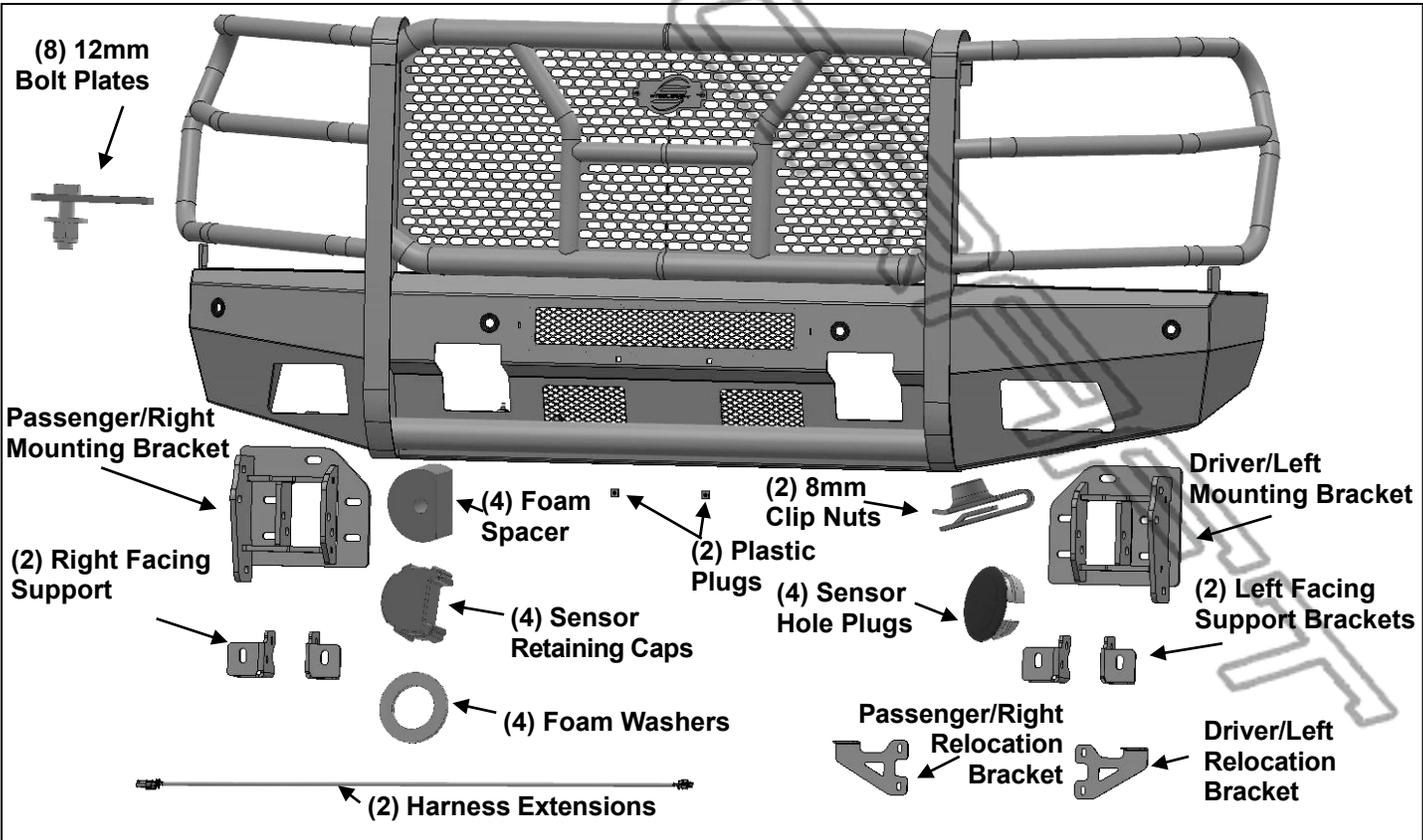


**STEELCRAFT ELEVATION FRONT BUMPER
2022-2024 CHEVY SILVERADO 1500**

Qty	Description	Qty	Description
1	Elevation Front Bumper	8	12-1.75mm Bolt Plates
1	Skid Plate	2	12-1.75mm x 120mm Hex Bolts
1	Driver/left Mounting Bracket	2	12-1.75mm x 60mm Hex Bolts
1	Passenger/right Mounting Bracket	10	12-1.75mm x 50mm Hex Bolts
2	Left Facing Support Brackets	2	12mm lock washers
2	Right Facing Support Brackets	34	12mm x 32mm x 3mm Flat Washers
1	Driver/left Relocation Bracket (turbo only)	20	12mm Nylon Lock Nuts
1	Passenger/right Relo Bracket (turbo only)	2	8-1.25mm x 25mm Hex Bolts (turbo only)
1	DS fog light bracket	2	8mm x 24mm x 2mm Flat Washers
1	PS fog light bracket	2	8mm Lock Washers
2	Plastic Plugs for License Plate	2	8mm Clip Nuts
1	Rubber Edge Trim	10	6mm x 25mm Hex Bolts
4	20mm x 10mm Foam Spacers	8	6mm x 25mm Button Head Bolts
4	15.5mm x 25mm x 2mm Foam Seals	32	6mm x 18mm x 1.6mm Flat Washers
4	Sensor Retaining Caps	14	6mm Nylon Lock Nuts
4	Plastic Sensor Plugs	4	6mm Lock Washers
2	Sensor Wiring Harnesses	8	4mm Self Tapping Screws
1	Sensor Cover Kit	4	4mm x 8.65mm x 0.8mm Flat Washers
1	2.5mm Hex Wrench	4	4mm lock washers
1	4mm Hex Wrench	4	4mm x 20mm button head screws



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. MINOR 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)**.
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. Models with grille mounted camera, unplug camera if equipped. Place grille on a clean, soft surface.
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.

