

American Made = American Jobs



**IRON CROSS**  
AUTOMOTIVE INC.

20/22/24-525-11  
11-13 Chevrolet 2500/3500

## Installation Instructions

### Hardware

8	½" Hex Bolt	8	½" Lock Washer
16	½" Flat washers	8	½" Hex Nut
1	Driver Side Bracket	1	Passenger Side Bracket
1	Front Bumper		

*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.*

## Bumper Removal

1. Remove bolt connecting bumper from arm brace.

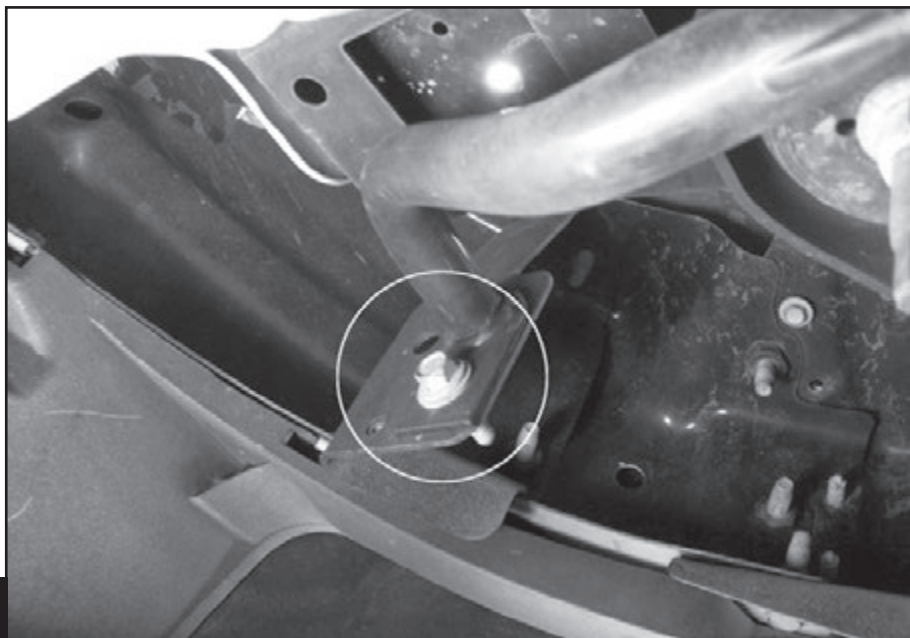


Fig 1

2. Remove nuts from factory U bolt (**Fig 2**).



**Fig 2**

3. Remove hardware connecting tow hooks (**Fig 3**).



**Fig 3**



## Bracket Install

1. Install driver/passenger bracket to inside of frame using factory U bolt (Fig 4).

1/2" hex bolt  
1/2" flat washers (x2)  
1/2" lock washer  
1/2" hex nut

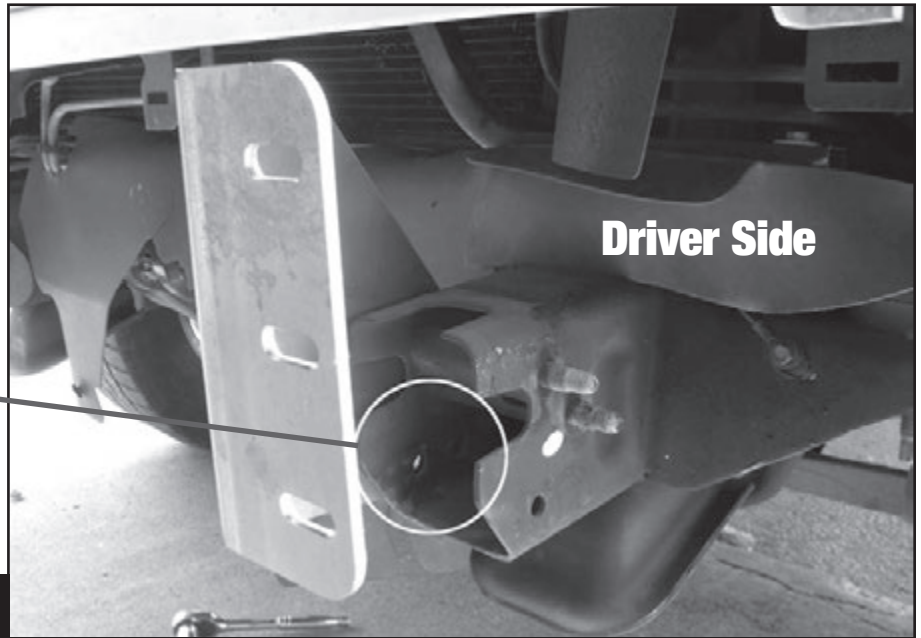


Fig 4

## Bumper Install

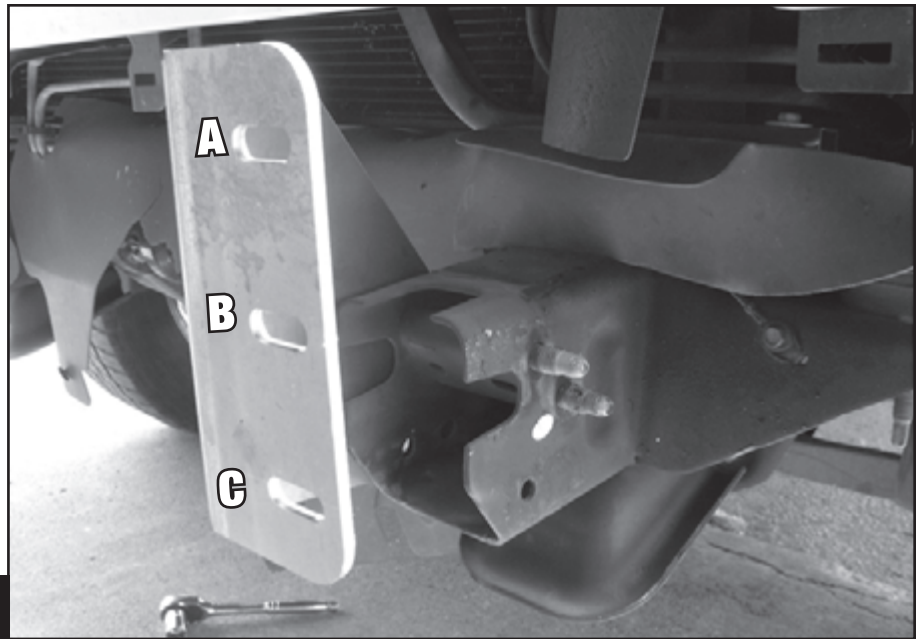
