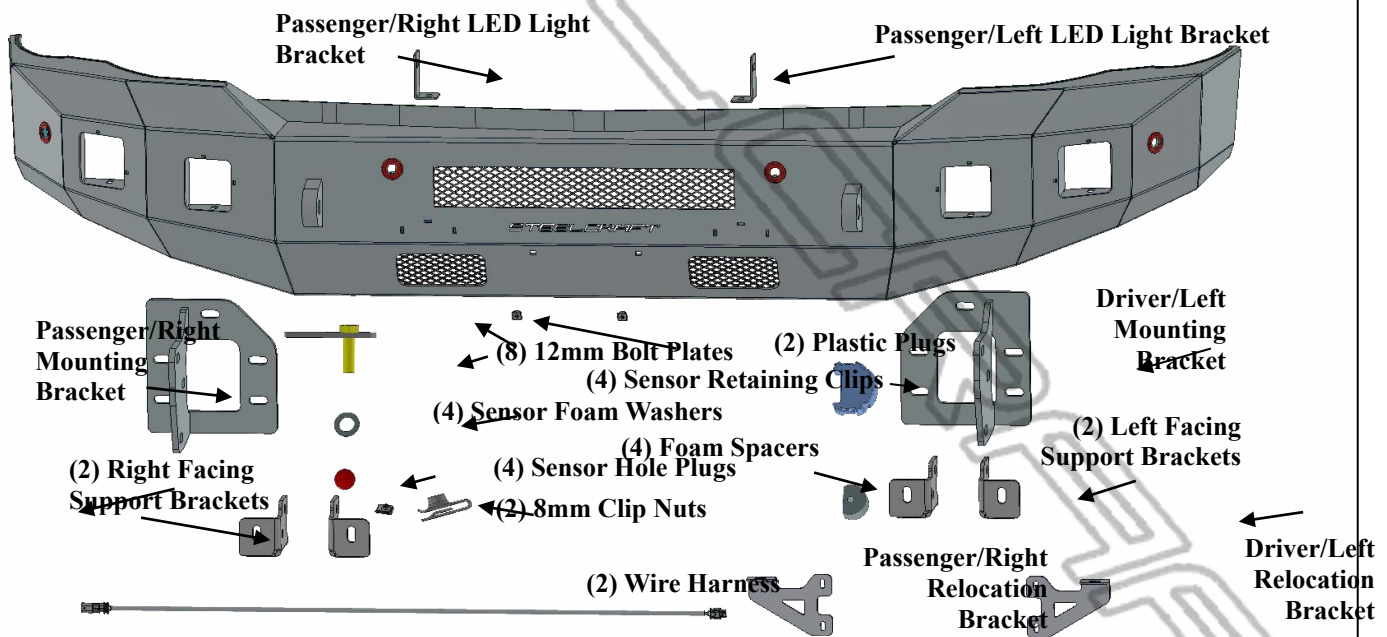


**STEELCRAFT FORTIS FRONT BUMPER
2022-24 SILVERADO 1500**

Qty	Description	Qty	Description
1	Fortis Front Bumper	8	12mm x 40mm Bolt Plates
1	Driver/left Mounting Bracket	28	12mm x 32mm x 3mm Flat Washers
1	Passenger/right Mounting Bracket	18	12mm Lock Washers
1	Skid Plate	10	12mm x 50mm Hex Bolts
1	Intercooler Shutter Relo Bracket (left)	18	12mm Hex Nuts
1	Intercooler Shutter Relo Bracket (right)	8	8mm x 24mm x 2mm Flat Washers
1	Driver/left LED light L-bracket	6	8mm Lock Washers
1	Passenger/right LED light L-bracket	2	8mm Hex Nuts
2	Left Facing Support Brackets	2	8mm Clip Nuts
2	Right Facing Support Brackets	2	8mm x 16mm Hex Bolts
2	Plastic Plugs for license plate mount	4	8mm x 25mm Hex Bolts
2	Parking Sensor Wire Extenders	12	6mm x 18mm x 1.6mm Flat Washers
4	Sensor Retaining Caps	4	6mm Nylon Lock Nuts
4	Plastic Sensor Hole Plugs	4	6mm x 25mm Hex Bolts
1	Sensor Cover Kit	4	6mm x 25mm Button Head Bolts
4	20mm x 10mm Foam Spacers	4	6mm Lock Washers
4	15.5mm x 25mm OD x 2mm Foam Washers	2	Rubber Trim
8	4mm Self Tapping Screws	1	Allen Wrench



Procedure:

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

1. Start installation at the driver/left wheel opening. Remove the screws/clips attaching the inner fender liner to the end of the bumper and fascia body panel, **(Figures 1 & 2)**. Open the hood and remove the bolts attaching the front end of the front fender to the end of the fascia, **(Figure 3)**. Repeat this **Step** to release the passenger/right end of the fascia panel. Pull the ends of the fascia out from below the headlights and from across the front of the vehicle, **(Figure 4)**.

