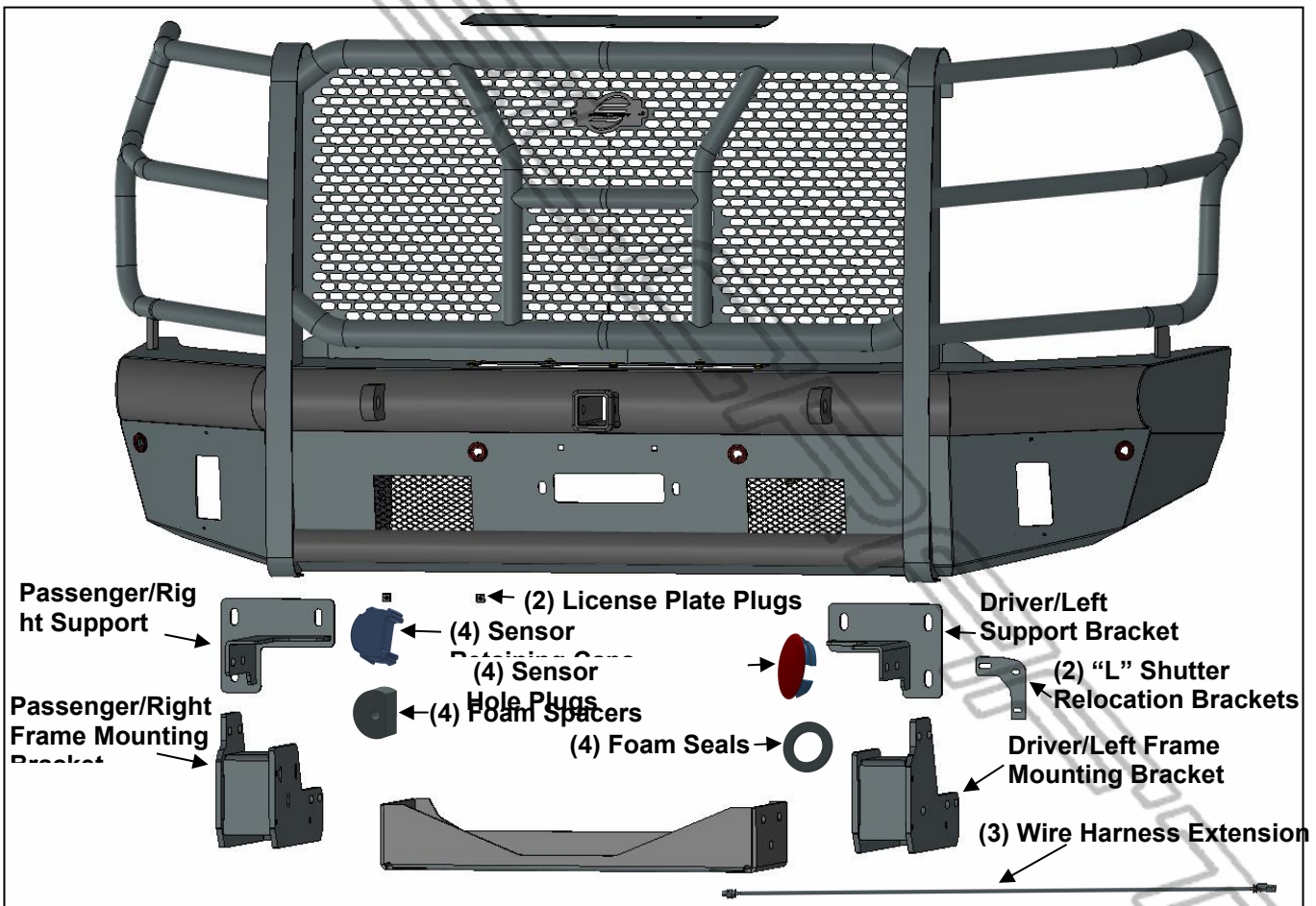


**HD REPLACEMENT FRONT WINCH BUMPER
2024 CHEVY SILVERADO 25-3500**

PARTS LIST:

1	HD Replacement Front Bumper	4	15.5mm x 25mm x 2mm Foam Seals
1	Winch Tray	4	12mm x 140mm Hex Bolts
1	Access Cover	32	12mm x 37mm x 3mm Flat Washers
1	Driver/left Frame Mounting Bracket	16	12mm Nylon Lock Nuts
1	Passenger/right Frame Mounting Bracket	12	12mm x 55mm Hex Bolts
1	Driver/left Support Brackets	9	10mm x 40mm Hex Bolts
1	Passenger/right Support Brackets	8	10mm Lock Washers
2	Shutter Relocation "L" Brackets	10	10mm x 34mm x 3mm Flat Washers
3	Sensor Wiring Harness Extensions	1	10mm Nylon Lock Nuts
2	Plastic Plugs for License Plate Mount	5	6mm Combo Bolts
1	Sensor Cover Kit	10	6mm x 20mm Hex Bolts
4	Sensor Hole Plugs	20	6mm x 18mm x 1.6mm Flat Washers
4	Sensor Retaining Caps	10	6mm Nylon Lock Nuts
1	Engine Block Heater Bracket	8	4mm Self Tapping Screws
4	20mm x 10mm Foam Spacers	1	4mm Hex 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 and the end of the plastic body panel, **(Figure 1)**. Carefully pull the fender flare out to

HD REPLACEMENT FRONT WINCH BUMPER 2024 CHEVY SILVERADO 25-3500

release the clips attaching it to the body panel (fascia) and end of the fender, **(Figure 2)**. Only release the forward end of the flare, it is not necessary to remove the flare. Remove the small bolt attaching the end of the fascia panel to the front fender, **(Figure 3)**. Repeat this Step to release the passenger/right end of the fascia from the fender. Pull along the center of the fascia to release the remainder of the clips and move the plastic panel to a clean surface, **(Figure 4)**.

