

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 for OEM Removal/Bumper Installation**

1 Additional Hour to Wire Center Light

1 Additional Hour to Wire Side Lights

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

****Labor Rates are based on a vehicle with no pre-existing damage. Wiring labor is based on a standard wiring procedure with light switches installed in an easily accessible location. Custom light triggering or switch mounting location will result in a greater labor charge.****

You will need the following tools:

- | | | |
|------------------------|------------------------|-----------------------------|
| - Ratchet | - 7mm Socket | - 10mm Socket |
| - 13mm Socket | - 15mm Socket & Wrench | - 17mm Socket & Wrench |
| - 18mm Socket & Wrench | - 9/16 Socket & Wrench | - 5/32" Allen Wrench/Socket |
| - 3/4" Socket & Wrench | - T15 Torx Socket | - Utility Knife |
| - Cutoff Wheel | - Black Paint | |

Included in Kit:

- | | |
|--|--|
| 4 - Hex Head Bolts (3/8"-16 x 1") | 8 - Flat Washers (3/8") |
| 4 - Nylon Lock Nuts (3/8"-16) | 6 - Hex Head Bolts (M10-1.5 x 30mm) |
| 6 - Flat Washers (M10) | 8 - Hex Head Bolts (1/2"-13 x 1 1/2") |
| 16 - Flat Washers (1/2") | 8 - Nylon Lock Nuts (1/2"-13) |
| 2 - Light Mount Tabs (L) | 2 - Bumper Side Pods |
| 1 - Bumper Center Section | |

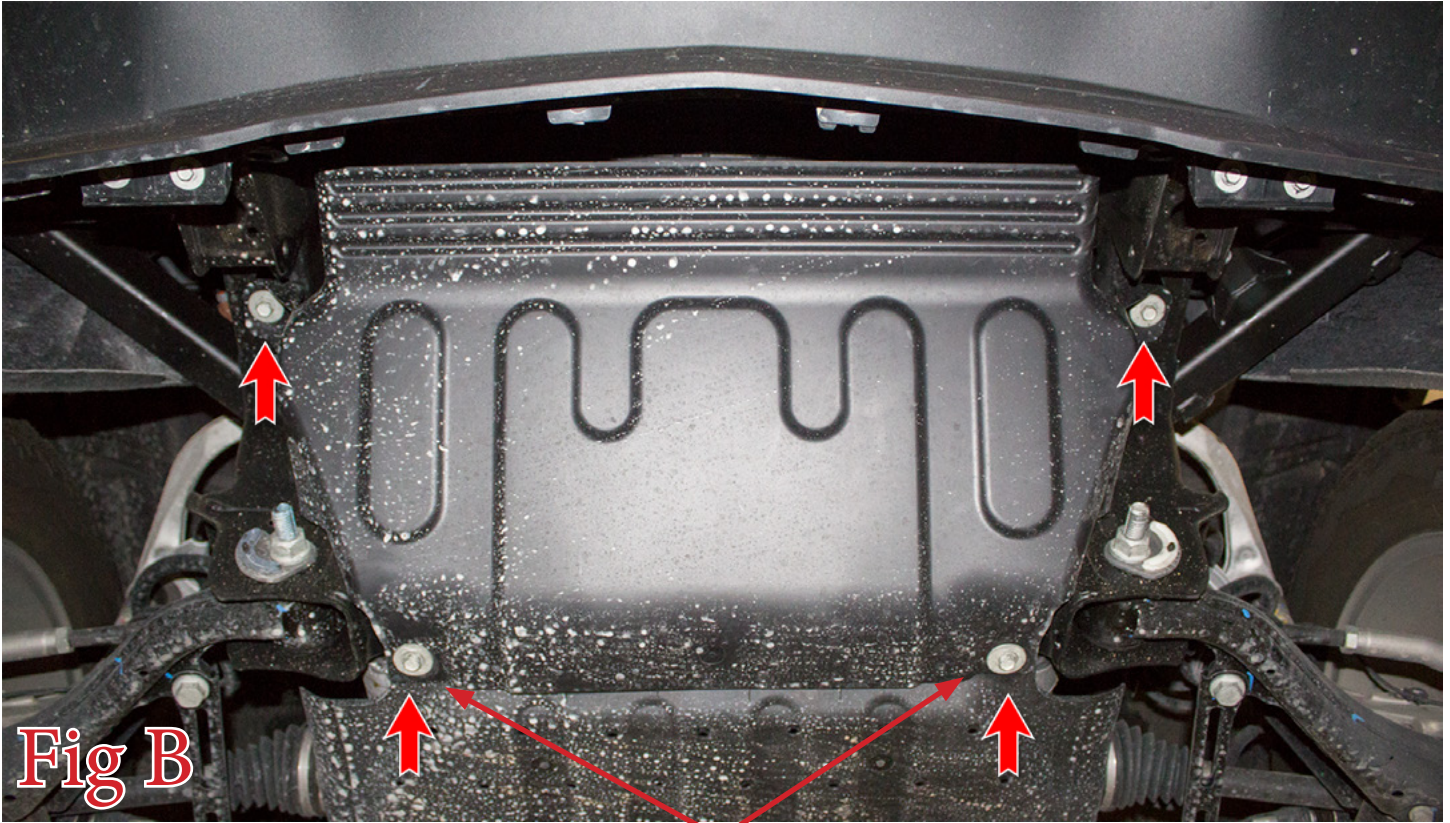
Removal:

1. Using a T-15 Torx Bit, remove the six (per side) most forward inner fender well bolts. (Fig A)



Fig A

- Using a 13mm Socket remove the skid plate mounting bolts (x4). Then, remove the skid plate from the vehicle. Once the skid plate is removed, reinstall the 2 rear bolts. (Fig B)

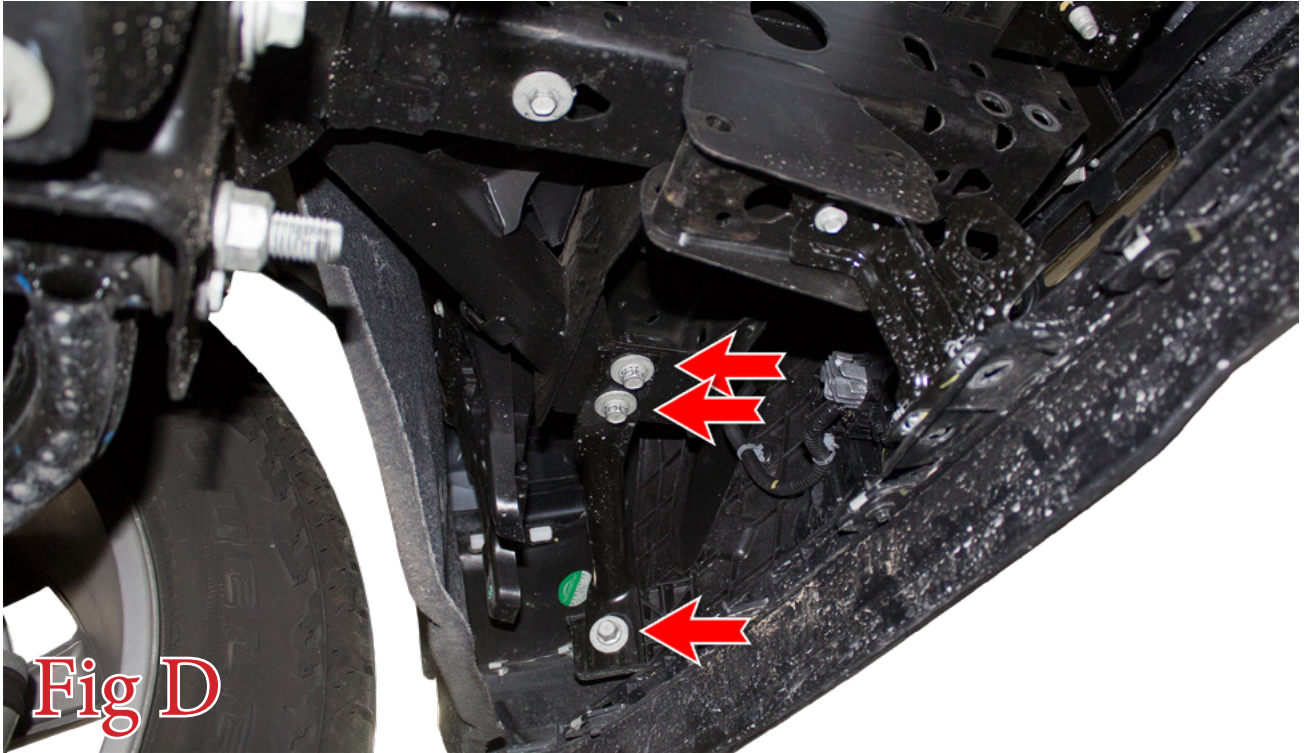


Once you remove the skid plate, reinstall these two bolts.

