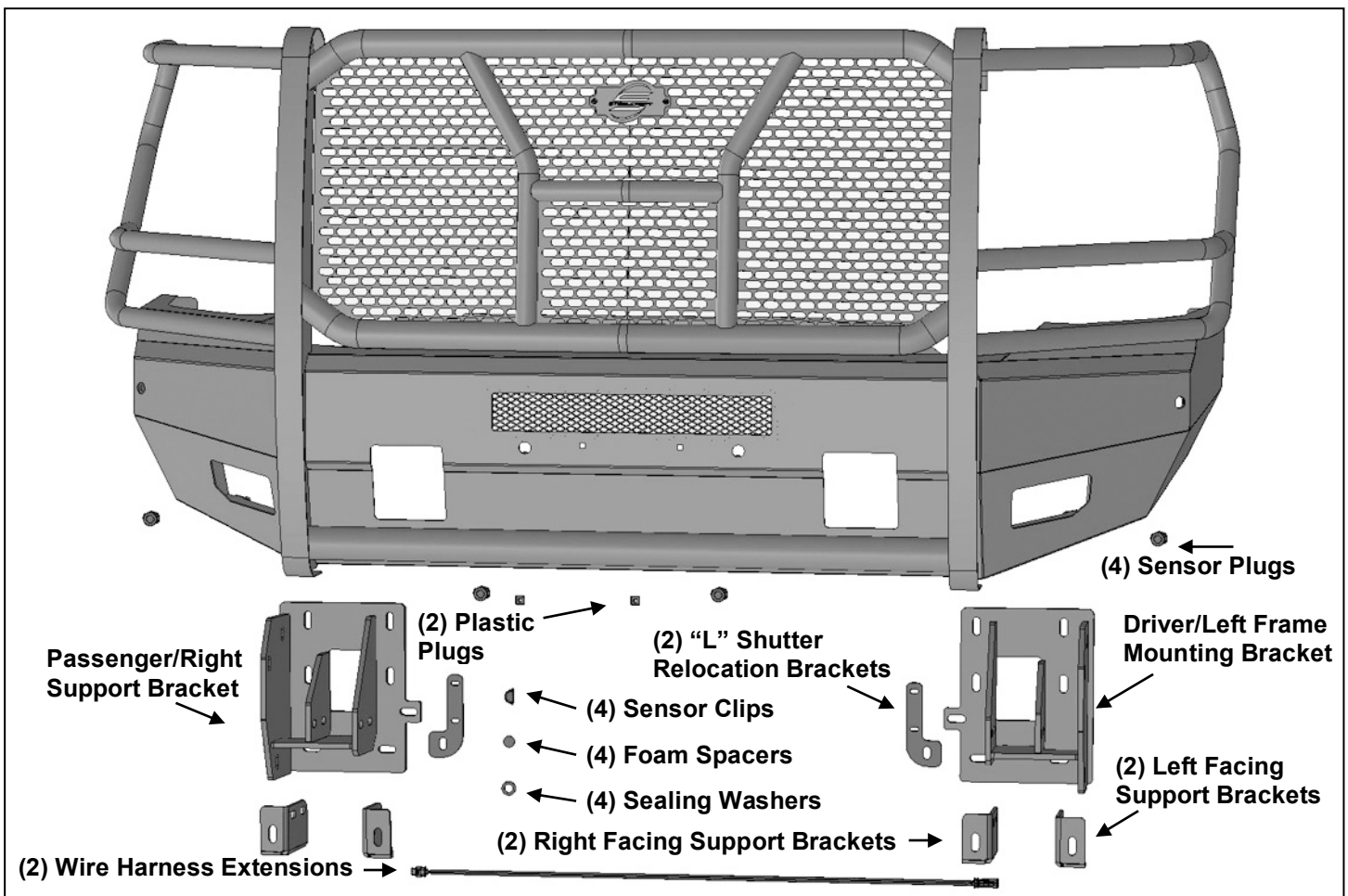




**ELEVATION FRONT BUMPER
2020 GMC SIERRA 25-3500**

PARTS LIST:

1	Elevation Front Bumper	4	12-1.75mm x 130mm Hex Bolts
1	Driver/left Mounting Bracket	18	12-1.75mm x 50mm Hex Bolts
1	Passenger/right Mounting Bracket	44	12mm x 32mm x 3mm Flat Washers
2	Left Facing Support Bracket	22	12mm Lock Washers
2	Right Facing Support Bracket	22	12mm Hex Nuts
2	Shutter Relocation "L" Brackets	2	8-1.25mm x 30mm Hex Bolts
4	Rubber Sensor Hole Block Offs	4	8mm x 28mm x 3mm Flat Washers
4	Sealing Washers	2	8mm Nylon Lock Nut
4	20mm x 2mm Foam Spacers	10	6-1.0mm x 20mm Hex Bolts
4	Retaining Rings	20	6mm x 18mm x 1.6mm Flat Washers
2	Sensor Wiring Harness Extensions	10	6mm Nylon Lock Nuts
1	Sensor Covers Kit	8	4mm x 10mm Button Head Screws
2	Plastic Plugs for License Plate	1	4mm Wrench
		1	2.5mm Wrench



PROCEDURE:

REMOVE CONTENTS FROM BOX. VERIFY ALL PARTS ARE PRESENT. READ INSTRUCTIONS CAREFULLY BEFORE STARTING INSTALLATION. BUMPER IS HEAVY, ASSISTANCE IS HIGHLY RECOMMENDED TO AVOID POSSIBLE INJURY OR DAMAGE TO THE VEHICLE.