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- 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 .
- 13.** Repeat **Steps 11 & 12** to install the passenger/right Support Brackets and Frame Bracket.
- 14.** Select (1) tow hook if equipped. Use the included (1) 12mm x 120mm Hex Bolt, (1) 12mm x 60mm Hex Bolt, (1) 12mm Lock washer, (3) 12mm Flat Washers and (1) 12mm Nylon Lock Nut to attach the tow hook to the Frame Bracket, **(Figures 22 & 23)**. Fully tighten tow hook hardware only at this time.
- 15.** Reinstall the plastic grille, camera if equipped and top cover removed in **Step 1**. Reinstall the plastic fascia body panel, **(Figure 24)**. Reattach the fender liners.
- 16.** Carefully unwrap the Bumper assembly.
- 17.** Push the included Edge Trim onto the top edge of the Bumper, **(Figure 25)**. Cut Edge Trim to fit.
- 18.** 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 26)**.
- Models with bumper mounted sensors:**
- 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 27)**.
- 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 27 & 28)**.
- 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.
- 19.** With assistance, position the Bumper Assembly up to the frame and over the tow hooks. 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.
- 20.** 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 29 & 30)**. Repeat this **Step** to attach the passenger/right side of the Bumper to the Bracket.
- 21.** Level and adjust the Bumper and fully tighten all 12mm hardware to 65-70ft-lbs.

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22. Models with fog lights:

- a. Remove driver/left fog light assembly from factory bumper.
- b. Select the Driver/left Fog Light Bracket. Use the included (2) 4mm x 20mm Button Head Screws, (2) 4mm Lock Washers, and (2) 4mm Flat Washers to attach the bracket to the bottom of the driver side fog light mount, **(Figure 31)**.
- c. Use the included (3) 6mm x 25mm Hex Bolts, (6) 6mm Flat Washers and (3) 6mm Nylon Lock Nuts to attach the fog light to the brackets, **(Figure 32)**. Do not overtighten hardware or damage to the light may result.
- d. Repeat previous **Steps** to install the passenger/right fog light.
- e. Plug wiring harness into lights.

23. If front license plate is required, insert (2) Plastic Plugs into the square holes in the Bumper. Reuse the factory screws to attach the license plate to the plastic plugs, **(Figure 33)**.

24. Models with grille mounted camera, remove the panel from the center of the grille, **(Figure 33)**.

25. 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 34)** using (4) 6mm x 25mm Button Head Bolts, (4) 6mm Flat Washer, (4) 6mm Nylon Lock Nuts.

NOTE: Skid Plate sits on top of Bumper flange.

- b. Finish installing the back end of the skid plate **(Fig 35)** using the factory hardware.

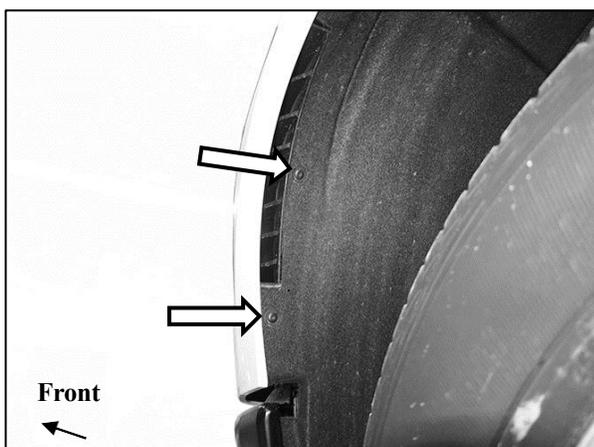
26. Optional: Fender Liner Trim

- a. Use a 1/4" drill bit to drill holes through the plastic fender liner bracket and the fender liner. **(Figure 36)**

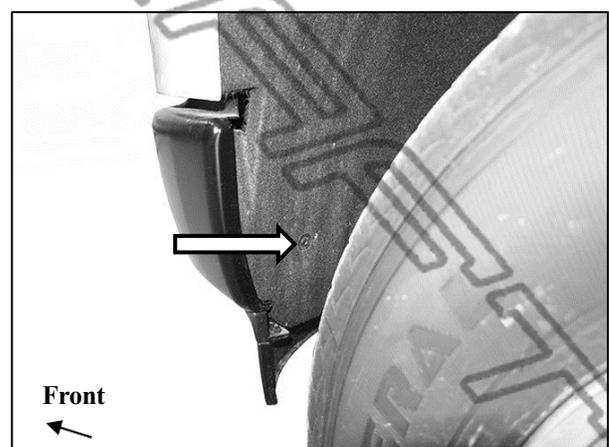
- b. Use the included (2) 6mm x 25mm Button Head Bolts, (4) 6mm Flat Washers and (2) 6mm Nylon Lock Nuts to attach the driver/left fender liner to the OE plastic fender liner bracket, **(Figure 36)**. Repeat this **Step** to attach the passenger/right fender liner. Trim the bottom of the fender liner flush with the bottom of the bumper.

