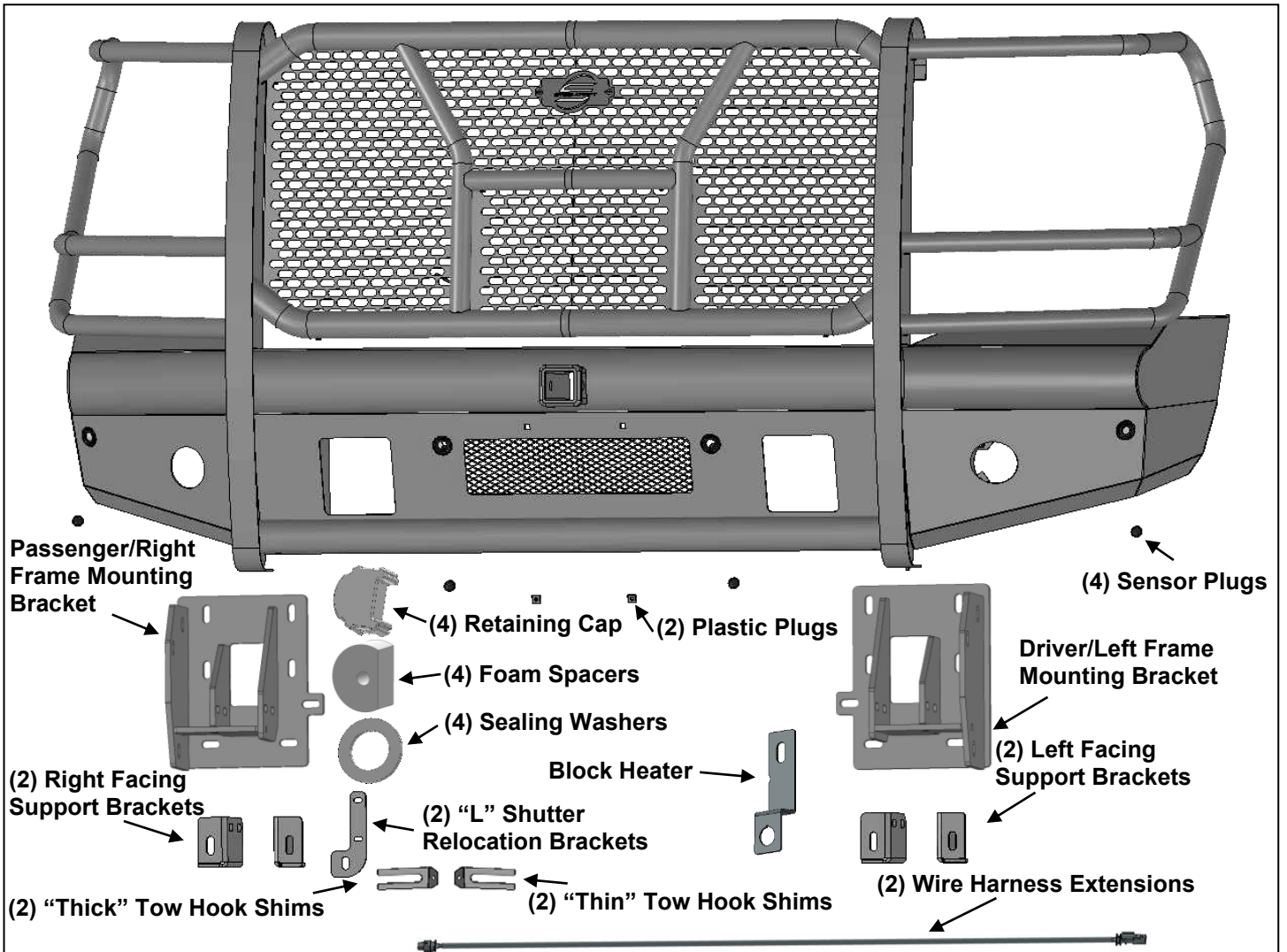


**HD REPLACEMENT FRONT BUMPER
2024 GMC SIERRA 25-3500**

PARTS LIST:

