

## Preparation:

- Disconnect the negative battery terminal. Park the vehicle on level ground and set the emergency brake.
- We recommend reading through the installation instructions in whole before performing the work.
- Estimated Installation Time: **2 Hours**

***\*\*This installation requires 2 people for best results\*\****

### You will need the following tools:

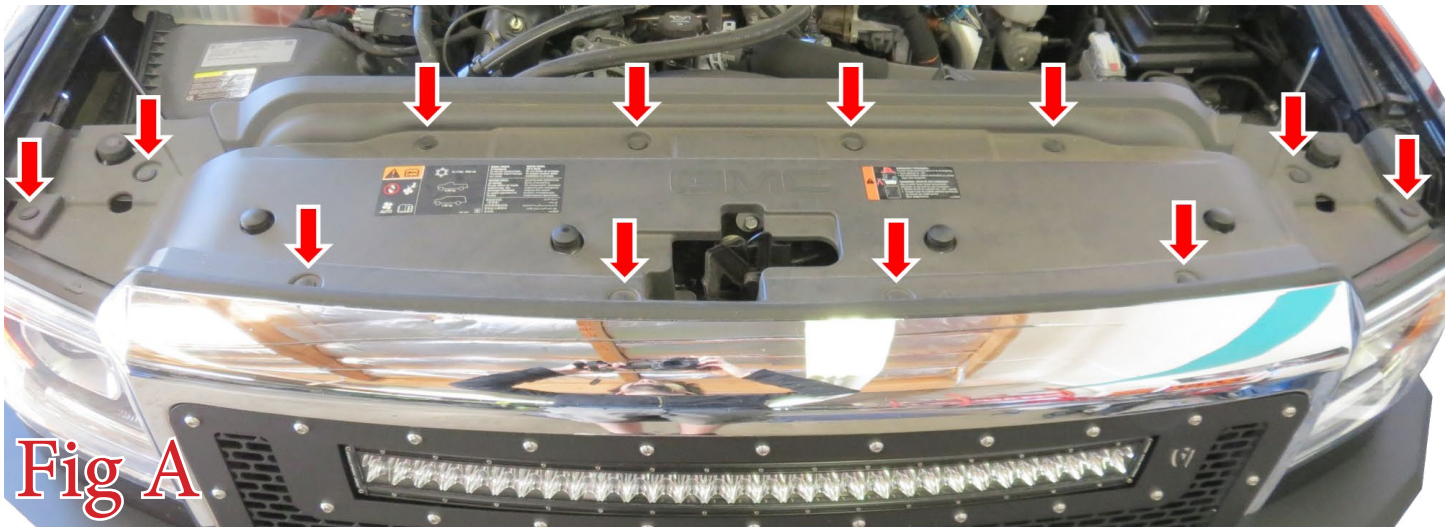
- |                |                |                 |
|----------------|----------------|-----------------|
| - Ratchet      | - 7mm Socket   | - 10mm Socket   |
| - 15mm Socket  | - 18mm Socket  | - T-15 Torx Bit |
| - Tape Measure | - Cutoff Wheel | - Grinder       |
| - Black Paint  | - Masking Tape | - Utility Knife |

