

American Made = American Jobs



IRON CROSS
AUTOMOTIVE INC.

**2015 Silverado Sierra
2500/3500**

20/22/24 325-15 20/22/24 525-15

Front Bumper Installation Instructions

| Hardware | | | |
|----------|--------------|----|-----------------|
| 14 | ½" Hex Bolts | 14 | ½" Lock Washers |
| 14 | ½" Hex Nuts | 28 | ½" Flat washers |

Removal

1. Remove plastic clips holding on radiator cover. Remove cover and set aside for reinstallation. **Fig 1.**

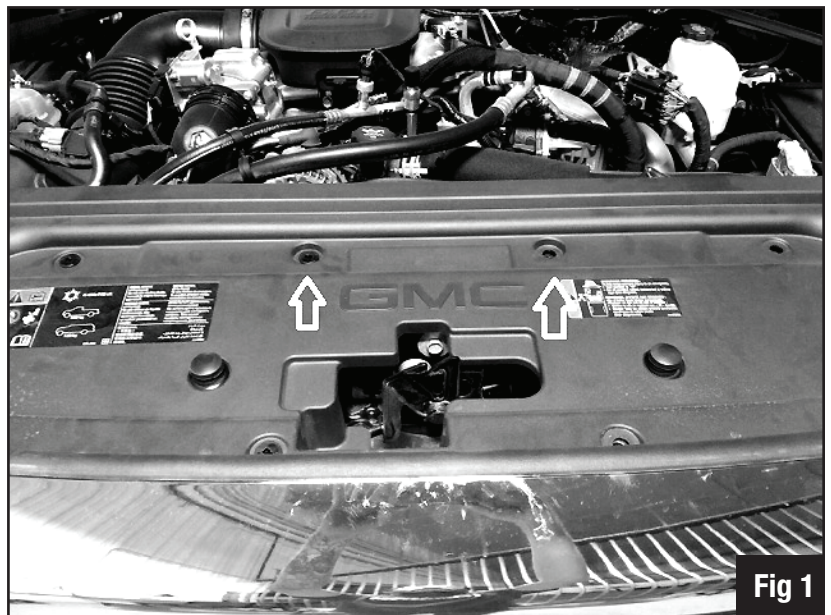


Fig 1



2. Remove the (4) bolts attaching the top of the grill. Firmly pull the grill straight forward from the bottom and center of the grill on each side. The grill will pop out of its push in clips. Set grill and hardware to the side for reinstallation.
Fig 2.