2. Open the hood and temporarily remove the hood release handle and plastic cover from the top of the grille and radiator **(Figure 5)**. 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, **(Figures 6 & 7)**.
3. Remove the license plate and bracket if equipped. Unplug any wiring harnesses leading to the front bumper, **(Figure 8)**. Move all harnesses away from bumper.
4. Remove the hardware at each end of the bumper attaching the bumper supports to each side of the frame, **(Figure 9)**.
5. 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 10)**. **WARNING!** Assistance is required to hold the bumper in place during bolt removal to prevent the bumper from falling. Remove the bumper assembly.
6. Remove the factory bumper brackets and tow hooks, (if equipped), from the end of frame, **(Figure 11 & 12)**. On models with lower radiator shutter assembly, unplug and remove the assembly, **(Figure 12)**.
7. Select the Driver/left Support Bracket, **(Figure 14)**. Attach the Bracket to the mounting plate on the end of the frame with the included (3) 10mm x 40mm Hex Bolts, (3) 10mm Lock Washers and (3) 10mm x 34mm large Flat Washers, **(Figures 14 & 15)**. Do not tighten hardware at this time.
8. Next, select the Driver/left Frame Mounting Bracket. Hold the Bracket up to the bottom of the frame. Attach the Bracket to the holes through the frame with the included (2) 12mm x 140mm Hex Bolts, (4) 12mm Flat Washers and (2) 12mm Nylon Lock Nuts. **(Figures 15—16)**. Do not fully tighten hardware at this time.
9. Repeat **Steps 7 & 8** to install the Passenger/right Frame and Support Brackets.
10. Remove shutter assembly from outer plastic housing, if equipped **(Figure 17)**. Attach the shutter assembly to the front of the "L" Relocation Brackets with the included (4) 6mm x 20mm Hex Bolts, (8) 6mm Flat Washers and (4) 6mm Nylon Lock Nuts, **(Figures 18 & 19)**. Do not overtighten the 6mm hardware or damage to the shutter assembly may result. Plug wiring harness into shutter assembly.
11. Select the Winch Tray, **(Figure 20)**. Slide Winch Tray between the Frame Brackets. Attach Winch Tray to Brackets with (6) 12mm x 55mm Hex Bolts, (12) 12mm Flat Washers and (6) 12mm Nylon Lock Nuts, **(Figures 20 & 21)**. Snug but do not fully tighten hardware at this time. Follow winch manufacturer's instructions to attach winch to Winch Tray. **NOTE:** Also install winch cable guide (not included) onto bumper before mounting to vehicle.
12. Reinstall fascia, grille and top cover removed in **Steps 1—3**.
13. Sensors, (if equipped), must be installed in Bumper before installing Bumper Assembly.

Models without bumper parking sensors:

- a. Select the included (4) Sensor Plugs.
- b. From the front of the bumper, push plugs into sensor mounting holes, **(Figure 22)**.

Models with bumper mounted parking sensors:

- a. Disassemble the front bumper to access the sensors and wiring harness, **(Figure 23)**. Remove the parking sensors and wire harness from the back of the factory bumper.
- b. Remove the OE silicone seal from the end of the sensors. Select the included larger (1) Foam Sensor Seal and peel off the adhesive backing. Slide the Sensor Seal over front of a sensor, **(Figure 24)**.
- c. Insert sensor with Seal into sensor mount on back of bumper until it clicks into position, **(Figure 25)**.
- d. Select the included (1) Foam Spacer and peel off the adhesive backing. Place Foam Spacer into (1) Sensor Retainer Cap. Push Sensor Retaining Cap and Foam Spacer onto sensor mount and lock into mounting holes, **(Figure 26)**.
- e. Repeat previous Steps to install remaining sensors.

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- f. Attach the wiring harness to the back of the Bumper and plug-in sensor closest to main connector on vehicle. **NOTE:** (3) Wire Harness Extensions have been included to extend the factory harness to reach the other sensors as needed. **(Figure 27).**