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2. Temporarily remove the hood release handle and plastic cover from the top of the grille and radiator, **(Figure 5)**. Reattach the hood release handle. Next, remove the hardware attaching the grille to the radiator core support and along the bottom, **(Figure 6)**. Once all hardware has been removed, firmly pull the grille straight out from the vehicle to release the grille from the clips. Place grille on a clean, soft surface. (Models with grille mounted camera, unplug camera if equipped.)
3. Remove the license plate and bracket. On models with factory fog lights and/or bumper sensors, unplug the wiring harness leading to the bumper. On **diesel models**, unplug the harness leading to the block heater plug in the bumper. **NOTE:** Main wiring harness connector is located up and behind the passenger/right side of the bumper. Release clips attaching passenger/right fender liner to access plug for harness. Move harness away from bumper.
4. From behind the driver/left side of the bumper, remove the outer bumper support connected to the side of the frame and the outer end of the bumper, **(Figure 7)**.
5. Locate and remove the hex bolts attaching the bottom of the bumper to the bumper bracket attached to the end of the frame, **(Figure 8)**.
6. Repeat **Steps 4 & 5** to remove the passenger/right bumper support and lower bumper hardware.
7. Move back to the top of the bumper. Remove the cover from the top of the bumper, **(Figure 9)**. Locate the hex bolts attaching the top of the bumper bracket to the frame, **(Figure 10)**.
8. 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 bumper bolts attaching the bumper assembly to the top of the bumper bracket, **(Figure 10)**. **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.
9. Remove both bumper brackets and tow hooks, if equipped, from the end of the frame, **(Figure 11)**.
10. On turbocharger equipped models (gas or diesel powered).
 - a. Remove the lower shutter assembly, **(Figures 11 & 12)**. Remove the shutter mechanism from the outer housing, **(Figure 13)**.
 - b. Insert (1) 8mm Clip Nut into the triangle shaped hole in the end of the frame on the bottom, **(Figure 14)**. Line up the Nut on the Clip Nut with the round hole directly behind the triangle hole.
 - c. Select the driver/left Relocation Bracket, **(Figure 15)**. Attach the Bracket to the Clip Nut with (1) 8mm x 25mm Hex Bolt, (1) 8mm Lock Washer and (1) 8mm Flat Washer. Repeat to attach the passenger/right Relocation Bracket.
 - d. Attach the shutter assembly to the back of the Relocation Brackets with the included (4) 6mm x 25mm Hex Bolts, (8) 6mm Flat Washers and (4) 6mm Nylon Lock Nuts, **(Figures 16 & 17)**. Fully tighten hardware at this time. Plug wire harness into shutter mechanism.
11. Select (1) Left Facing and (1) Right Facing Support Bracket, **(Figure 18)**. Starting on the driver/left side, attach the Right Facing Support Bracket to the inner facing side of the frame with (2) 12mm Bolt Plates, (2) 12mm Flat Washers and (2) 12mm Nylon Lock Nuts. Next, attach (1) Left Facing Support Bracket to the outer facing side of the frame with (2) 12mm Bolt Plates, (2) 12mm Flat Washers and (2) 12mm Nylon Lock Nuts, **(Figures 18 & 19)**. Do not tighten hardware at this time.
12. Select the driver/left Frame Mounting Bracket, **(Figure 20)**. Reuse the (3) factory bumper bolts to attach the top mounting holes on the Mounting Bracket to the threaded bumper mount. Attach the (2) lower holes in the Mounting Bracket to the (2) Support Brackets with (2) 12mm x 50mm Hex Bolts, (4) 12mm Flat Washers and (2) 12mm Nylon Lock Nuts, **(Figure 21)**. Snug but do not fully tighten hardware at this time.
13. Reinstall the plastic grille, camera if equipped and top cover removed in **Step 1 and Step 2**. Reinstall the plastic fascia body panel, **(Figure 22)**. Reattach the fender liners.
14. Carefully unwrap the Bumper assembly.
15. Determine if the vehicle is equipped with front bumper sensors. **NOTE:** Sensors and/or bumper wiring harness must be installed in Bumper before installing Bumper Assembly.

Models without Bumper Sensors:

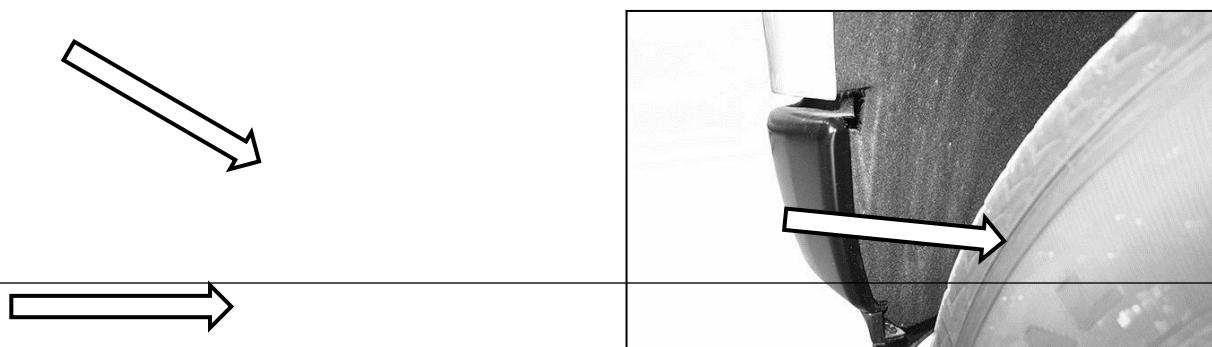
 - a. From the front of the bumper, push the included Plugs into the sensor mount holes, **(Figure 23)**.