1. Start installation at the driver/left wheel opening. Remove the hardware attaching the fender liner to the front of the fender, bumper and the end of the plastic body panel, (**Figure 1**). Repeat this Step to release the passenger/right fender liner.
2. Open the hood and remove the hood handle. Next remove the plastic cover from the top of the radiator and the grille, (**Figure 2**). **NOTE:** Temporarily reinstall the hood release handle.

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3. Move to the inner end of the body panel, (fascia panel), below the headlight. Carefully pull the end next to the grille, outward to release the body panel from the clips, **(Figure 3)**. The fascia panel does not need to be removed, only released from the clips toward the grille. Repeat to release the passenger/right fascia panel.
4. Remove the hardware attaching the grille and pull it straight out from the vehicle. On models with grille mounted camera, unplug harness leading to the camera and remove the grille, **(Figure 4)**.
5. Unplug any wiring harnesses leading to the front bumper, **(Figure 5)**. Move all harnesses away from bumper. Remove the license plate and bracket if equipped, **(Figure 4)**.
6. Remove the bumper supports attached to the bottom of the frame and end of the bumper, **(Figure 6)**.
7. Place blocks or jack stands under the front bumper to support it during mounting bolt removal. Once the bumper has been safely supported, from above the bumper, remove the (2) factory upper and lower bumper bolts from each side, **(Figure 7)**. **WARNING!** Assistance is required to hold the bumper in place during bolt removal to prevent the bumper from falling. Remove the bumper assembly.
8. Remove the factory bumper brackets and tow hooks, (if equipped), from the end of frame, **(Figure 8)**. On models with lower radiator shutter assembly, unplug and remove the assembly, **(Figures 8 & 9)**.
9. Select the driver/left Frame Mounting Bracket, **(Figure 10)**. Reuse the factory hex bolts to attach the Bracket to the end of the frame. Do not tighten hardware at this time.
10. Next, select (1) Right Facing Lower Support Bracket, **(Figure 11)**. Attach the Right Facing Support Bracket to the inner facing side of the frame with (2) 12mm x 50mm Hex Bolts, (4) 12mm Flat Washers, (2) 12mm Lock Washers and (2) 12mm Hex Nuts. Attach the Support Bracket to the back of the Frame Mounting Bracket with (1) 12mm x 50mm Hex Bolt, (2) 12mm Flat Washers, (1) 12mm Lock Washer and (1) 12mm Hex Nut, **(Figure 13)**. Do not fully tighten at this time. Repeat this **Step** to attach (1) Left Facing Support Bracket to the outside of the frame and Mounting Bracket, **(Figures 12—14)**.
11. Repeat **Steps 9 & 10** to install the passenger/right Frame Bracket and Support Brackets
12. On models equipped with lower radiator shutter system, remove shutter assembly from outer plastic housing, **(Figure 15)**. Select (1) "L" Relocation Bracket. Attach the Bracket to the front of the Frame Bracket with (1) 8mm x 30mm Hex Bolt, (2) 8mm Flat Washers and (1) 8mm Nylon Lock Nut, **(Figure 16)**. Repeat this Step to attach the remaining "L" Bracket to the passenger/right Frame Mounting Bracket. Attach the shutter assembly to the "L" Brackets with the included (4) 6mm x 20mm Hex Bolts, (8) 6mm Flat Washers and (4) 6mm Nylon Lock Nuts, **(Figures 17 & 18)**. Do not overtighten the hardware or damage to the shutter assembly may result. Plug wiring harness into shutter assembly
13. Select the driver/left tow hook if equipped. Attach the tow hook to the Frame Bracket with the included (2) 12mm x 130mm Hex Bolts, (4) 12mm Flat Washers, (2) 12mm Lock Washers and (2) 12mm Hex Nuts, **(Figure 19)**. Repeat to install the passenger/right tow hook, **(Figure 20)**. Fully tighten the tow hook hardware only.
14. Disassemble factory bumper to remove wiring harness, sensors and lights as equipped, **(Figure 21)**.
15. Determine if the vehicle is equipped with parking sensors.

Models without bumper sensors:

- a. Select the included (4) Rubber Plugs.
- b. From behind bumper, push plugs into sensor mounting holes, **(Figure 22)**. Screws have been provided to lock the plugs in the sleeve. Use is optional.