27. Do periodic inspections of the installation to make sure that all hardware is secure and tight.

Driver/left Side Installation Pictured

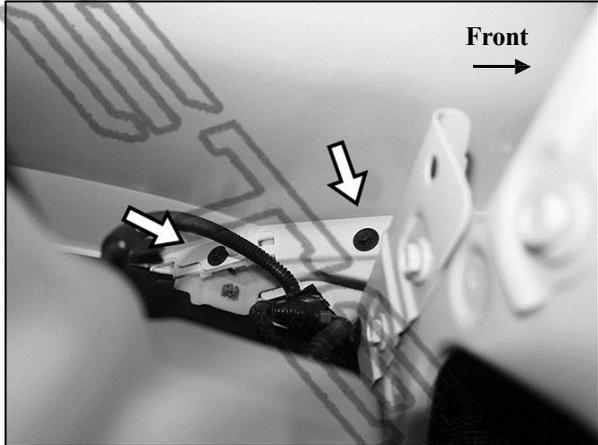


(Fig 1) Remove screws attaching driver/left fender liner to fascia body panel

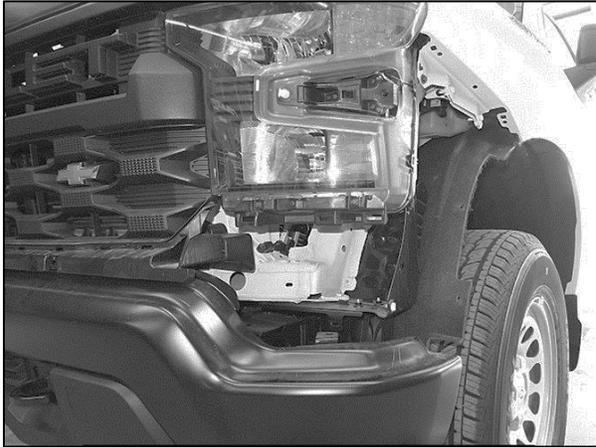


(Fig 2) Remove screws attaching driver/left fender liner to end of bumper

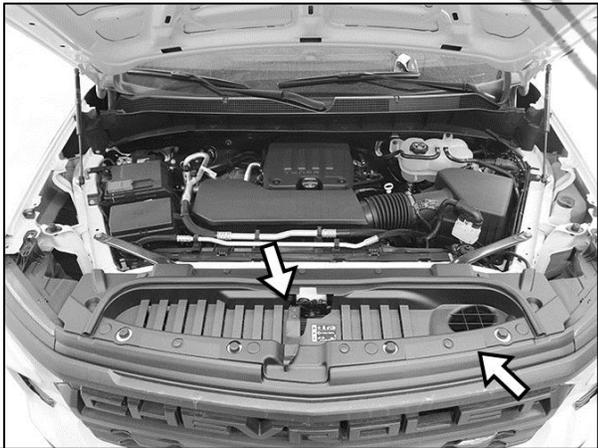
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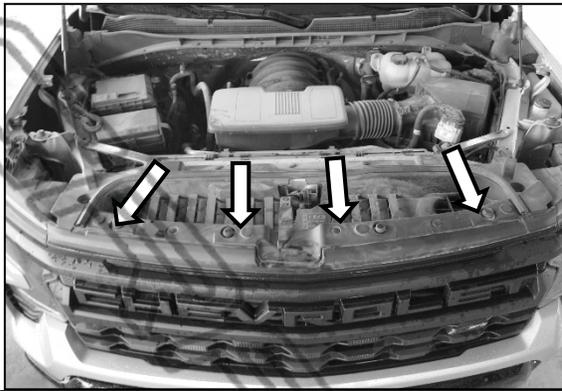
(Fig 3) Remove screws behind headlight attaching driver/left front end of fender to fascia body panel (arrows)



(Fig 4) Remove fascia body panel

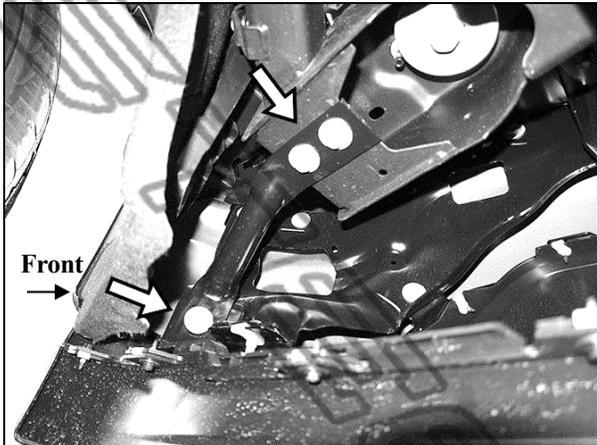


(Fig 5) Remove hood release handle and cover

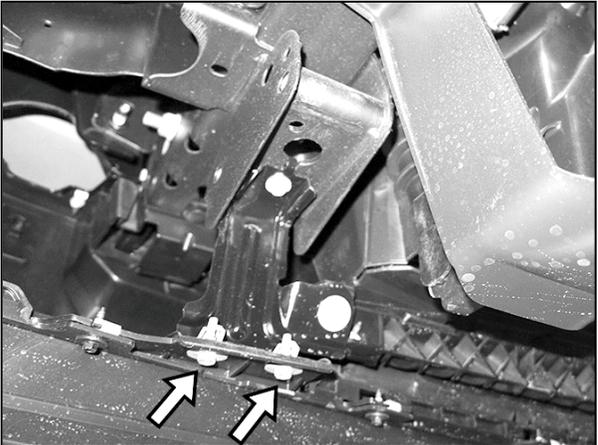


(Fig 6) Remove hardware attaching top and bottom of grille. Firmly pull grille straight out from vehicle