1	HD Replacement Front Bumper	22	12mm Lock Washers
1	Driver/left Mounting Bracket	22	12mm Hex Nuts
1	Passenger/right Mounting Bracket	4	12-1.75mm x 130mm Hex Bolts
2	Tow Hook Side Shims - Thick	18	12-1.75mm x 50mm Hex Bolts
2	Tow hook Side Shims - Thin	44	12mm x 32mm x 3mm Flat Washers
2	Left Facing Support Bracket	8	M10 lock washers
2	Right Facing Support Bracket	10	10mm x 34mm x 3mm Flat Washers
2	Shutter Relocation "L" Brackets	9	10-1.5mm x 40mm Hex Bolt
1	Block Heater Bracket	1	10mm Nylon Lock Nut
4	Sensor Plugs	2	8-1.25mm x 30mm Hex Bolt
4	Sealing Washers	4	8mm x 28mm x 3mm Flat Washers
4	20mm x 10mm Foam Spacers	2	8mm Nylon Lock Nuts
4	Retaining Caps	4	6-1.0mm x 20mm Hex Head Bolt
2	Sensor Wiring Harness Extensions	4	6mm Nylon Lock Nuts
2	Plastic Plugs for License Plate	8	6mm x 18mm flat washers
1	Sensor Covers Kit	6	5-0.75mm x 20mm Button Head Bolt
1	3mm Allen Wrench	6	5mm Nylon Lock Nuts
1	4mm Allen Wrench	12	5mm x 10mm x 1mm Flat Washers
2	Rubber Edge Trim	8	4mm Self-Tapping Screws



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 hood release lever, **(Figure 1)**. Remove the plastic pins and cover from the top of the grille and radiator **(Figure 2)**. Temporarily reattach the release lever.
2. Remove the now exposed hardware attaching the top of the grille to the body.
3. Starting at the front of the wheel well, remove the 2 screws attaching the fender liner to the fascia panels **(Figure 3)**. Grab plastic fender flare and pull to release plastic pins securing the plastic fender flare to body, **NOTE:** flare does not need to be fully removed, only the first few pins. Remove the now exposed small hex bolt attaching fascia to body **(Figure 4)**.
4. On models with grille mounted camera, unplug harness leading to the camera.
5. Once all attaching screws and clips have been removed, pull grille straight out to release from clips, **(Figure 5)**.
6. From under the vehicle, remove the hardware at each end of the bumper attaching the bumper supports to each side of the frame, **(Figure 6)**.
7. 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 upper and lower bumper bolts from each side, **(Figure 7)**. **WARNING!** Assistance is required to hold the bumper in place during bolt removal to prevent the bumper from falling. Remove the bumper assembly. Move the bumper to a clean surface.
8. Remove the factory bumper brackets and tow hooks, (if equipped), from the end of frame, **(Figure 8 & 9)**. On models with lower radiator shutter assembly, unplug and remove the assembly.
9. Select (1) Left Facing Lower Support Bracket, **(Figure 10)**. Attach the Left Facing Support Bracket to the outer side of the drive side frame with the included (2) 12mm x 50mm Hex Bolts, (4) 12mm Flat Washers, (2) 12mm Lock Washers and (2) 12mm Hex Nuts. Do not fully tighten hardware at this time. Repeat this **Step** to attach (1) Right Facing Support Bracket to the inner side of the driver side frame.
10. Select the Driver/left Frame Mounting Bracket, **(Figure 11)**. Attach the Bracket to the mounting plate on the end of the frame with the included (4) 10mm x 40mm Hex Bolts, (4) 10mm Lock Washers and (4) 10mm x 34mm large Flat Washers. Do not fully tighten at this time.
11. Attach the bottom of the Frame Bracket to the front of the Support Brackets with (2) 12mm x 50mm Hex Bolt, (4) 12mm Flat Washers, (2) 12mm Lock Washers and (2) 12mm Hex Nuts, **(Figures 12 & 13)**. Do not fully tighten at this time.
12. Repeat **Steps 7—9** to install the passenger/right Frame and Support Brackets.
13. Only on models equipped with lower radiator shutter system, remove shutter assembly from outer plastic housing, **(Figure 14)**. Select (1) "L" Relocation Bracket. Attach the "L" Bracket to the front of the Frame Mounting Bracket with the included (1) 8mm x 30mm Hex Bolt, (2) 8mm Flat Washers and (1) 8mm Nylon Lock Nut. Repeat this Step to attach the remaining "L" Bracket, **(Figure 15)**.
14. Attach the shutter assembly to the front of the "L" Brackets with the included (4) 6mm x 20mm Hex Bolts, (8) 6mm Flat Washers and (4) 6mm Nylon Lock Nuts, **(Figures 15 & 16)**. Do not overtighten the 6mm hardware or damage to the shutter assembly may result. **NOTE:** Shutter assembly may be installed upside-down. Plug wiring harness into shutter assembly
15. Select the driver/left tow hook if equipped. Attach the tow hook to the Bracket with the included (2) 12mm x 130mm Hex Bolts, (4) 12mm Flat Washers, (2) 12mm Lock Washers and (2) 12mm Hex Nuts, **(Figure 17)**. Use the included Thick or Thin Shims to adjust the fit between the sides of the tow hook and the inside of the Frame Bracket to prevent rattling, **(Figure 18)**. Fully tighten the tow hook hardware. Repeat this Step to install the passenger/right tow hook.
16. Disassemble the front bumper to access and remove the sensors, wiring harness and fog lights as equipped, **(Figure 19)**. Sensors, (if equipped), must be installed in Bumper before installing Bumper Assembly.