Models with bumper mounted sensors:

- a. Select the driver/left outer sensor. Remove the silicone seal from the end of the sensor. Slide the included larger Sensor Seal over front of sensor, **(Figure 23)**.
- b. Insert sensor with Seal into sensor mount, **(Figure 24)**.
- c. Place Foam Washer over end of sensor. Push Sensor Retaining Clip into sensor mount and lock into mounting holes, **(Figure 24)**.
- d. Repeat previous Steps to install remaining sensors.
- e. Install the factory bumper wiring harness for sensors and fog lights as equipped. Run wiring harness over or through Brackets to reach sensors, **(Figure 25)**. **NOTE:** (2) Wire Harness Extensions have been included to extend the factory harness to outer sensors as needed.
- f. Plug harness into sensors.

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16. With assistance, position the Bumper Assembly up to and over the Brackets and tow hooks. Temporarily support the weight of the Bumper. **WARNING:** To avoid possible injury or damage to the vehicle, do not proceed until the Bumper is fully and safely supported.
17. Line up the (3) holes in the driver/left side mounting plate on the inside of the Bumper with the (3) slots in the Frame Bracket. Attach the Bumper to the Bracket with the included (3) 12mm x 50mm Hex Bolts, (6) 12mm Flat Washers, (3) 12mm Lock Washers and (3) 12mm Hex Nuts, (**Figures 26 & 27**). Do not fully tighten hardware at this time. Repeat this Step to attach the passenger side mounting plate to the Frame Bracket.
18. Level and adjust the bumper and fully tighten all 12mm hardware to 65-70ft-lbs.
19. **Models with fog lights:**
 - a. Select the driver/left fog light. Rotate light 90-degrees and attach the fog light to the mounting tabs on the back of the Bumper with the included (3) 6mm x 20mm Hex Bolts, (6) 6mm Flat Washers and (3) 6mm Nylon Lock Nuts, (**Figures 28 & 29**). Do not overtighten hardware or damage to the light may result.
 - b. Repeat the previous Steps to attach the passenger/right fog light.
 - c. Plug wiring harness into fog lights.
20. Use the included (2) push-in Plastic Plugs to attach the front license plate, (if required), to the (2) holes in the front Bumper, (**Figure 30**).
21. Models with grille mounted camera, remove screen from center of Bumper, (**Figure 30**).
22. Back of Bumper is equipped with mounting tabs for LED center light, (**Figure 24**). Follow manufacturer's installation and wiring instructions for proper installation.
23. Do periodic inspections to the installation to make sure that all hardware is secure and tight.

To protect your investment, Do not use any type of polish or wax that may contain abrasives that could damage the finish. Mild soap may be used to clean the Elevation Front Bumper assembly.

Driver/left Side Installation Pictured



(Fig 1) Release hardware attaching fender liner to back of bumper and fender (driver/left side pictured)



(Fig 2) Open hood. Temporarily remove release handle (arrow). Remove plastic cover from top of grille and radiator

Driver/left Side Installation Pictured



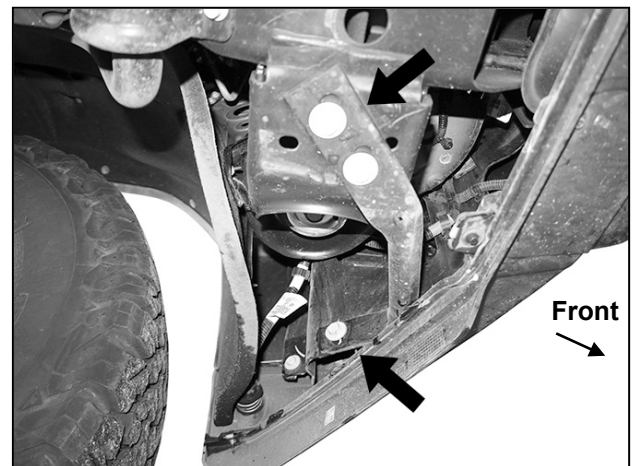
(Fig 3) Pull outward to release plastic fascia body panel from clips. Do not remove, only release inner end to remove grille



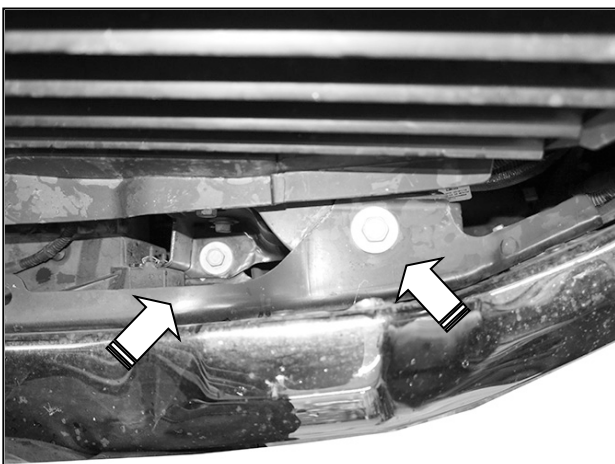
(Fig 4) Disconnect harness to camera (if equipped) and remove grille



(Fig 5) Disconnect all wire harnesses leading to front bumper



(Fig 6) Remove outer bumper supports attached to bottom of frame



(Fig 7) From above, remove the hex bolts attaching the bumper assembly to the frame bumper brackets