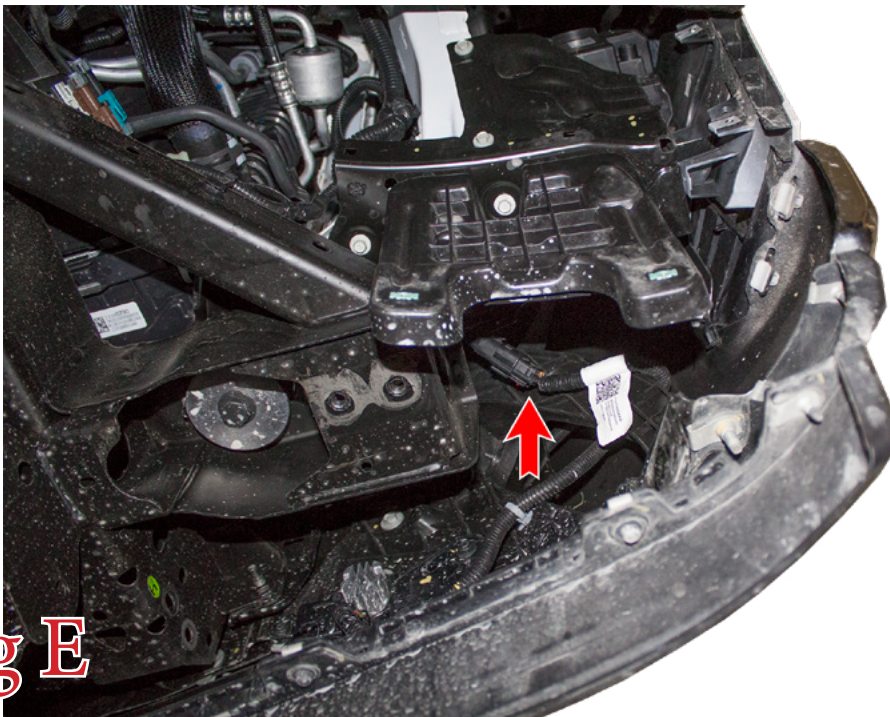
- Using a 10mm Socket, remove the bolts (x4) on the underside of the OEM bumper. (Fig C)



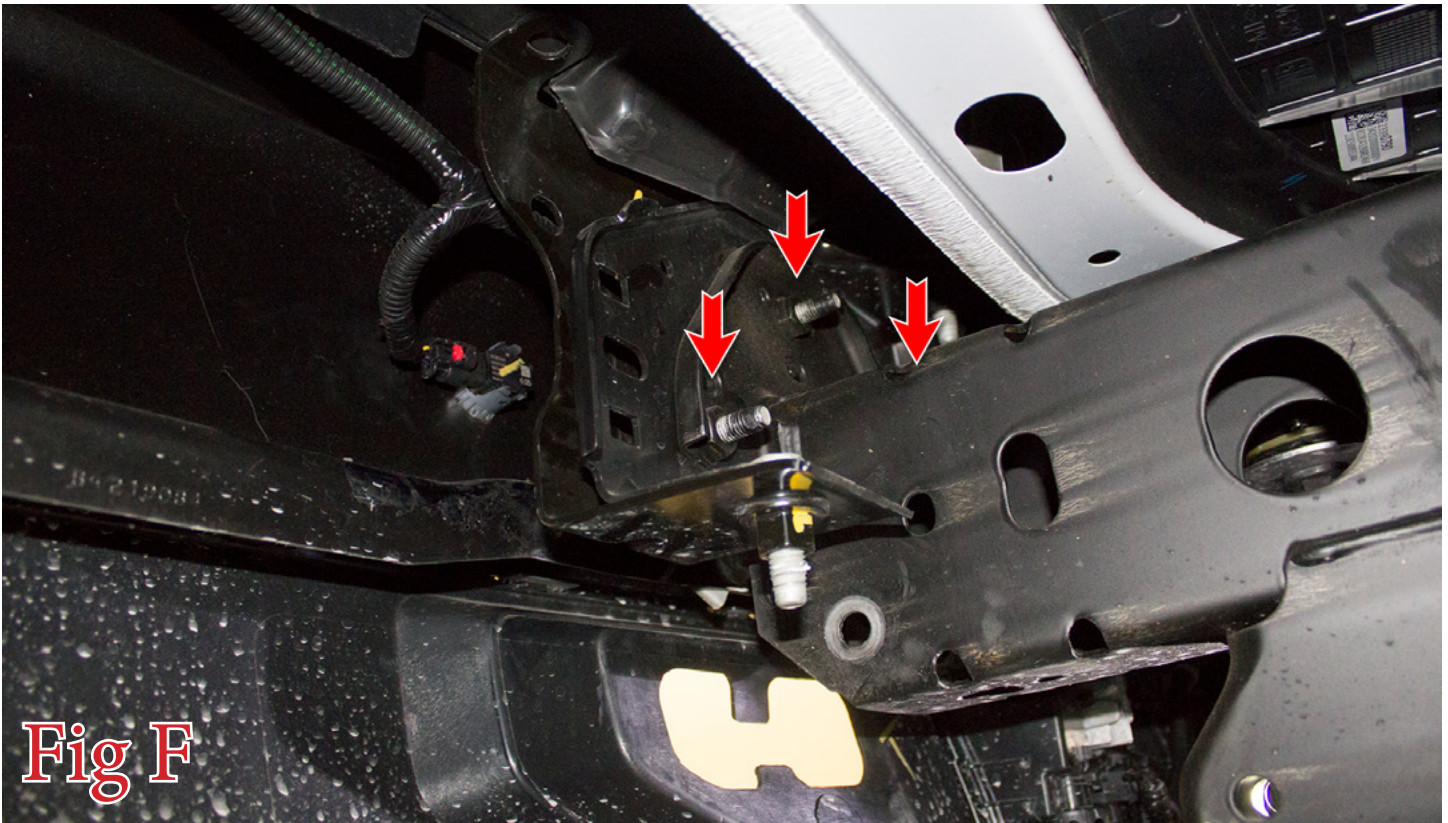
- Using a 15mm Socket, remove the bumper support bar mounting bolts (3 per side). Then, remove these bumper support bars from the vehicle. (Fig D)