Models without bumper sensors:

- a. From the front of the Bumper, push the included Plastic Plugs into the sensor mounting holes, (Figure 20).

Models with bumper mounted sensors:

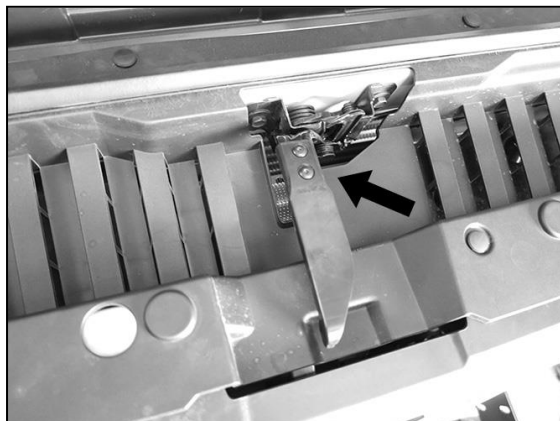
- a. Select the driver/left outer sensor.
- b. Remove the silicone seal from the end of the sensor. Slide the included larger Sensor Seal over front of sensor, (Figure 21).
- c. Insert sensor with Seal into sensor mount, (Figure 22).
- d. Place Foam Spacer over the end of sensor. Push Sensor Retaining Cap onto sensor mount and lock into mounting holes, (Figure 22).
- e. Repeat previous Steps to install remaining sensors.

17. Models with fog lights:

- a. Attach the driver/left fog light to the mounting tabs on the back of the Bumper with the included (3) 5mm x 20mm Button Head Bolts, (6) 5mm Flat Washers and (3) 5mm Nylon Lock Nuts, (Figure 23). **NOTE:** Do not overtighten hardware or damage to the light may result.
 - b. Repeat the previous Steps to attach the passenger/right fog light.
- 18.** Install the factory bumper wiring harness for sensors and fog lights as equipped. Run wiring harness through Brackets to reach sensors, (Figure 24). **NOTE:** (2) Wire Harness Extensions have been included to extend the factory harness to reach the sensors as needed.
- 19.** Push the (2) Rubber Edge Trim pieces onto the top edge of the Bumper, (Figure 25). Repeat this Step to the other side.
- 20.** 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.
- 21.** Line up the (3) holes in the driver/left 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 50mm Hex Bolts, (6) 12mm Flat Washers, (3) 12mm Lock washers and (3) 12mm Hex Nuts, (Figures 26 & 27). Do not fully tighten hardware at this time. Repeat this Step to attach the passenger/right side of the Bumper.
- 22.** Level and adjust the Bumper and fully tighten all 12mm hardware to 65-70ft-lbs.
- 23. (Optional)** Attach Block Heater Bracket to the Bumper Bracket Support, (Figure 28).
- 24.** Use the included (2) push-in Plastic Plugs to attach the front license plate, (if required), to the (2) holes in the front Bumper, (Figure 29).
- 25.** Models with grille mounted camera, remove screen from center of Bumper, (Figure 29).
- 26.** 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

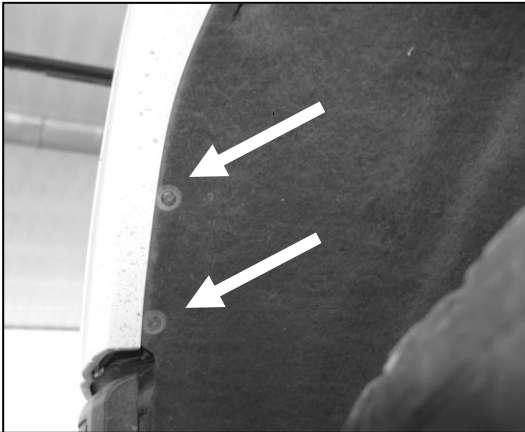


(Fig 1) Remove hood release lever (arrow).