### Included in Kit:

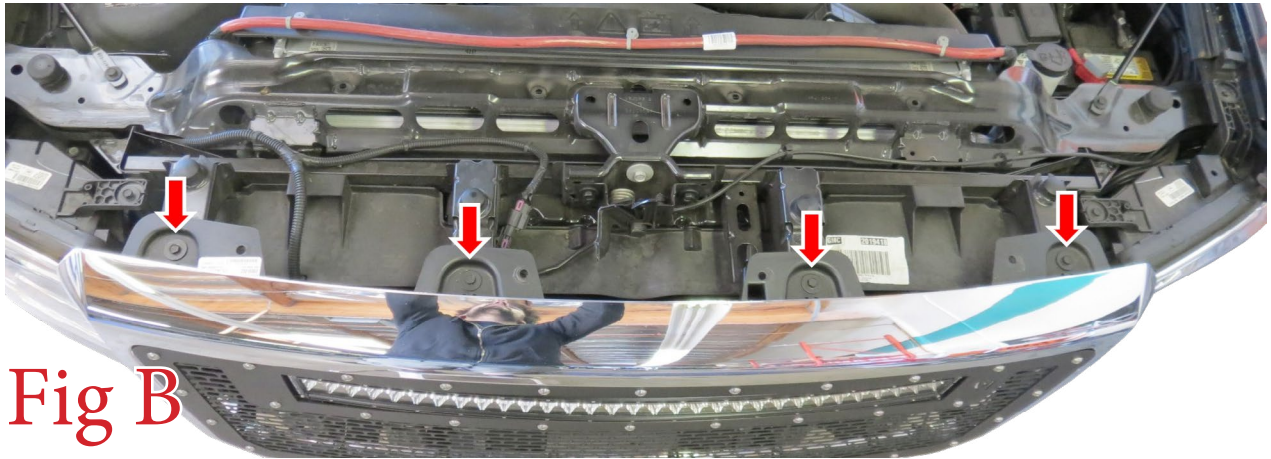
**OEM Hardware is Reused**

## Removal:

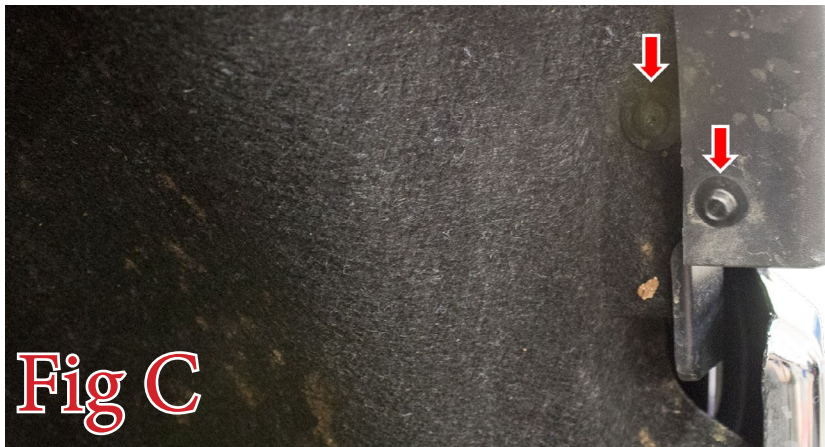
1. From underneath the truck, unplug your fog lights.
2. Pop your hood. Remove the radiator cover clips. Then, remove your radiator cover. (Fig A)



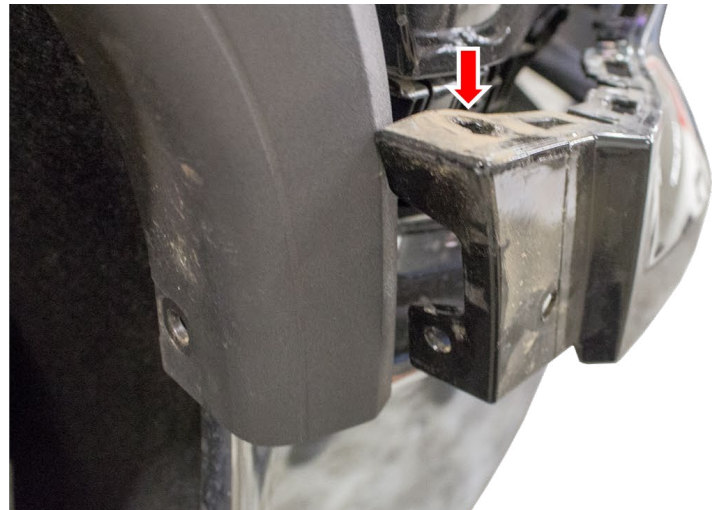
3. Using a 10mm Socket, remove the upper grille bolts. (Fig B)



4. In the front portion of the wheel well, remove the T-15 Bolt and 7mm Bolt located at the meeting point of your fender flare and front bumper. (Fig C)



5. Peel the inner fender liner back a little bit to gain access. Behind that liner, there is one more 7mm Bolt that needs to be removed. The bolt is just inside the liner, with the bolt head facing towards the ground. I was unable to get a picture of the bolt due to limited access, but (Fig D) shows the bolt hole in the valance that it corresponds with.



6. Repeat Steps 4 & 5 on the opposite side of the vehicle.
7. Carefully pull the valance off of the vehicle. There is a series of tabs holding the valance on. It is best to get at these tabs from the back side. We were able to reach the back of the tabs from underneath the truck.
8. Remove the lower grille bolts (x4). Then, remove the grille. (Fig E)