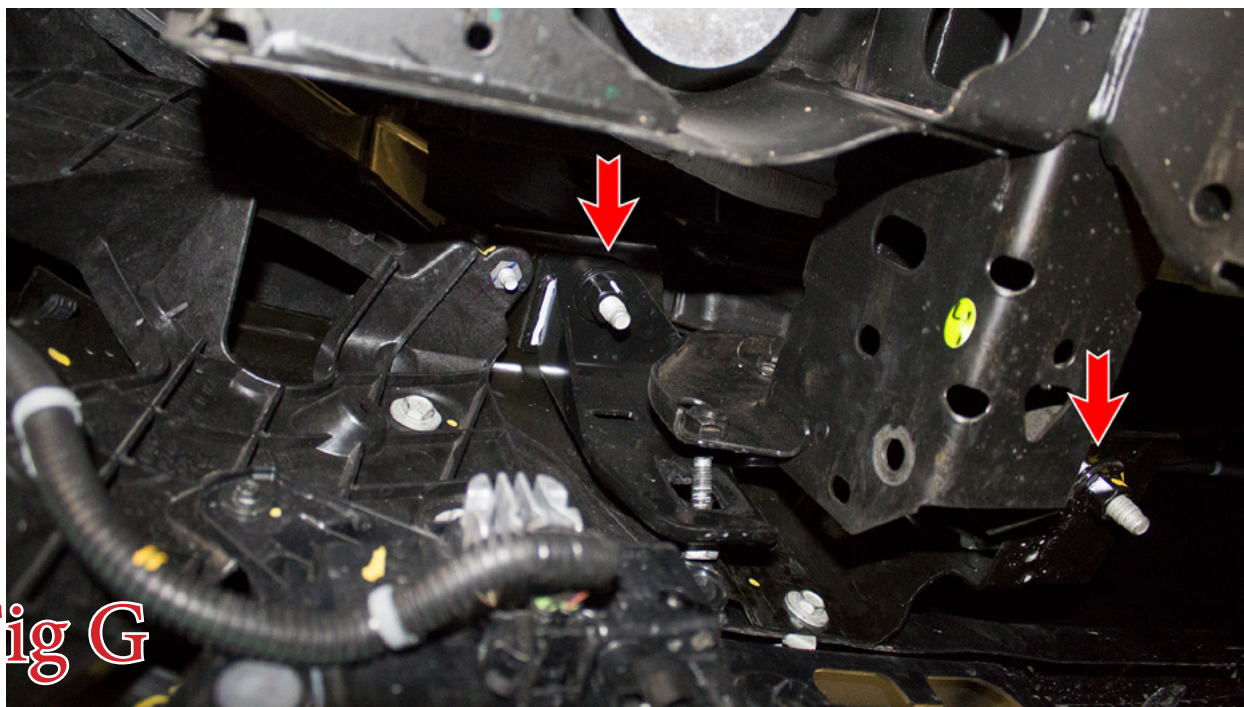
- On the passenger side of the vehicle, just in front of the inner fender liner, unplug the main bumper harness connector. (Fig E)



6. Using a 15mm Wrench, loosen the 3 bolts per side that hold the bumper to its mounting brackets. Do not take these all the way out, just loosen them until the bumper is loose and drops down about a half inch. The head of the bolts are between the bumper and the frame horn, you will need a wrench to access them. (Fig F)



7. Now that the bumper has dropped a little, you can access the two bolts (per side) that hold the bumper to its mounting brackets with an 18mm Wrench. Remove these bolts, then remove the OEM bumper from the vehicle. (Fig G)



8. Using a 15mm Socket, remove the bumper brackets from the truck's frame horns. (Fig H)

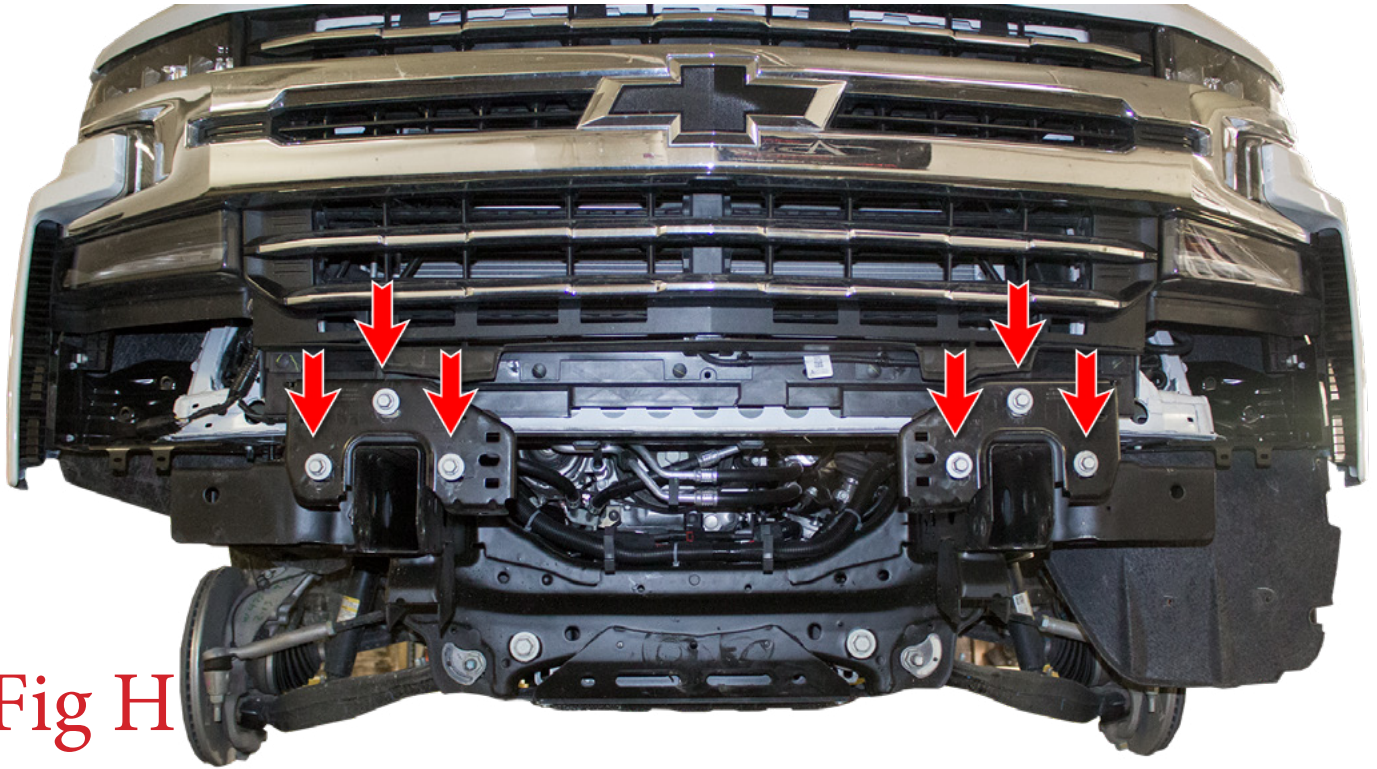


Fig H

9. Using a 10mm Socket, remove the four bolts that hold on the plastic fender liner brackets. Then, remove these brackets from the vehicle. (Fig I)

