



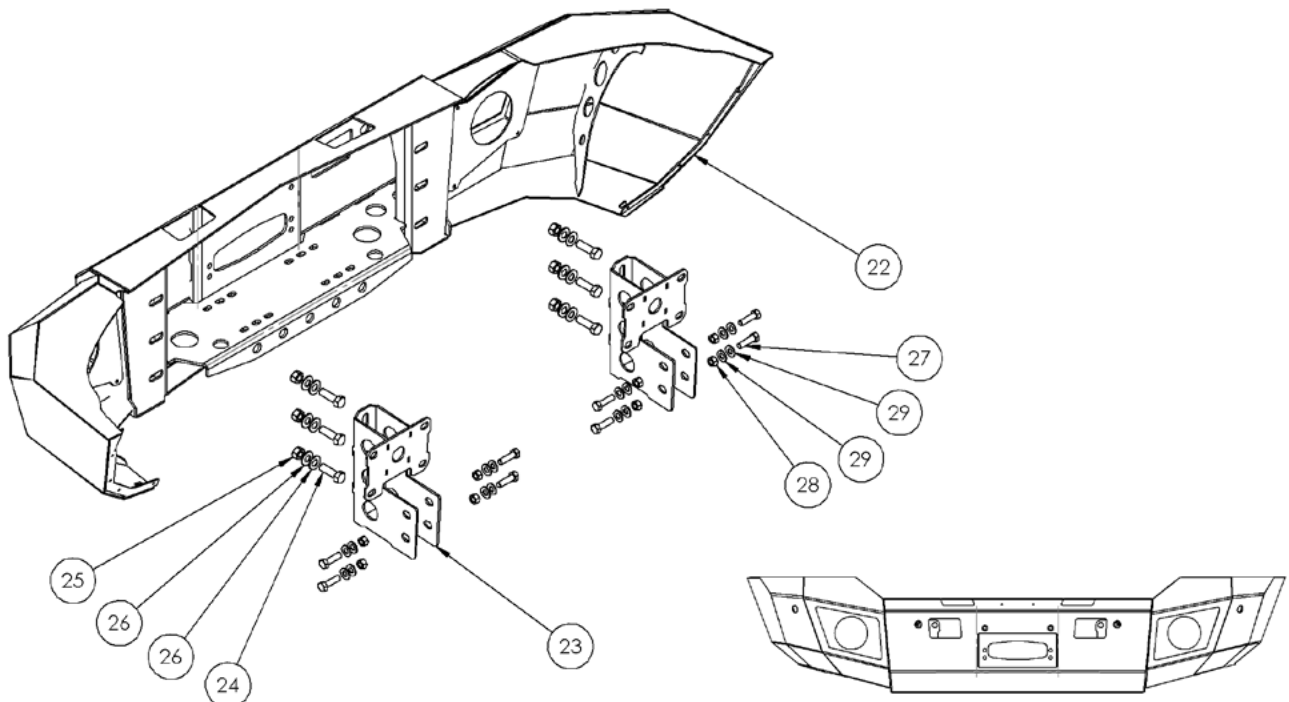
SIGNATURE SERIES
GMC SIERRA
2500 HD
 FRONT BUMPER

INSTALLATION INSTRUCTIONS

****PLEASE READ
 THROUGH THE
 INSTRUCTIONS
 AND CHECK ALL
 PARTS BEFORE
 BEGINNING ANY
 PART OF THE
 INSTALLATION
 PROCESS****

Parts List

ITEM NO.	PART NUMBER	DESCRIPTION	General Assembly/QTY.
22	GFB1001	GMC 2500 Front Bumper	1
23	4GFB1501-03	GMC Front Bumper Mounts	2
24	HBOLT 0.6250-11x2x1.5-N	5/8" x 2" Hex Bolt	6
25	HNUT 0.6250-11-D-N	5/8" Hex Nut	6
26	FW 0.625	5/8" Washer	12
27	HBOLT 0.5000-13x1.75x1.25-N	1/2" x 1-3/4" Hex Bolt	8
28	HNUT 0.5000-13-D-N	1/2" Hex Nut	8
29	FW 0.5	1/2" Washer	16



1.