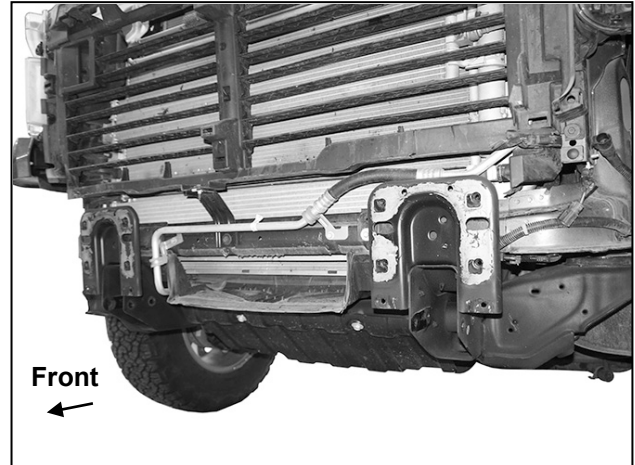
WARNING! Do not crawl under bumper unless it is properly supported on blocks or stands or the bumper may fall.

Driver/left Side Installation Pictured

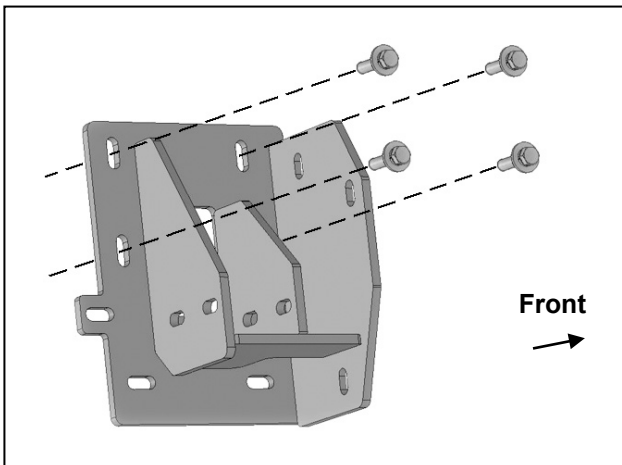


(Fig 8) Remove tow hooks, bumper brackets and shutter assembly (arrow) if equipped

WARNING! Do not crawl under bumper unless it is properly supported on blocks or stands or the bumper may fall.

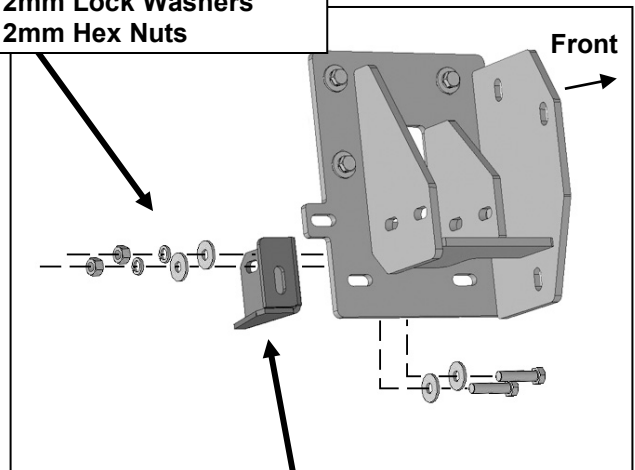


(Fig 9) Remove tow hooks, bumper brackets and shutter assembly if equipped

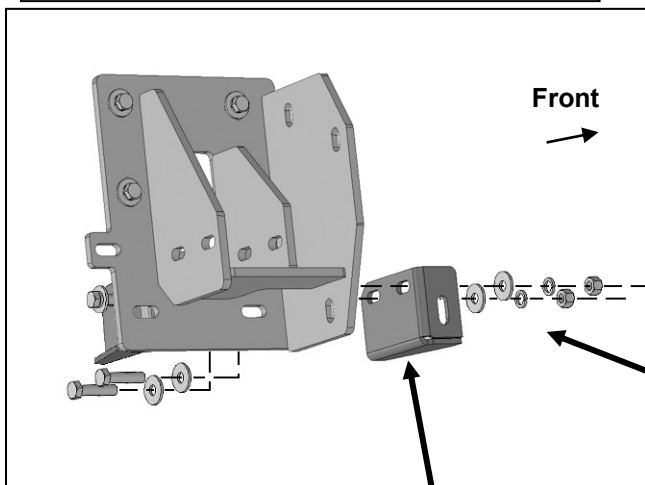


(Fig 10) Reuse factory bolts to attach Frame Brackets to end of frame (driver/left Bracket illustrated)

- (2) 12mm x 50mm Hex Bolts
- (4) 12mm Flat Washers
- (2) 12mm Lock Washers
- (2) 12mm Hex Nuts



