



Installation Instructions

Black Steel/Elite Front Bumper

Product Number: K2160,K2161,K2162,R2160,R2161,R2162

Application: '07.5+ GMC Sierra 1500

SAFETY

Your safety and the safety of others is very important.

- In order to help you make informed decisions about safety, we have provided installation instructions and other information.
- These instructions alert you to potential hazards that could hurt you or others.
- Please do a job safety analysis (JSA) before each task to identify potential hazards for your situation and remove/protect against them.
- You must use your own good judgment, and take your time.

Read and understand all safety precautions and instructions before installing this product.

THIS PRODUCT IS FOR OFFROAD USE ONLY. ALL LIABILITY FOR INSTALLATION AND USE RESTS WITH THE OWNER.

CARELESS INSTALLATION AND OPERATION CAN RESULT IN SERIOUS INJURY OR EQUIPMENT DAMAGE.

Injury hazard

Failure to observe these instructions could lead to severe injury or death.

- Always** remove jewelry and wear eye protection.
- Always** use extreme caution when jacking up a vehicle for work. Set emergency brake and use tire blocks. Locate and use the vehicle manufacturers designated lifting points. Use jack stands.
- Always** use appropriate and adequate care in lifting components into place.
- Always** insure components will remain secure during installation and operation.
- Always** wear safety glasses when installing this kit. A drilling operation will cause flying metal chips. Flying chips can cause serious eye injury.
- Always** use extreme caution when drilling on a vehicle. Thoroughly inspect the area to be drilled (on both sides of material) prior to drilling, and relocate any objects that may be damaged.
- Always** use extreme caution when cutting and trimming during fitting.
- Always** tighten all nuts and bolts securely per installation instructions.
- Always** route electrical cables carefully. Avoid moving parts, components that become hot and rough or sharp edges.
- Always** insulate and protect all exposed wiring and electrical terminals.
- Always** perform regular inspections and maintenance on mounts and related hardware.





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NOTE: Black Steel Accessory Compatibility

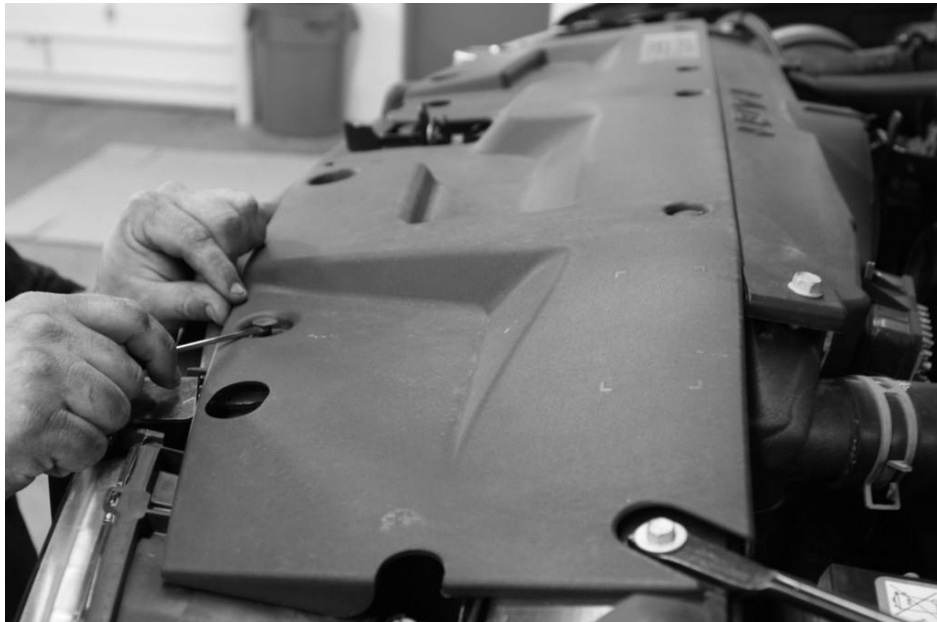
- This product **is** compatible with the Black Steel D-Ring mounting kit - M1850
- This product **is** compatible with the Black Steel Winch Mount kit 20483
- This product **is not** compatible with the Black Steel Winch Mount and 2" receiver hitch kits – M1650 & M1750

I. Tool List

- Metric and Standard socket set
- Various socket extensions
- 3/4" box end wrench
- Philips head screwdriver
- Flat head screwdriver
- "Christmas tree" clip remover

II. OEM Bumper Removal

1. Disconnect the factory fog lamp connectors (if applicable), zip tie harness to frame.
2. Open the hood and remove the 8 dart clips holding the plastic radiator valence.