Models with bumper mounted sensors:

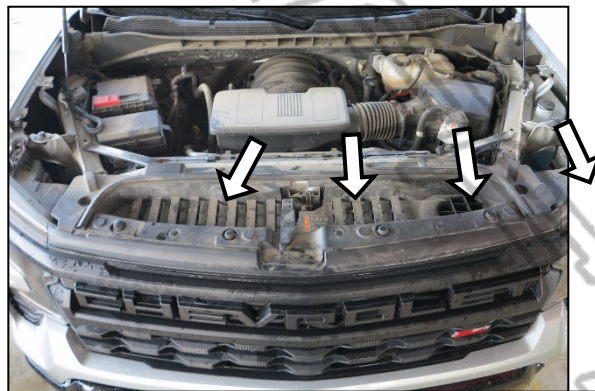
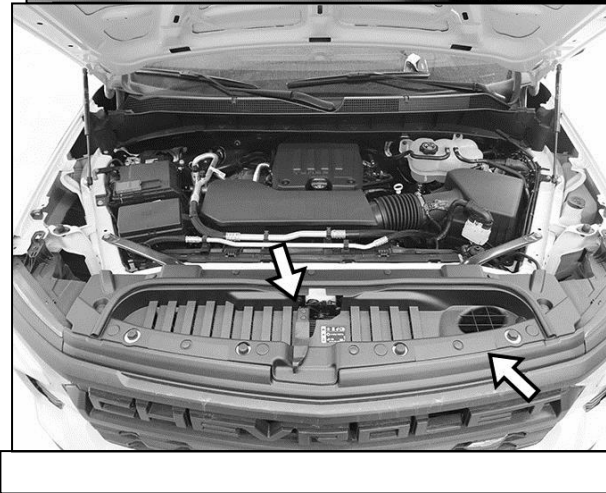
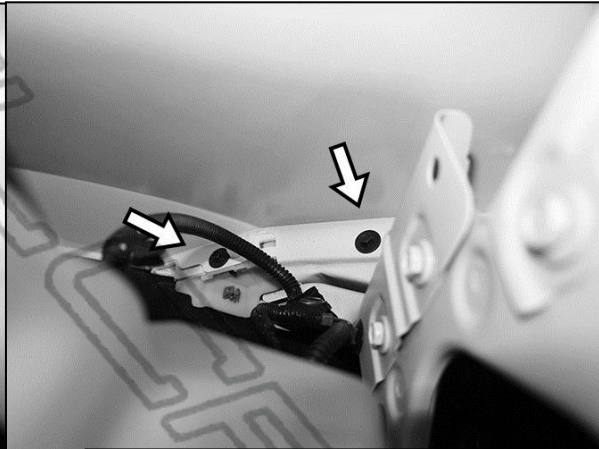
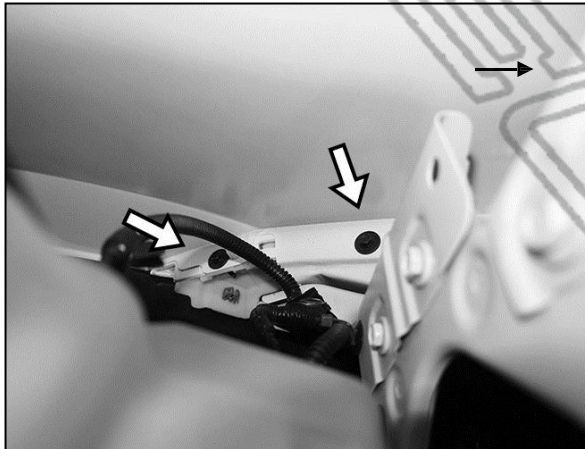
**STEELCRAFT FORTIS FRONT BUMPER
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- a. Remove the sensors and wiring harness from the factory bumper.
 - b. Remove the factory sealing washer from the sensor. Attach the provided Foam Sealing Washer to the front of the sensor, **(Figure 24)**.
 - c. Push the sensor in from the back of the Bumper until it is flush with the outer Bumper. Place (1) Foam Spacer over the end of the sensor. Push the Retaining Cap onto the sensor mount and snap into place, **(Figures 24 & 25)**.
 - d. Repeat the previous **Steps** for the remaining sensors.
 - e. Attach factory wiring harness to Bumper. **NOTE:** Use the (2) included Wire Harnesses to extend the factory harness to the sensors as needed.
- 16. Center LED light installation (sold separately)**
- a. Select the L/R “L” Brackets, **(Figure 26)**. Attach the Brackets to the top of the (2) mounting tabs welded onto the back of the bumper with the included 8mm x 25mm Hex Bolts, (4) 8mm Flat Washers, (2) 8mm Lock Washers and (2) 8mm Hex Nuts. Leave loose at this time.
 - b. Attach the LED light assembly to the “L” Brackets with the included (2) 8mm x 16mm Hex Bolts, (2) 8mm Lock Washers and (2) 8mm Flat Washers, **(Figure 26)**. Do not fully tighten hardware at this time. **IMPORTANT:** “L” Brackets are designed for 8mm light mounting hardware only. Modify “L” Brackets if necessary or use brackets supplied by the light manufacturer if possible, to install hardware larger than 8mm.
 - c. Follow light manufacturer’s instructions to properly wire the light.
- 17.** Push the included Edge Trim onto the top edge of the Bumper, **(Figure 27)**. Cut Edge Trim to fit.
- 18.** With assistance, position the Bumper up to 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.
- 19.** Line up the (3) slots in the driver/left side mounting plate on the back of the Bumper with the (3) slots in the Mounting 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, **(Figures 28 & 29)**. Repeat this **Step** to attach the passenger/right side of the Bumper to the Bracket.
- 20.** Level and adjust the Bumper and fully tighten all 12mm hardware to 65-70ft-lbs.
- 21. Skid Plate installation on turbocharger equipped models (gas or diesel). NOTE: Installation is optional on non turbo charger equipped gas models.**
- a. Attach the front end of the Skid Plate to the bottom of the Bumper **(Figure 30)** using (4) 6mm x 25mm Button Head Bolts, (4) 6mm Flat Washer, (4) 6mm Nylon Lock Nuts.
 - b. Finish installing the back end of the skid plate **(Fig 31)** using the factory hardware.
- 22.** Use the included (2) 6mm x 25mm Button Head Bolts, (4) 6mm Flat Washers and (2) 6mm Nylon Lock Nuts to attach the driver/left fender liner to the OE plastic fender liner bracket (optional). Use a 1/4” drill bit to drill mounting holes through the bracket and the fender liner, **(Figure 32)**. Repeat this **Step** to attach the passenger/right fender liner. Trim the bottom of the fender liner flush with the bottom of the bumper.
- 23.** Use the included (2) push-in Plastic Plugs to attach the front license plate, (if required), to the (2) square holes in the center of the Bumper, **(Figure 33)**.
- 24.** Do periodic inspections to the installation to make sure that all hardware is secure and tight.