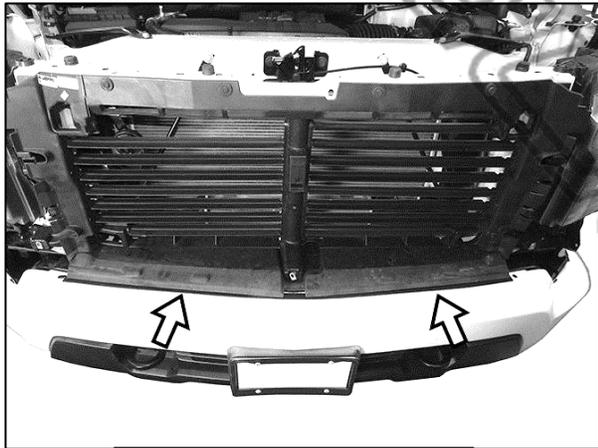
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(Fig 7) Remove outer bumper supports (arrows)



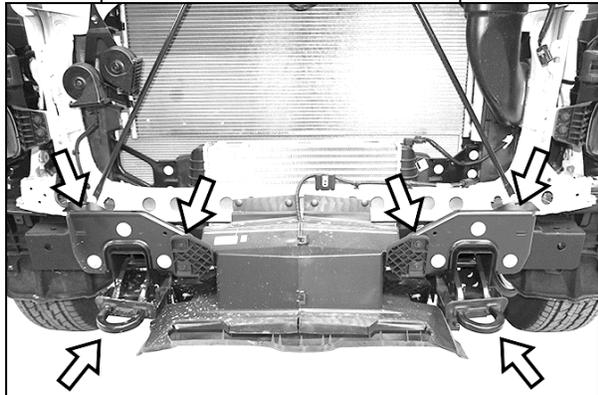
(Fig 8) Remove bolts attaching bottom of bumper to brackets (arrows). Driver/left side pictured



(Fig 9) Remove cover from top of bumper (arrows)

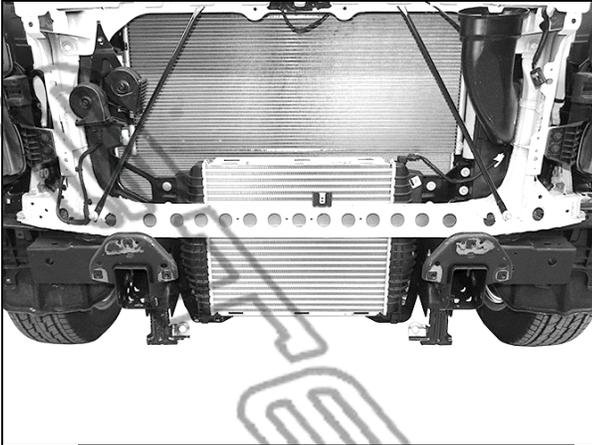


(Fig 10) Remove driver/left top bumper bolts (arrows)



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

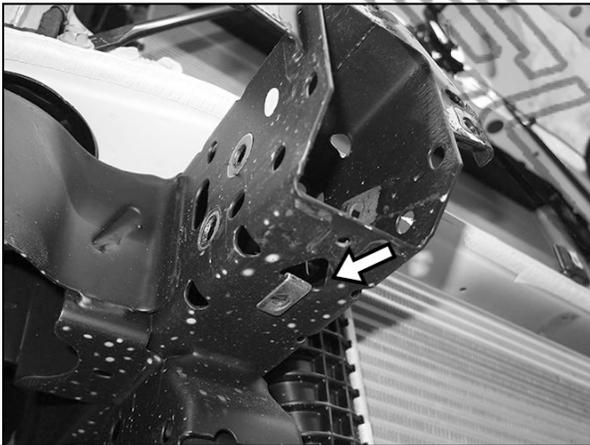
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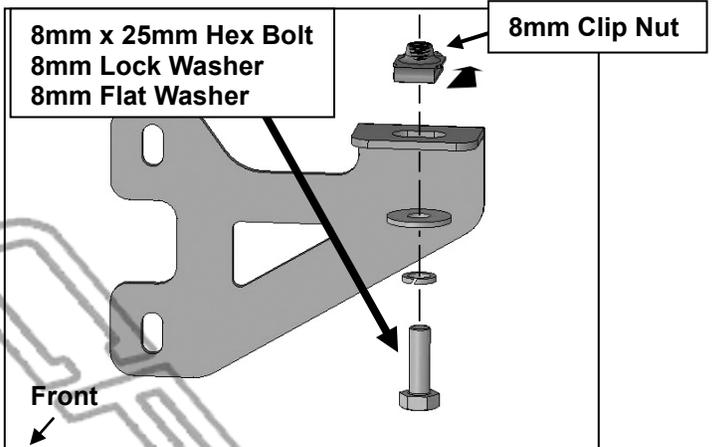
(Fig 12) Models with turbo, shroud and shutter assembly removed



