST:

| | | | |
|----|--------------------------------------|---|-----------------------------------|
| 1 | 2014-15 Silverado 1500 Legend Bumper | 2 | 10-1.5mm x 50mm Hex Bolts |
| 1 | License Plate Light | 4 | 10mm x 34mm OD x 3mm Flat Washers |
| 2 | License Plate Plugs | 2 | 10mm Nylon Lock Nuts |
| 6 | 14-2.0mm x 45mm Hex Bolts | 1 | 4mm Allen Wrench |
| 12 | 14mm x 28mm OD x 2.5mm Flat Washers | 8 | 4mm x 10mm Button Head Bolts |
| 6 | 14mm Nylon Lock Nuts | 4 | Sensor Hole Plugs |



PROCEDURE:

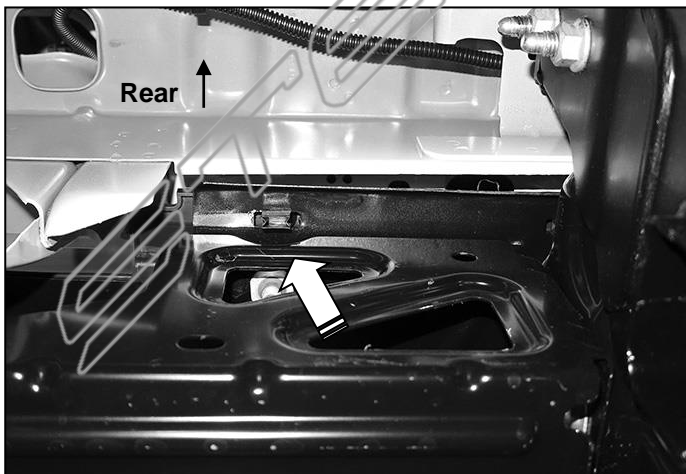
REMOVE CONTENTS FROM BOX. VERIFY ALL PARTS ARE PRESENT. READ INSTRUCTIONS CAREFULLY BEFORE STARTING INSTALLATION. BUMPER IS HEAVY, ASSISTANCE IS HIGHLY RECOMMENDED TO AVOID POSSIBLE INJURY OR DAMAGE TO THE VEHICLE.

1. Remove the license plate. On models with bumper sensors, unplug all sensors. Remove the trailer plug from the bumper. Release the wiring harness from the clips attached to the back of the bumper and move harness away from bumper as necessary.
2. Place blocks or jack stands under the bumper to support it during mounting bolt removal.
NOTE: Bumper may be attached to top of factory tow hitch. Remove these (2) hex bolts first if equipped. Release the plastic clips attaching the plastic cover to the steel bumper, **(Figure 1)**. Remove cover and hardware attaching the bumper to the bumper brackets, **(Figure 2)**. With assistance, remove the outer steel bumper, then remove the hex bolts attaching the brackets to the frame and slide the brackets out of the ends of the frame, **(Figures 3 & 4)**.
3. With assistance, position the Bumper Assembly up to and into the end of the frame. 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.
4. Line up the forward mounting holes in the mounting plates on the Bumper with the smaller forward holes in the frame with the included (2) 10mm x 50mm Hex Bolts, (4) 10mm Flat Washers and (2) 10mm Nylon Lock Nuts, **(Figures 5 & 6)**. Next, attach the brackets to the larger factory holes in the frame with (2) 14mm x 45mm Hex Bolts, (4) 14mm Flat Washers and (2) 14mm Nylon Lock Nuts. **NOTE:** On some models/years, the factory tow hitch may have support straps attached to the side of the frame, **(Figure 6)**. Use the included (2) 14mm x 45mm Hex Bolts, (4) 14mm Flat Washers and (2) 14mm Nylon Lock Nuts to attach the straps to the top mounting holes.