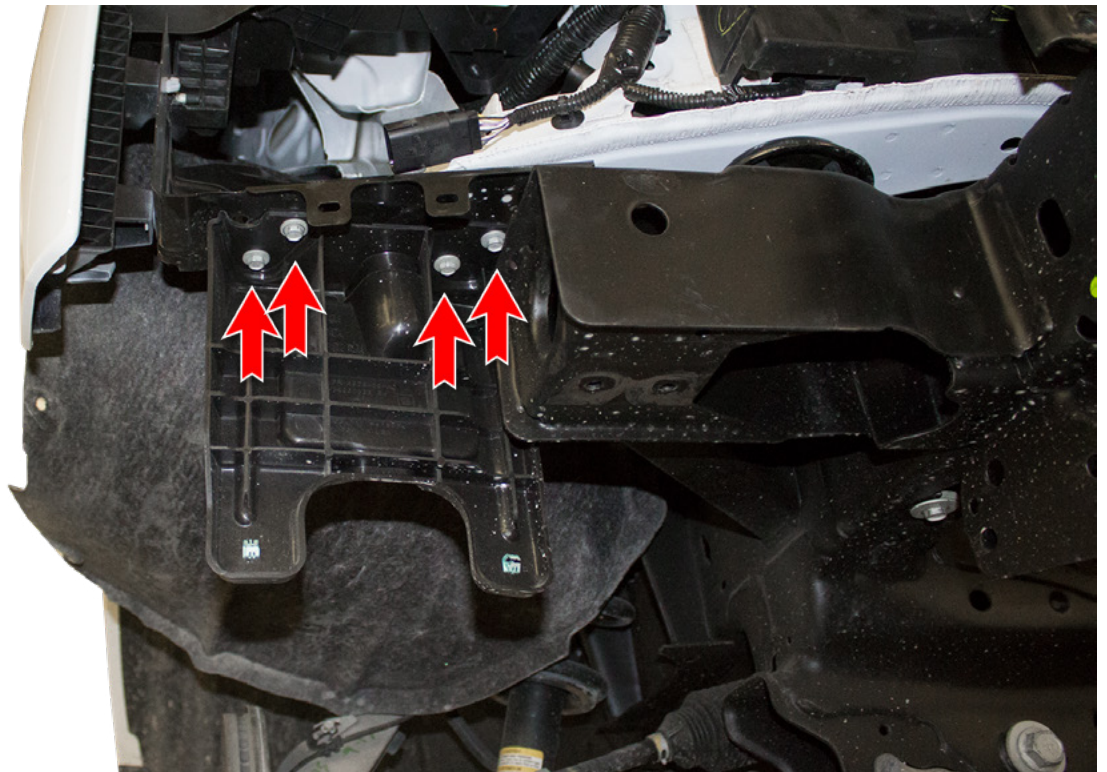
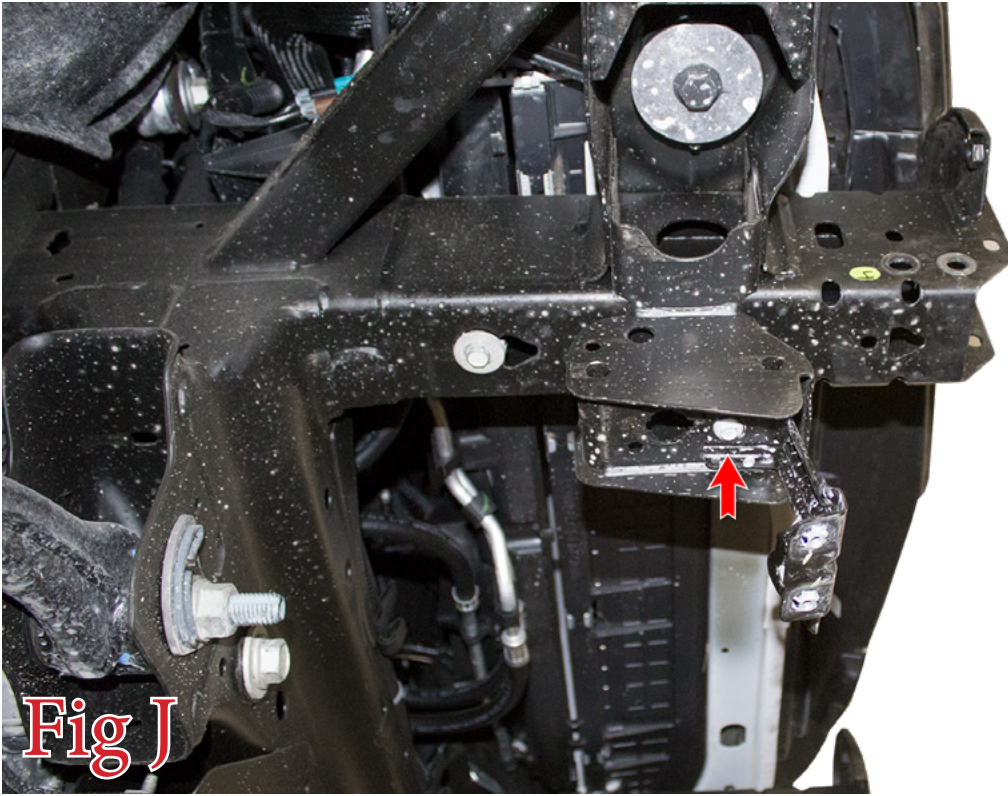


Fig I

10. Remove the bolts (one per side) that hold on the skid plate mounting brackets. Then, remove these brackets. (Fig J)



11. Remove the three inner fender liner bolts referenced in (Fig K) **Save these bolts for reuse.**



12. Pull the inner fender liner back, then use a 7mm Socket to remove the three bolts holding the air dam bracket to the fender. (Fig L) **Save these bolts for reuse.**

