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IRON CROSS AUTOMOTIVE INC.

1999-2002 Silverado 1500
2000-2006 Suburban/Tahoe
Front Bumper Installation

20/22/24-515-99

Installation Instructions

Hardware

12	1/2" Flat Washers	6	3/8" Flange Bolts
6	1/2" Lock Washers	6	3/8" Flat Washers
6	1/2" Hex Bolts	6	3/8" Lock Washers
6	1/2" Hex Nuts	6	3/8" Nuts
1	Passenger Side Bracket	1	Driver Side Bracket
1	Front Bumper		

Vehicle Preparation

1) Remove (7) plastic clips holding radiator support cover on *Fig 1*.

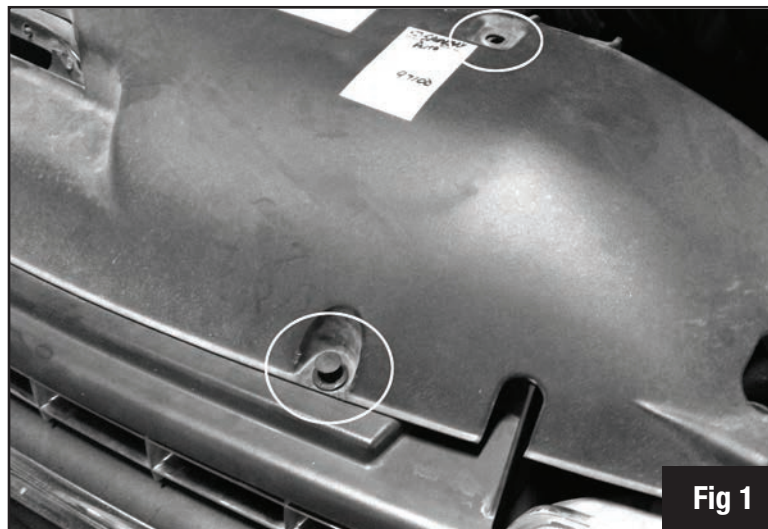


Fig 1



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Vehicle Preparation Continued...

2) Twist (4) locks holding grill in. Also remove (1) bolt holding grill shell in place. Carefully pull grill from very outer edge under headlight. Grill will pop out of clip under headlight allowing removal *Fig 2*.

3) Set grill and hardware off to the side for reassembly after bumper is attached.

4) Unbolt (4) bolts holding on tow hook. Remove and discard all components.

5) Unhook fog light and move wiring out of the way.

6) Remove (2) bolts from outer bumper support *Fig 3*.

7) Remove (4) bolts holding bumper on to frame. Bolts are located behind bumper directly below where the grill was *Fig 4*.

8) Remove bumper and discard.



Fig 2



Fig 3

Bumper Installation

1) Use (6) 3/8" bolts and attach the brackets to the frame. Leave bolts loose so you can adjust the bumper after bolted to the brackets.

2) Attach bumper to brackets using (6) 1/2" bolts.

3) Align bumper side to side till it sticks out evenly on both sides of the vehicle. Also align bumper up and down, leaving 1/2" gap between any factory body parts.

4) Tighten the 1/2" bumper to bracket bolts first (65 ft/lb). Next, tighten the 3/8" bolts going into the side of the bracket and through the frame rail (35 ft/lb). Tighten the bottom bracket bolts last. Make sure not to tighten these bolts too much, as they can twist the alignment of the bumper.

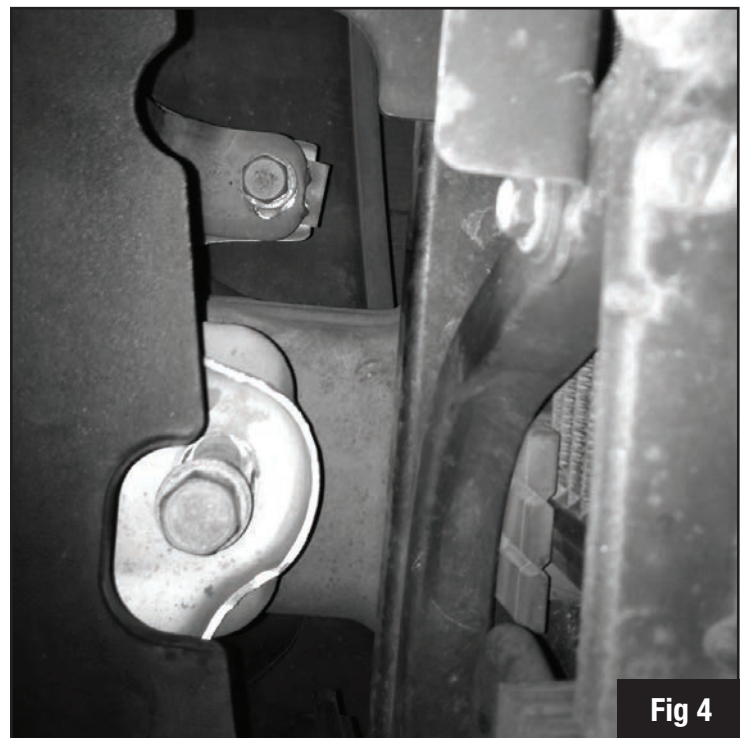


Fig 4