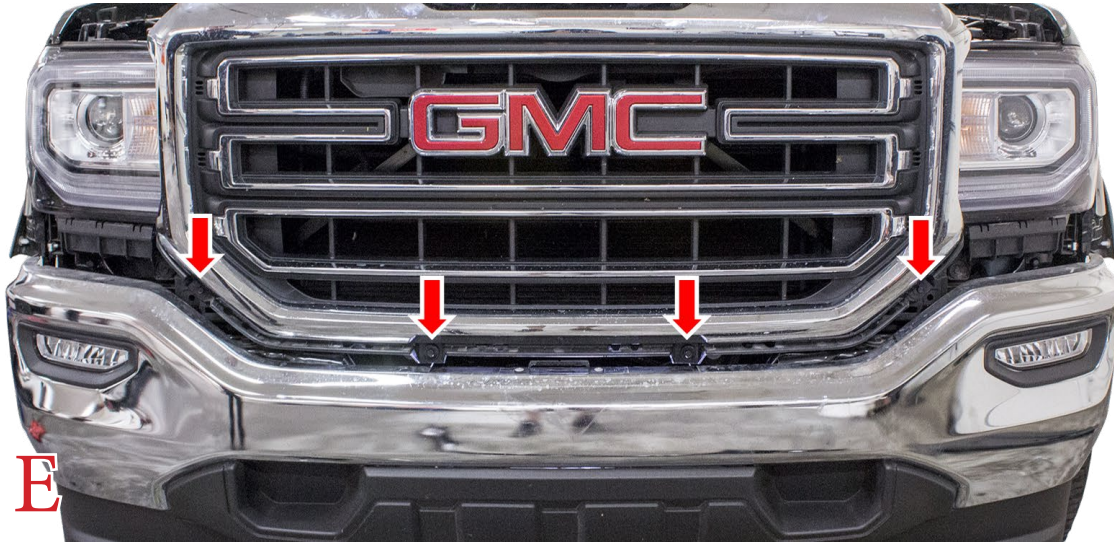


Fig E

9. Using a 15mm Socket, remove the bumper side support bolts. There are 2 bolts per side. These bolts can be accessed from underneath the