(Fig 2) Remove the plastic pins and cover from the top of the grille and radiator, then temporarily reinstall the hood release

Driver/left Side Installation Pictured



(Fig 3) Remove the 2 screws attaching the fender liner to the fascia panels

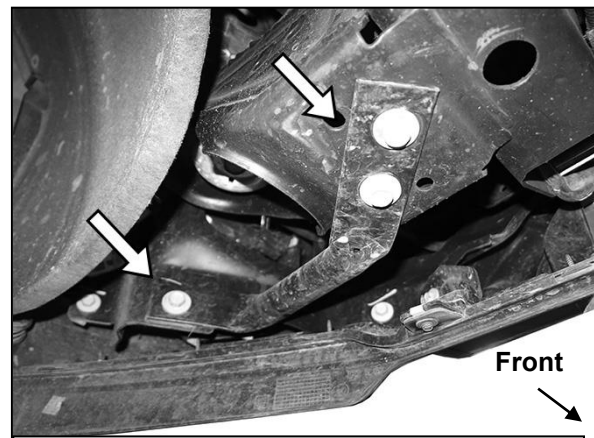


(Fig 4) Firmly pull flare to expose hex bolt.

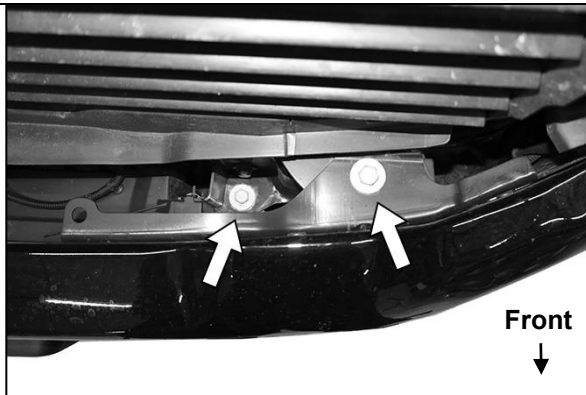


(Fig 5) Once both fascia body panels (arrows) have been loosened, remove grille

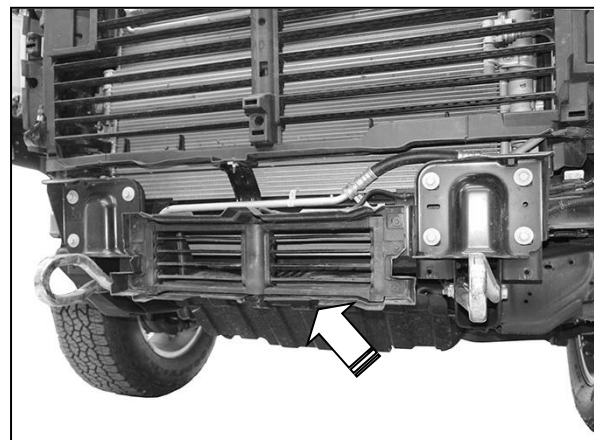
WARNING! Do not crawl under bumper unless it is properly supported on blocks or stands or the bumper may fall.



(Fig 6) Remove the outer bumper supports attached to the bottom of the frame



(Fig 7) From above, remove the hex bolts attaching the bumper assembly to the frame bumper brackets (top visible-arrow)



(Fig 8) Remove tow hooks and bumper brackets. Unplug and remove the shutter assembly (arrow) if equipped

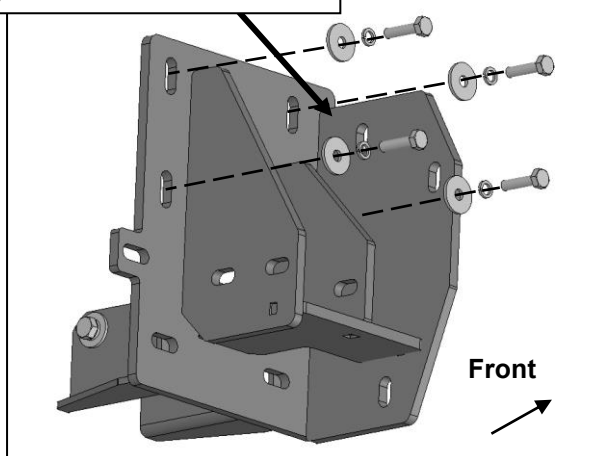
HD REPLACEMENT FRONT BUMPER 2024 GMC SIERRA 25-3500