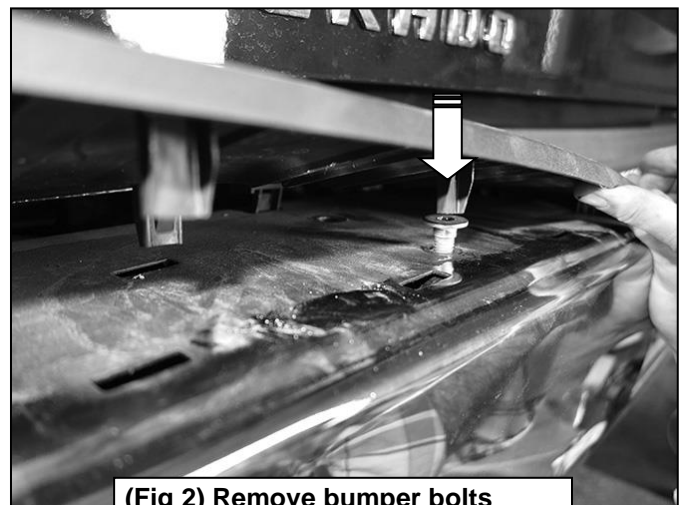
5. Next, from under the frame, attach the bumper brackets to the bottom of the frame with (2) 14mm x 45mm Hex Bolt, (4) 14mm Flat Washers and (2) 14mm Nylon Lock Nut, **(Figures 5 & 7)**. Do not tighten hardware at this time.
6. Check the bumper to see if it is level and if there is a gap between the top of the factory trailer hitch and the bottom of the mounting plate on the back of the bumper. Slowly open tailgate and check for clearance. Level and adjust the bumper and fully tighten all 14mm hardware to 65-70ft-lbs. Tighten the 10mm hardware to 35-40ft-lbs.
7. Use the included (2) push-in Plastic Nuts to attach the rear license plate to the (2) holes in the Bumper, **(Figure 8)**.
8. Insert the License Plate Light into the hole in the bumper, **(Figure 8)**. Attach the License Plate Light wiring to the end of the factory license plate light wire harness. Reinstall the factory trailer harness plug into the opening in the bumper. **NOTE:** Use a small flat blade screwdriver to bend the metal clips to hold plug in bumper.
9. On models without bumper sensors, use included (4) Rubber Plugs to fill sensor holes in bumper, **(Figure 8)**
10. On 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 9)**. **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.
11. 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 Rear Bumper assembly.

WARNING! Before removing hardware, fully support the weight of the bumper with blocks or stands to prevent injury or damage to the vehicle.

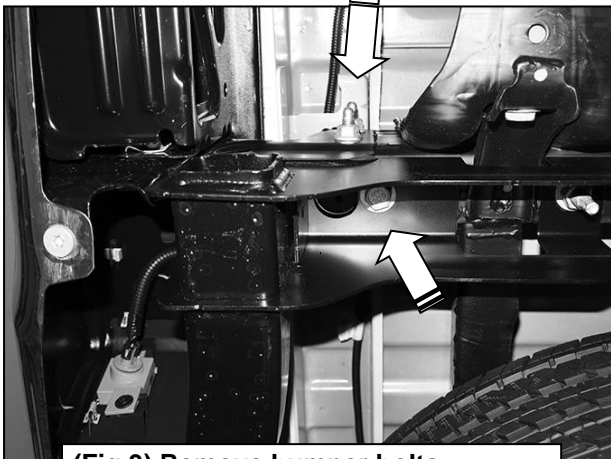


(Fig 1) Release clips to remove plastic bumper cover (arrow). Passenger side pictured from below