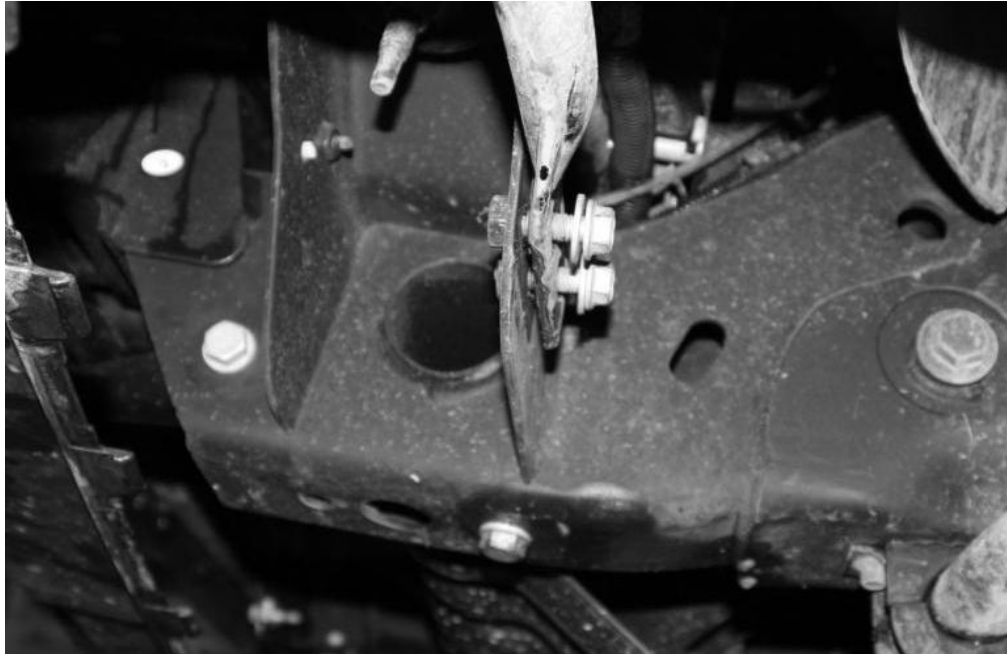
3. Remove the two 7mm screws from the plastic piece from inside the wheel well. Repeat on other side.



4. Reaching behind the grill, use needle nose pliers or a flat blade screwdriver to pop loose all clips holding the painted bumper section to the grill.
5. Remove the painted bumper section from the front of the truck.



6. Using a 15mm socket remove bolts (2 per side) and swing outer bumper support tubes down and out of the way.



7. Remove the dart clips holding the rubber valence between the frame and the bumper.

8. Remove 21mm nuts (2 per side) from the bolt strips holding the bumper brackets to the frame. **NOTE: SUPPORT BUMPER BEFORE REMOVING BOLT STRIPS!**

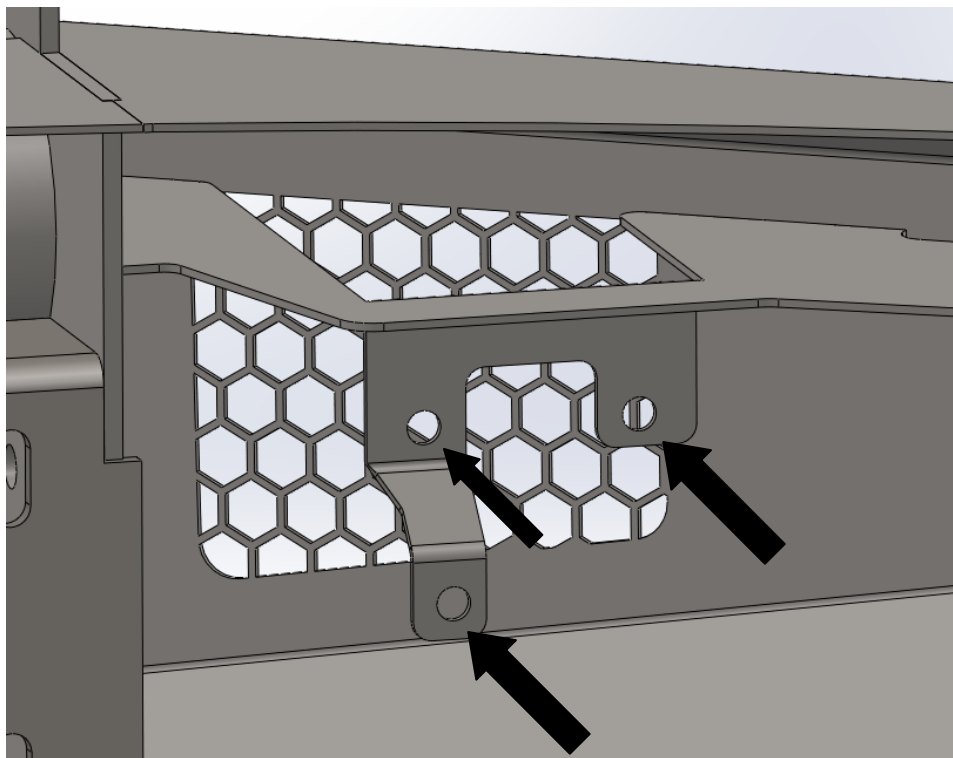


9. With the bumper supported, remove the bolt strips holding the bumper to the frame.
10. Pull outward slightly at the fender wells and remove the bumper from the front of the vehicle.
11. With the bumper removed from the truck, remove the 18mm bolts attaching the factory tow hooks to the frame. Remove the tow hooks.