Driver/left Side Installation Pictured

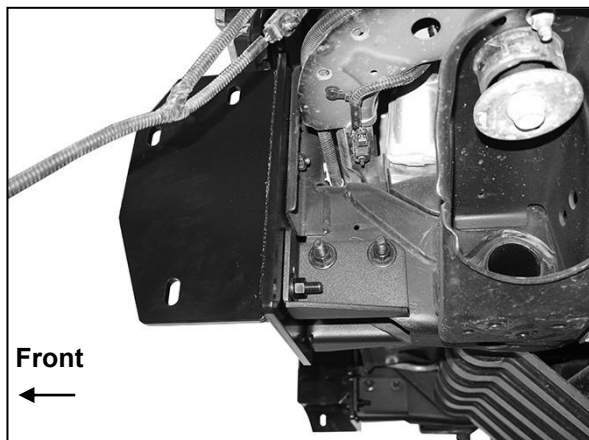


(Fig 9) Bumper removed

- (4) 10mm x 40mm Hex Bolts
- (4) 10mm Flat Washers
- (4) 10mm Lock Washers

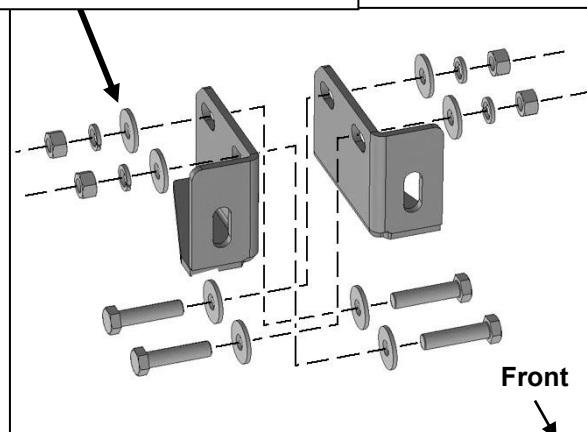


(Fig 11) Attach Driver/left Frame Bracket to end of frame



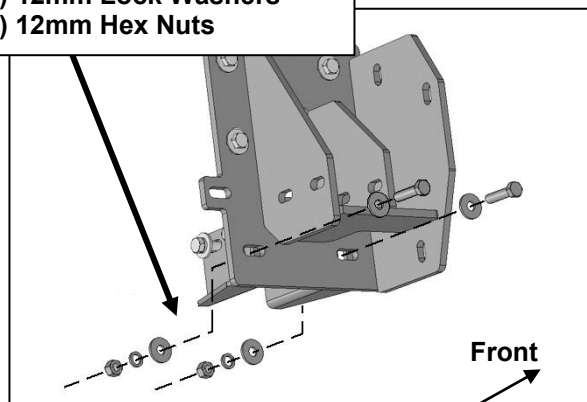
(Fig 13) Left facing Support Bracket installed

- (4) 12mm x 50mm Hex Bolts
- (8) 12mm Flat Washers
- (4) 12mm Lock Washers
- (4) 12mm Hex Nuts

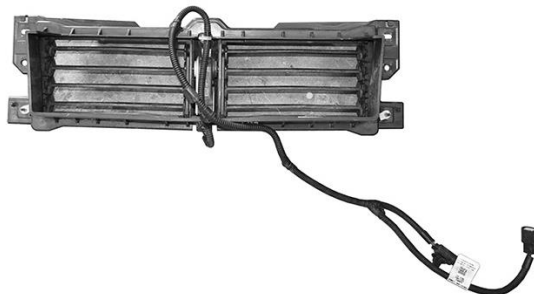


(Fig 10) Attach (1) Left Facing and (1) Right Facing Support Bracket to the sides of the frame

- (2) 12mm x 50mm Hex Bolts
- (4) 12mm Flat Washers
- (2) 12mm Lock Washers
- (2) 12mm Hex Nuts



(Fig 12) Attach the Support Brackets to the bottom slots in the driver/left Frame Bracket

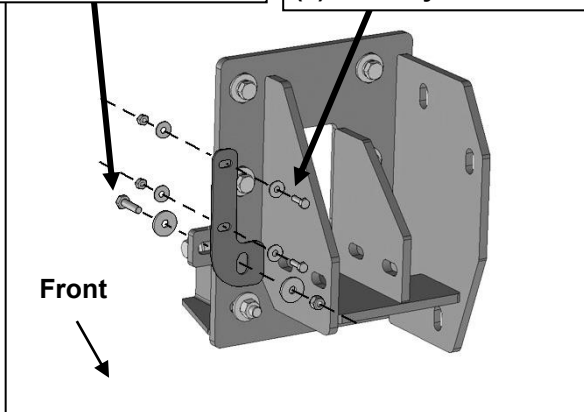


(Fig 14) Remove inner shutter assembly from plastic outer housing (if equipped)