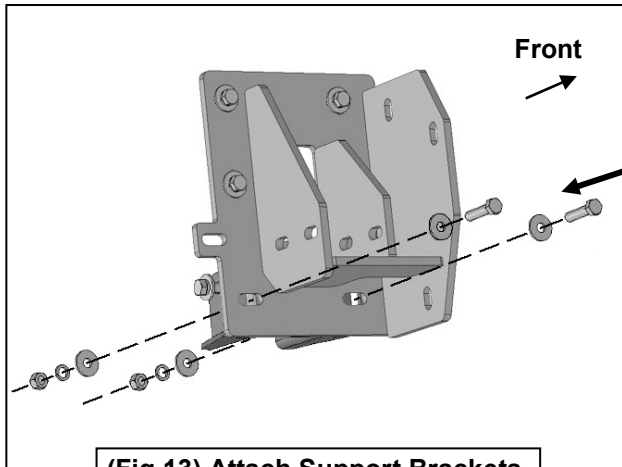
(Fig 11) Attach (1) right facing Support Bracket to inner facing side of frame



(Fig 12) Attach (1) left facing Support Bracket to outside of frame

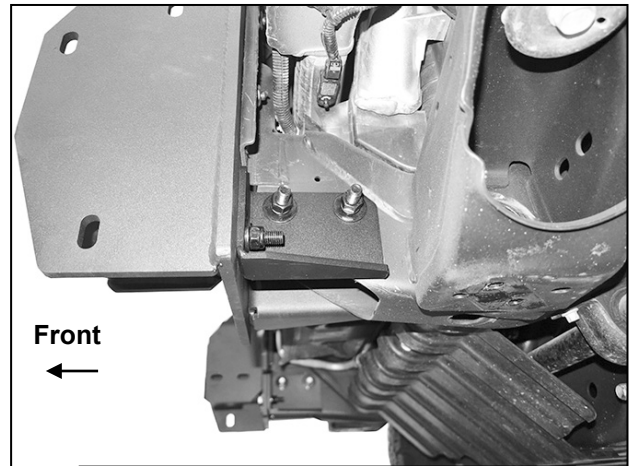
- (2) 12mm x 50mm Hex Bolts
- (4) 12mm Flat Washers
- (2) 12mm Lock Washers
- (2) 12mm Hex Nuts

Driver/left Side Installation Pictured

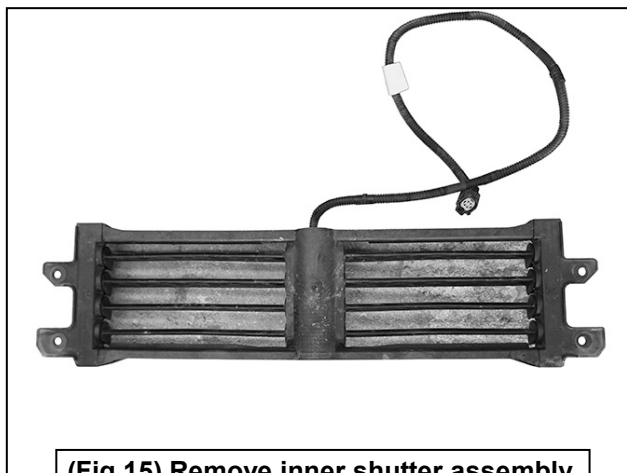


(Fig 13) Attach Support Brackets to back of Frame Bracket

- (2) 12mm x 50mm Hex Bolts
- (4) 12mm Flat Washers
- (2) 12mm Lock Washers
- (2) 12mm Hex Nuts

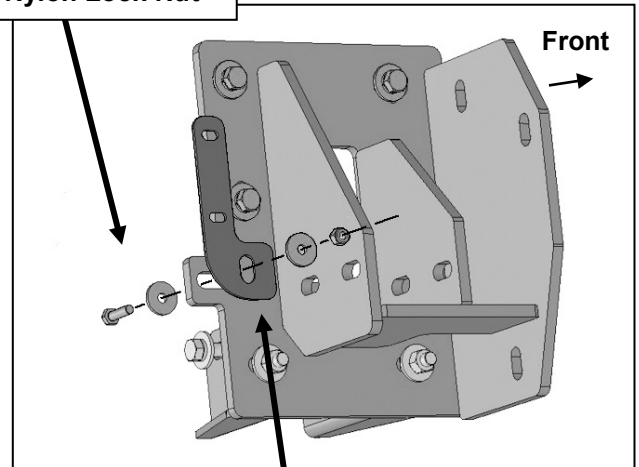


(Fig 14) Frame and Support Brackets installed (driver/left side pictured)

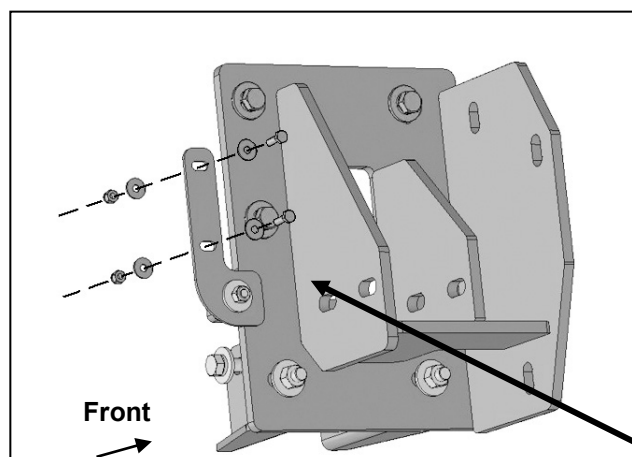


(Fig 15) Remove inner shutter assembly from plastic outer housing (if equipped)

