



SIGNATURE SERIES
GMC SIERRA
2500 HD
FRONT BUMPER

INSTALLATION INSTRUCTIONS

****PLEASE READ THROUGH THE INSTRUCTIONS
BEFORE BEGINNING ANY PART OF THE
INSTALLATION PROCESS****

1.

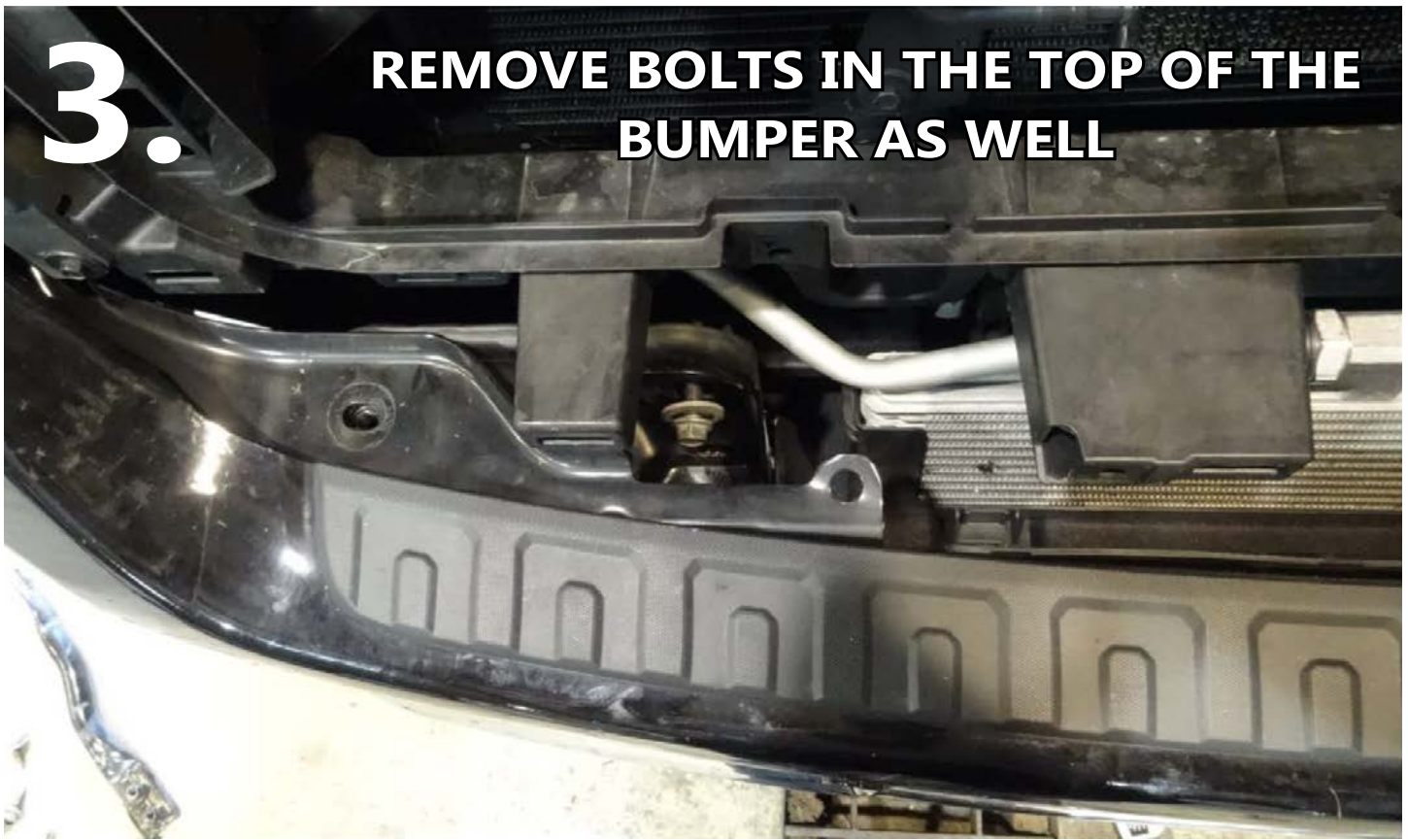
**REMOVE THE GRILLE TO ACCESS
FRONT BUMPER BOLTS.**



2.

**REMOVE BOLTS ATTACHING
BUMPER TO THE FRAME RAILS**





YOU WILL BE REQUIRED TO CUT AND SPLICE THE WIRES FOR THE SENSORS, AS THE WIRES WILL NOT BE LONG ENOUGH FOR THE NEW BUMPER.