REMOVE THE GRILLE TO ACCESS FRONT BUMPER BOLTS.



2.

REMOVE BOLTS ATTACHING BUMPER TO THE FRAME RAILS



3.

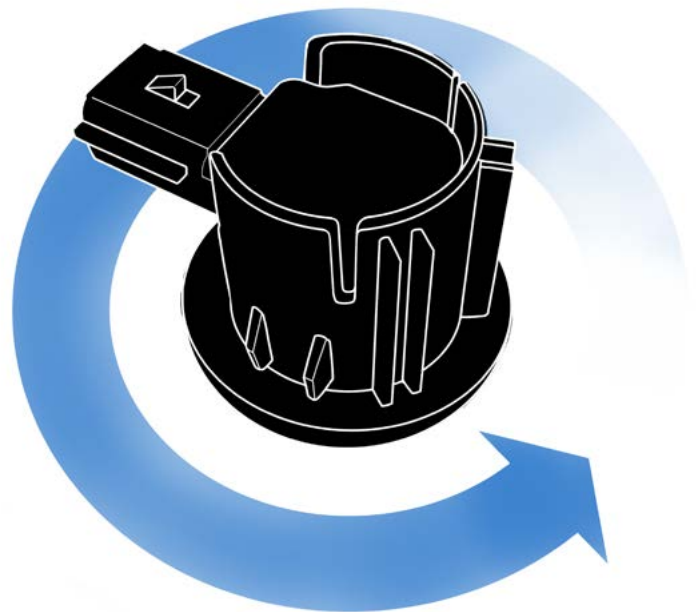
REMOVE BOLTS IN THE TOP OF THE BUMPER AS WELL



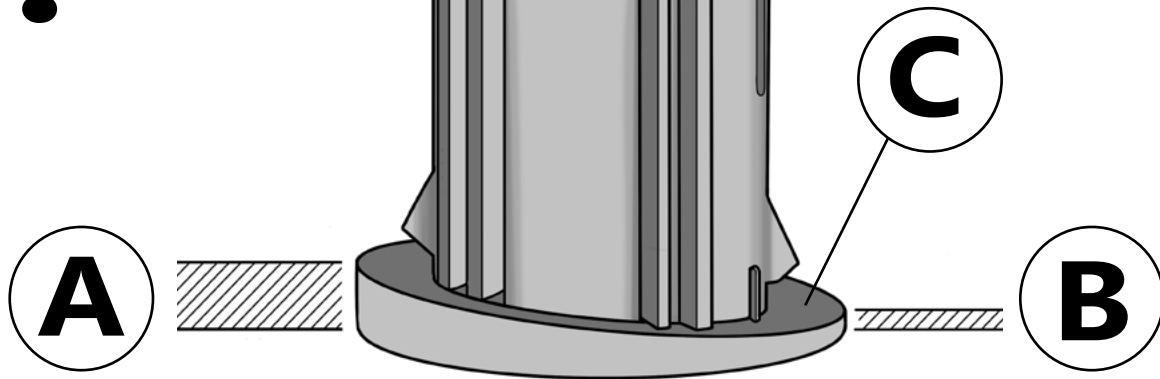
IMPORTANT: The next two steps will show you proper sensor placement in the new bumper. Placing them correctly is crucial, so that the safety systems will work as designed.

4.

First, note the direction the plug is facing relative to the bumper. You will be installing the sensors facing the same way in the new bumper.



5.



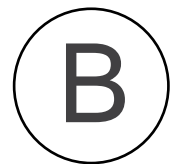
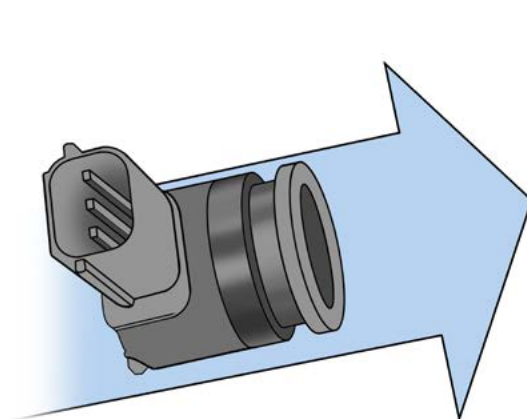
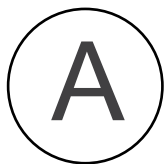
When positioning the sensors, also pay attention to the bezel. Side “A” is thicker than “B”, to seat the sensor at an angle. You must position it in the same way as in the factory bumper. Apply a dab of glue to the surface labelled “C”

6.