- 8mm x 30mm Hex Bolt
- (2) 8mm Flat Washers
- 8mm Nylon Lock Nut



(Fig 16) Models with shutter system, attach "L" Relocation Bracket to front of Frame Bracket (driver/left Bracket illustrated)

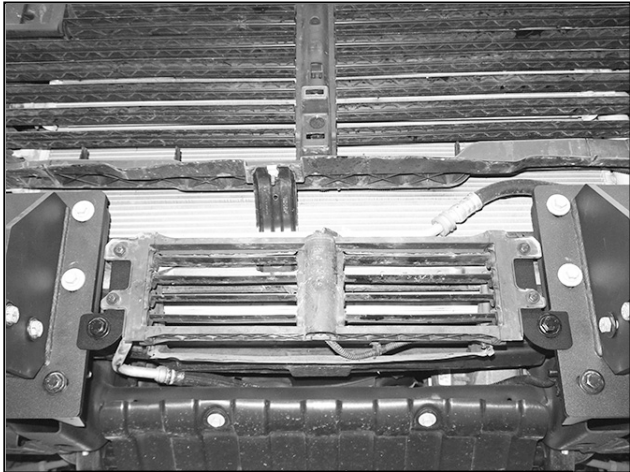


(Fig 17) Attach shutter assembly, (if equipped), to front of Relocation Brackets (see Fig 18)

- (2) 6mm x 20mm Hex Bolts
- (4) 6mm Flat Washers
- (2) 6mm Nylon Lock Nuts

**ELEVATION FRONT BUMPER
2020 GMC SIERRA 25-3500**

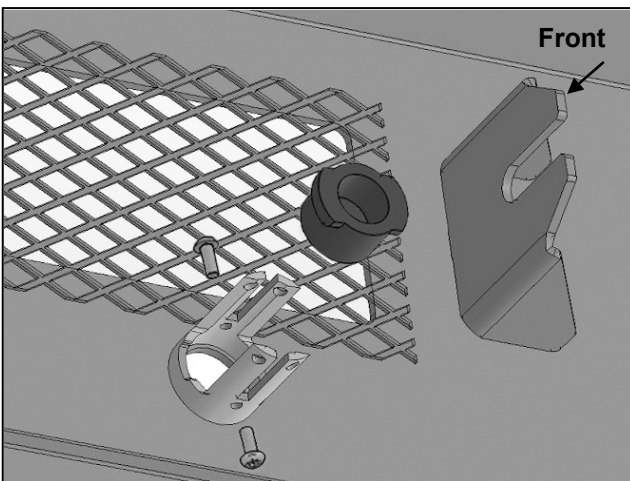
Driver/left Side Installation Pictured



(Fig 18) Shutter mechanism relocated

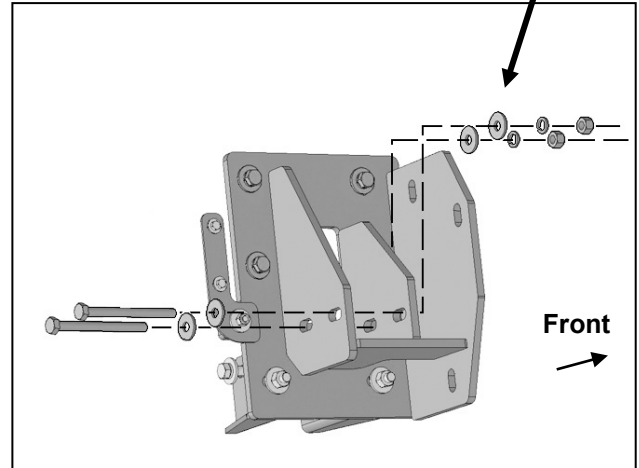


**(Fig 20) Tow hooks and all Brackets installed.
Reinstall grille and plastic cover**

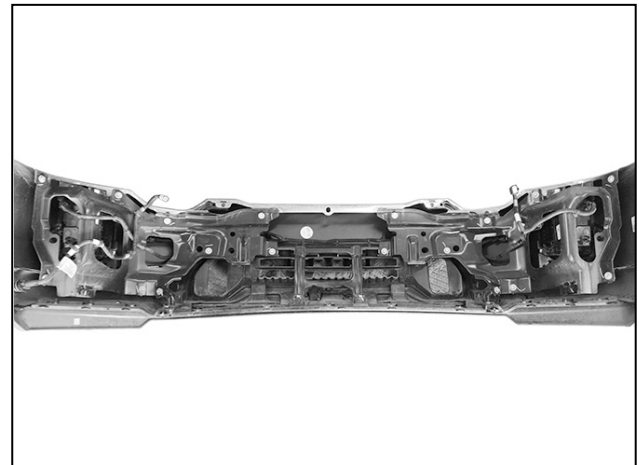


(Fig 22) Push sensor plug into mounting sleeve

- (2) 12mm x 130mm Hex Bolts**
- (4) 12mm Flat Washers**
- (2) 12mm Lock Washers**
- (2) 12mm Hex Nuts**