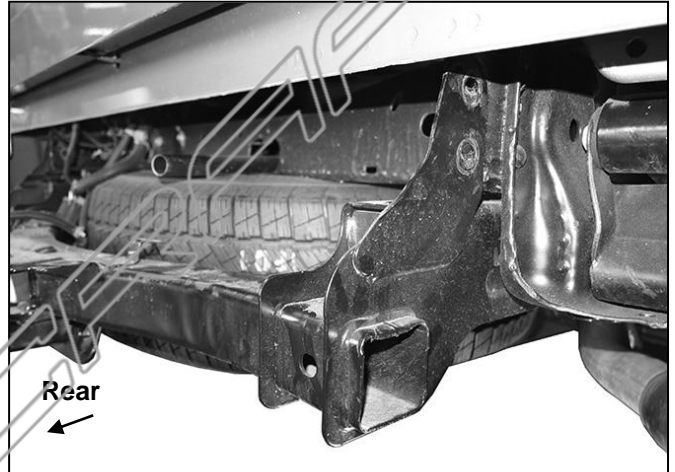
(Fig 2) Remove bumper bolts attaching bumper to inner bracket

Passenger side installation pictured



(Fig 3) Remove bumper bolts attaching brackets to frame (arrows)

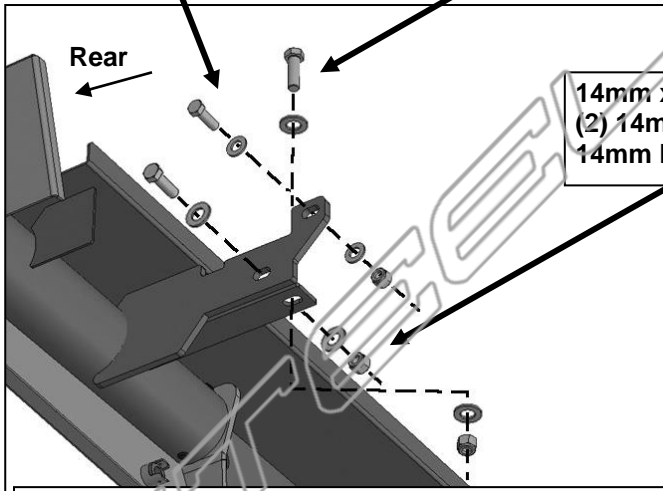
WARNING! Before removing hardware, fully support the weight of the bumper with blocks or stands to prevent injury or damage to the vehicle.



(Fig 4) End of frame once factory bumper is removed

10mm x 50mm Hex Bolt
(2) 10mm Flat Washers
10mm Nylon Lock Nut

14mm x 45mm Hex Bolt
(2) 14mm Flat Washers
14mm Nylon Lock Nut



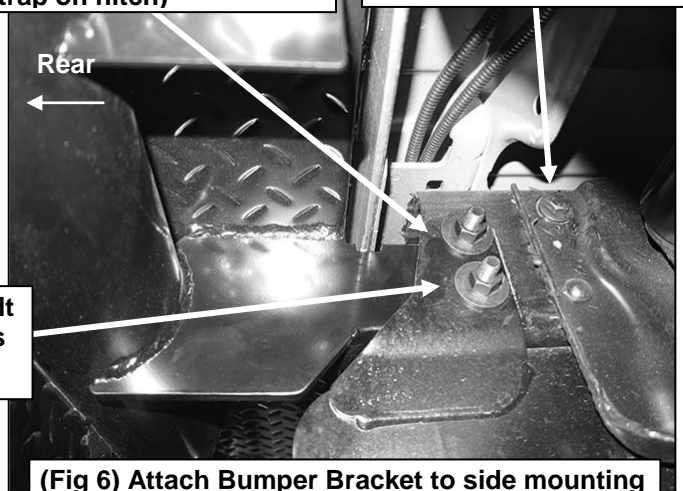
(Fig 5) Attach passenger side of Bumper to frame

14mm x 45mm Hex Bolt
(2) 14mm Flat Washers
14mm Nylon Lock Nut

Replace top factory hex bolt with:
14mm x 45mm Hex Bolt
(2) 14mm Flat Washers
14mm Nylon Lock Nut
(if equipped with support strap on hitch)