The sensor assembly is made of two parts: (A) and (B).

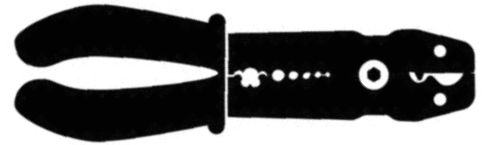
To **REMOVE** the sensor, pop out A first, then B.

To **INSTALL** the sensor, place the sleeve labelled B in first, then insert A.

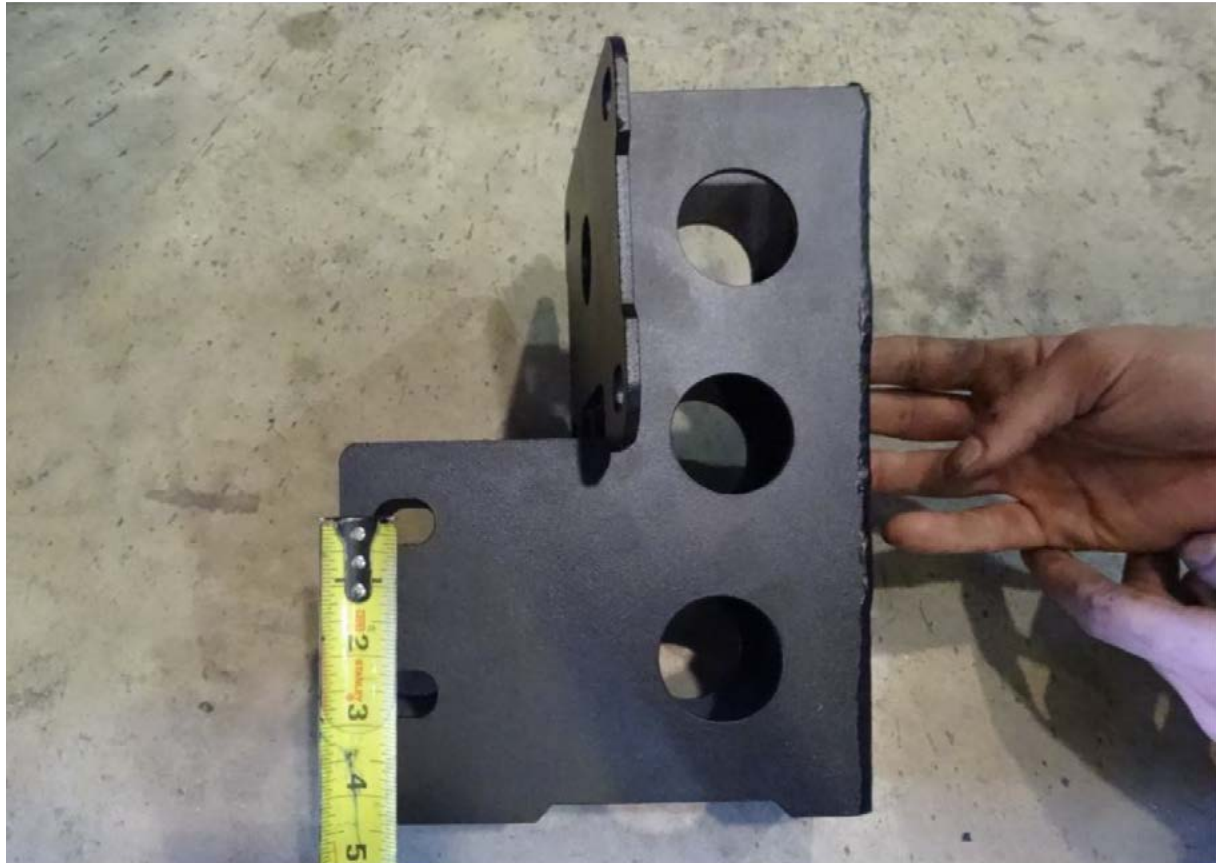




****YOU WILL BE REQUIRED TO CUT AND SPLICE THE WIRES FOR THE SENSORS, AS THE WIRES WILL NOT BE LONG ENOUGH FOR THE NEW BUMPER.****



8.