14. Models with fog lights:

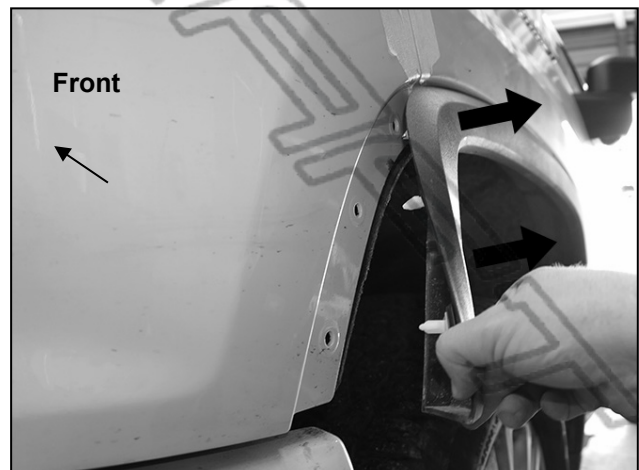
- a. Remove the fog lights from the factory bumper. Brackets may need to be removed to gain proper access **(Figure 23).**
 - b. Attach the driver/left fog light to the Bumper with the included (3) 6mm x 20mm Hex Bolts, (6) 6mm Flat Washers and (3) 6mm Nylon Lock Nuts, **(Figure 28).** Do not overtighten hardware or damage to the light may result.
 - c. Repeat the previous Steps to attach the passenger/right side fog light.
15. With assistance, position the Bumper Assembly up to and over the Brackets. 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.
 16. Line up the (3) holes in the driver/left side of the Bumper with the (3) slots in the Frame Bracket. Attach the 2 top slots in the Bumper to the Frame and Support Bracket with (2) 12mm x 55mm Hex Bolts, (4) 12mm Flat Washers and (2) 12mm Nylon Lock Nuts, **(Figures 29 & 30).** Insert (1) 12mm x 55mm Hex Bolt, (2) 12mm Flat Washers and (1) 12mm Nylon Lock Nut through the bottom slot and into the Frame Bracket only. Do not fully tighten hardware at this time. Repeat this Step to attach the passenger/right side of Bumper to the Frame and Support Brackets.
 17. Level and adjust the bumper and fully tighten all 12mm hardware to 65-70ft-lbs.
 18. Optional: Trim fender liners to match new bumper height, **(Figure 31).**
 19. Use the included (2) push-in Plastic License Plate Plugs to attach the front license plate, (if required), to the (2) holes in the front Bumper, **(Figure 32).**
 20. Models with grille mounted camera, remove screen from center window of Bumper, **(Figure 32).**
 21. Optional: Models with engine block heater; use universal Engine Block Heater Bracket to relocate the heater plug, **(Figure 33).**
 22. Do periodic inspections to the installation to make sure that all hardware is secure and tight.

To protect your investment, wax this product after installing. Regular waxing is recommended to add a protective layer over the finish. 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 Front Bumper assembly.

Driver/left Side Installation Pictured



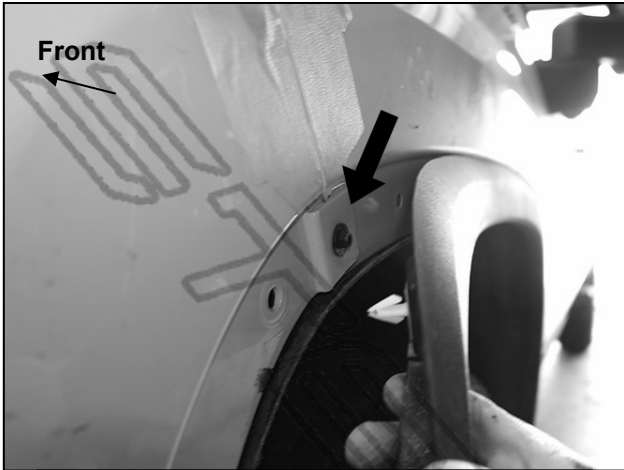
(Fig 1) Release hardware attaching fender liner from plastic panel (fascia-see arrows)



(Fig 2) Pull front end of fender flare out and away from fender. Do not remove flare, only release the front section

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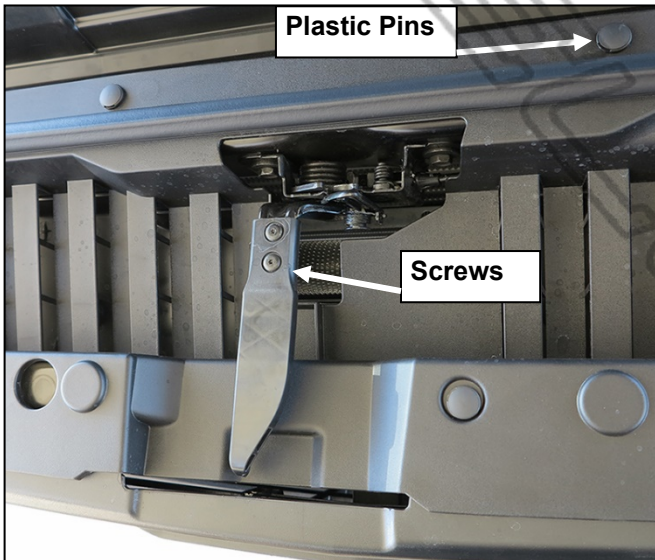
Driver/left Side Installation Pictured



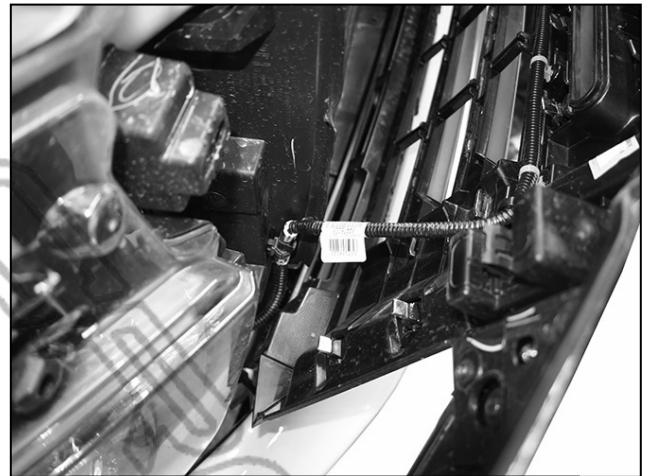
(Fig 3) Remove screws attaching plastic fascia panel to front end of fender (arrow)