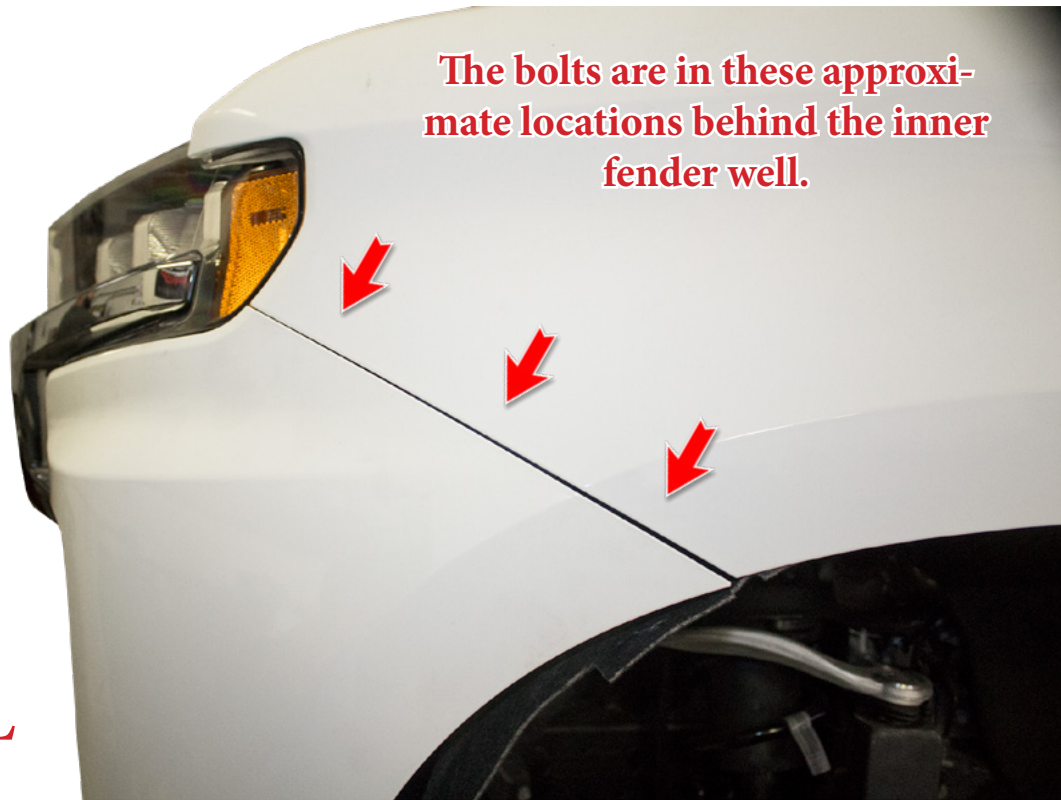


Fig L

13. Release the series of clips holding on the air dam piece, then remove that piece from the vehicle. (Fig M)



Fig M

14. Use a 10mm Socket to remove the six bolts referenced in (Fig N). Then remove this bracket from the vehicle.

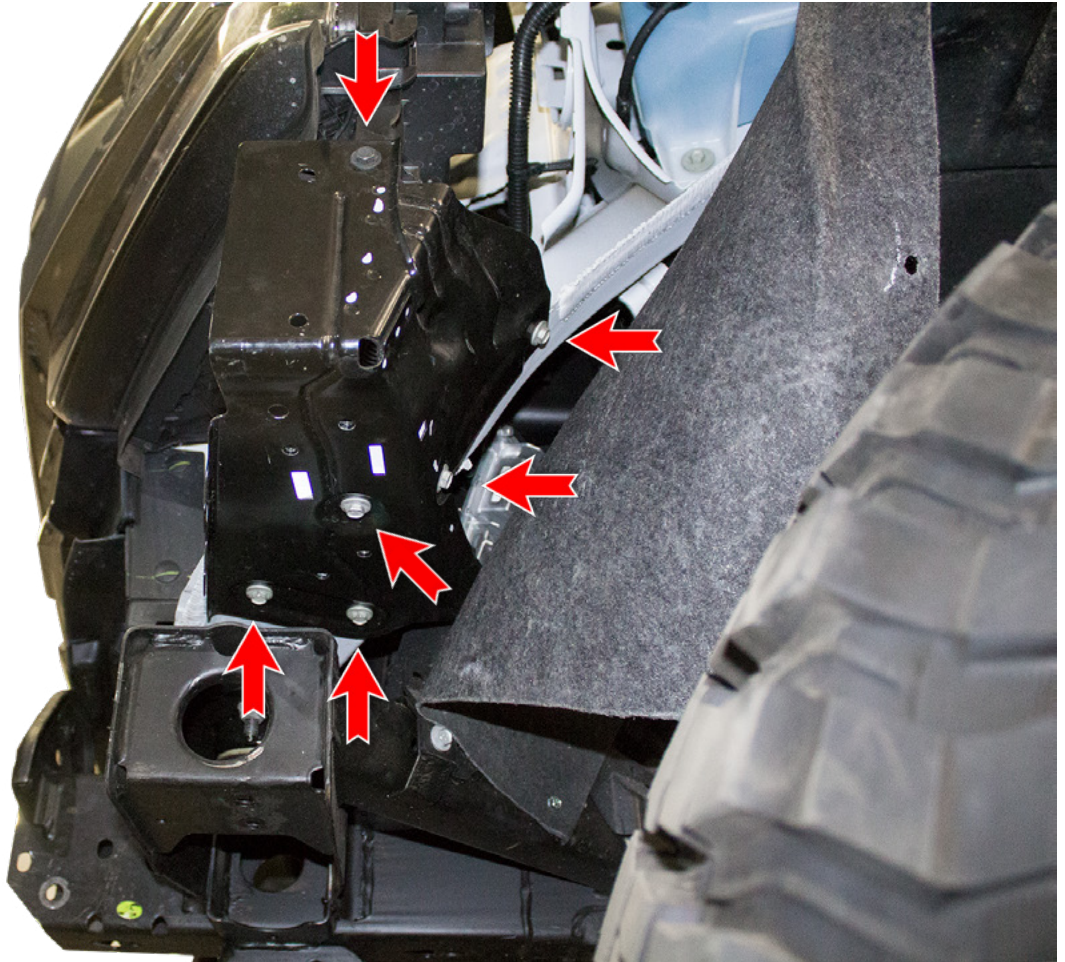
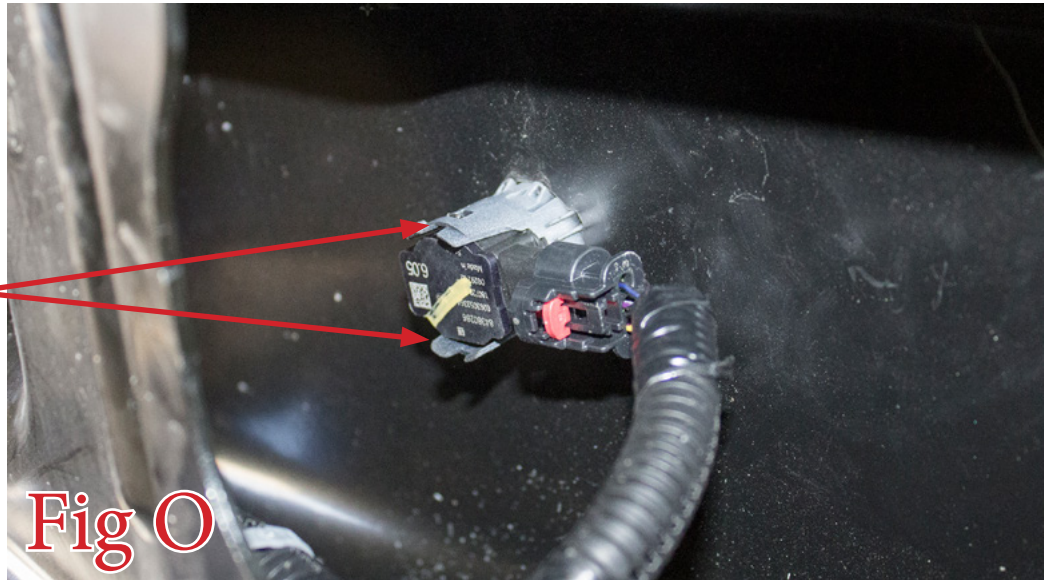


Fig N

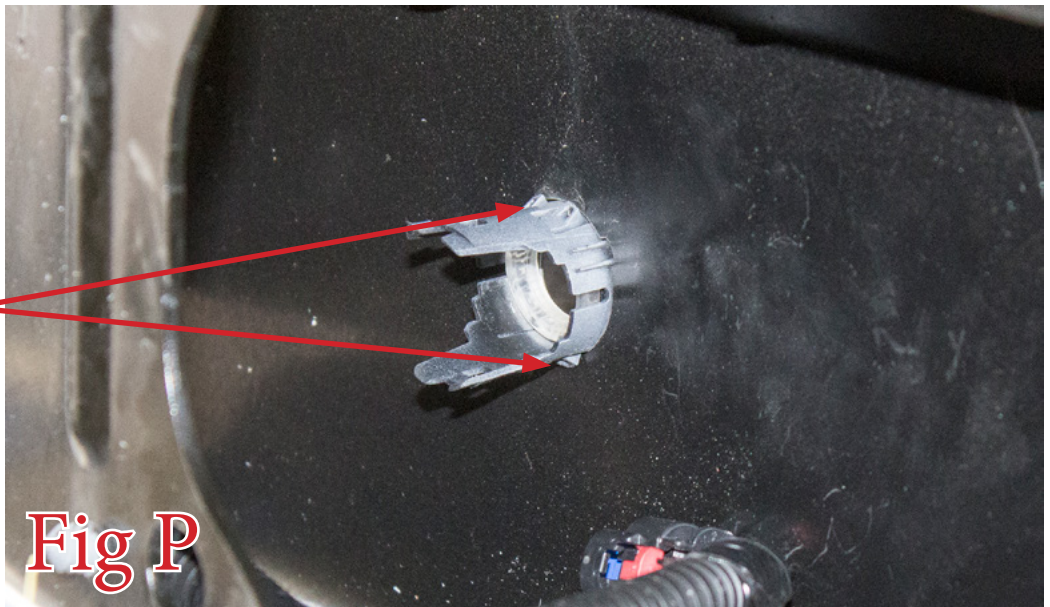
15. Remove the parking sensors from your OEM bumper. Do this by spreading the two tabs on the back side of the sensor mounting rings. Make sure to keep track of the position/orientation that these come off your OEM bumper so you can install them on your new bumper in the same position/orientation. (Fig O)

Spread these two tabs to release the sensor.



16. Remove the parking sensor mounting rings. Do this by squeezing the two tabs on the back side of the mounting ring and pushing that ring out the front side of the bumper. (Fig P)

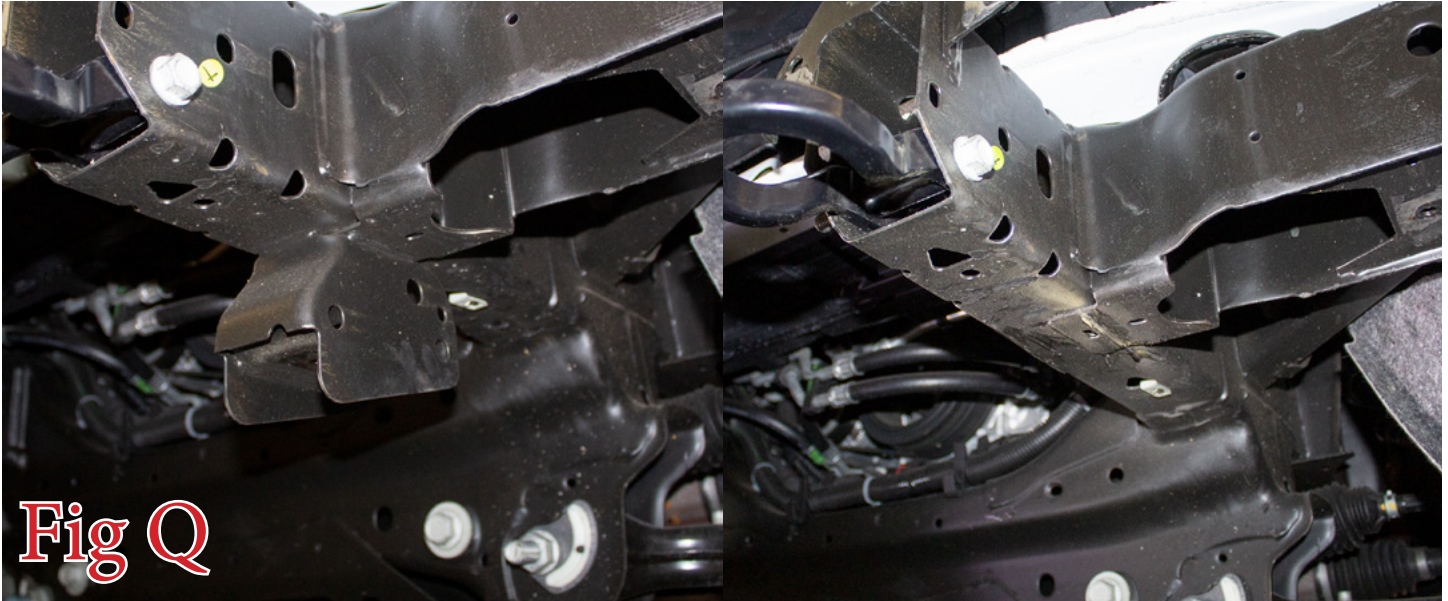
Squeeze these two tabs to release the ring.



