



## 21-515-14 & 21-525-15 Rear Bumper for 2014 & 2015 GM Models

Bumper removal – There are two ways you can remove your factory rear bumper. Chevy did not make this an easy chore on the new model. The first way is easier but requires some prying and maybe a little more bending and twisting on your new truck than you may like. The second way is more time consuming and may require certain tools a lot of DIY'ers may not have.

### Removal method

1. Unhook all wiring factory or otherwise going to the rear bumper. Also go ahead and take off your license plate. You will need it for later.
2. Remove the (8) bolts holding your rear bumper on. There are (2) double bolt clips and (2) bolts going through the side wall of the frame. There is also (2) bolts going up vertically through the receiver, into the frame. Fig 1
3. Inside the license plate hole, there are (2) bolts that need to be removed. Fig 2
4. This is where the bending and twisting come into play. Your bumper can now slide out of the truck. The only problem is that you will see the factory brackets will hit the bed. With a little forceful prying the bumper will come out.
5. You basically have to get the lip from the bed to flex enough to allow the brackets to slide out. We did this pretty easily by actually pulling the bumper out until it hit, then putting pressure on the step area in the center of the bumper allowing the bumper to roll down and flexing up the bed lip. After it was removed there was no evidence or scratches to the bed that was noticed from the outside of the vehicle. If you are not ok with doing this, then jump to step 5, and we will continue on.
6. Look at fig. 3 and it will show all the attachment bolts for the outer bumper shell. There are (4) inside the step, and (6) inside the bumper end. The (4) bolts that are circled you don't need to unbolt. Once you have all the bolts undone from each side, then you can go to the next step of removing the plastic cover.
7. Your top cap on the bumper is held on by numerous plastic push clips, see fig.4. These can be pryed out or if you can reach them from the bottom side, squeezed together and then pushed through the bumper shell. There (21) clips total holding the top cap on. There is a good possibility you will destroy the top cap getting it off.
8. Once the cover is off the bumper unbolt the (10) bolts shown in fig 5. This will allow the bumper to be removed from the truck. Then you can remove the brackets from the truck
9. Once the bumper is removed, bend the tabs up to free the spare tire holder cover from the bumper, fig 6. Save for install on your new bumper.
10. Push in the (2) clips holding in the trailer plug and remove from the bumper. Save for reinstall on your new bumper. Fig 7

### Installation

1. Install your factory trailer plug and spare tire cover opposite of how you removed it.

2. Bolt your new iron cross brackets to the frame, using the same holes the factory brackets came out of. Use the supplied (6) ½" bolts and tighten to 60 ft/lb.
3. Align the bumper up to the brackets on the truck. Use the supplied (4) ½" bolts to attach the bumper to the brackets. Align the bumper to the truck and tighten to 60 ft/lbs
4. Plug in your factory wire harness and enjoy and your new Iron Cross Automotive bumper!

#### Hardware

10 – ½" nuts, bolts, and lock washers

20 – ½" Flat Washers

2-Tag Lights

2-Brackets