To protect your investment, 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 Front Bumper assembly.

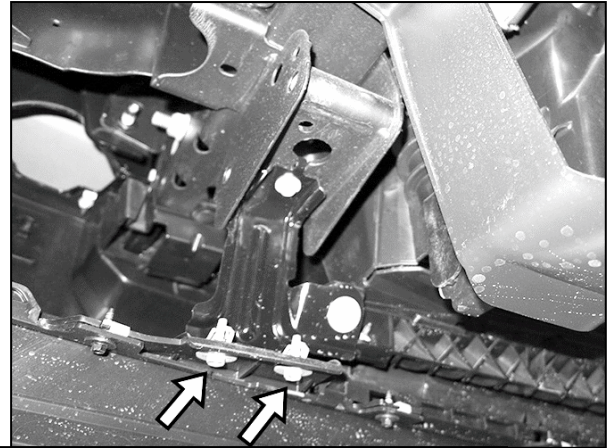
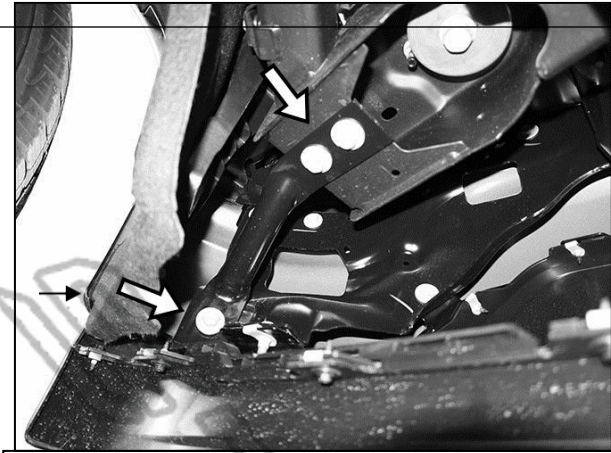


Driver/left Side Installation Pictured

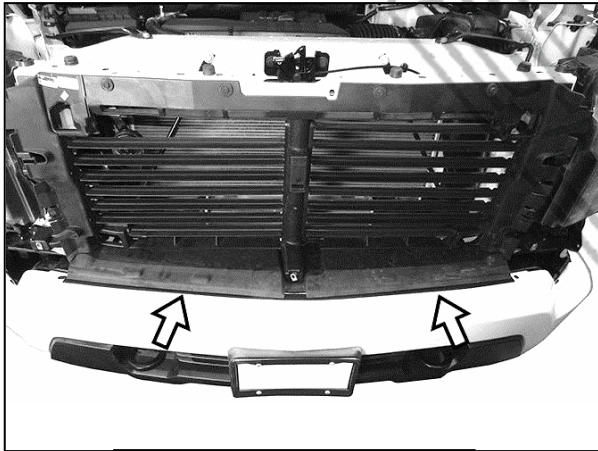


(Fig 6) Remove hardware attaching top and bottom of grille. Firmly pull grille straight out from vehicle

