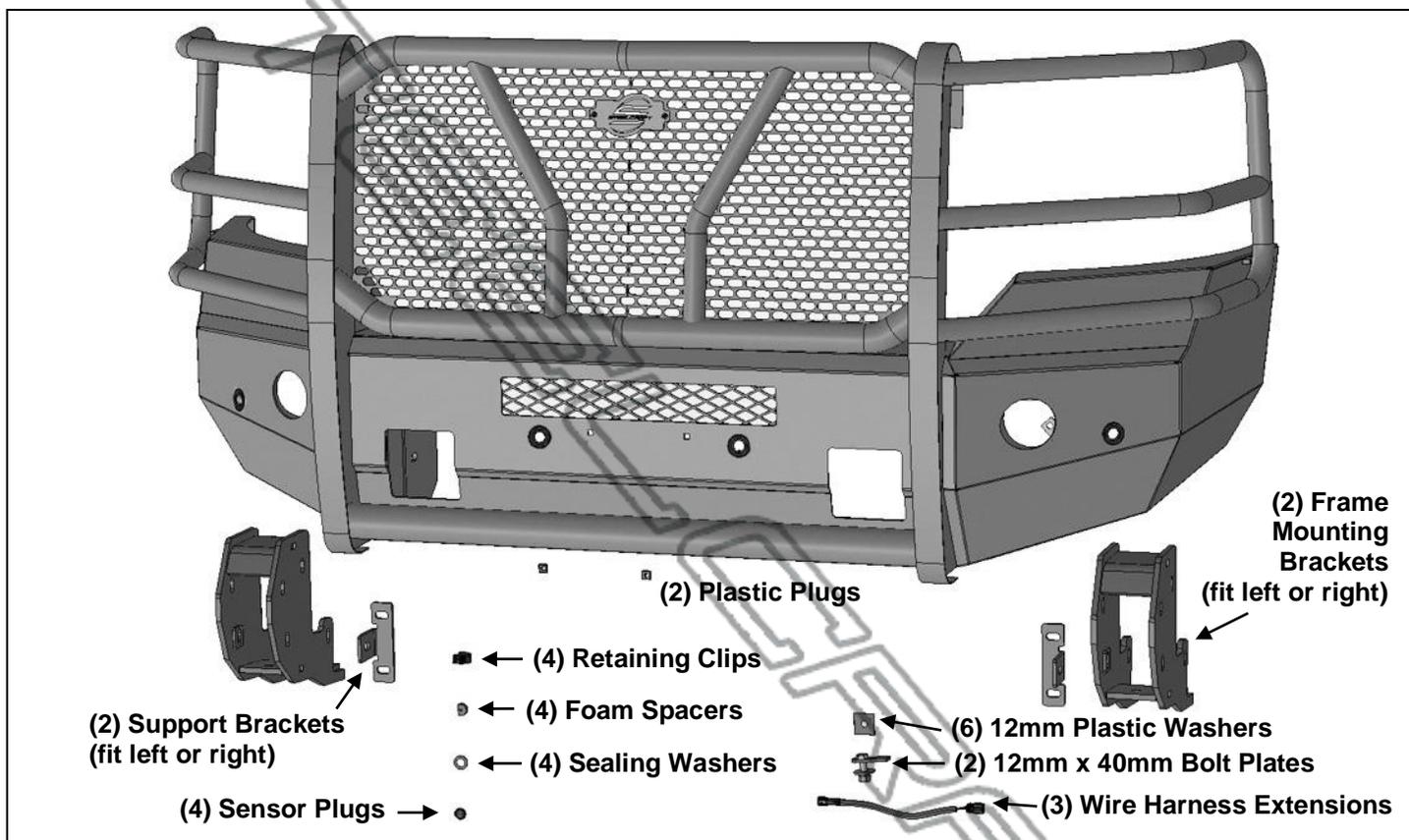


**ALUMINUM ELEVATION FRONT BUMPER
2015-19 GMC SIERRA 25-3500**

PARTS LIST:

1	Elevation Front bumper	2	Plastic Plugs for License Plate
2	Frame Mounting Brackets (fit left or right)	6	12mm Plastic Washers
2	Support Brackets (fit left or right)	2	12mm Bolt Plates
4	Sensor Plugs	6	12-1.75mm x 160mm Hex Bolts
4	Foam Sealing Washers	2	12-1.75mm x 50mm Hex Bolts
4	20mm x 10mm Foam Spacers	18	12mm x 37mm OD x 3mm Flat Washers
4	Retaining Caps	10	12mm Lock Washers
3	Wire Harness Extensions	10	12mm Hex Nuts
1	Sensor Cover Kit	8	Self Tapping Screws



RECOMMENDED TO REPLACE THE 12MM HEX BOLTS ON AN ANNUAL BASIS

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 and bracket. On models with factory fog lights and/or bumper sensors, unplug the wiring harness leading to the front bumper and move it out of the way, **(Figure 1)**.
2. Remove the bumper supports running from the outside of the frame to the outer ends of the bumper.
3. Open the hood and remove the plastic cover from the top of the radiator, **(Figure 2)**. Temporarily remove the plastic grille, **(Figure 3)**.
4. 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 bumper bolts from each side, **(Figure 4)**. **WARNING!** Assistance is required to hold the bumper in place during bolt removal to prevent the bumper from falling. Carefully slide the bumper off of the frame.
5. Remove the factory bumper brackets and tow hooks from the end of frame, **(Figure 5)**.

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6. Select (1) Frame Mounting Bracket. Attach the Bracket to the driver/left end of the frame with the included (1) 12mm x 160mm Hex Bolt, (2) 12mm Flat Washers, (1) 12mm Lock Washer and (1) 12mm Hex Nut, **(Figures 6 & 9)**. Next, select (1) 12mm Bolt Plate. Insert the Bolt Plate into the end of the frame and down through the Frame and Bracket. Attach the Bracket to the Bolt Plate with (1) 12mm Flat Washer, (1) 12mm Lock Washer and (1) 12mm Hex Nut, **(Figures 6 & 9)**. Do not fully tighten hardware at this time.
7. Next, select (1) Support Bracket, **(Figure 7)**. Reuse (2) factory bumper bracket bolts to attach the Support Bracket to the mounting plate on the end of the frame, **(Figures 7 & 8)**. Do not attach the Support Bracket to the side of the Frame Bracket at this time, **(See Step 12, Figure 13A)**. Do not fully tighten hardware at this time.
8. Repeat **Steps 6 & 7** to install the passenger/right side Frame and Support Brackets, **(Figure 9)**.
9. Carefully remove both fog light assemblies, all sensors and the wiring harness from the back of the OE bumper as equipped. Note location of each sensor for correct reinstallation.

Models without bumper sensors:

- a. Insert (1) Plug into the outer hole in the Sensor Mount, **(Figure 10)**.
- b. Repeat this Step to plug remaining (3) mounting holes in Bumper. Continue to **Step 10**.

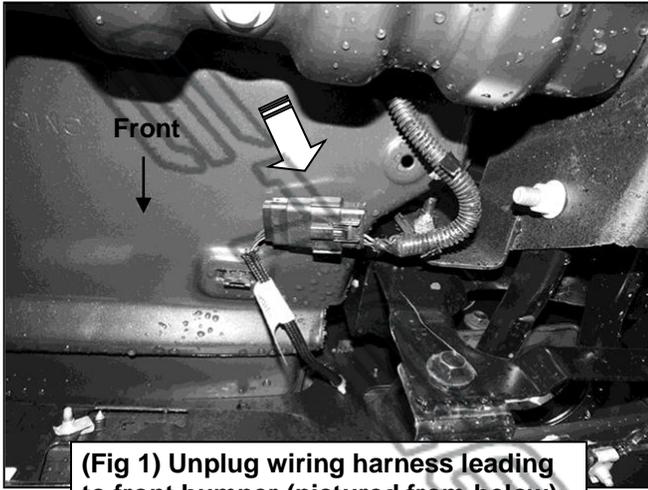
Models with bumper mounted sensors:

- a. Select the driver/left outer sensor. Remove the seal from the end of the sensor, **(Figure 11)**. Replace the seal with the included larger Foam Seal.
 - b. Push the sensor into the Mount from the back of the Bumper until it is flush with the front of the Mount.
 - c. Push (1) Foam Spacer onto the back end of the sensor, **(Figure 12)**.
 - d. Snap (1) Sensor Retaining Cap onto the Sensor Mount, **(Figure 12)**.
 - e. Repeat the previous Steps to install the remaining sensors in order from factory bumper.
10. Install the factory bumper wiring harness for sensors and fog lights as equipped. Run wiring harness over or through Brackets to reach sensors. **NOTE:** (3) Wire Harness Extensions have been included to extend the factory harness to reach the sensors as needed.
 11. 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.
 12. Line up the (3) holes in the driver/left side mounting plate on the back of the Bumper with the (3) slots in the Frame Bracket. Insert (1) 12mm x 160mm Hex Bolt, (1) 12mm Flat Washer and (1) Plastic Washer through the top inner slot and the inner Support Bracket, **(Figure 13A)**. Secure the long Hex Bolt to the Support Bracket with (1) 12mm Flat Washer, (1) 12mm Lock Washer and (1) 12mm Hex Nut. **NOTE:** Place the included (6) 12mm Plastic Washers between all 12mm Flat Washers and the mounting plate on the Bumper to minimize corrosion, **(Figures 13A, 13B, 14 & 15)**.
 13. Next, from in front of the Bumper, insert (1) 12mm x 50mm Hex Bolt, (2) 12mm Flat Washers, (1) 12mm Plastic Washer, (1) 12mm Lock Washer and (1) 12mm Hex Nut through the tow hook opening and out the slot in the outside of the Bracket, **(Figures 13A & 13B)**.
 14. Repeat **Steps 12 & 13** to attach the passenger/right side of the Bumper to the Frame Bracket.
 15. Select (1) factory tow hook, (if equipped). Insert the tow hook into the opening in the driver/left side Frame Bracket, **(Figure 14)**. Reuse the short factory tow hook hex bolt to attach the tow hook to the bottom plate on the Bracket. Insert (1) 12mm x 160mm Hex Bolt, (2) 12mm Flat Washers, (1) 12mm Plastic Washer, (1) 12mm Lock Washer and (1) 12mm Hex Nut, through the Bumper Bracket and tow hook, **(Figures 14 & 15)**. Leave tow hook hardware loose at this time. Repeat this **Step** to install the passenger side tow hook.
 16. Level and adjust the Bumper and fully tighten all 12mm hardware to 65-70ft-lbs.
 17. **Models with fog lights and/or bumper sensors:**
 - a. Slide the driver/left side light into place through the opening in the bumper, **(Figures 16 & 17)**. Carefully push the attaching posts into the tabs on the bumper. Plug the wiring harness into the light. Repeat to install passenger/right side fog light.
 18. Use the included (2) push-in Plastic Nuts to attach the front license plate, (if required), to the (2) holes in the front Bumper, **(Figure 18)**.
 19. Do periodic inspections to the installation to make sure that all hardware is secure and tight.

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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.

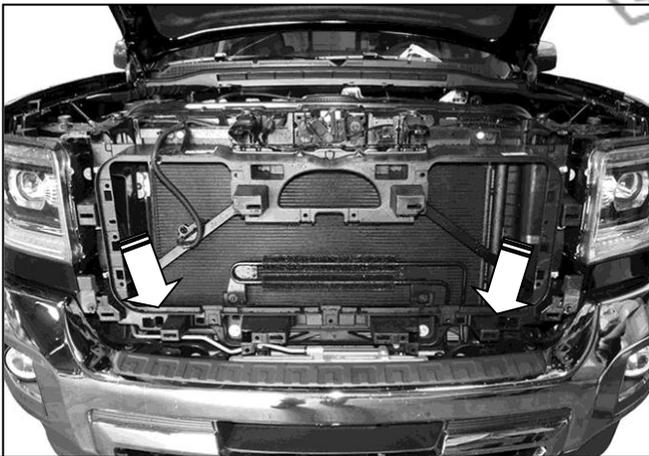
Driver/left Side Installation Pictured



(Fig 1) Unplug wiring harness leading to front bumper (pictured from below)