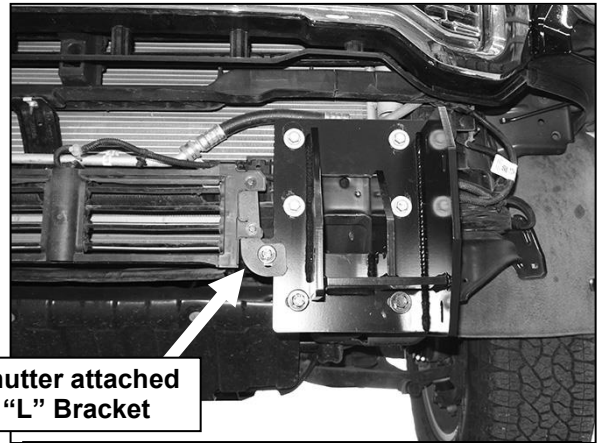
Driver/left Side Installation Pictured

- (1) 8mm x 30mm Hex Bolt
- (2) 8mm Flat Washers
- (1) 8mm Nylon Lock Nut

- (2) 6mm x 20mm Hex Bolts
- (4) 6mm Flat Washers
- (2) 6mm Nylon Lock Nuts

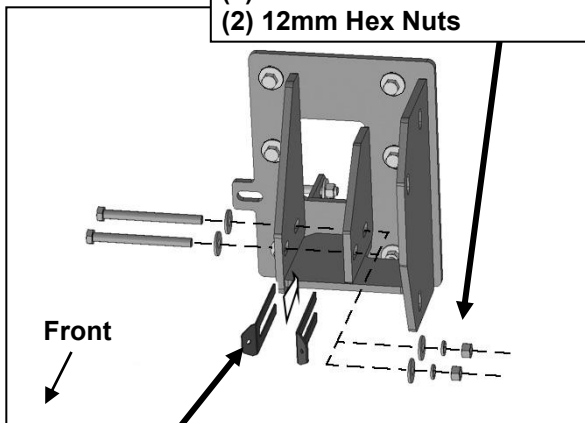


(Fig 15) Attach "L" Relocation Brackets to front of Frame Brackets. Attach shutter assembly to front of Relocation Brackets

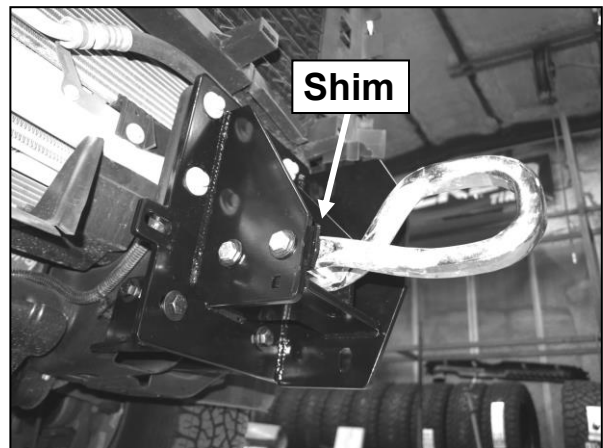


(Fig 16) Attach shutter assembly, (if equipped), to front of Relocation Brackets

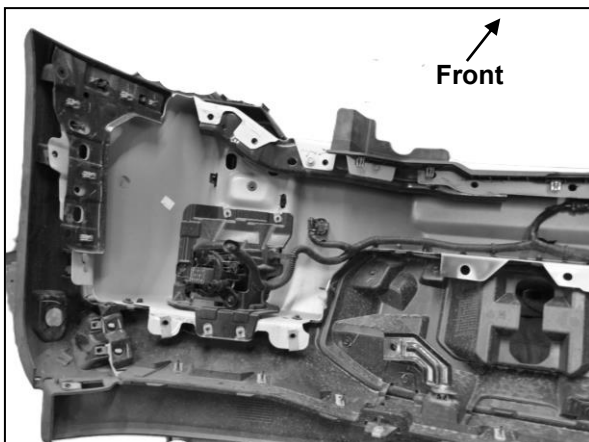
- (2) 12mm x 130mm Hex Bolts
- (4) 12mm Flat Washers
- (2) 12mm Lock Washer
- (2) 12mm Hex Nuts



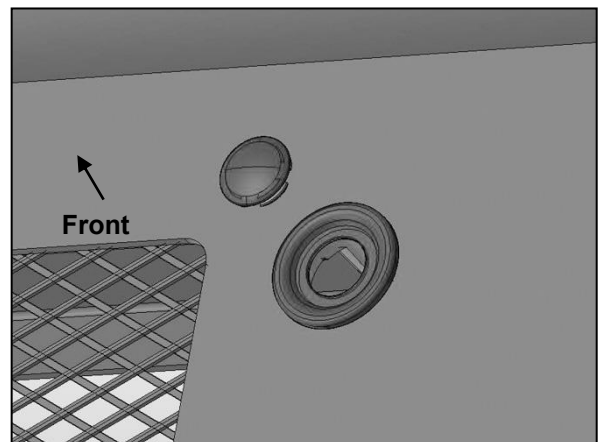
(Fig 17) Insert Thick or Thin Shims to adjust fit between tow hook and Bracket