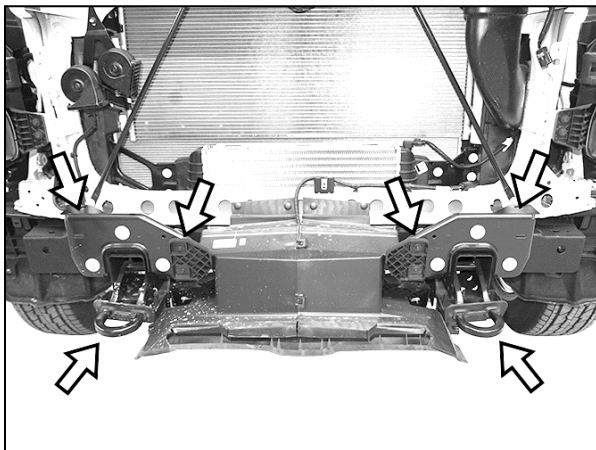
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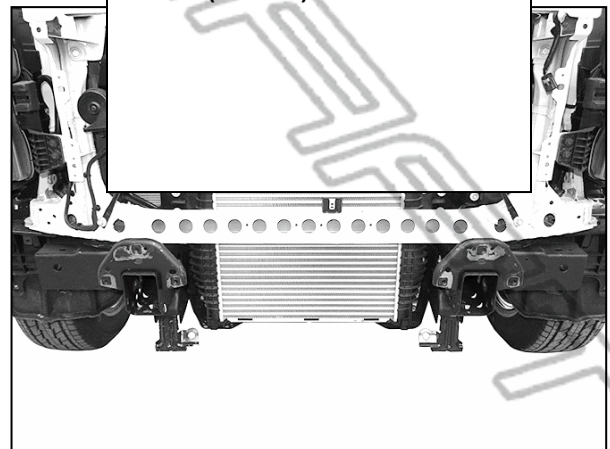
(Fig 8) Remove bolts attaching bottom of bumper to brackets (arrows). Driver/left side pictured



(Fig 10) Remove driver/left top bumper bolts (arrows)



(Fig 11) Remove bumper brackets and tow hooks if equipped. Models with turbo, unplug harness and remove shroud and shutter assembly

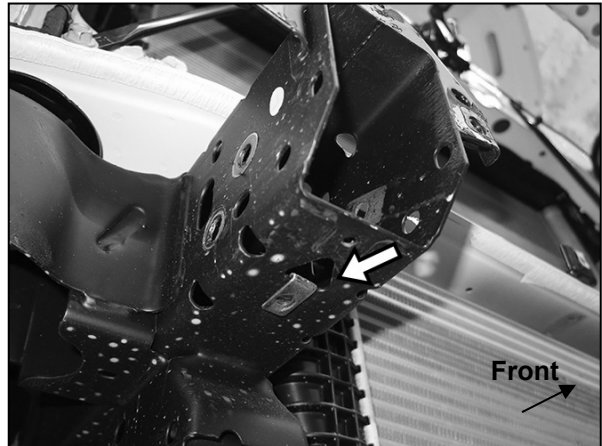


(Fig 12) Models with turbo, shroud and shutter assembly removed

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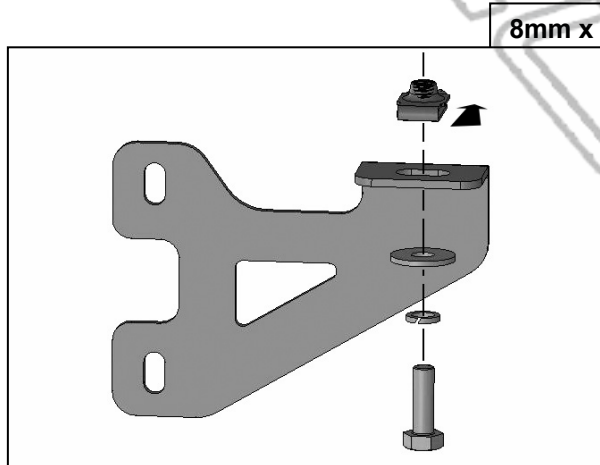


(Fig 13) Models with turbo, remove shutter assembly from shroud. Gas model with turbo pictured

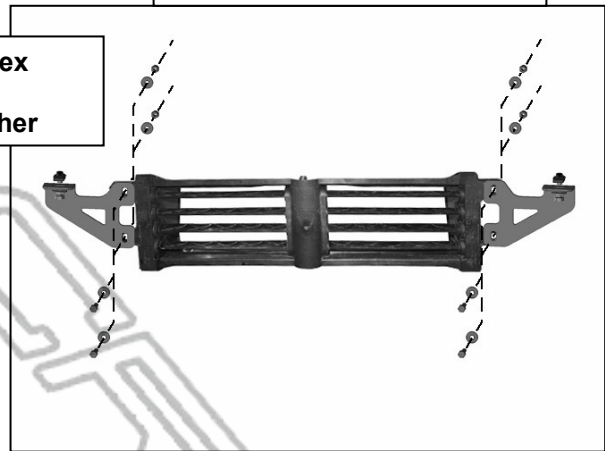


(Fig 14) Turbo model only, slide 8mm Clip Nut into triangle hole and over round hole (arrow)