THE REAR HOLES ON THE MOUNTS WILL NEED TO HAVE 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.

9.

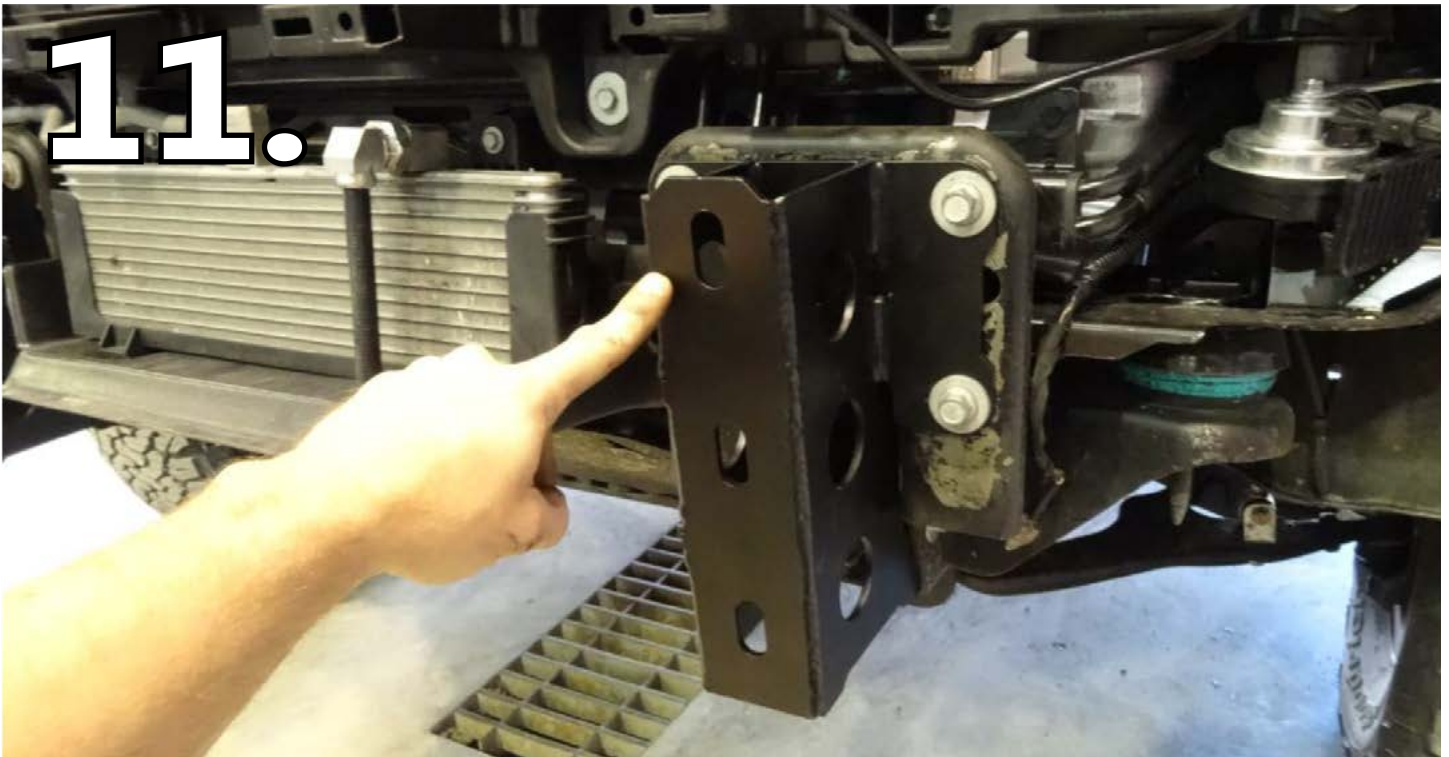
USE A CENTER PUNCH TO MARK THE EXACT CENTER OF EACH HOLE.



10.

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





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.



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

13.



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!