17. Using a cutoff wheel, or something similar, cut off the bell tabs on the bottom of the vehicles frame rails. Make sure to paint over any bare metal when you are finished. (Fig Q)

Before

After



18. For each air dam, count down 9 ribs from the top. Then, make a mark at the 9th rib. Where that mark is, draw a straight line horizontally across the air dam. When you get to the edge that sits in the wheel well, go down and around the inner liner mount so that inner liner mount does not get cut off. ()



**Make a mark at the 9th rib
from the top.**



**Make a straight horizontal line
even with the mark you made at
the 9th rib, but make sure to go
around the inner liner mount as
shown here.**

19. Cut along your marked line, so that your air dam looks like the one pictured in (Fig R).



Fig R

Installation:

20. Bolt the Bumper Side Pods to the center section of the bumper. Use the supplied 1/2" Bolts (4 per side), 1/2" Washers (8 per side), and 1/2" Lock Nuts (4 per side). Once all bolts are loosely installed, go back and torque them to 70 foot pounds. (Fig S)

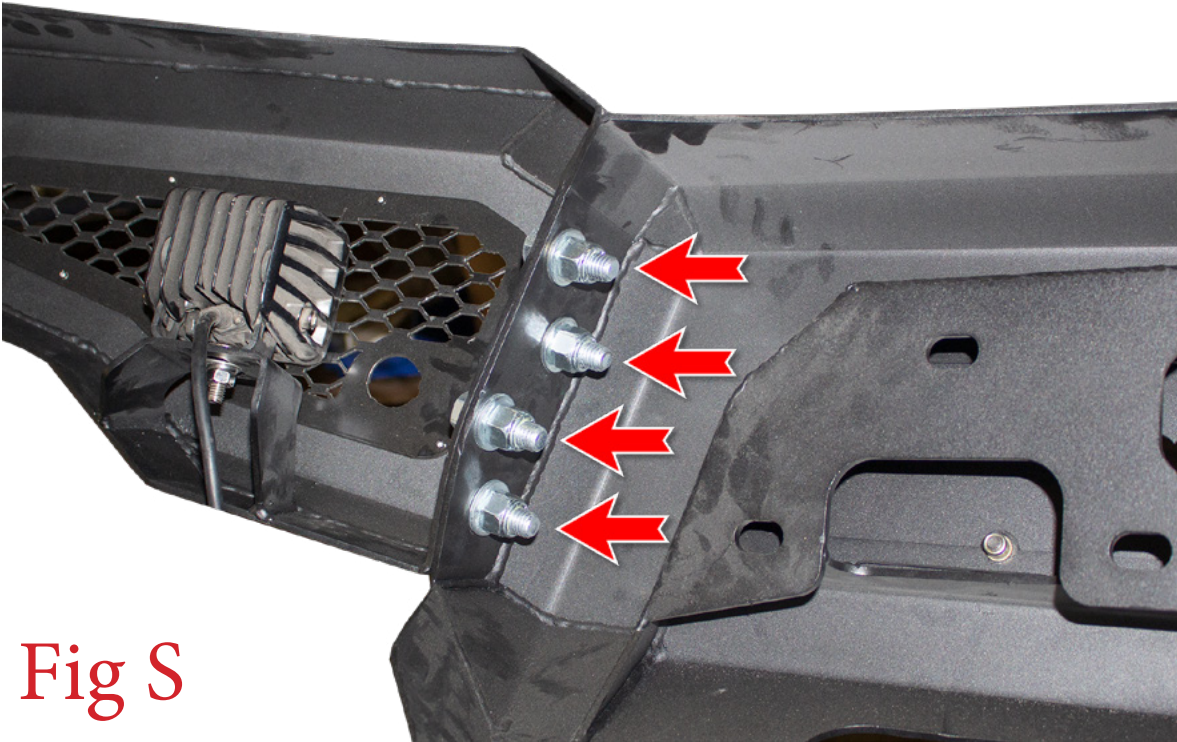


Fig S

21. Install any lights you have for your bumper. Use the supplied Light Tabs and the supplied 3/8" Bolts (x2), 3/8" Washers (x4), and 3/8" Lock Nuts (x2) to hold the tabs to the bumper. Use the light manufacturer's hardware to bolt the light to the tabs. Use the light manufacturer's hardware to bolt the cube lights to their mounts. Follow the light manufacturer's install guide for wiring information. (Fig T)

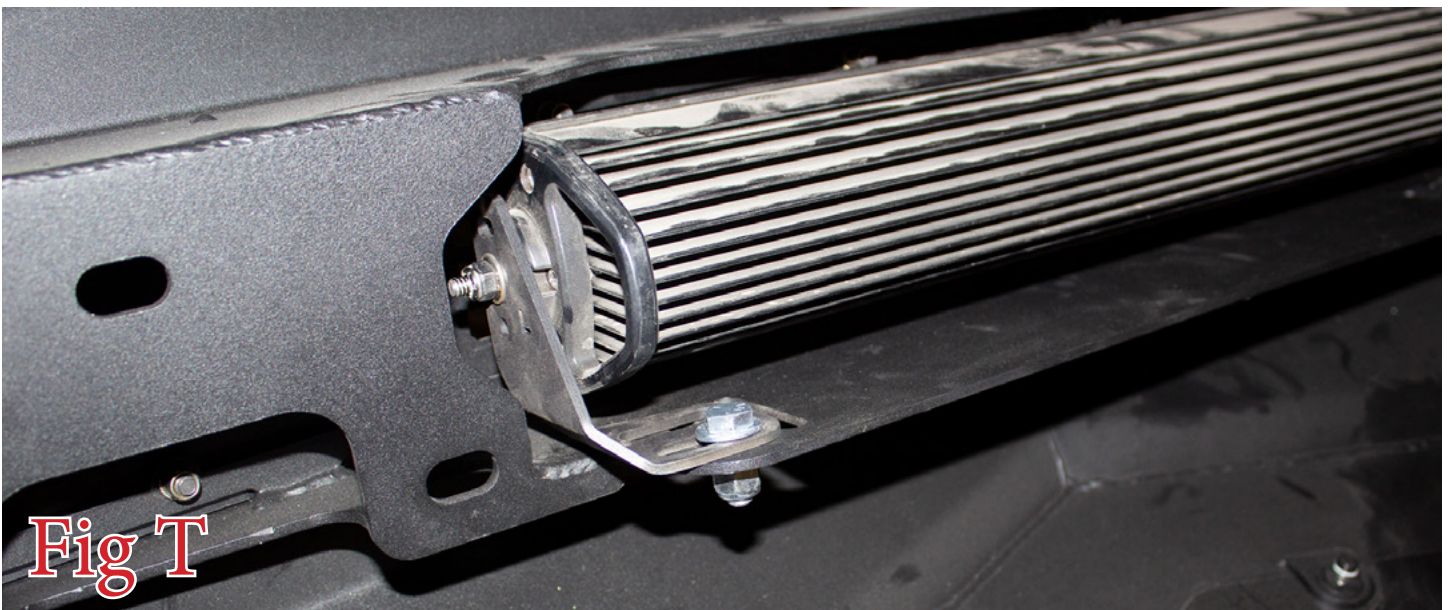


Fig T

22. Using a 5/32" Allen Wrench or Socket, remove the Bolts (x14) that hold on the front bumper panel. Then, remove this panel from the bumper. (Fig U) **Save these bolts for reuse.**