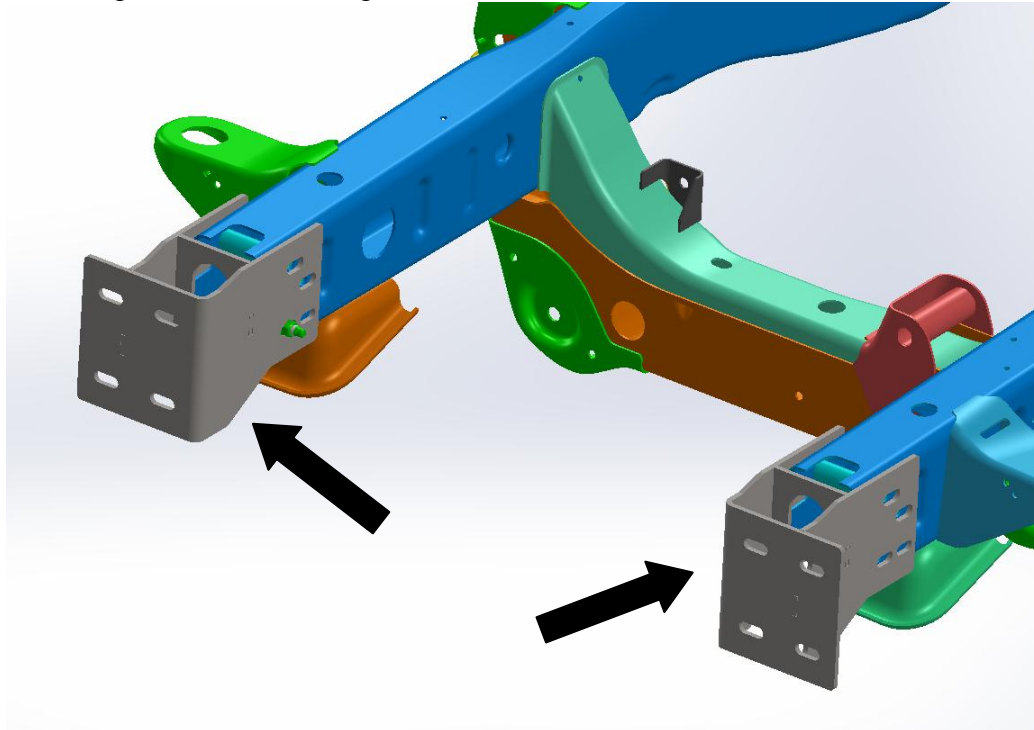


III. Installation

1. If equipped, remove the fog light and mounting brackets from the OEM bumper. Remove the adjuster screw and spring; save for reinstallation.
2. If equipped, reinstall the OEM fog light into the brackets in the Black Steel front bumper. Use the OEM adjuster screw and spring to set the position of the beam.



3. Slide frame mounts over frame ends and align with OEM mount locations (3 per side). Use factory bolt strips and tow hook hardware to fasten to the frame. Be sure to use the correct bracket for the side of the vehicle that it is intended for. The flanges should be facing outward.



4. Reinstall the OEM painted upper bumper
5. If you have the M1850 D-ring kit, it must be installed at the same time as the bumper:
 - a. Install the lower guard in the bumper by inserting it between the uprights from the bottom of the bumper. Loosely secure it with one bolt per side.
 - b. Insert the D-ring mounts into the pockets on either side of the lower guard, aligning the D-ring mounting holes to the bumper mounting holes.
6. With the assistance of a hoist or multiple assistants, lift the bumper and align the mounting slots on the bumper with those on the frame brackets. Fasten with the provided 1/2"- 13 x 2.0" bolts, washers, and nuts. Do not full tighten at this time.
 - a. If installing the bumper with the M1850 D-Ring kit, remove the one fastener per side holding the lower guard, allowing it to rest on the top of



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the D-Rings. This will greatly improve access to the top outside fastener location.

7. Adjust the side to side alignment, and the level of the bumper in relation to the front clip of the truck.
8. Fully tighten all bumper and frame fasteners.
9. Install the lower guard with the supplied hardware. Fully tighten the fasteners.
10. If equipped, reconnect the fog light wiring harness and check fog light aim.

IV. Maintenance/Care

- Periodically check and tighten all nuts.
- Stripped, fractured, or bent bolts or nuts need to be replaced.



More than expected... Better than expected