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

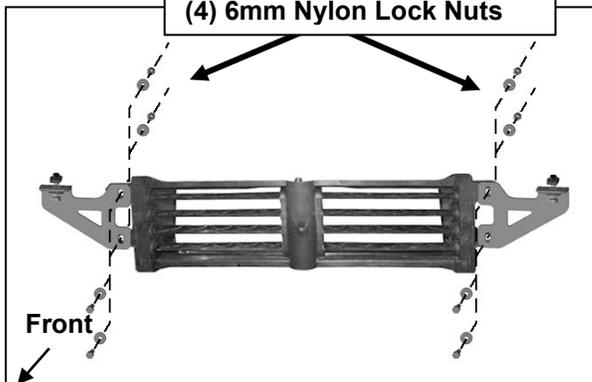


(Fig 14) Turbo model only, slide 8mm Clip Nut into triangle hole and over round hole (arrow)



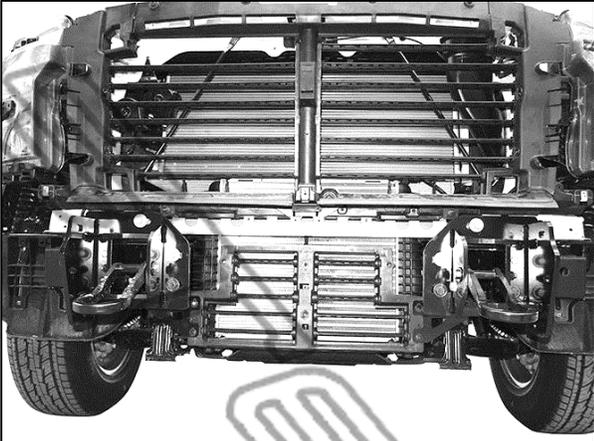
(Fig 15) Turbo model only, attach Driver/left shutter Relocation Bracket to 8mm Clip Nut in bottom of frame (see Fig 14). Repeat for passenger/right Bracket

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



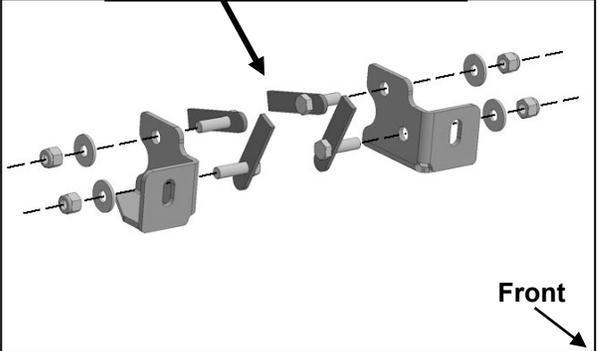
(Fig 16) Turbo model only, attach shutter mechanism to back of Relocation Brackets. Diesel model pictured

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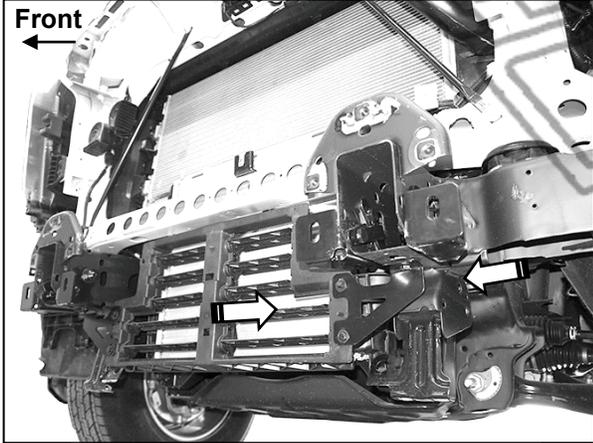


(Fig 17) Turbo model only, attach shutter mechanism to back of Relocation Brackets. Gas model pictured.

- (4) 12mm Bolt Plate
- (4) 12mm Flat Washer
- (4) 12mm Nylon Lock Nut



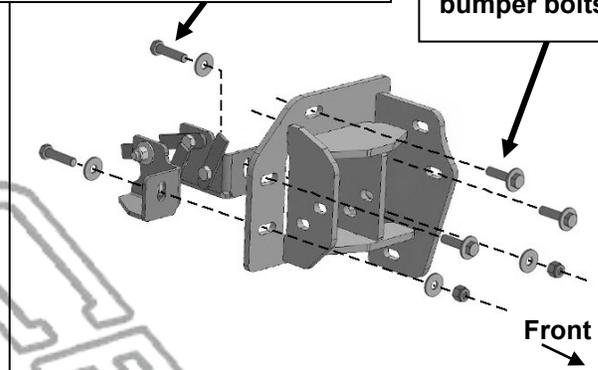
(Fig 18) Attach Support Brackets to outside of frame