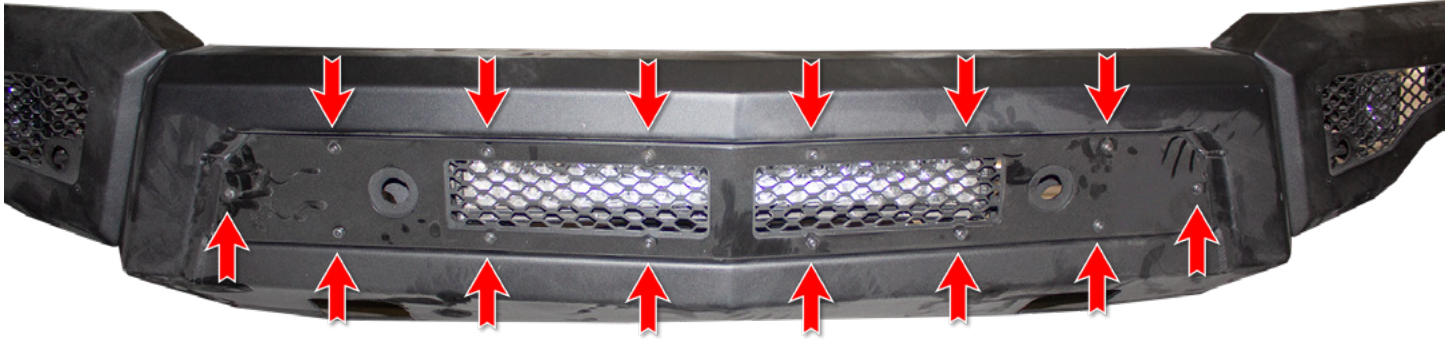


Fig U

23. Install the parking sensor mounting rings into your new bumper. Be sure to install them in the same position/orientation as they came off the OEM bumper. If the rings do not click into place, you may have to file the tabs down a little to allow for the thicker material of your new bumper. (Fig V)

**You may have to
file these surfaces
back a little.**

**Then, push it into
its precut hole in the
bumper.**

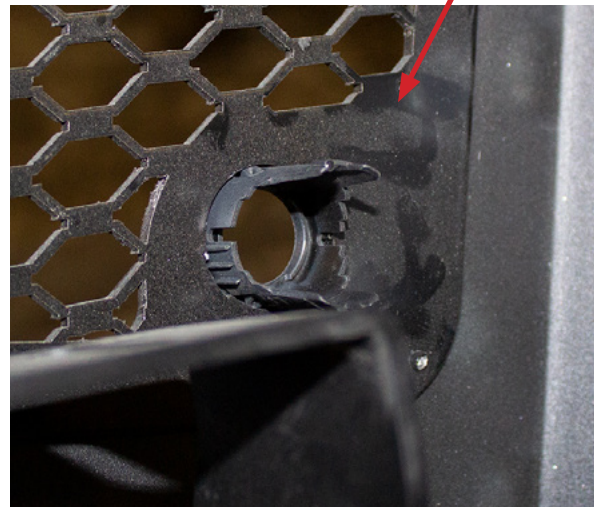
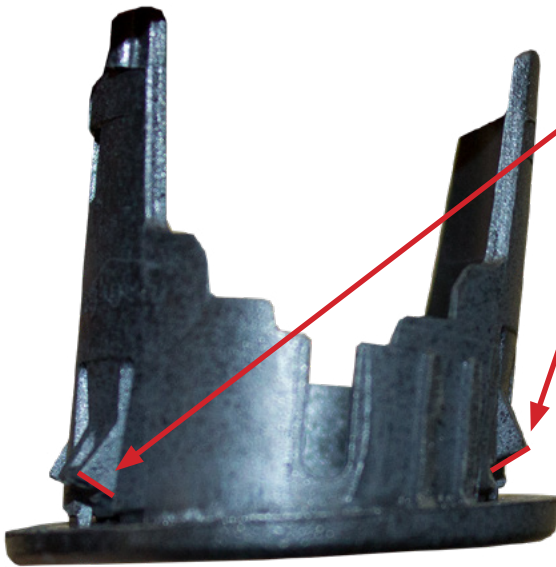
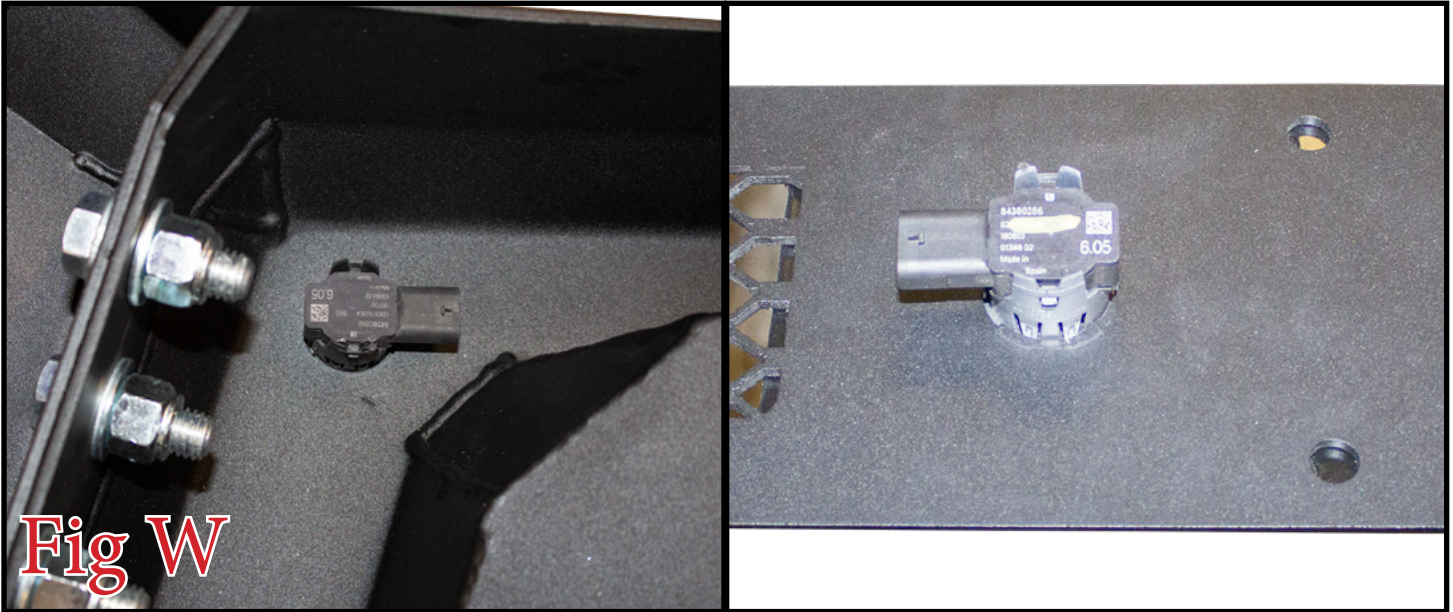