vehicle and sit directly in front of the inner fender liners. (Fig F)

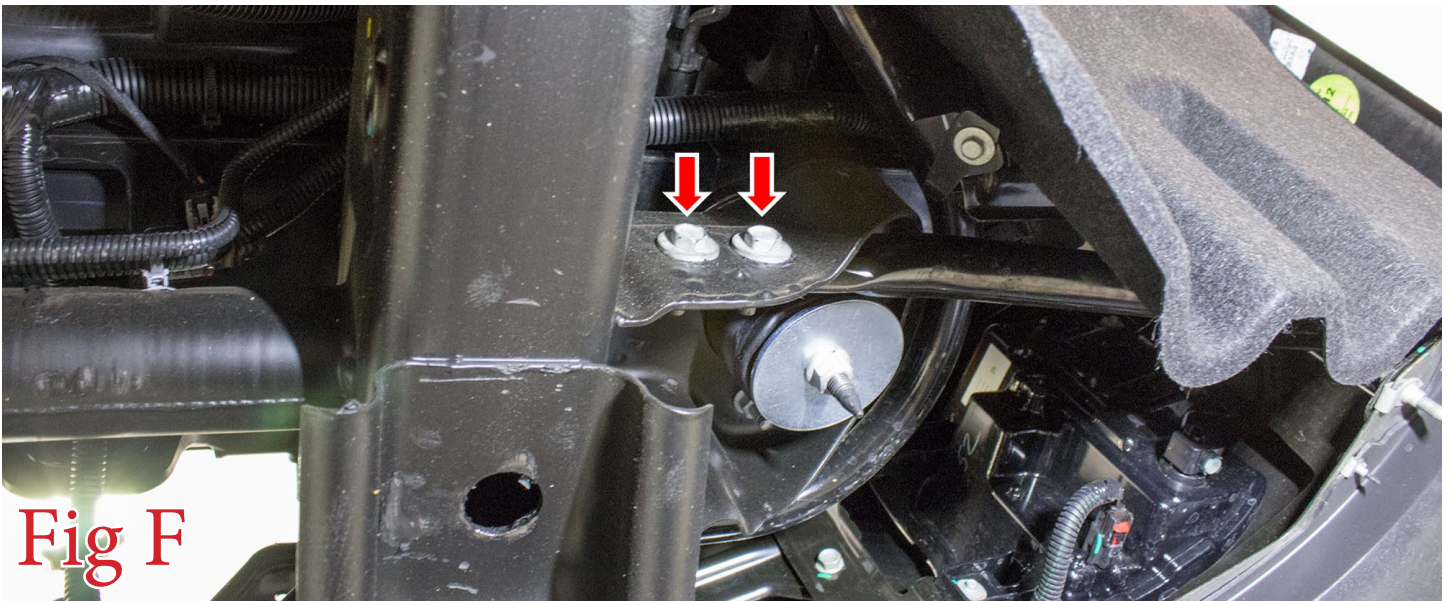
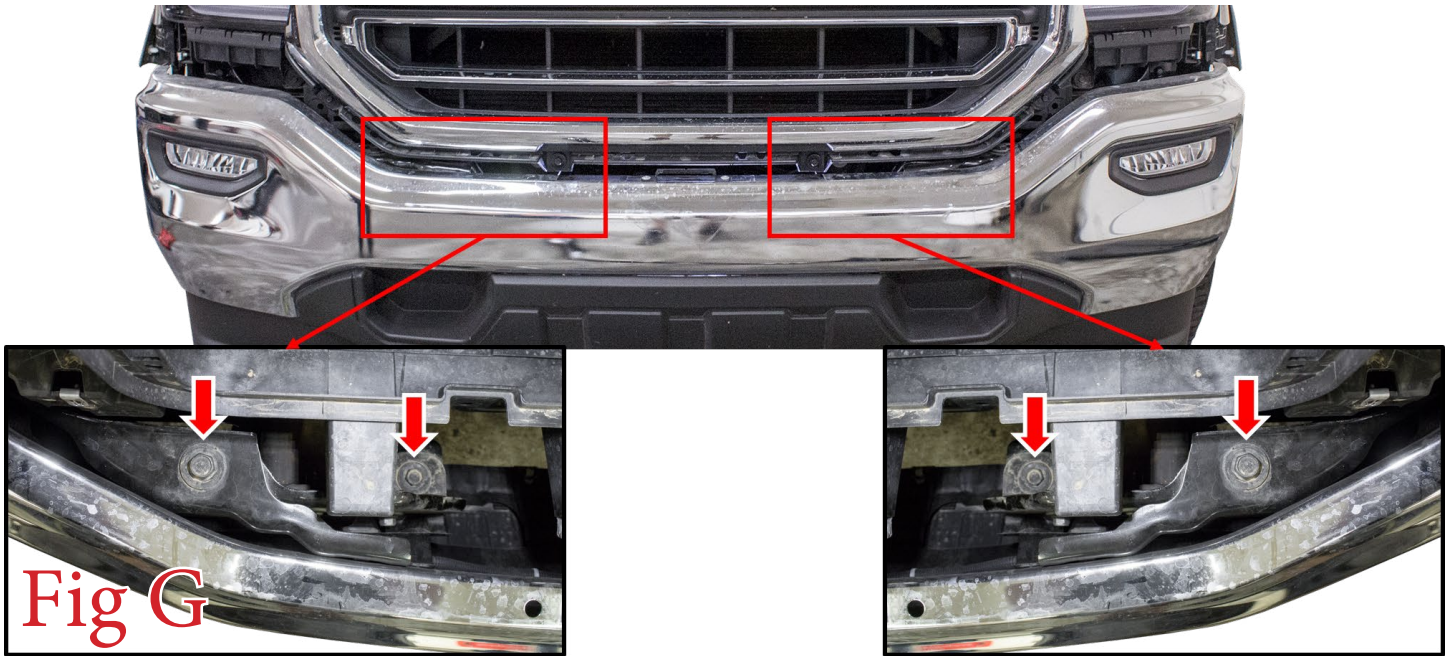
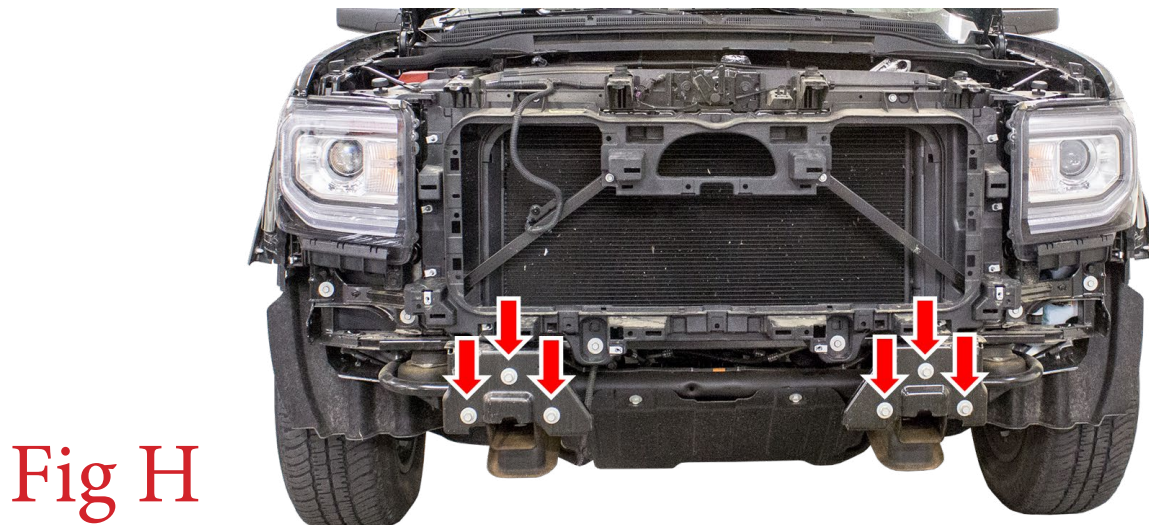


