

IRON CROSS AUTOMOTIVE INC.

INSTALLATION INSTRUCTIONS FRONT [WINCH BUMPER](#)

20/22/24-525-03 & 325-03
03-07 CLASSIC CHEVROLET 2500/3500
03-07 CLASSIC GMC 2500/3500



PARTS LIST

20	1/2" FLAT WASHERS
10	1/2" LOCK WASHERS
10	1/2" HEX BOLTS
10	1/2" HEX NUTS
1	DRIVER SIDE BRACKET
1	PASSENGER SIDE BRACKET
1	FRONT BUMPER

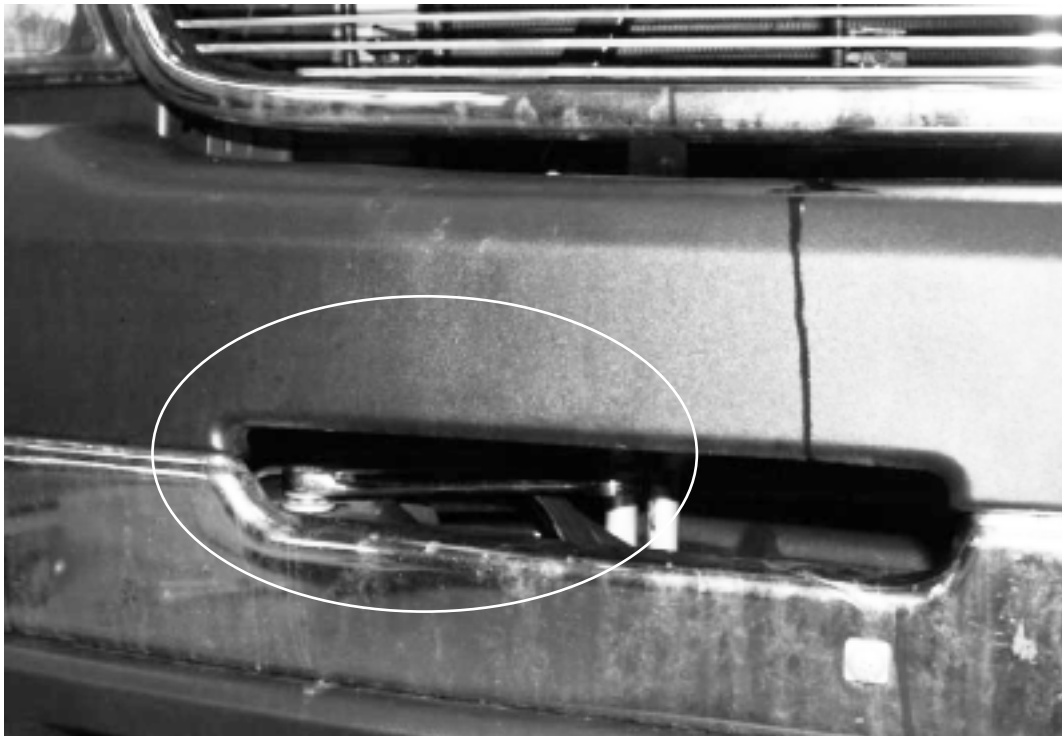
THIS PRODUCT IS FOR OFFROAD USE ONLY. ALL LIABILITY FOR INSTALLATION AND USE RESTS WITH THE OWNER.

CARELESS INSTALLATION AND OPERATION CAN RESULT IN SERIOUS INJURY OR EQUIPMENT DAMAGE.