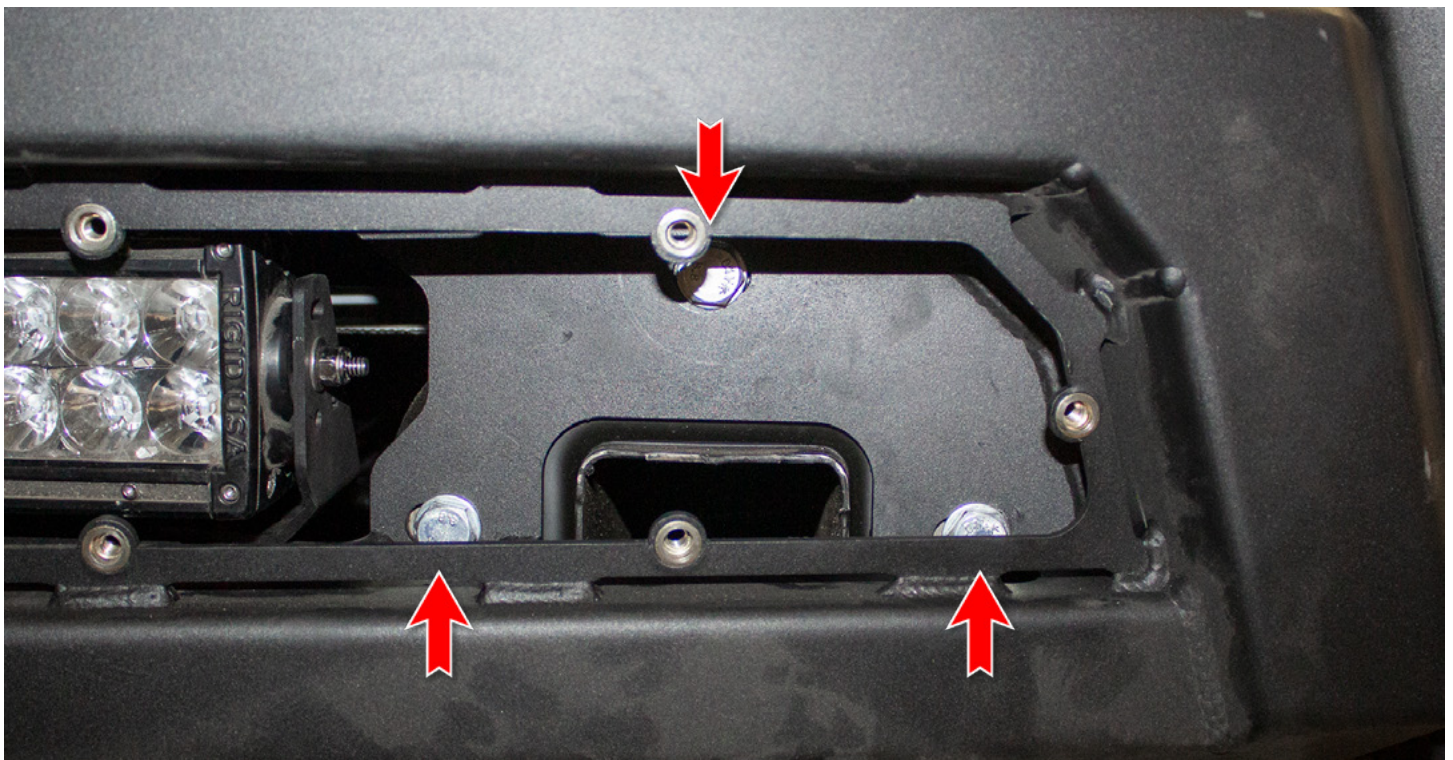
Fig V

24. Install the parking sensors by pressing them into the back side of the mounting rings until they click into place. Be sure to install these in the same position/orientation as they came off the OEM bumper (with the connectors facing towards the center of the bumper). (Fig W)



25. Install the bumper's wiring harness by plugging it into the parking sensors and routing it out of harm's way. Keep the main connector on the same side as it came off the OEM bumper. Leave the middle two sensors unplugged for now.

26. Set the bumper in place on the vehicle. Then, secure the bumper using the supplied M10 Bolts (3 per side) and M10 Washers (3 per side). Leave these bolts loose for now. (Fig X)



27. Install the supplied 3/8" Bolts (x2), 3/8" Washers (x4), and 3/8" Lock Nuts (x2) in the skid plate mounting holes as shown in (Fig Y).



Fig Y

28. Align the bumper so it is centered left to right and straight in relation to the grille. Torque the M10 Mounting Bolts to 40 foot pounds. Then, torque the 3/8" Mounting Bolts to 30 foot pounds.

29. Reinstall the front bumper grille onto the bumper by reusing the hardware from Step 22. Torque these bolts to 7 foot pounds. Make sure to plug in both parking sensors as you install these panels. (Fig Z)

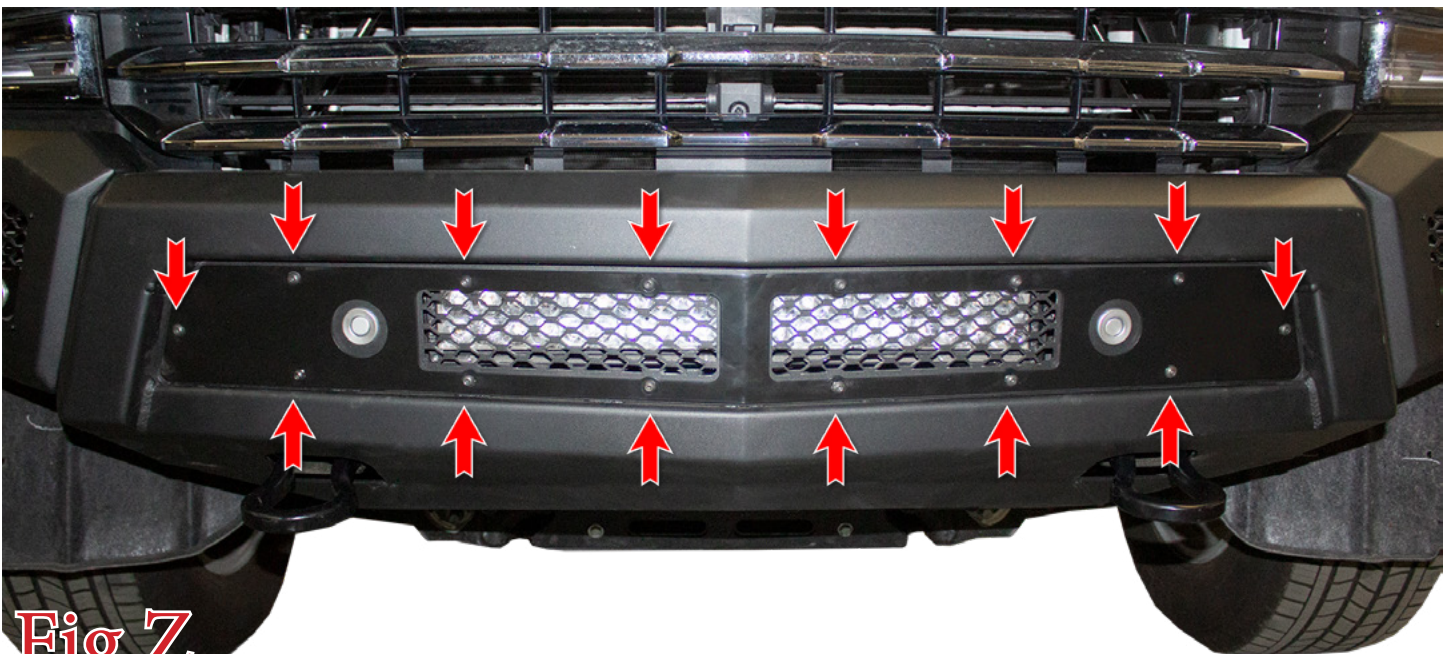


Fig Z

30. Reinstall your air dam by reversing Steps 12-13. **Your air dam is still going to be too long to fit at this time, you will have to use the bumper as a guide on how much more you will need to trim off. Trim it to your preference.** (Fig AA)



31. Plug in the main bumper harness connector from Step 5.
32. Reinstall two of the three bolts you removed in Step 11. Leave the bottom most bolt out. (Fig AB)



Fig AB

33. Using a utility knife, or something similar, trim the inner fender liner to preference.(Fig AC)



Fig AC

34. Stand back and enjoy your new ADD Stealth™ Front Bumper.
35. Check and re-tighten, if needed, all mounting bolts after 100 miles and periodically thereafter.

2019-Current Chevy 1500
Stealth™ Front Bumper Installation Instructions