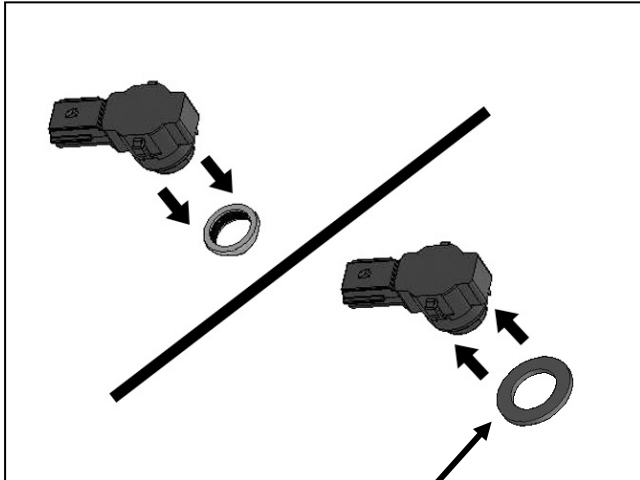


**(Fig 19) Attach tow hooks to
mounting location on Brackets**

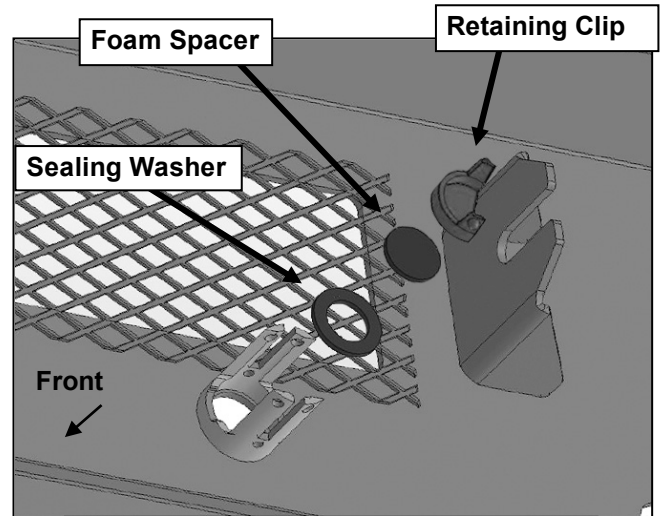


**(Fig 21) Disassemble bumper and remove fog
lights, sensors and wiring harness as equipped**

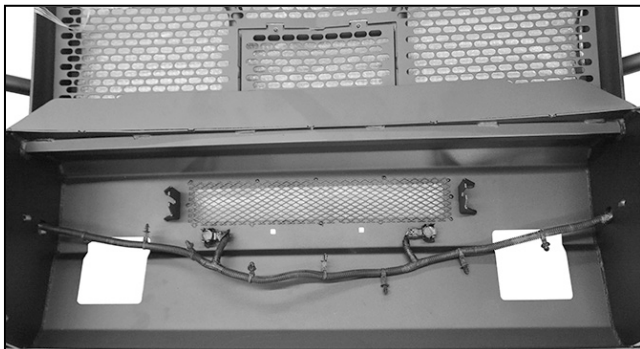
Driver/left Side Installation Pictured



(Fig 23) Remove silicone seal from sensor. Slide large Seal over end of sensor (arrow)



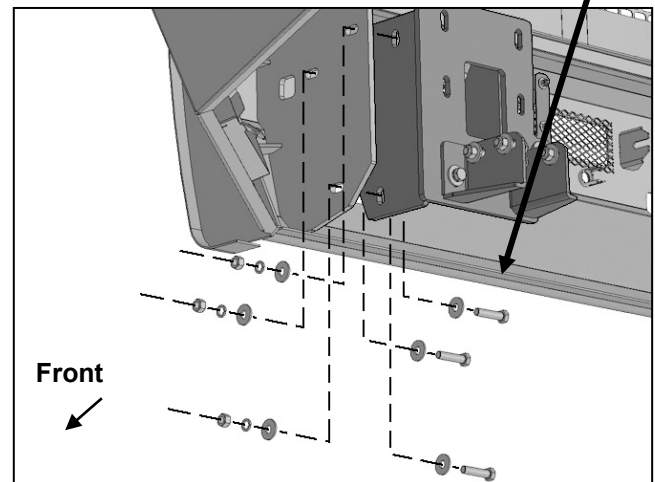
(Fig 24) Insert sensor assembly through the sensor sleeve behind the Bumper



(Fig 25) Reinstall factory wiring harness over or through mounts on back of Bumper. NOTE: Use the included (2) Harness Extensions as necessary to reach the outer parking sensors