- (4) 6mm x 25mm Hex Bolts
- (8) 6mm Flat Washers
- (4) 6mm Nylon Lock Nuts

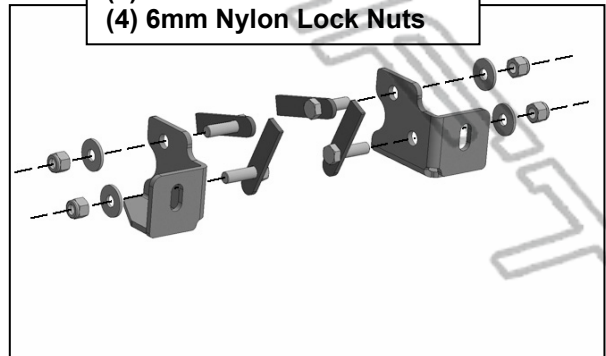


(Fig 15) Turbo model only, attach Driver/left shutter Relocation Bracket to 8mm Clip Nut in bottom of frame (see Fig 14). Repeat for passenger/right Bracket



(Fig 16) Turbo model only, attach shutter mechanism to back of Relocation Brackets. Diesel model pictured

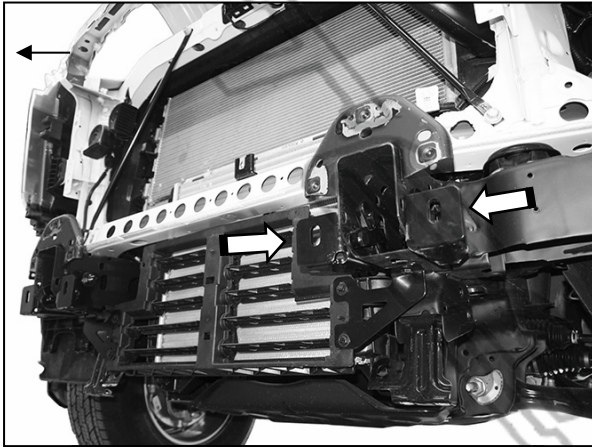
- (4) 6mm x 25mm Hex Bolts
- (8) 6mm Flat Washers
- (4) 6mm Nylon Lock Nuts



(Fig 18) Attach Support Brackets to outside of frame

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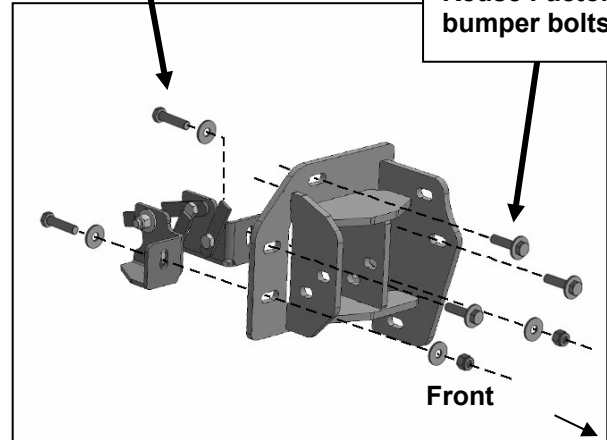
Front



(Fig 19) Support Bracket installed

**(2) 12mm x 50mm Hex Bolts
(4) 12mm Flat Washers**

Reuse Factory bumper bolts



(Fig 20) Reuse factory bumper bolts to attach top of Frame Bracket to bumper mount on frame. Diver/left Bracket

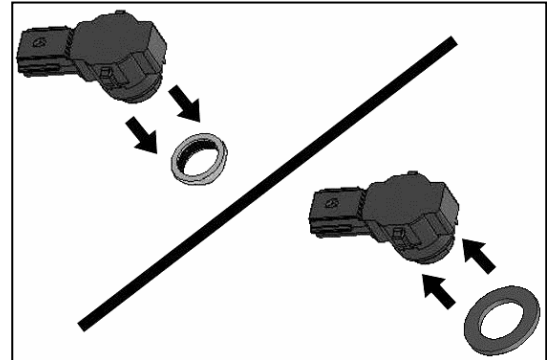
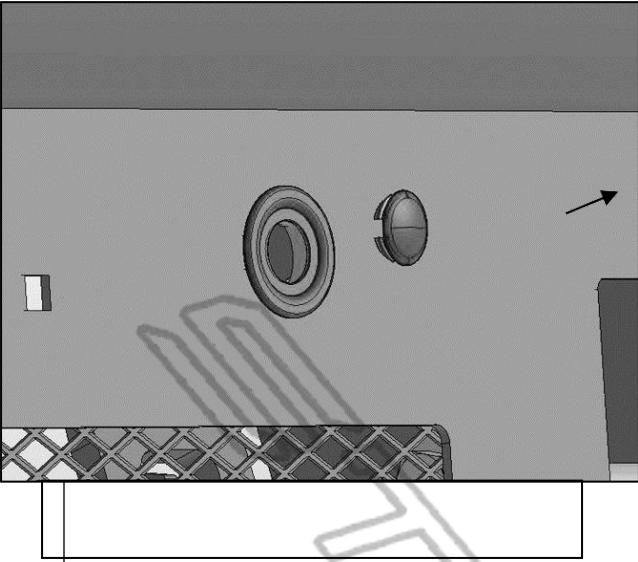