5.



THE BACK HOLES ON THE MOUNTS WILL NEED THE FRAME DRILLED. THE HOLE SPACING FOR THESE HOLES (CENTER TO CENTER) WILL BE 2-1/2". THESE HOLES SHOULD BE DRILLED WITH A 9/16" DRILL BIT.

6.

USE A CENTER PUNCH TO MARK THE EXACT CENTER OF EACH HOLE.

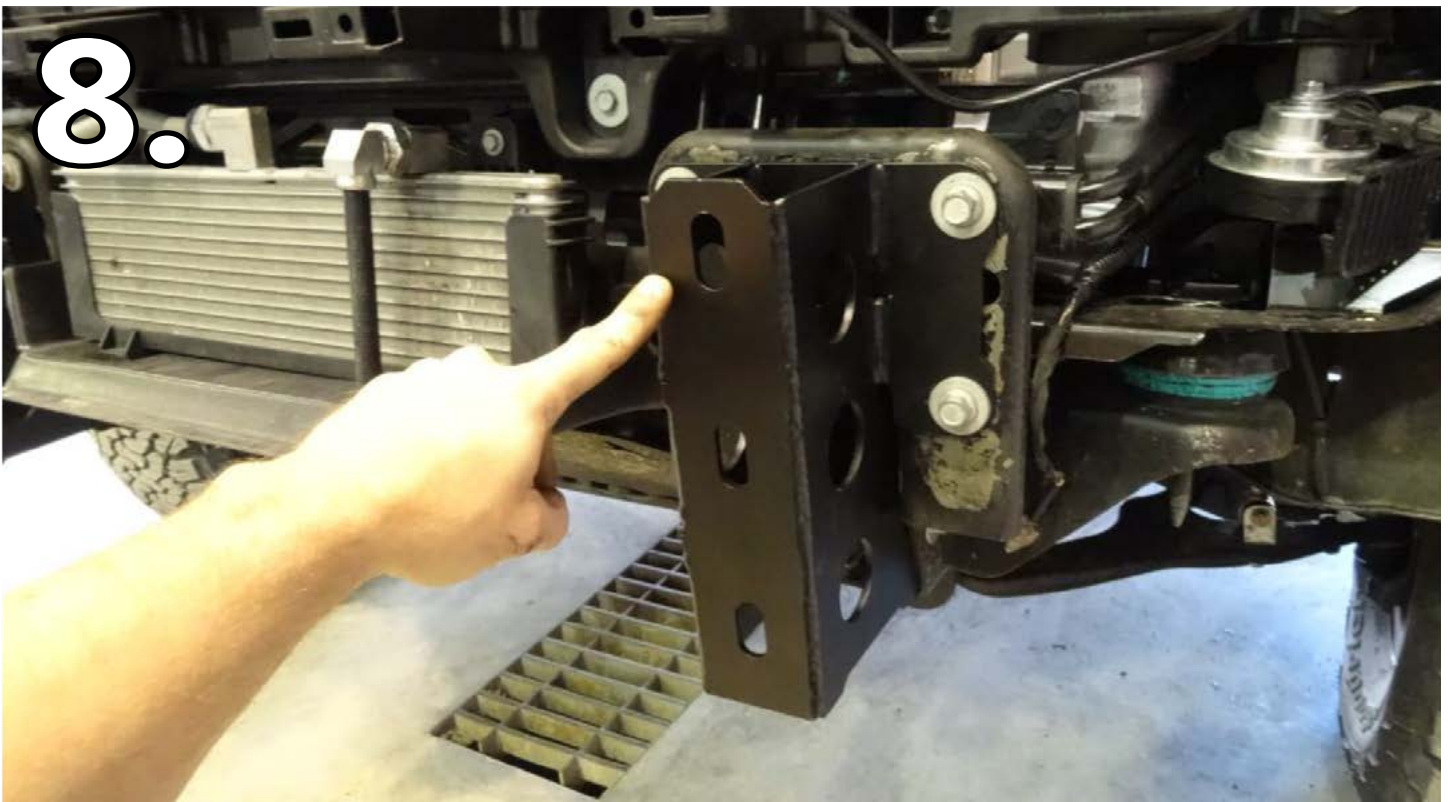


7.

