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Full-size Front Bumper Installation

Please read all the instructions before beginning

Tools Required:

- **T15 torx bit and socket**
- **10mm socket, ratchet and assorted extensions**
- **15mm socket and ratchet**
- **7mm socket and ratchet**
- **18mm socket and ratchet**

- **18mm combination wrench**
- **Laser Level ([Harbor Freight has a nice low cost option](#))**
- **4-1/2" grinder with Cut-off wheel**
- **Blue painters tape**

Step 1:

Begin removing the front fascia. There are a series of T15 torx screws that follow the perimeter of the front fascia (Note: you may need to remove the skid plate to access all the screws). Going through the slot below the grill, you can remove two 10mm bolts tucked up in the fascia (ZR2 models have 4).

Step 2:

Remove the T15 torx screws on the front half of the inner fender liner. (Removing the front tires can make these easier to access, but not necessary). With the wheel liner folded out of the way, you can remove the 3 (per side) 7mm screws that attach the fascia to the fenders. You should be able to remove the fascia at this point.

Step 3:

With the fascia removed, remove the crash bar that's bolted to the front of the frame rails, using the 15mm socket and ratchet. Next, remove the factory tow hooks with the 18mm socket and wrench.

Step 4:

Take two of the 15mm bolts, from the crash bar, and install them from the back side of frame horn mount, so the head of the bolt faces the engine, and the

threads face the front. This will allow you to slide the bumper on to the bolts and hold it there while you install the other two bolts from the front. You can now remove those two bolts and install from the front.

Step 5:

With the bumper on the truck, take the laser level and set it up 6-8 feet in front of the truck. With the laser on the horizontal line setting, aim the laser towards the truck.

Step 6:

With the laser pointing towards the truck, position the laser so it is 1/8-3/16" above the bumper. Now you can level the laser with the truck by picking symmetrical points on each side of the truck and lining up the laser line. You may need to adjust the height of the level to ensure the laser is on the same plane as the vehicle. You can measure this by checking the laser height at the corners of the bumper, and in the center.

Step 7:

Once you're are happy with the laser positioning (1/8"-3/16" above the top of the bumper), you can remove the bumper and reinstall the factory fascia. You don't need to replace all the bolts, just enough to hold it in place while cutting.

Step 8:

With the factory fascia reinstalled, take the blue painters tape and follow the laser line across the fascia. Keep the pieces of tape small in length (6-8") to help make it easier to follow the line.

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Step 9:

Once you're happy with the tape, you can start cutting. Be sure to use the guard on the grinder as it will throw hot plastic everywhere. Using a 4-1/2" metal cut-off wheel, start on the driver's side and cut towards the passenger side. You will want to cut so the TOP of the cut-off wheel is touching the line. This helps give you're a precise edge to follow. Once you cut all the way across the fascia, you may need to come back and trim the mounting brackets underneath the grill to clear the bumper.

Step 10:

Now that you have cut everything, you can clean up the cut by dragging (Not pushing!) and razor blade across the plastic. This will help remove the fraying from the cut-off wheel. You want to have 3/16"-1/4" of clearance between the bumper and the fascia, to give the body room to flex from the frame. You can use a Flap wheel on the grinder to help smooth and level out and edges.

Step 11:

Reinstall all the remaining fasteners into the fascia, and install the bumper with the included hardware. Be sure to install your desired winch into the bumper, and plumb the wiring before installing the bumper.

Step 12:

Trim and reattach the inner fender liners. You may need to secure the forward inside part of the liner as it is now not attached.

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Step 13:

(ZR2 Only) To re-use your factory front skit plate, you will need to trim the front corners off (pictured).