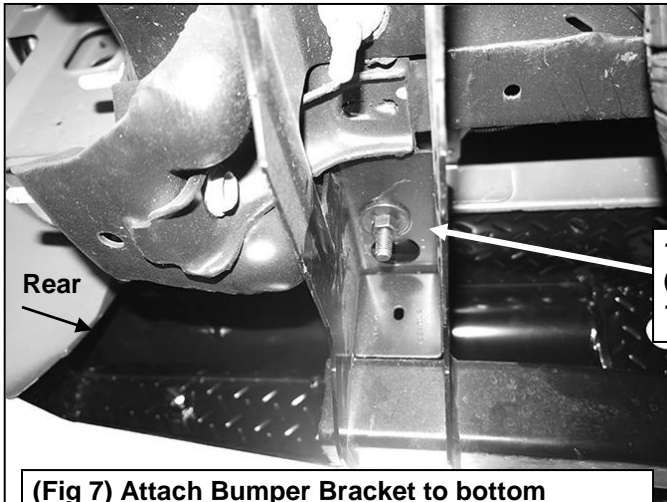
10mm x 50mm Hex Bolt
(2) 10mm Flat Washers
10mm Nylon Lock Nut

14mm x 45mm Hex Bolt
(2) 14mm Flat Washers
14mm Nylon Lock Nut



(Fig 6) Attach Bumper Bracket to side mounting holes in frame and hitch if equipped

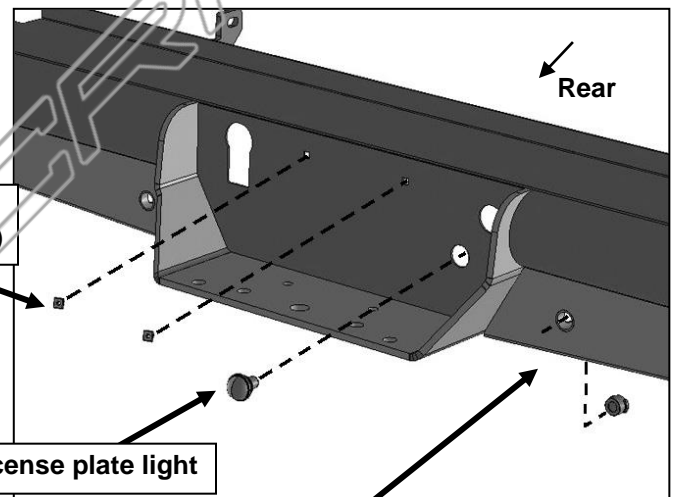
Passenger side installation pictured



WARNING! To avoid possible injury or damage to vehicle, fully support the weight of the bumper with blocks or stands during installation.

14mm x 45mm Hex Bolt
(2) 14mm Flat Washers
14mm Nylon Lock Nut

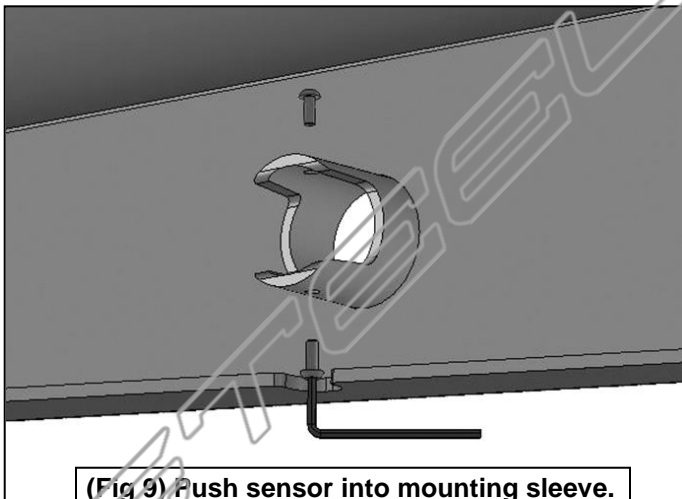
(Fig 7) Attach Bumper Bracket to bottom mounting holes in frame and hitch if equipped



(2) License plate mounting nuts (plugs)

License plate light

(Fig 8) On models without rear bumper sensors, use included rubber plugs to fill sensor holes



(Fig 9) 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.



Complete Installation