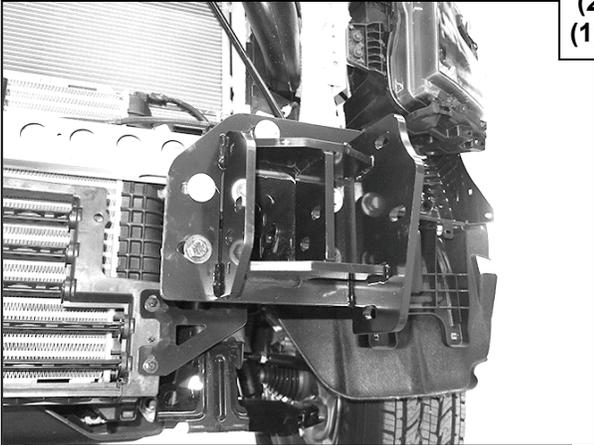
(Fig 19) Support Bracket installed

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

Reuse Factory bumper bolts



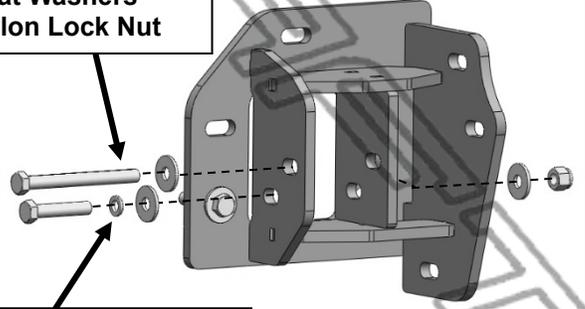
(Fig 20) Reuse factory bumper bolts to attach top of Frame Bracket to bumper mount on frame. Diver/left Bracket illustrated



(Fig 21) Diver/left Frame Bracket attached to frame and Support Brackets

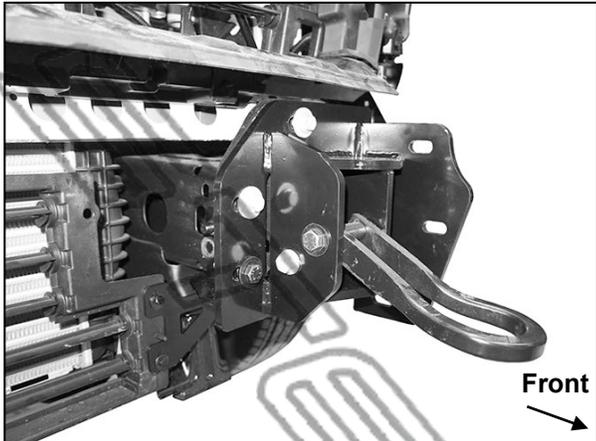
- (1) 12mm x 120mm Hex Bolt
- (2) 12mm Flat Washers
- (1) 12mm Nylon Lock Nut

- (1) 12mm x 60mm Hex Bolt
- (1) 12mm Lock Washer
- (1) 12mm Flat Washer



(Fig 22) Attach factory tow hook to Bracket

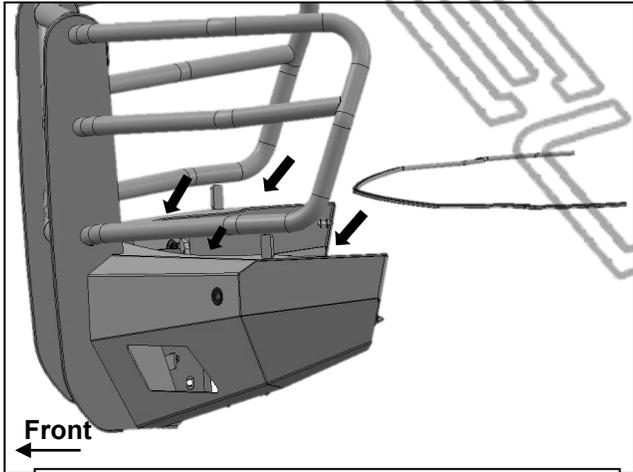
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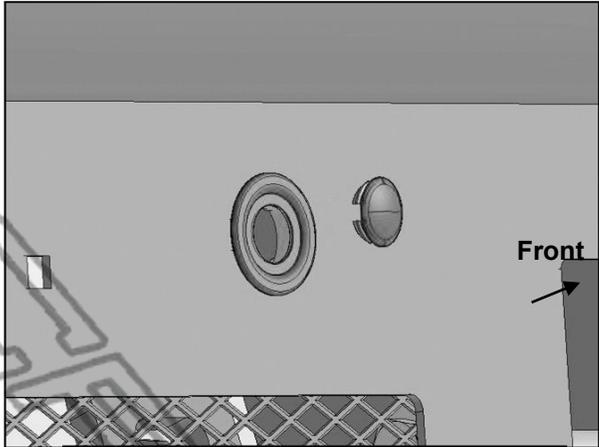
(Fig 23) Attach factory tow hook to Bracket



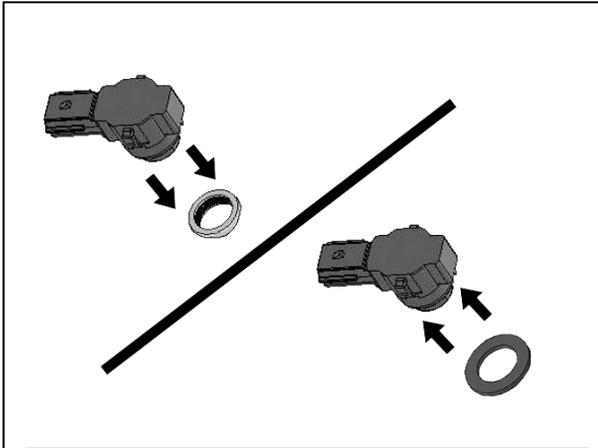
(Fig 24) Reinstall fascia body panel, grille and cover. Reattach inner fender liners