(Fig 4) Remove plastic fascia from top of bumper



(Fig 5) Remove hood handle and radiator cover



(Fig 6) Disconnect harness to camera (if equipped) and remove grille



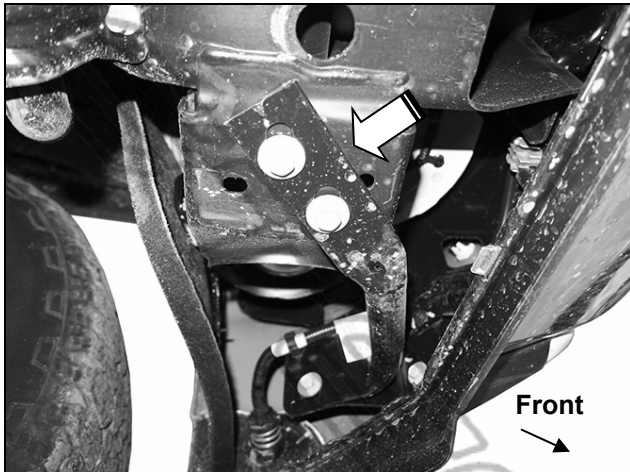
(Fig 7) Grille and fascia removed



(Fig 8) Disconnect all wire harnesses leading to front bumper

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Driver/left Side Installation Pictured

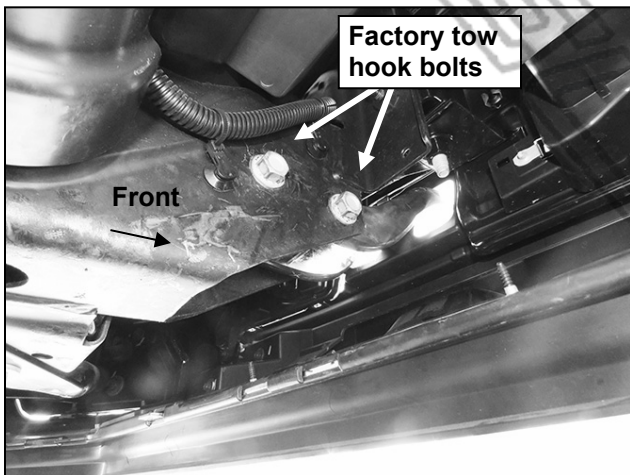


(Fig 9) Remove driver/left and passenger/right outer bumper supports attach to bottom of frame

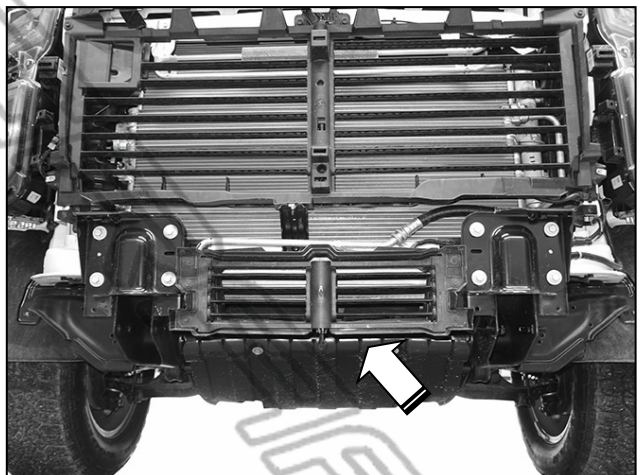
WARNING! Do not crawl under bumper unless the bumper is properly supported on blocks or stands or the bumper may fall.



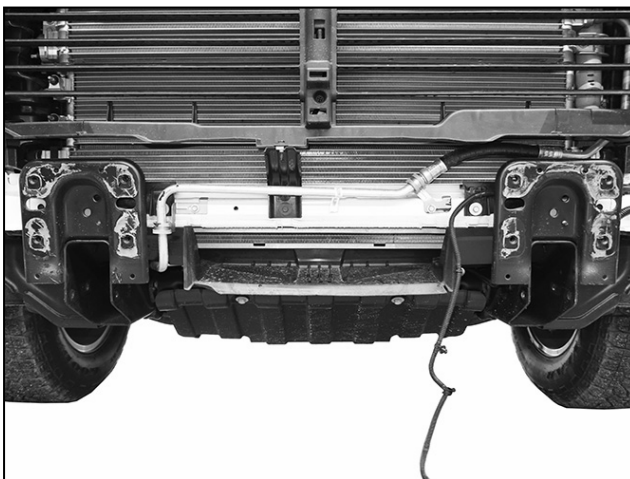
(Fig 10) From above, remove the hex bolts attaching the bumper assembly to the frame bumper brackets (top visible-arrow)



(Fig 11) Remove tow hooks, (if equipped) after bumper has been removed



(Fig 12) Remove tow hooks, bumper brackets and shutter assembly (arrow) if equipped