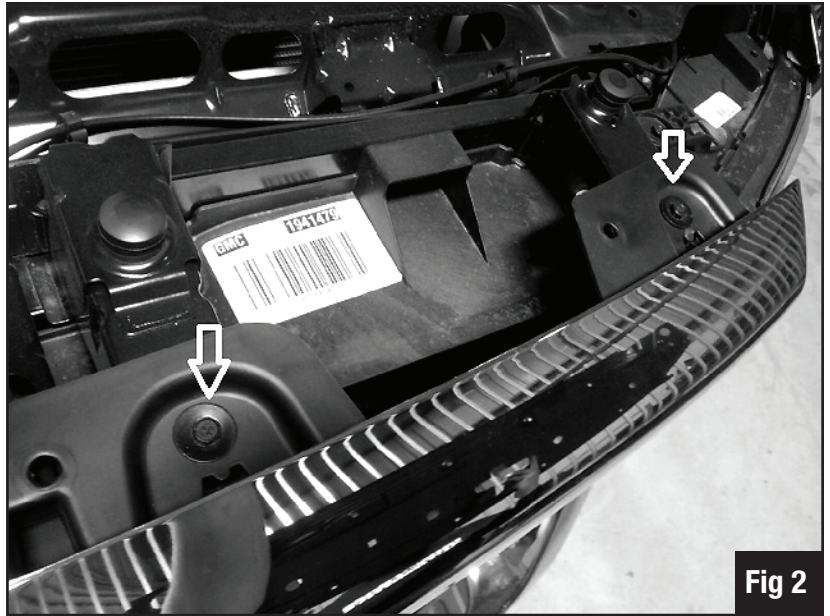


Fig 2

3. Unbolt front bumper from the frame. The bolts are located behind the top of the bumper and downwards. **Fig 3.**

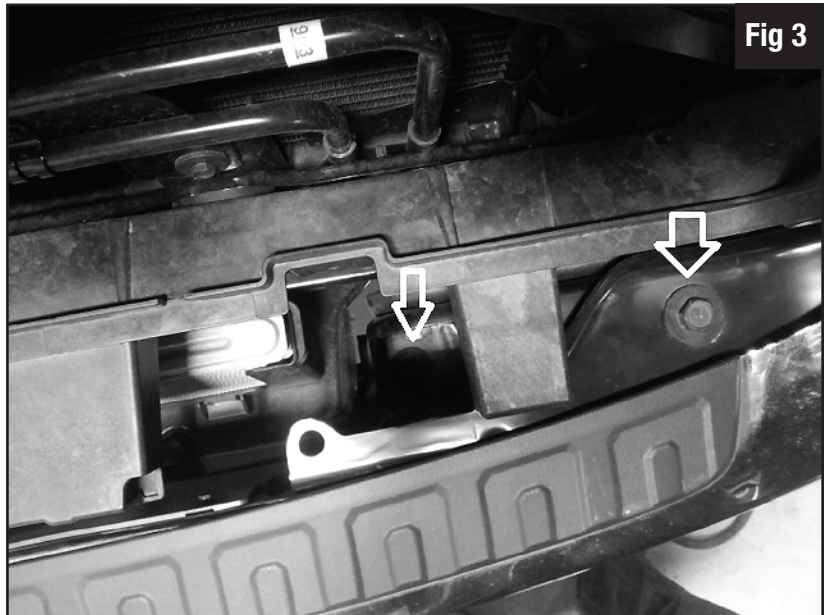
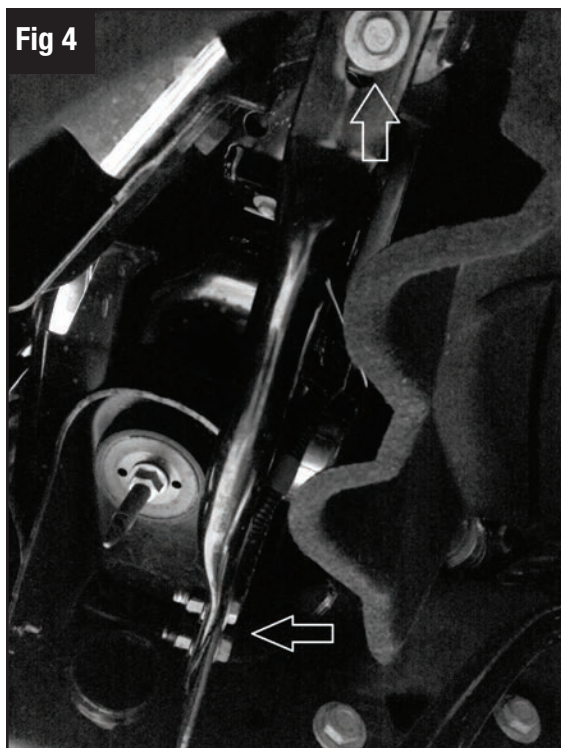


Fig 3



Fig 4



4. Unbolt the factory bumper supports located inside each fender well. There is one bolt going into the bumper and two into the frame. Discard these items. **Fig 4.**