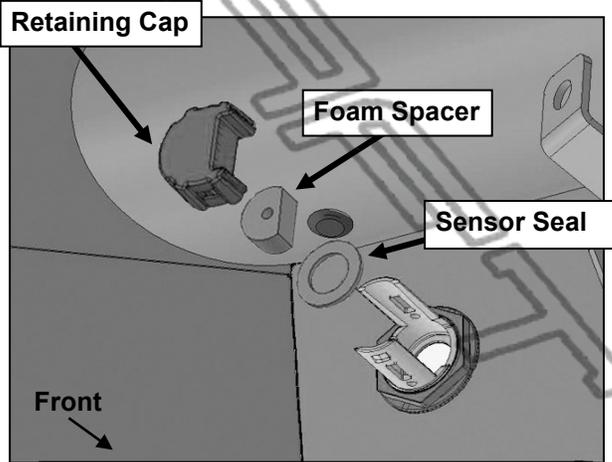
(Fig 25) Push Edge Trim onto top of Bumper



(Fig 26) Models without front sensors, push sensor plugs into mounts



(Fig 27) Remove silicone seal from sensor. Slide large Seal over end of sensor (arrow)

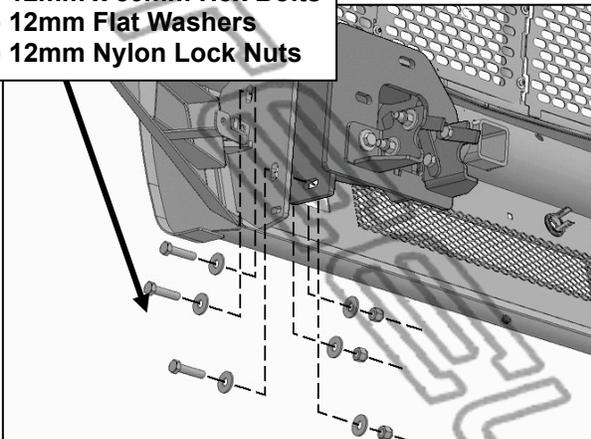


(Fig 28) Insert sensor assembly through the sensor mount on back of Bumper

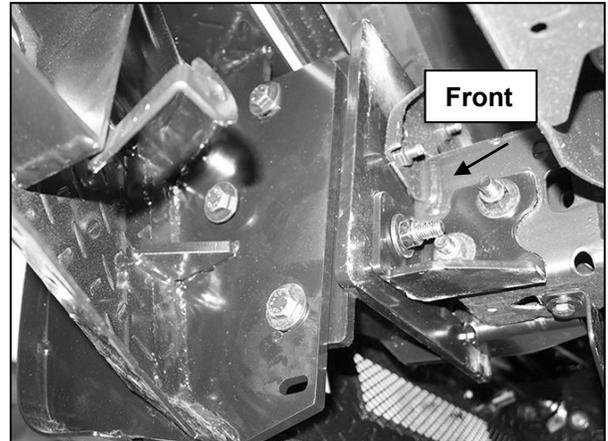
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WARNING! Do not crawl under bumper unless it is properly supported on blocks or stands or the bumper may fall.

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

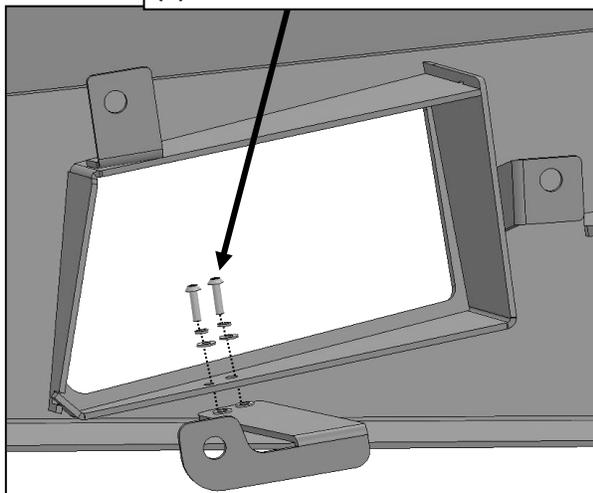


(Fig 29) Attach the Bumper to Frame Bracket



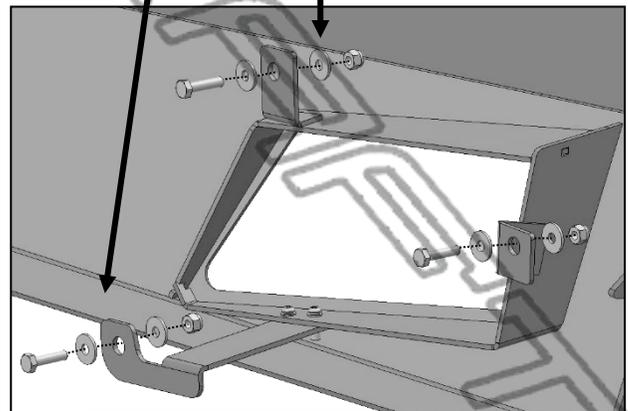
(Fig 30) Driver/left side of Bumper attached to Bracket

- (2) 4mm x 20mm Button Head Screws
- (2) 4mm Lock Washers
- (2) 4mm Flat Washers