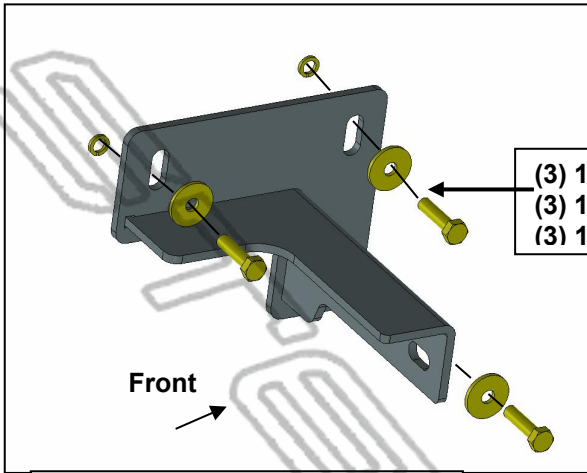


(Fig 13) Attach Frame Brackets to end of frame

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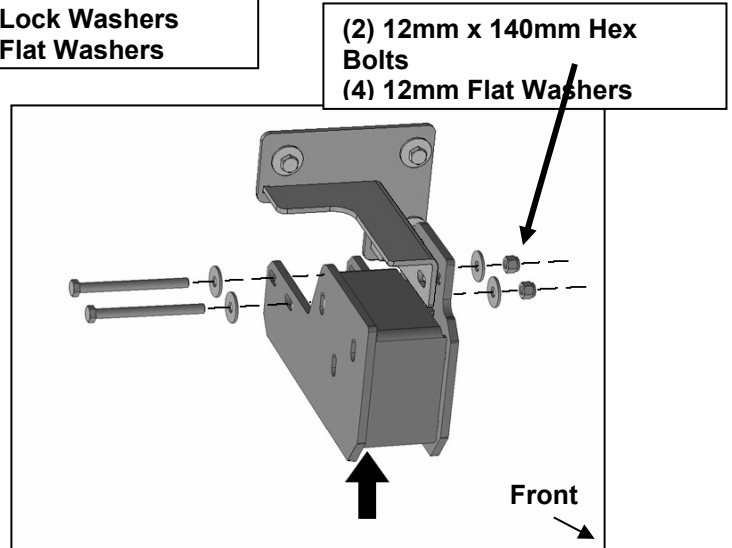
Driver/left Side Installation Pictured

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



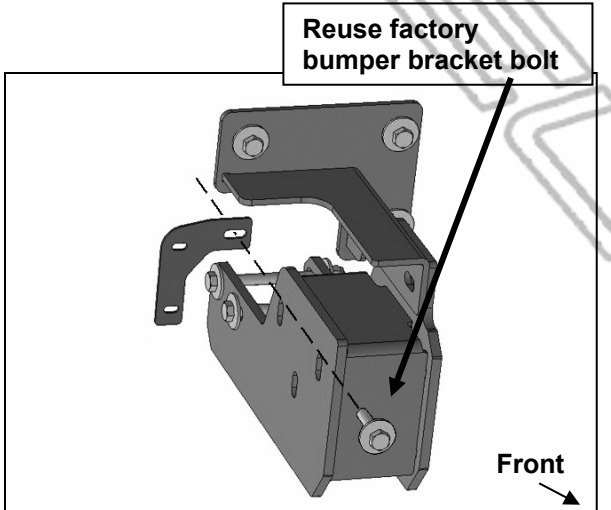
(3) 10mm x 40mm Hex Bolts
(3) 10mm Lock Washers
(3) 10mm Flat Washers

(Fig 14) Attach driver/left Frame Bracket to end of frame



(2) 12mm x 140mm Hex Bolts
(4) 12mm Flat Washers

(Fig 15) Attach driver/left Frame Bracket to holes through

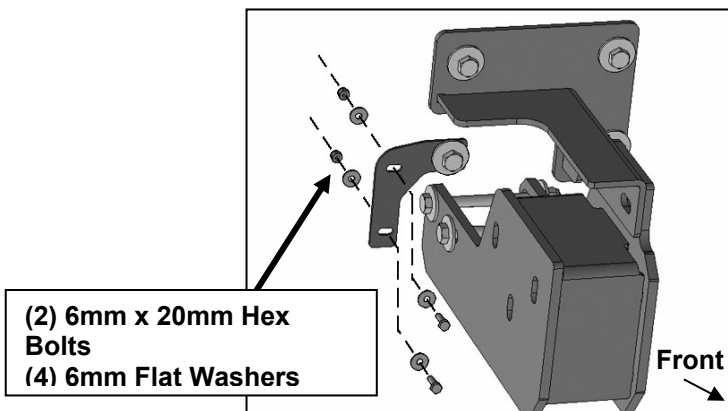


Reuse factory bumper bracket bolt

(Fig 16) Reuse the factory bolt to attach the "L" Relocation Bracket to the lower/inner threaded



(Fig 17) Remove inner shutter assembly from plastic outer housing (if equipped)