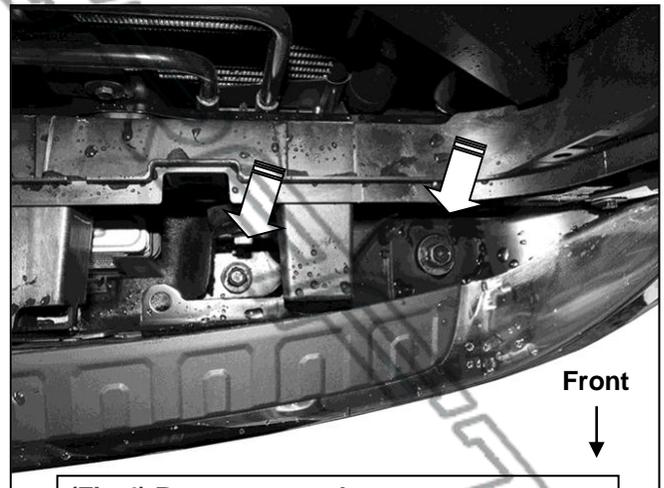


(Fig 2) Remove plastic cover from top of radiator



(Fig 3) Remove grille to access bumper bolts (Fig 4)

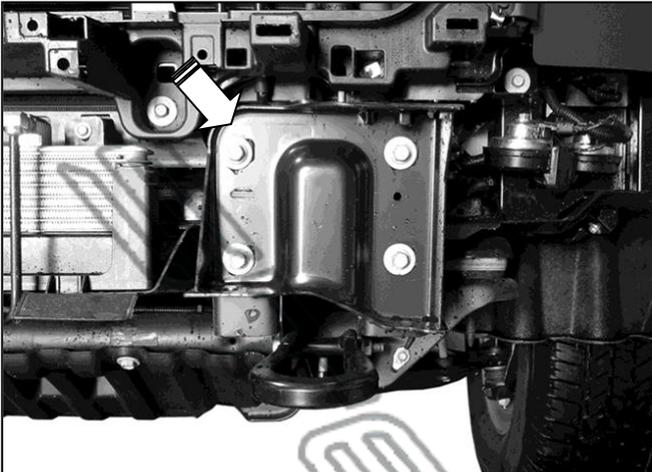
WARNING! Do not remove bumper bolts unless it is properly supported on blocks or stands or the bumper may fall.



(Fig 4) Remove outer bumper supports attached to frame and ends of the bumper. Remove bumper bolts (arrows) to remove bumper (driver side pictured from above).

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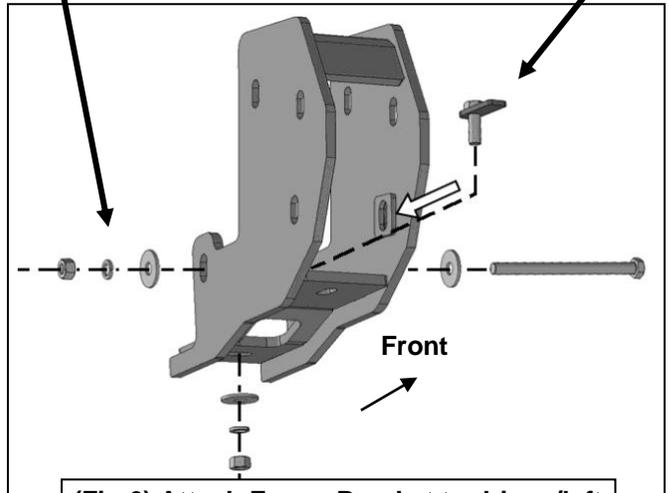
Driver Side Installation Pictured