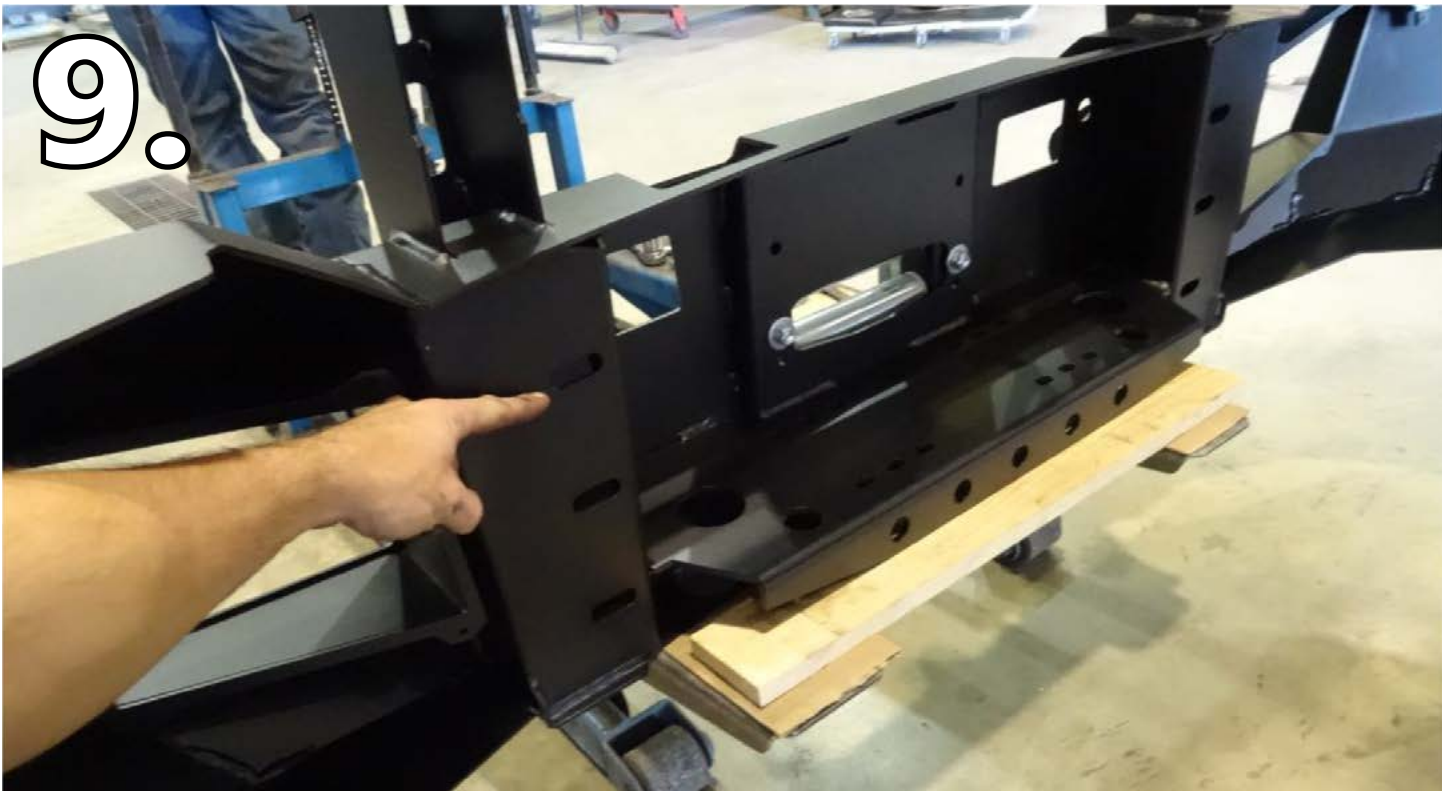
DRILL A PILOT HOLE USING A 1/4" OR SMALLER BIT, THROUGH BOTH SIDES OF THE FRAME



8.



WITH THE FRAME MOUNTS INSTALLED, TIGHTEN ALL 8 OF THE 1/2" x 1-3/4" BOLTS. THE FRAME MOUNTS ARE SLOTTED IN DIFFERENT DIRECTIONS TO ALLOW ADJUSTABILITY WHEN MOUNTING THE BUMPER.



9. MOUNT BUMPER USING THE **5/8" x 2"** BOLTS PROVIDED. ADJUST THE BUMPER SO THE TOP SURFACE HAS AN EVEN GAP ALONG THE TOP.



10. ONCE THE BUMPER HAS BEEN PROPERLY ALIGNED, MARK THE INNER FENDER WELL ON EACH SIDE. THEN CUT OFF SO THAT THE FENDER MATCHES UP TO THE BUMPER!