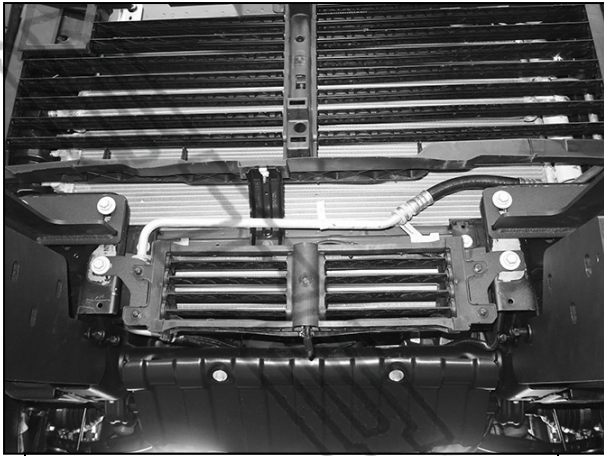


(2) 6mm x 20mm Hex Bolts
(4) 6mm Flat Washers

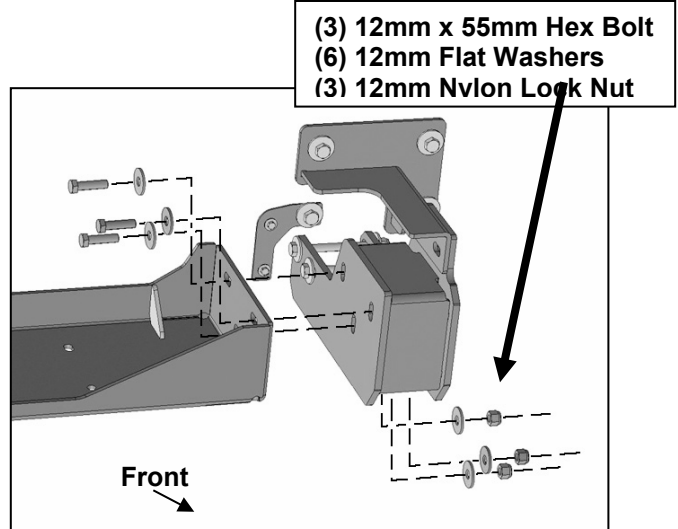
(Fig 18) Attach shutter assembly, (if

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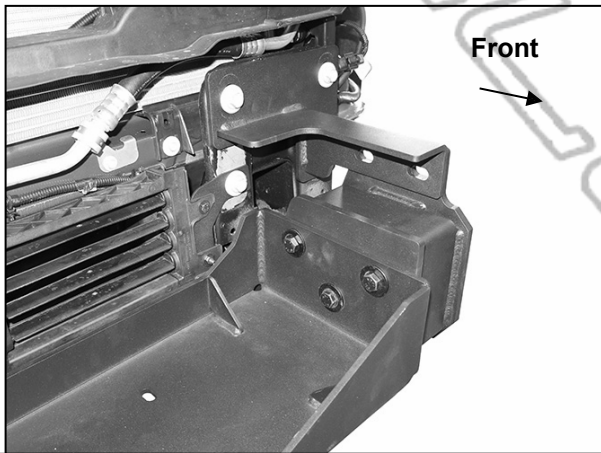
Driver/left Side Installation Pictured



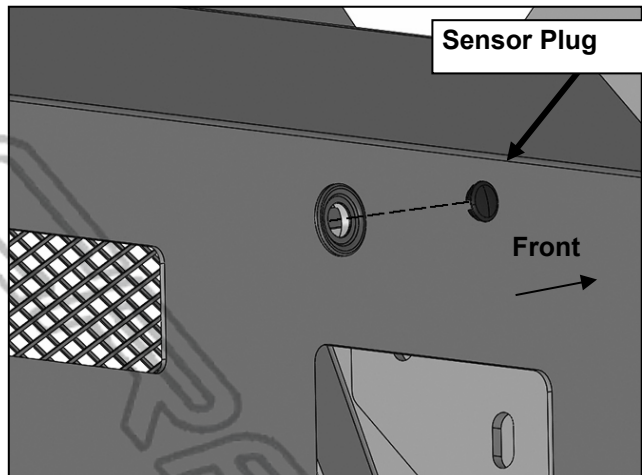
(Fig 19) Attach shutter assembly, (if equipped), to front of Relocation



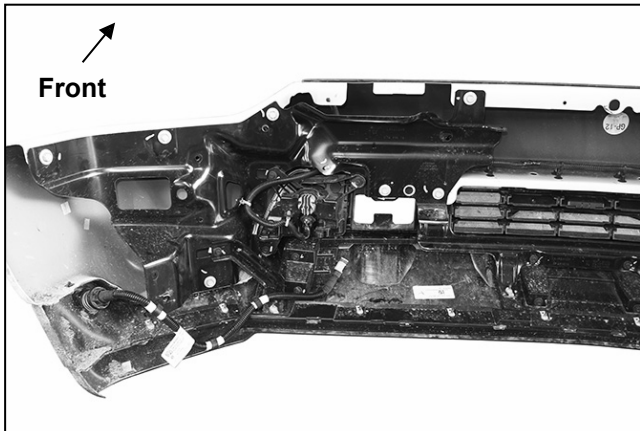
(Fig 20) Attach Winch Tray to Frame Brackets