Fig F

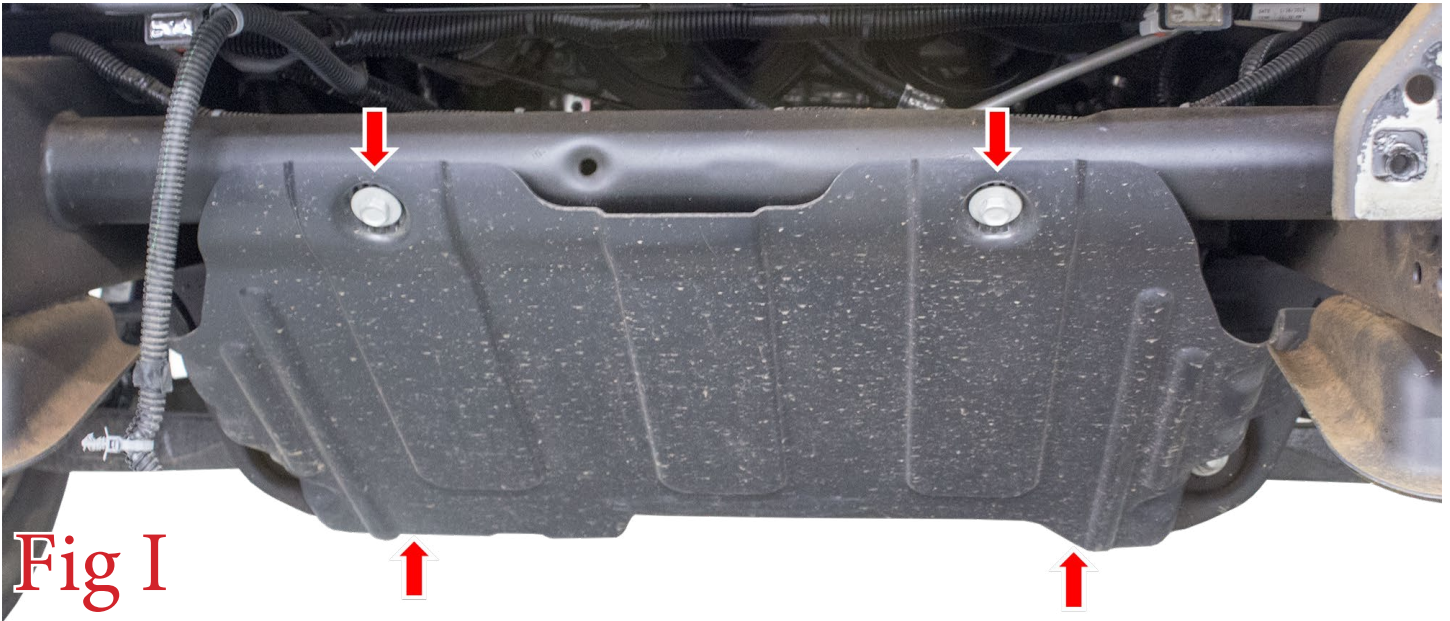
10. Using an 18mm Socket, remove the bumper mounting bolts (x4). Then, remove the bumper from the vehicle. (Fig G)



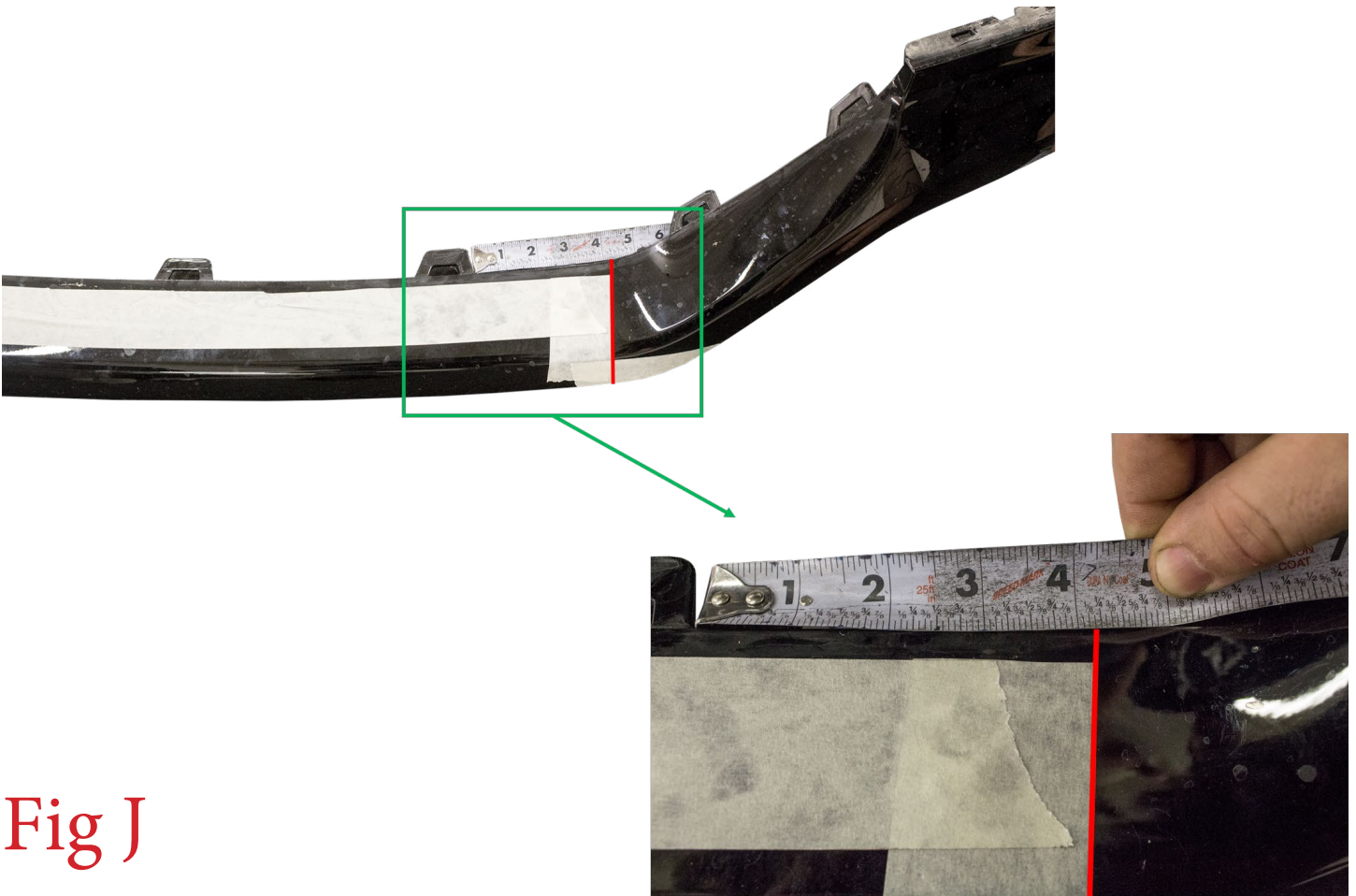
11. Using a 15mm Socket, remove the OEM Bumper Bracket Bolts (x6). Then, remove both brackets. Save these bolts for reuse. (Fig H)