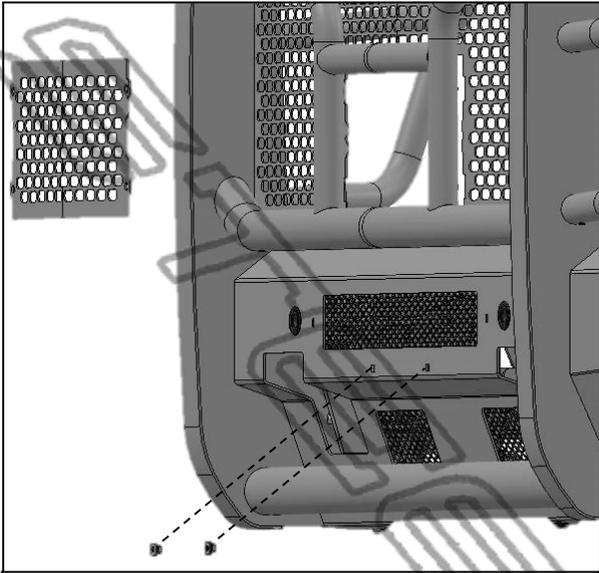
(Fig 31) Attach Fog Light Bracket to bottom of fog light mount.

- (3) 6mm x 25mm Hex Bolts
- (6) 6mm Flat Washers
- (3) 6mm Nylon Lock Nuts

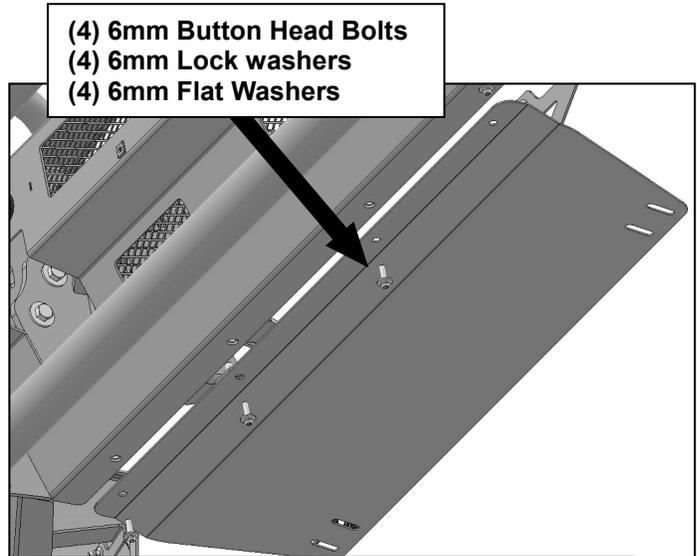


(Fig 32) Attach fog light assembly to mounting tabs on back of Bumper

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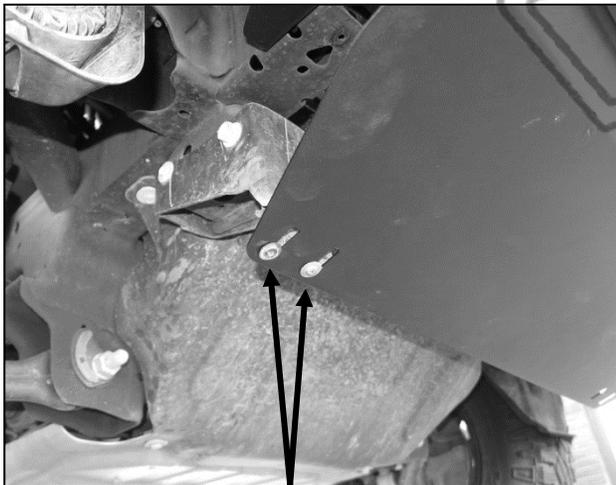


(Fig 33) Models with camera, remove screen. Push Plugs into holes for license plate



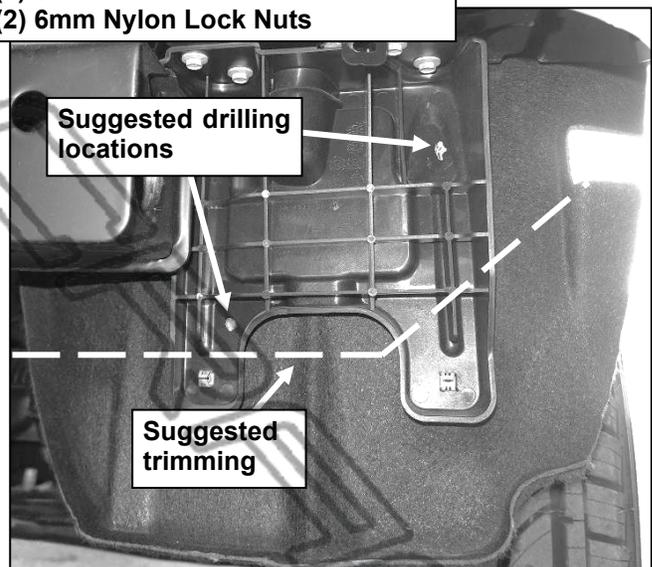
- (4) 6mm Button Head Bolts
- (4) 6mm Lock washers
- (4) 6mm Flat Washers

**(Fig 34) Attach front end of Skid Plate to the bottom of bumper.
NOTE: Skid Plate sits on top of Bumper flange**



(Fig 35) Reuse factory hardware to attach back end of Skid Plate

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



Suggested drilling locations

Suggested trimming

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



Complete Installation