(Fig 21) Attach Winch Tray to Frame Brackets



(Fig 22) Models without front sensors, push sensor Plug into sensor mount

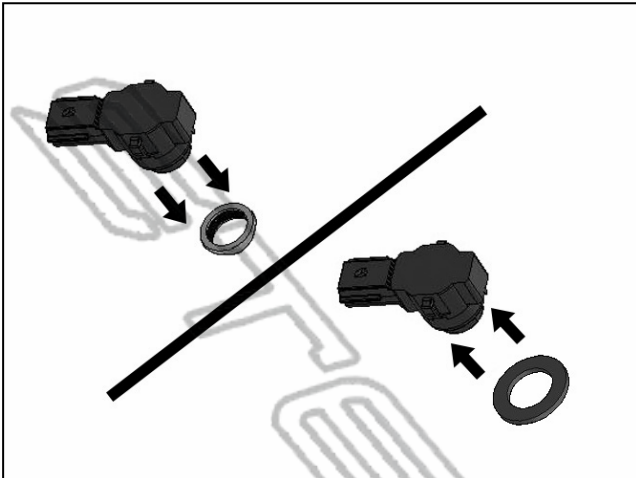


(Fig 23) Disassemble bumper and remove sensors, wiring harness and fog lights as

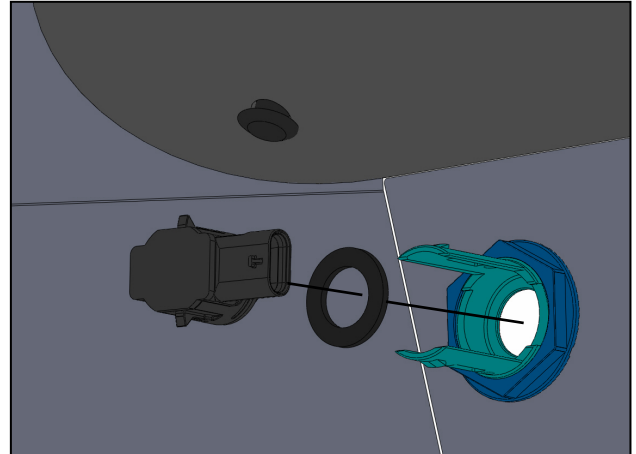
WARNING! Do not crawl under bumper unless it is properly supported on blocks or stands or the bumper may

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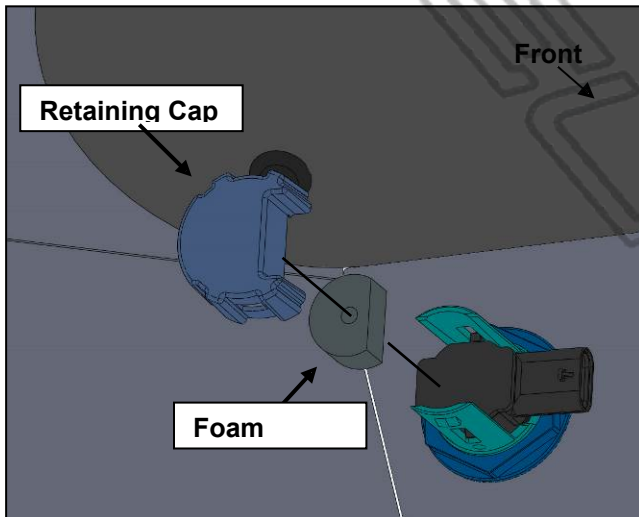
Driver/left Side Installation Pictured



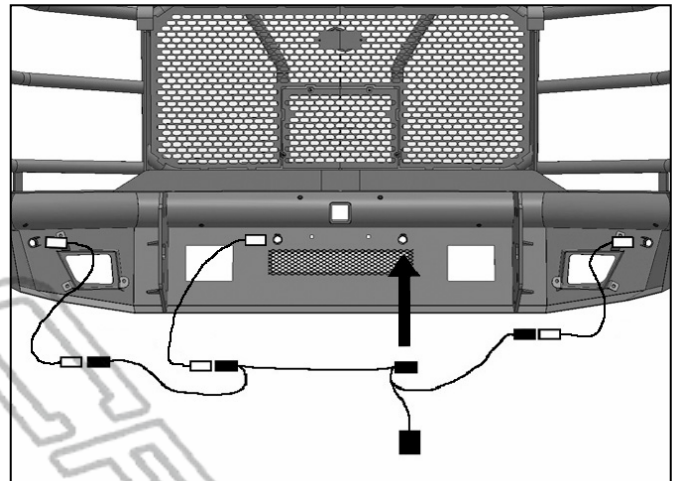
(Fig 24) Remove OE silicone seal from sensor. Slide large Seal over end of sensor (arrow)



(Fig 25) Insert sensor with seal into Mount on back of Bumper



(Fig 26) Insert foam spacer and retaining cap onto back of sensor mount.



(Fig 27) Reinstall factory wiring harness on back of Bumper. NOTE: Use the included (3) Wire Harness Extensions as necessary to reach the parking sensors.