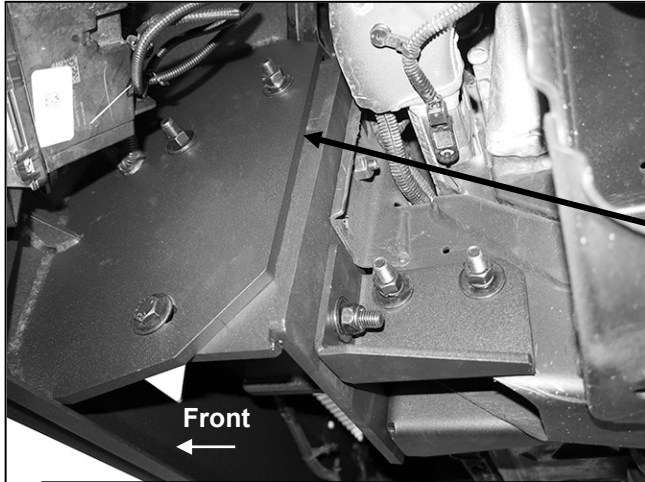
WARNING! Do not crawl under bumper unless it is properly supported on blocks or stands or the bumper may fall.

- (3) 12mm x 50mm Hex Bolts
- (6) 12mm Flat Washers
- (3) 12mm Lock Washers
- (3) 12mm Hex Nuts



(Fig 26) Attach the Bumper to Frame Brackets

Driver/left Side Installation Pictured

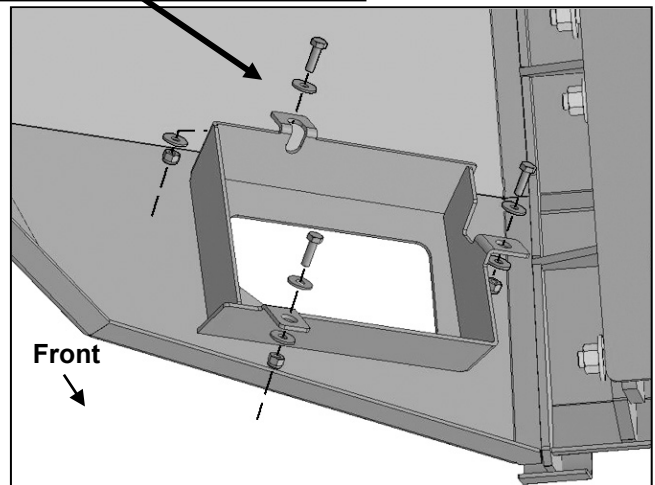


(Fig 27) Driver/left side of Bumper installed

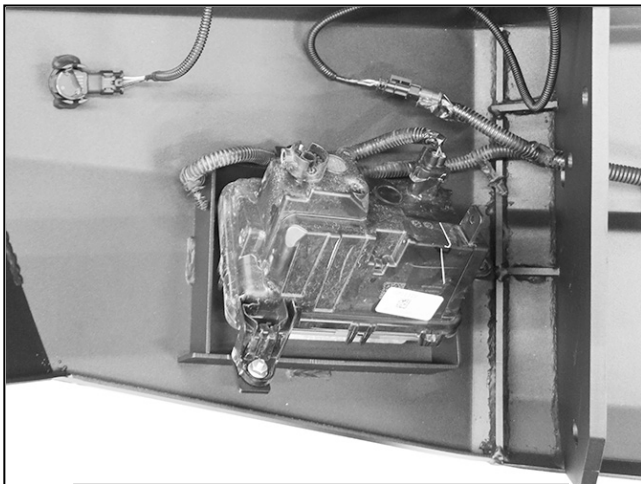
WARNING! Do not crawl under bumper unless it is properly supported on blocks or stands or the bumper may fall.

- (3) 12mm x 50mm Hex Bolts
- (6) 12mm Flat Washers
- (3) 12mm Lock Washers
- (3) 12mm Hex Nuts

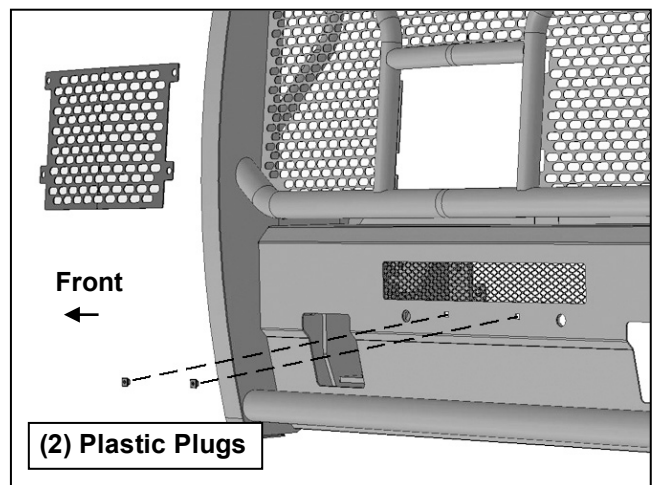
- (3) 6mm x 20mm Hex Bolts
- (6) 6mm Flat Washers
- (3) 6mm Nylon Lock Nuts



(Fig 28) Rotate fog light 90-degrees and attach to mounting tabs on Bumper



(Fig 29) Driver/left fog light installed



(Fig 30) Models with camera, remove screen Attach License Plate Bracket to Bumper