(Fig 21) Complete installation of Frame Brackets

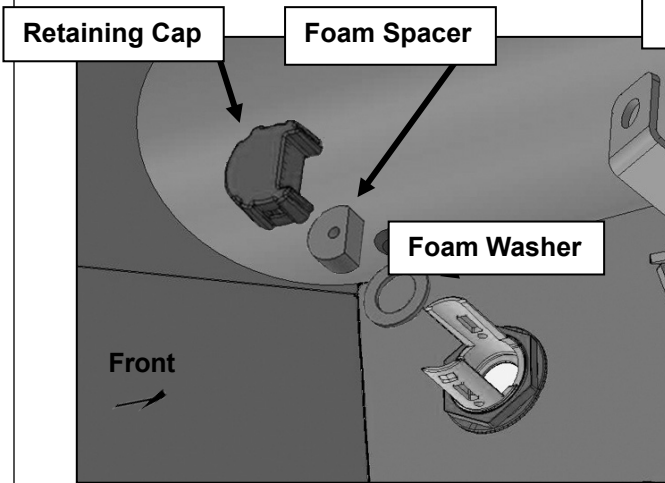


(Fig 22) Reinstall fascia body panel, grille and cover. Re-attach inner fender liners

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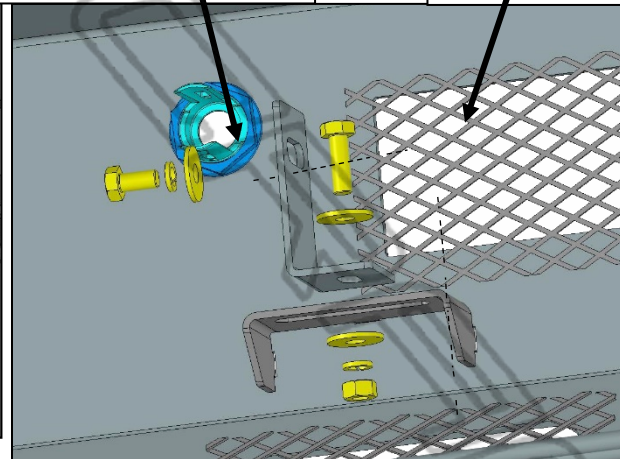
(Fig 24) Remove silicone seal from sensor. Slide large Seal over end of sensor (arrow)



(Fig 25) Insert sensor assembly through the sensor mount on back of Bumper

**8mm x 16mm Hex Bolt
8mm Lock Washer
8mm Flat Washer**

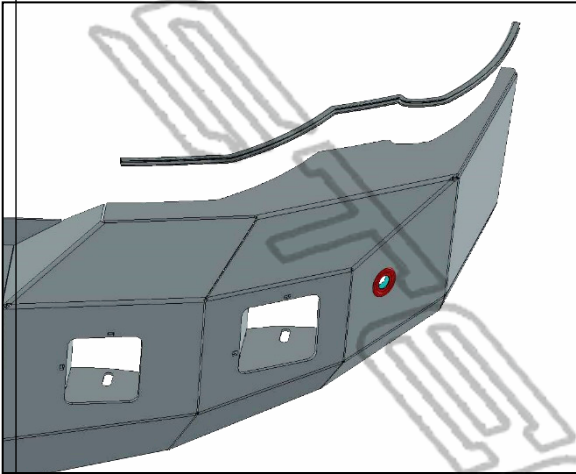
**8mm x 25mm Hex Bolt
(2) 8mm Flat Washers
8mm Lock Washer
8mm Hex Nut**



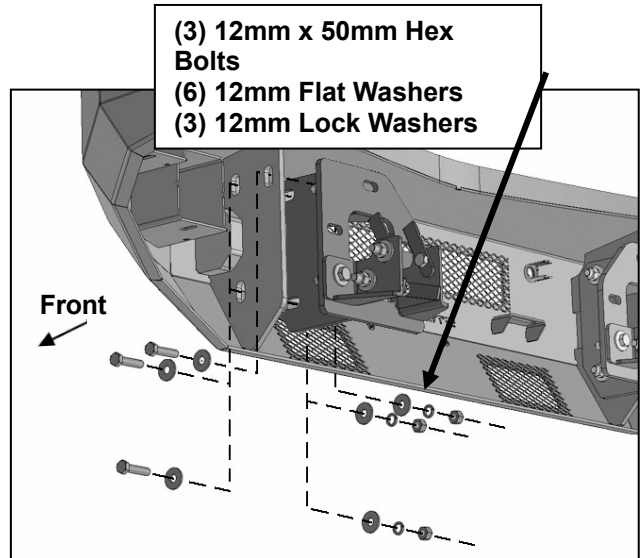
(Fig 26) Universal LED Brackets

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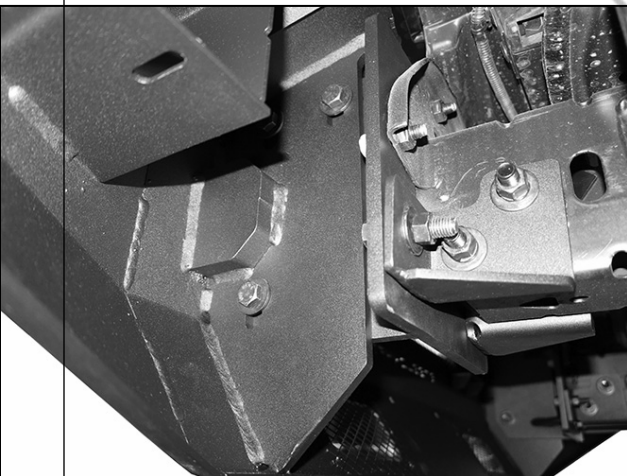
WARNING! Do not crawl under bumper unless the bumper is properly supported on blocks or stands or the bumper may fall.