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



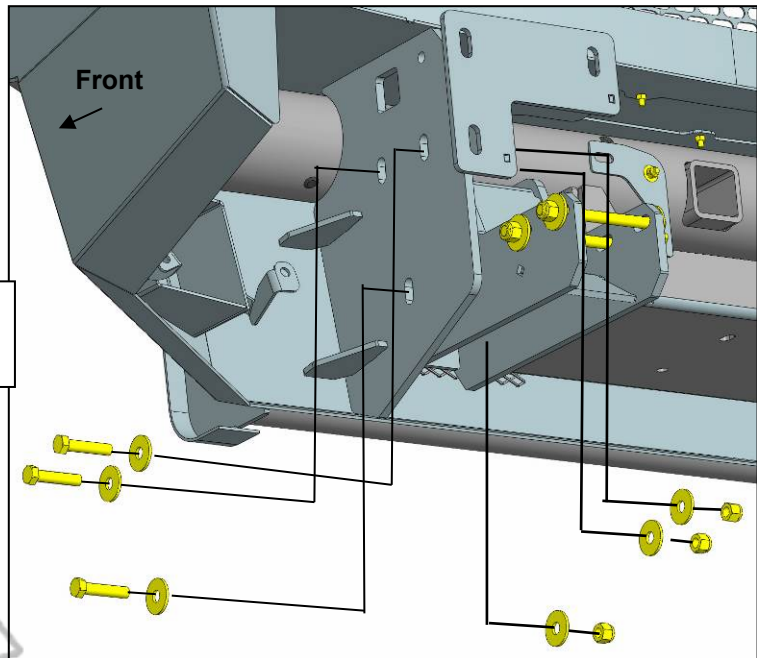
(Fig 28) Attach fog light to mounting tabs on driver/left side of Bumper

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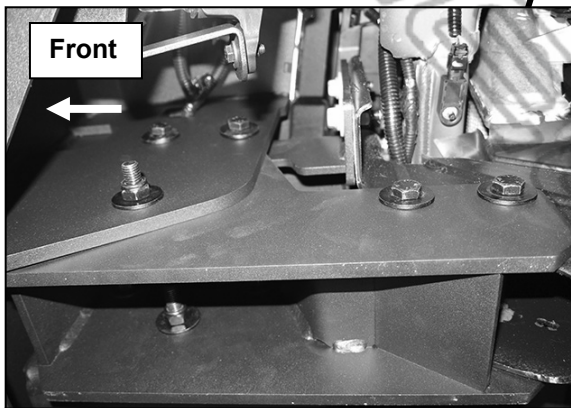
Driver/left Side Installation Pictured

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

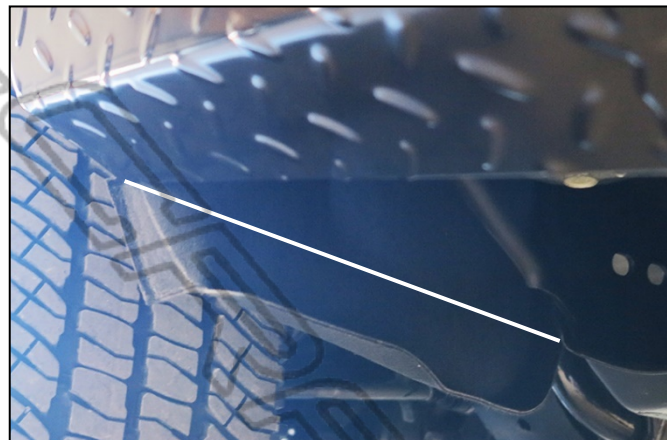
- (3) 12mm x 55mm Hex Bolts
- (6) 12mm Flat Washers
- (3) 12mm Nylon Lock Nuts



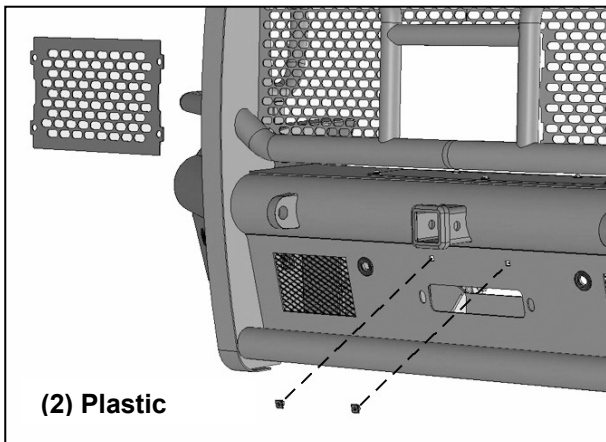
(Fig 29) Attach the Bumper to Frame Brackets



(Fig 30) Driver/left side of Bumper



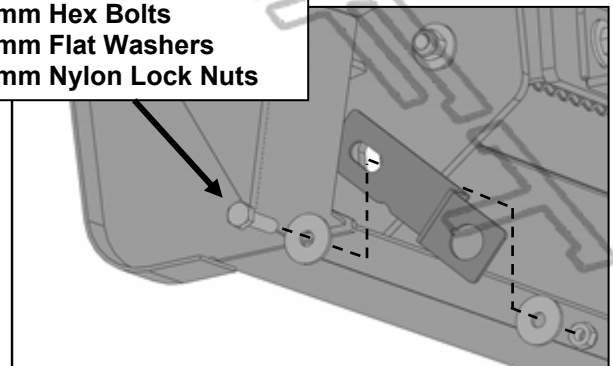
(Fig 31) (Optional) Trim fender liner flush with bottom



(2) Plastic

(Fig 32) Models with grille mounted camera, remove panel from Bumper. Models with front license plate, push the included (2) Plastic Plugs into the square holes in the Bumper. Reuse factory screws to attach License Plate to Plastic Plugs in Bumper

- (1) 10mm Hex Bolts
- (2) 10mm Flat Washers
- (1) 10mm Nylon Lock Nuts



(Fig 33) Block heater relocation bracket example