12. Using a 15mm Socket, remove the skid plate mounting bolts (x4). Then, remove the skid plate. (Fig I)



13. Lay your valence flat on the ground. Measure 4 3/16" outward from the most outer tab on the flate/middle portion of the valence (before it curves up to meet the headlights). Make this measurement on the other side of your valence as well. (Fig J)



14. Measure 1/2" down from the inside edge of the valance in several areas. Draw this horizontal line all the way across the center section of the valance until it intersects with both lines drawn in Step 13. (Fig K)

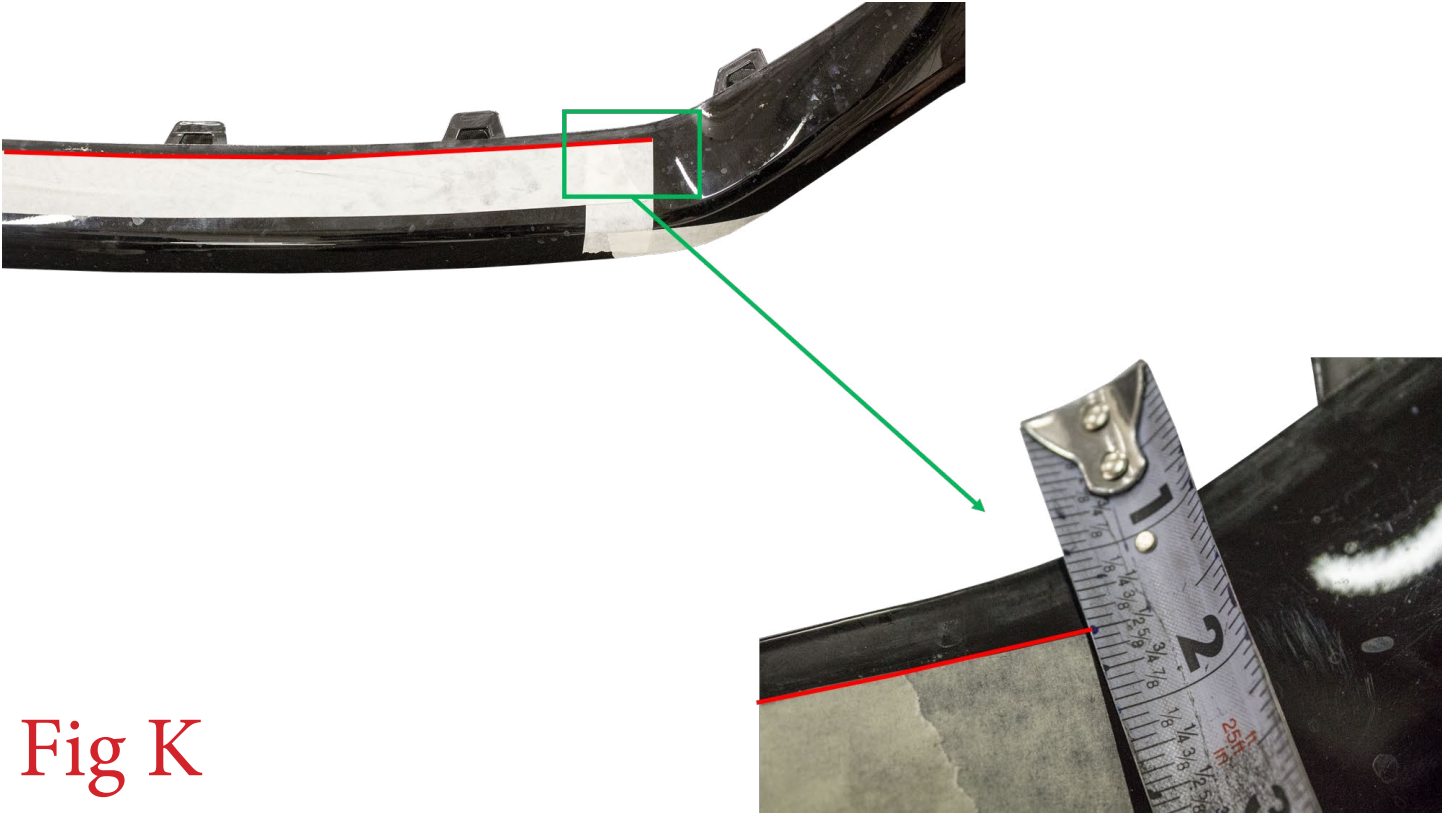