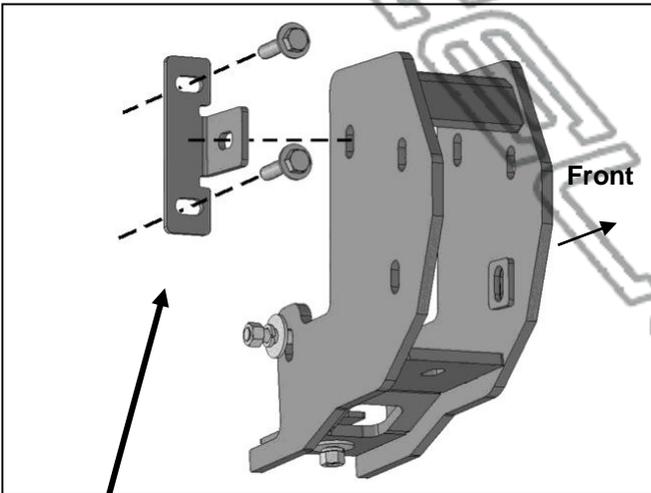
(Fig 5) Remove bumper brackets and tow hooks

12mm x 160mm Hex Bolt
(2) 12mm Flat Washers
12mm Lock Washer
12mm Hex Nut

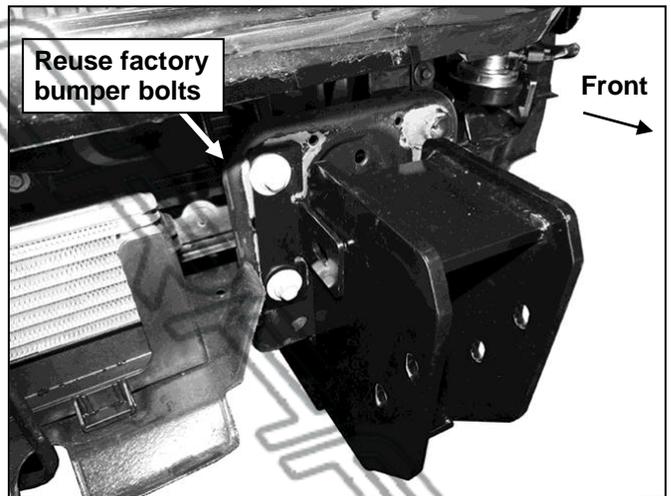
12mm Bolt Plate
12mm Flat Washer
12mm Lock Washer
12mm Hex Nut



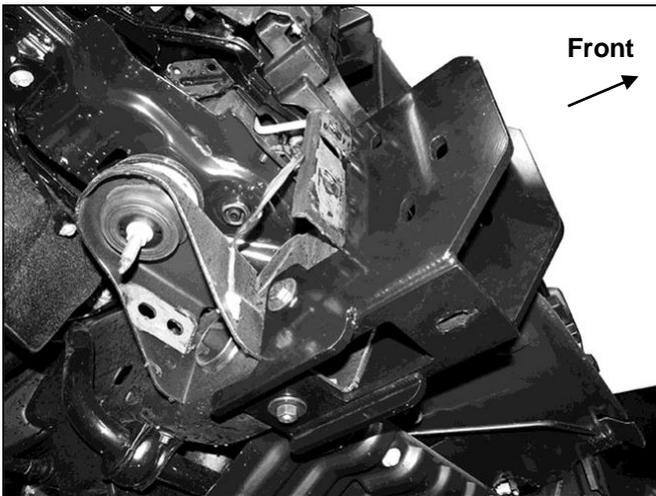
(Fig 6) Attach Frame Bracket to driver /left side of frame. Insert 12mm Bolt Plate down through hole in bottom of the frame



(Fig 7) Reuse factory bumper bolts to attach Support Bracket to bumper/frame mounting plate