(Fig 18) Frame Bracket, Shim and tow hook installed

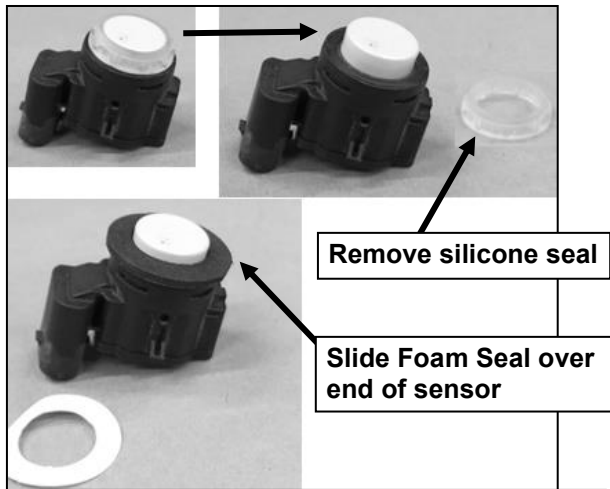


(Fig 19) Disassemble bumper and remove fog lights, sensors and wiring harness as equipped



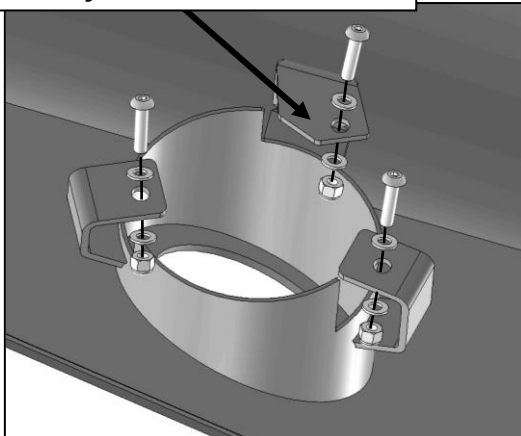
(Fig 20) Push Plug into sensor mount

Driver/left Side Installation Pictured

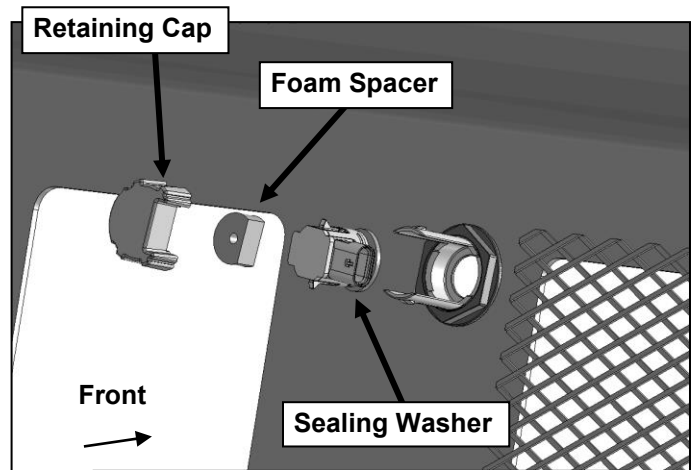


(Fig 21) Remove silicone seal from sensor. Slide large Seal over end of sensor

- (3) 5mm x 20mm Button Head Bolts
- (6) 5mm Flat Washers
- (3) 5mm Nylon Lock Nuts



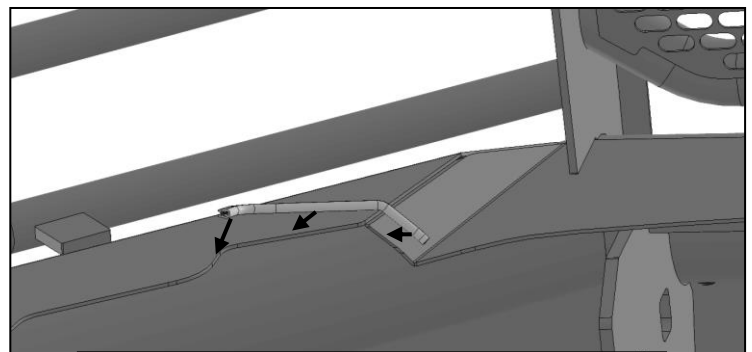
(Fig 23) Attach Driver/Left fog light to mounting tabs on driver/left side of Bumper. Reinstall factory wiring harness through Bumper Brackets on back of Bumper.