5. Unhook any factory wiring and pull bumper straight forward away from your truck.

6. Unbolt the factory bumper mount and discard. Keep the bolts to reinstall your new Iron Cross bumper. **Fig 5.**

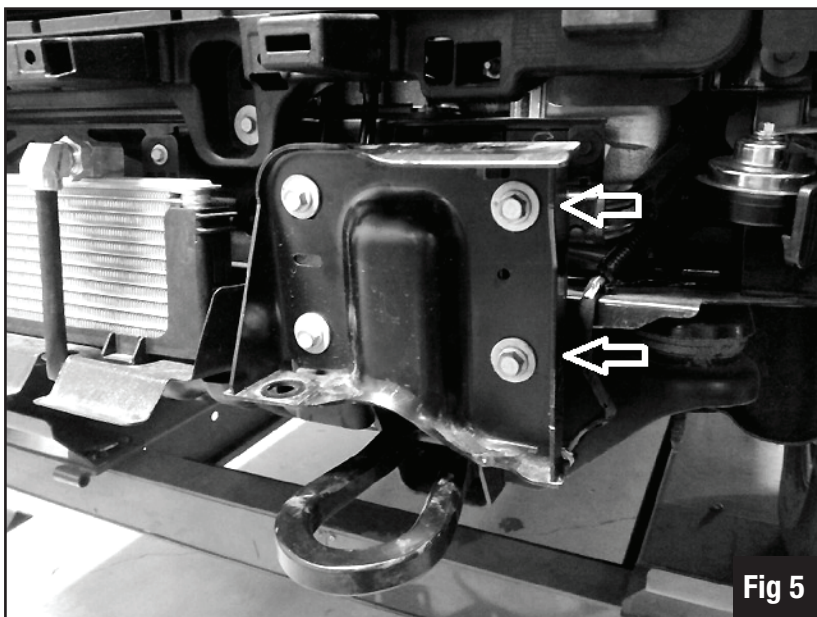


Fig 5

7. Remove your factory tow hooks and discard. **Fig 6.**

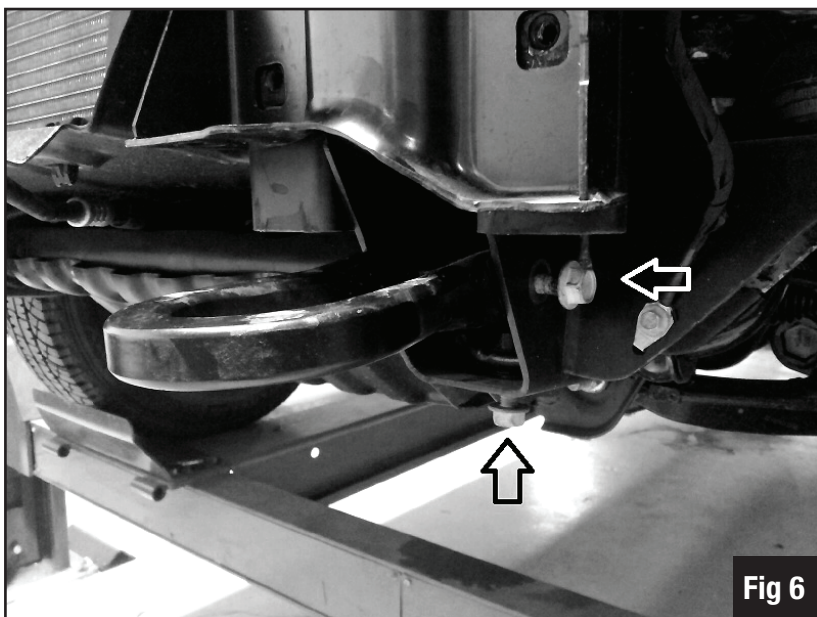


Fig 6



Bumper Installation

1. Attach your new Iron Cross Bumper brackets to the frame at the factory location using the factory hardware. **Fig 7** (Chevy) and **Fig 8** (GMC) Center brackets leaving 28" between them.

Hand tighten at this time.

2. Slide your new Iron Cross Bumper inbetween the brackets. Use the supplied 1/2" hardware and hand tighten.

3. Align bumper left and right, making sure to leave 1/2" between your bumper and any factory panels. Tighten your brackets to the frame.

4. Align the bumper up and down and in and out, again leave 1/2" between any factory panels and your bumper. Tighten the bumper to the brackets to 60 ft/lb.

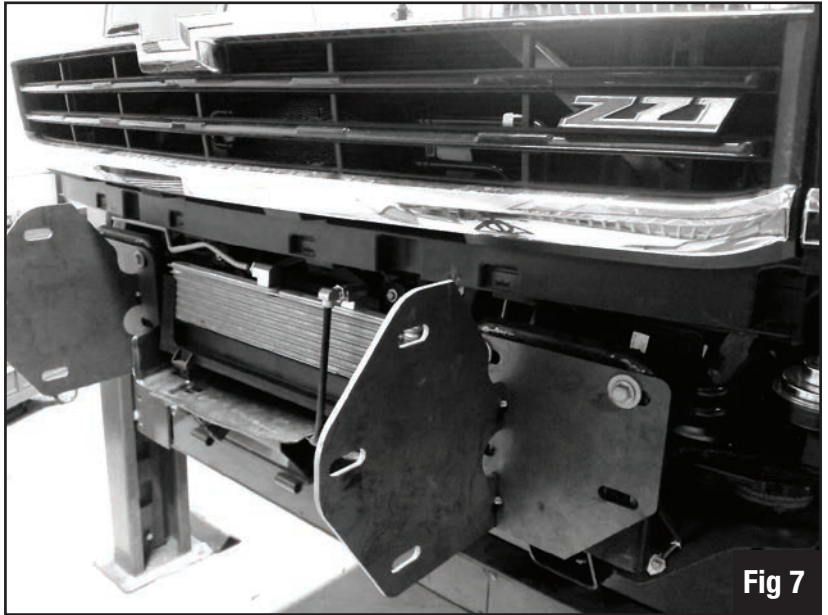


Fig 7

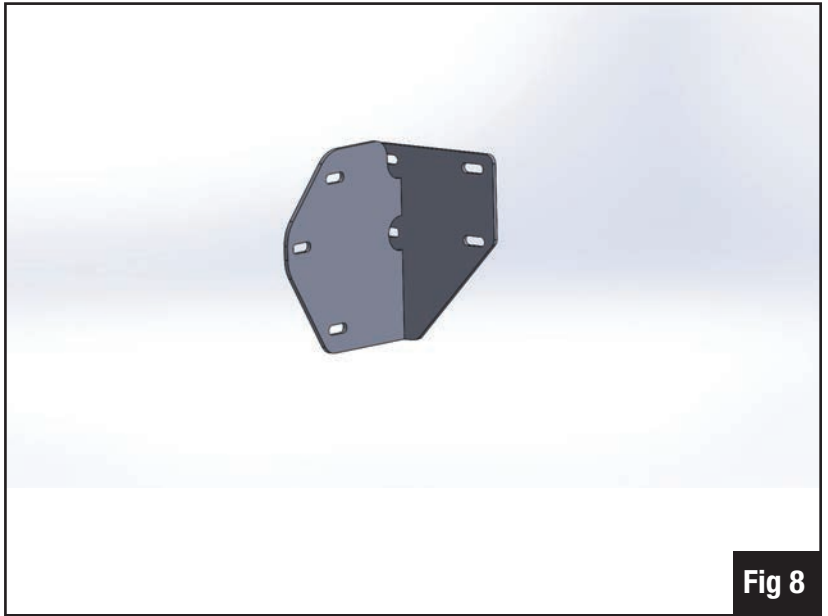


Fig 8