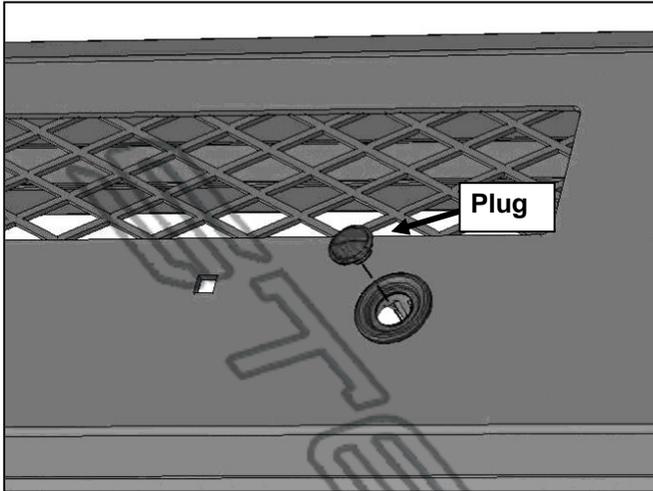


(Fig 8) Mounting Bracket and Support Bracket

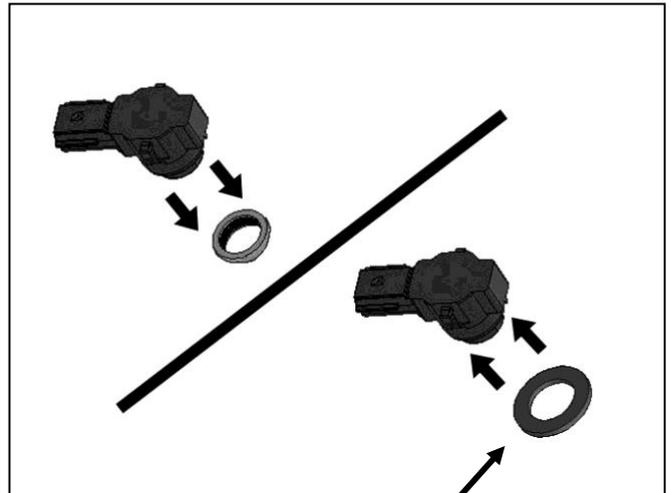


(Fig 9) Passenger/right Bracket assembly

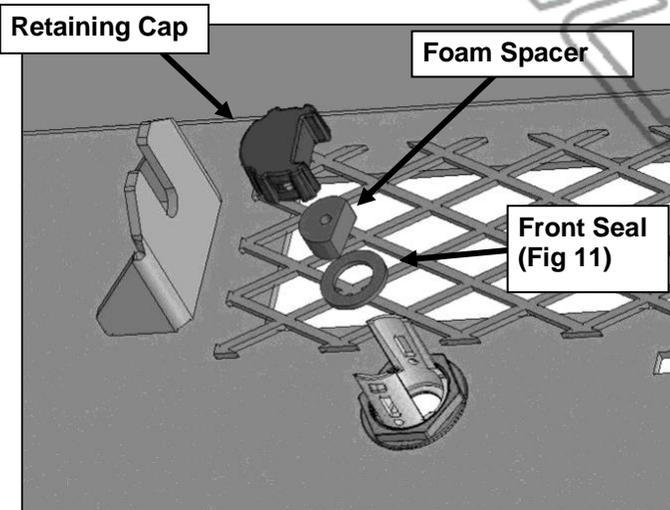
Driver side installation pictured



(Fig 10) Models without sensors, insert Plug into Sensor Mount



(Fig 11) Remove silicone seal from sensor. Slide large Seal over end of sensor (arrow)