(Fig 22) Insert sensor assembly through the sensor sleeve behind the Bumper



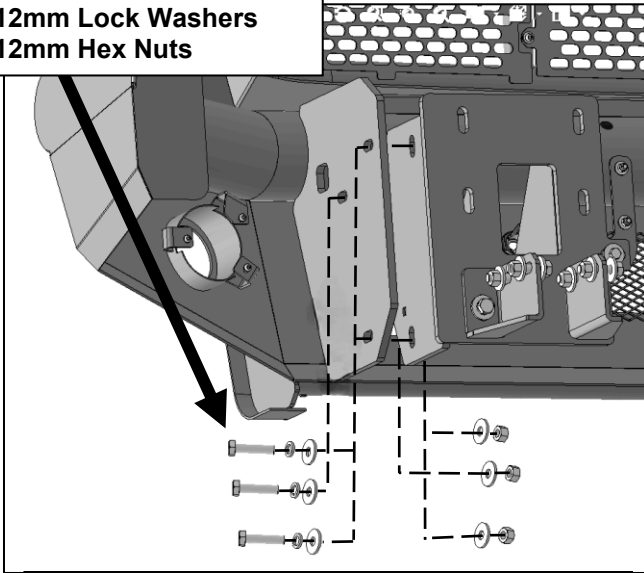
(Fig 24) Use the included (2) Wire Harness Extensions as necessary to reach the parking sensors



(Fig 25) Attach Rubber Edge Trim onto top of the bumper.

Driver/left Side Installation Pictured

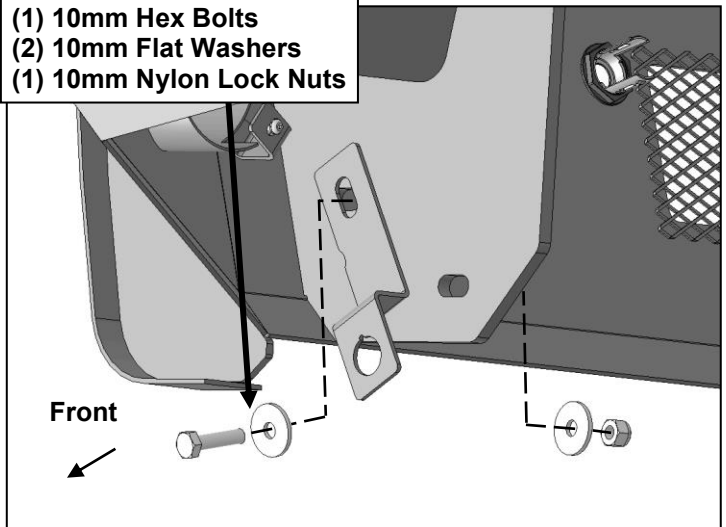
- (3) 12mm x 50mm Hex Bolts
- (6) 12mm Flat Washers
- (3) 12mm Lock Washers
- (3) 12mm Hex Nuts



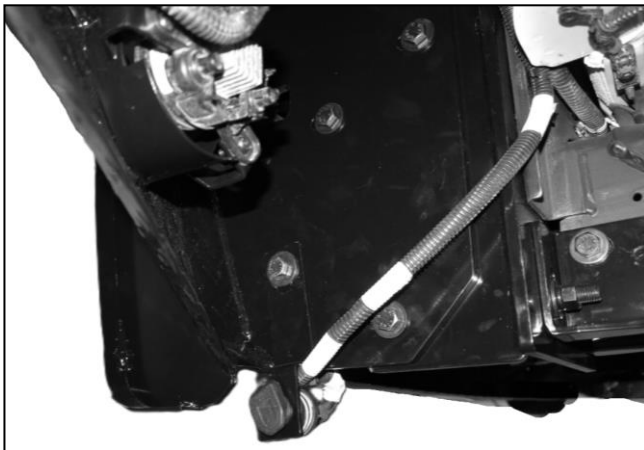
(Fig 26) Attach the Bumper to Frame Brackets

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

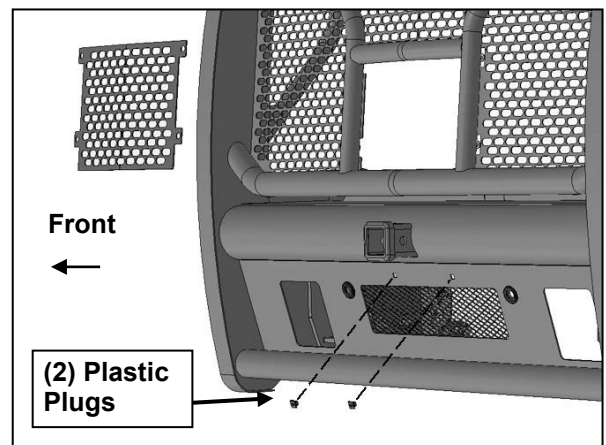
- (1) 10mm Hex Bolts
- (2) 10mm Flat Washers
- (1) 10mm Nylon Lock Nuts



(Fig 27) Block heater relocation bracket example (Optional)



(Fig 28) Driver/left side of Bumper installed (Optional Block Heater installed)



(Fig 29) Models with camera, remove screen. Push Plastic Plugs into hole in Bumper for License Plate



Complete Installation