(Fig 27) Apply Rubber Trim to inner edge of Bumper, remove after Bumper installation is complete

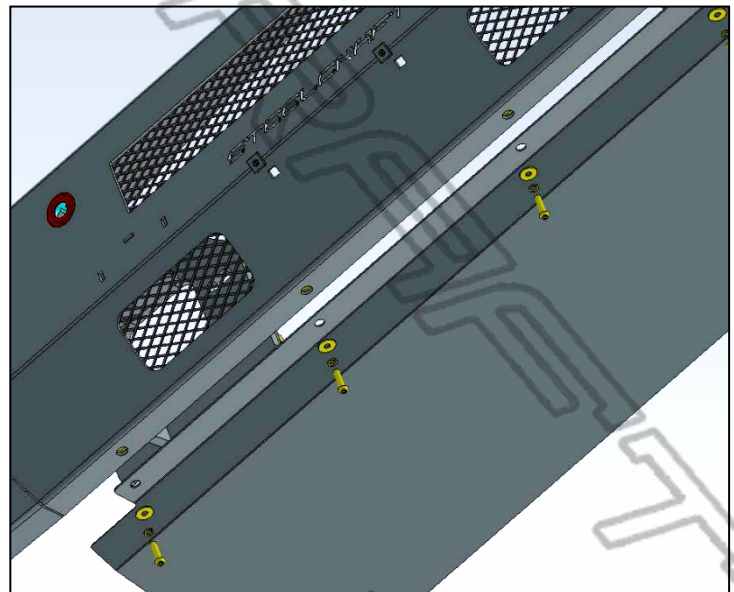


(Fig 28) Attach the Bumper to Frame Bracket



(Fig 29) Driver/left side of Bumper attached to Bracket

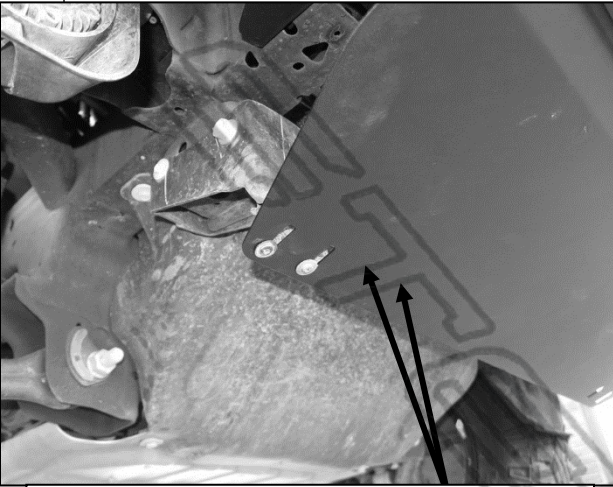
(4) 6mm Button Head Bolts
(4) 6mm Lock washers
(4) 6mm Flat Washers



(Fig 30) Attach front end of Skid Plate to the bottom of bumper.

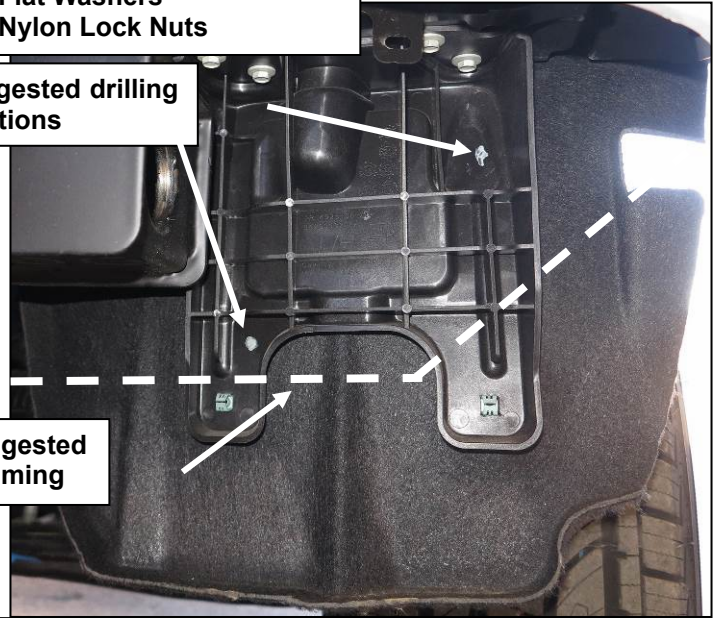
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- (2) 6mm x 25mm Button Head Bolts
- (4) 6mm Flat Washers
- (2) 6mm Nylon Lock Nuts



(Fig 31) Reuse factory hardware to attach back end of Skid Plate

Suggested drilling locations



Suggested trimming

(Fig 36) Attach the driver/left fender liner to the OE plastic fender liner bracket (optional). Use a 1/4" drill bit to drill mounting holes through the plastic bracket and the fender liner. Trim liner flush with bottom of bumper



(Fig 33) Attach License Plate Bracket to Bumper

Completed Installation