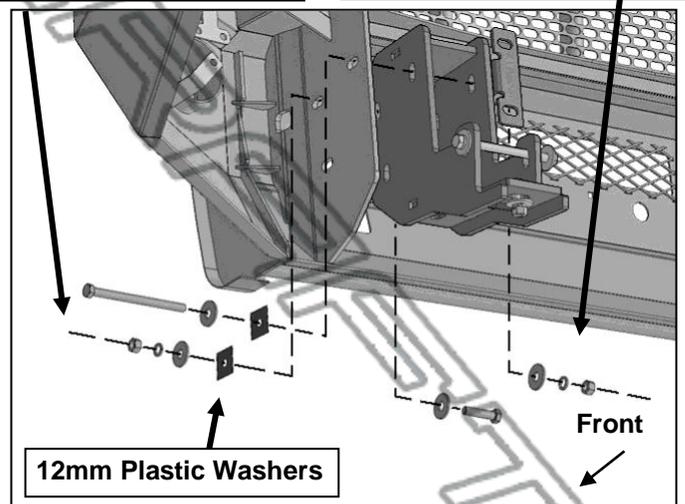


(Fig 12) Insert sensor into back of Mount. Attach Foam Spacer to back of sensor. Snap Retaining Cap onto end of Mount, over sensor and Spacer

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

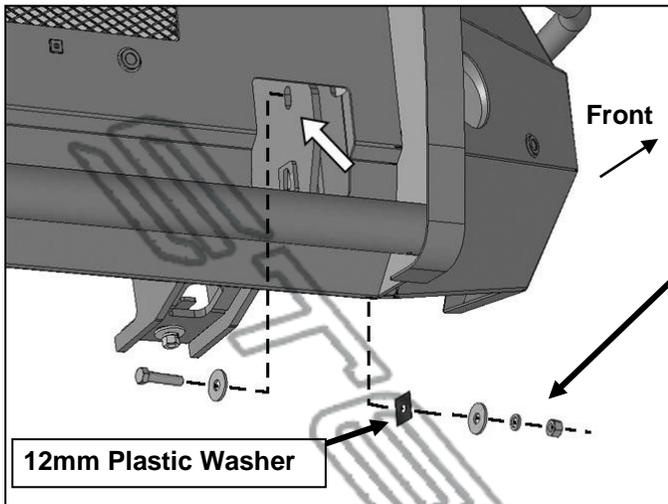
- 12mm x 50mm Hex Bolt
- (2) 12mm Flat Washers
- 12mm Lock Washer
- 12mm Hex Nut

- 12mm x 160mm Hex Bolt
- (2) 12mm Flat Washers
- 12mm Lock Washer
- 12mm Hex Nut



(Fig 13A) Insert long 12mm x 160mm Hex Bolt, Flat Washer and Plastic Washer into top slot in Bumper and through Bracket. Back of driver/left side of Bumper illustrated