Fig K

15. Follow the body line of the middle portion of the valance (where it folds down) out until you reach the edge of the valance. Repeat this step on the other side of the valance. (Fig L)



Fig L

16. Your valance should now look like the one in (Fig M). Cut your valance at the newly marked lines.

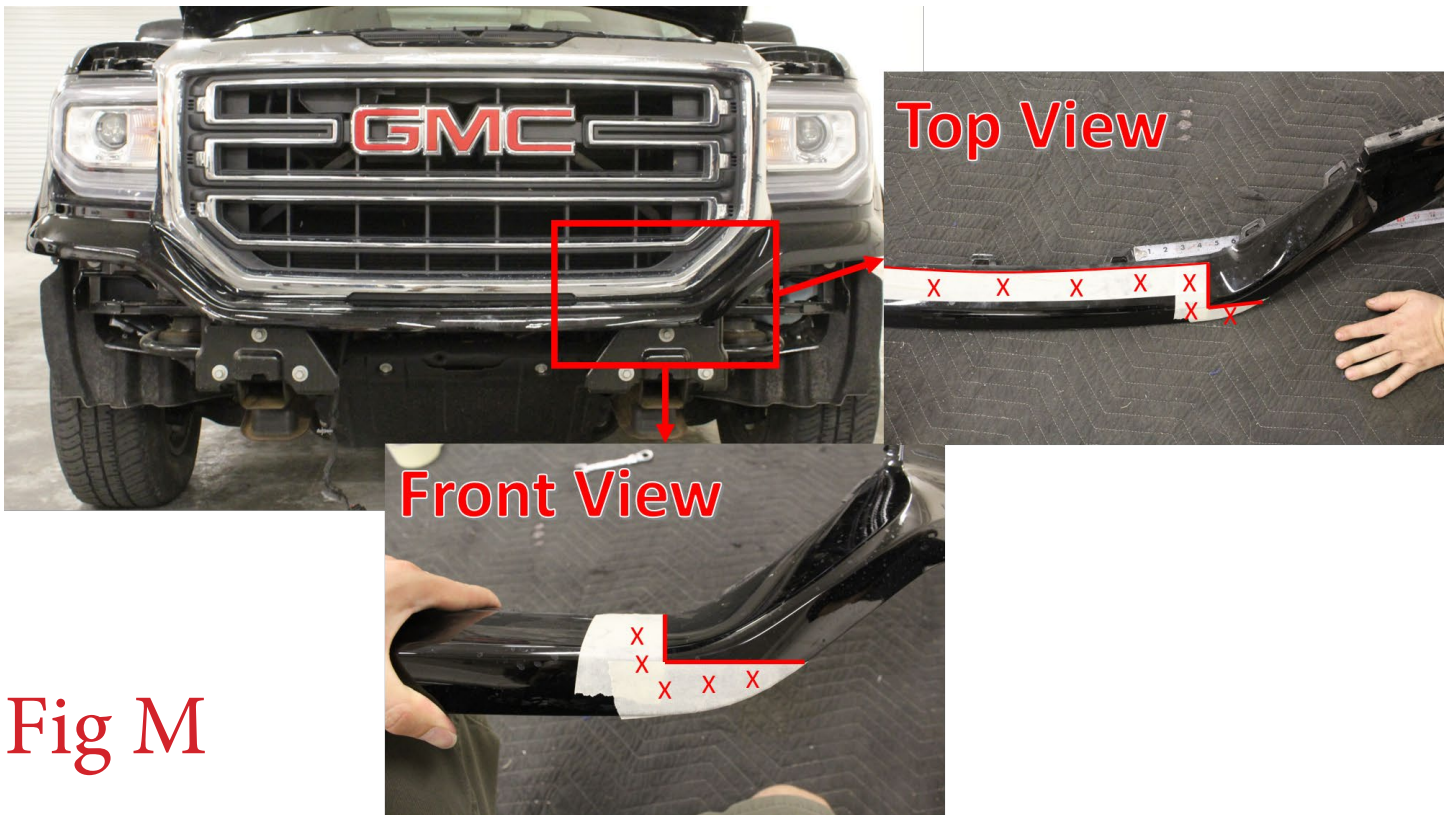


Fig M

17. Cut the bells off your frame. There is a weld that runs along each side. With a cutoff wheel, cut through these welds and the bells will come off. Then, make sure to grind the frame smooth and paint over any bare metal. (Fig N)