1. Install bumper to brackets. Use jack stands or a person to help hold bumper to brackets. Insert 1/2" hardware and loosely tighten to allow for adjustment (Fig 5).



Fig 5

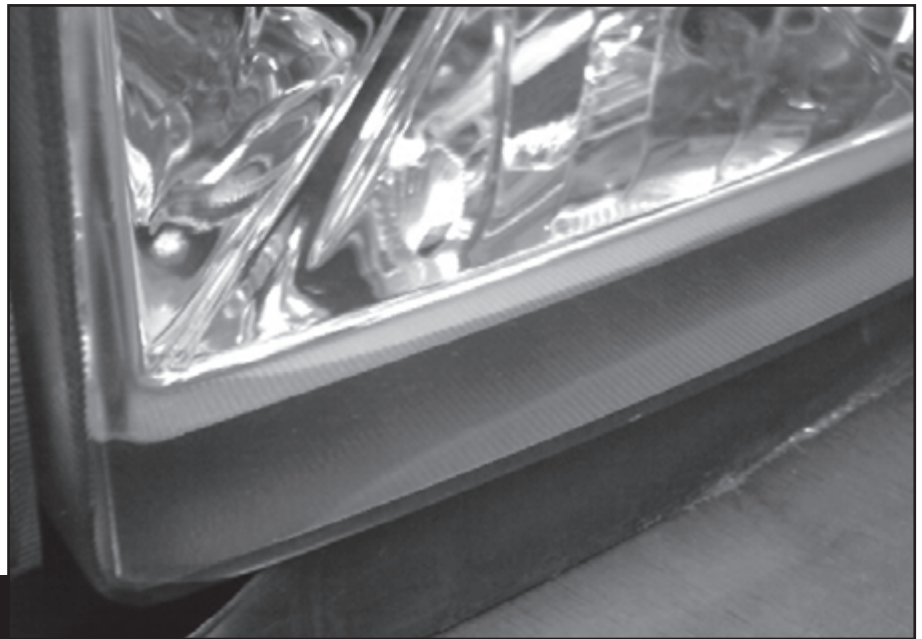


2. Install 1/2" hex bolt, (x2) 1/2" flat washers, 1/2" lock washer, and 1/2" hex nut into holes A, B, & C through bumper and bumper brackets (Fig 6).



**Fig 6**

3. On some models you may need to remove the rubber trim from the top of the bumper that goes underneath the headlights. Trim rubber to length to fit the Iron Cross bumper properly (Fig 7).



**Fig 7**

4. Align the bumper side to side and top to bottom to ensure a perfect fit to the truck. Allow for a 0.25" clearance to all painted surfaces if possible to allow for frame flex.



Tighten all hardware for final installation (Fig 8).



**Fig 8**