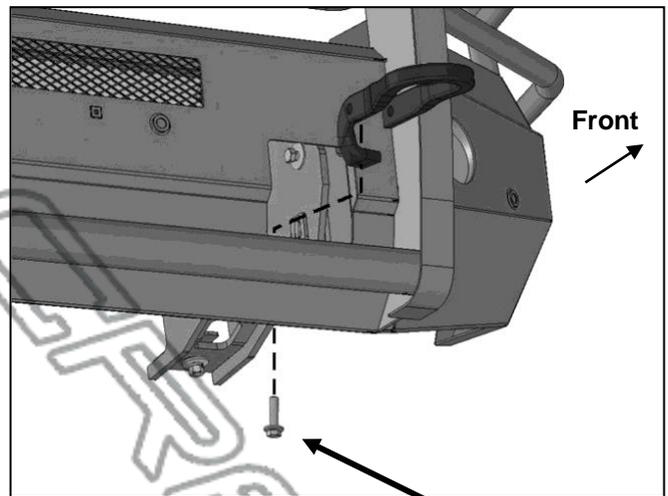
Driver side installation pictured



12mm x 50mm Hex Bolt
(2) 12mm Flat Washers
12mm Lock Washer
12mm Hex Nut

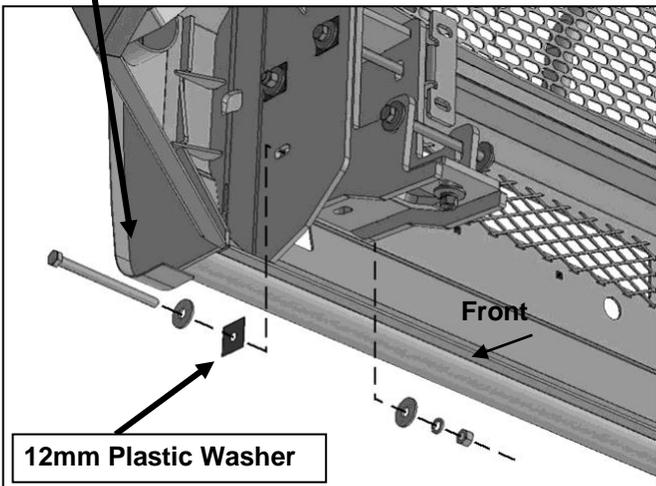
12mm Plastic Washer

(Fig 13B) Insert 12mm x 50mm Hex Bolt and Flat Washer into opening for tow hook and out through inside slot in top of Bracket. Front of driver side of Bumper illustrated. Insert Plastic Washer between Flat Washer and mounting plate on back of Bumper



(Fig 14) Reuse factory tow hook bolt to attach tow hook to bottom of Bracket

12mm x 160mm Hex Bolt
(2) 12mm Flat Washers
12mm Lock Washer
12mm Hex Nut

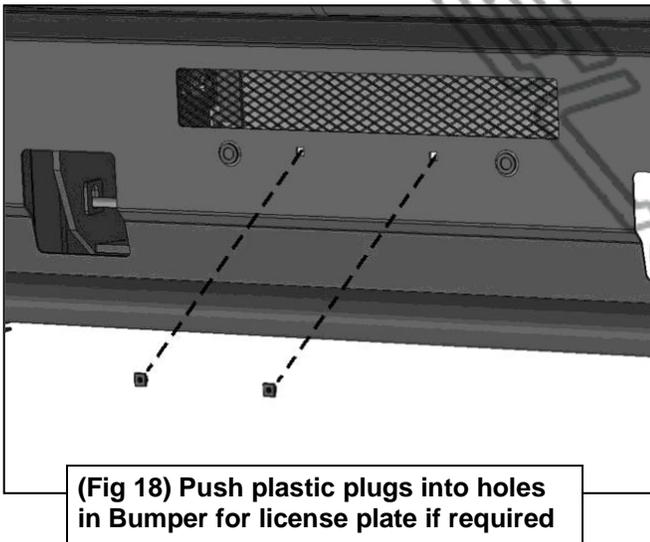
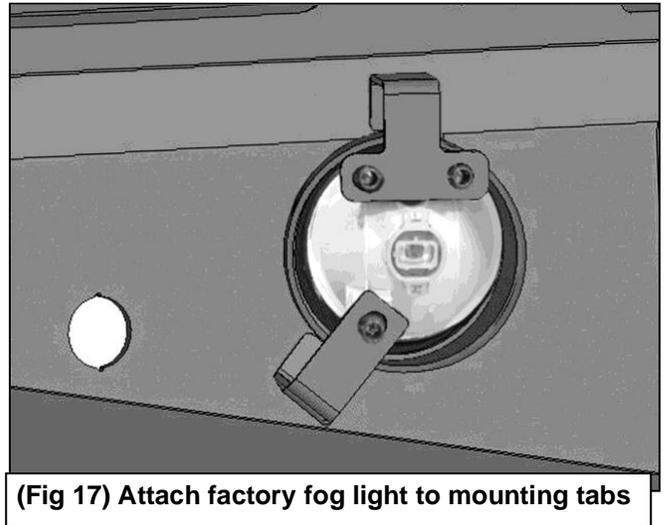


12mm Plastic Washer

(Fig 15) Insert long 12mm x 160mm Hex Bolt with Flat Washer through Bumper, Bracket and tow hook. Back of driver side of Bumper illustrated

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

Driver side installation pictured



Special Note: While Aluminum does not rust, there is potential for galvanic corrosion if the coating is scratched between your bumper and the steel frame brackets + hardware (especially in extreme environments such as the coastlines or where road salt is used during winter). A visual inspection should be performed by the user at least on an annual basis to determine if excessive corrosion is present on or surrounding the hardware.