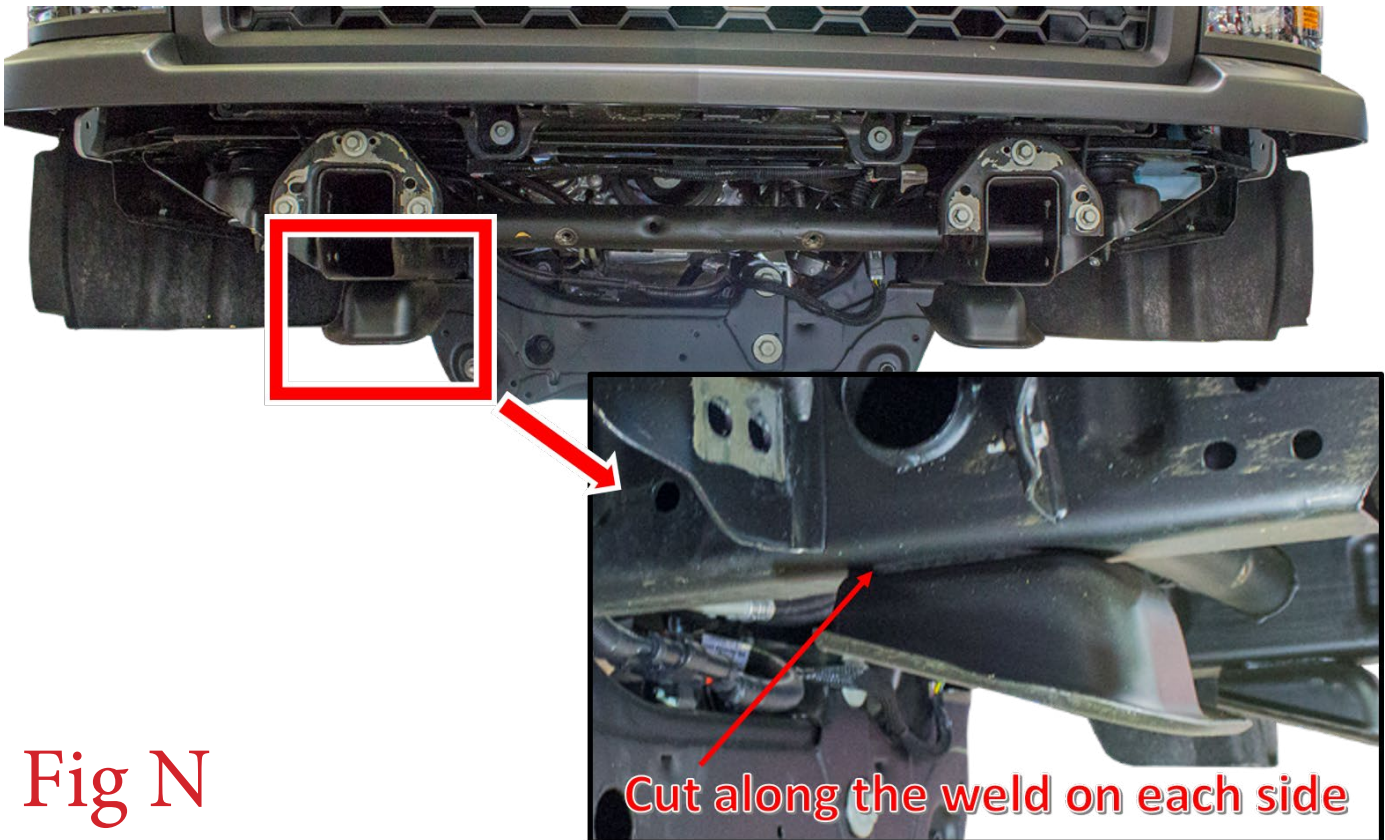


Fig N

18. Reinstall your grille and valance by reversing Steps 2 through 8. Your vehicle should now look like the one in (Fig O).



**Fig O**

19. Prepare to install your new ADD front bumper.

### **Installation:**

20. If you purchased any lights for your bumper, now is a good time to install those. Please follow the light manufacturer's guide for mounting/wiring information.



21. Line up the mounting holes on your bumper with the mounting holes on your vehicle's frame horns. Secure the bumper to your frame horns with the bolts (x6) you set aside in Step 11. Leave these bolts finger tight for now. (Fig P)



Fig P

22. Align the bumper with your valance and make sure it is centered left to right. Then, tighten the mounting bolts (x6) to the factory torque spec.

23. Using a utility knife, cut your inner fender liner to preference. We suggest cutting a line similar to what is shown in (Fig Q)



Fig Q

24. Stand back and enjoy your new ADD Stealth™ R Front Bumper.

25. Check and re-tighten, if needed, all mounting bolts after 100 miles and periodically thereafter.

2016-Current GMC 1500  
Stealth™R Front Bumper Installation Instructions