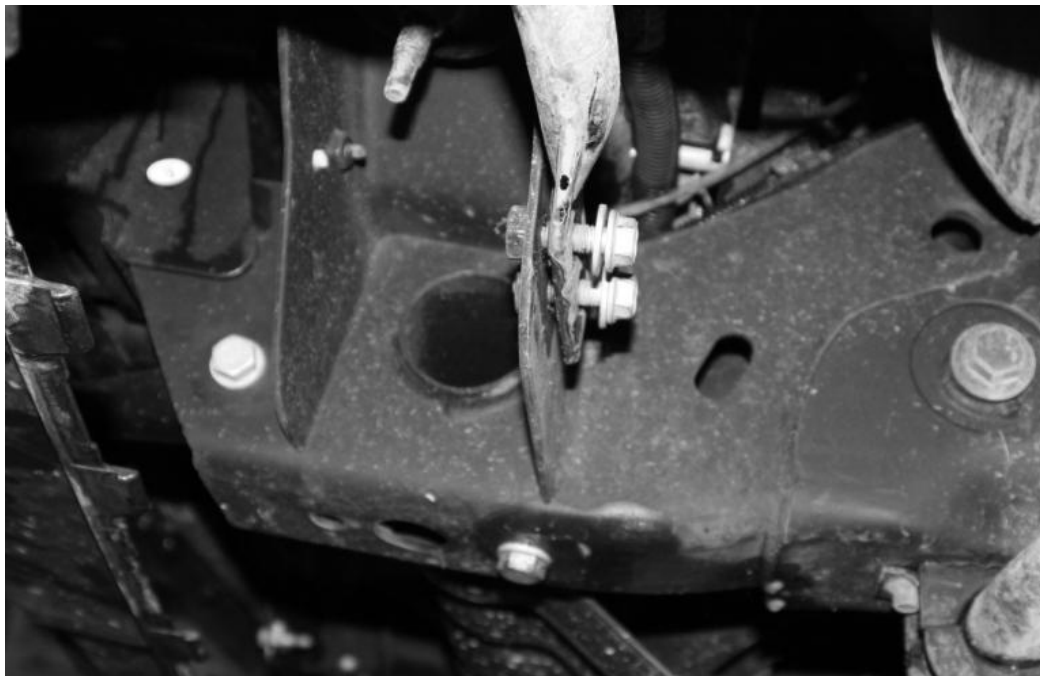
IV. Vehicle Preparation

A) Disconnect factory fog lamp connectors (if applicable). Zip tie harness to frame.

B) Remove fasteners holding OEM bumper to chassis using a 15mm wrench. Fasteners may be accessed from the sides underneath and through the slots in the OEM bumper.



C) Loosen fastener and swing outer bumper support tube down to allow the OEM bumper to come off the front..



D) Remove dart clips and bolt (passenger side only) connecting inner fender to body.



E) Remove OEM bumper.



F) Remove factory tow hook assemblies by removing 3 bolts (each).



DRIVER SIDE

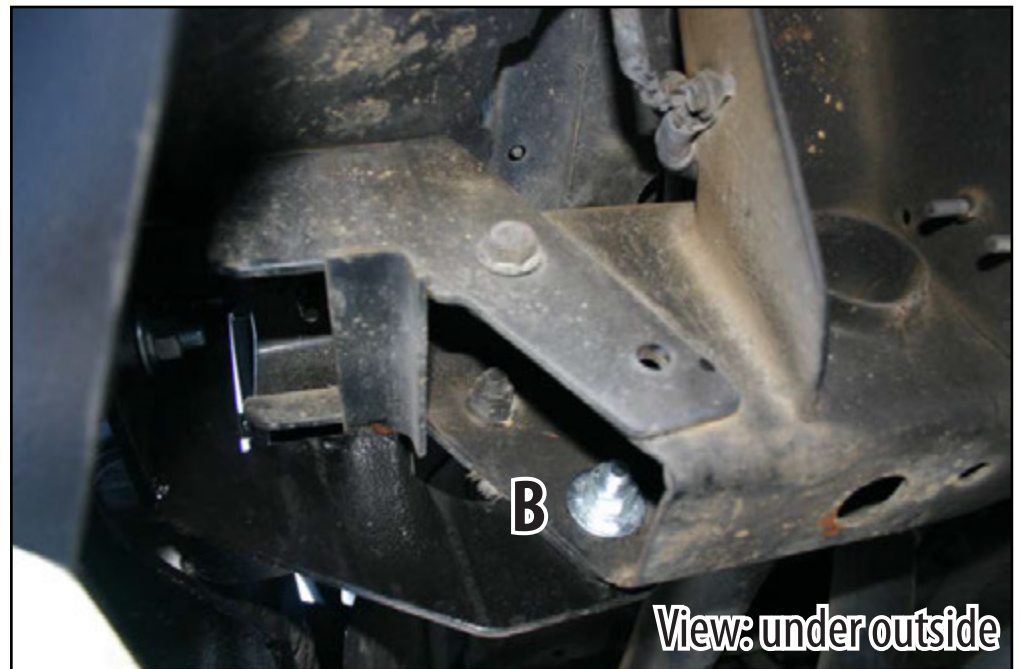
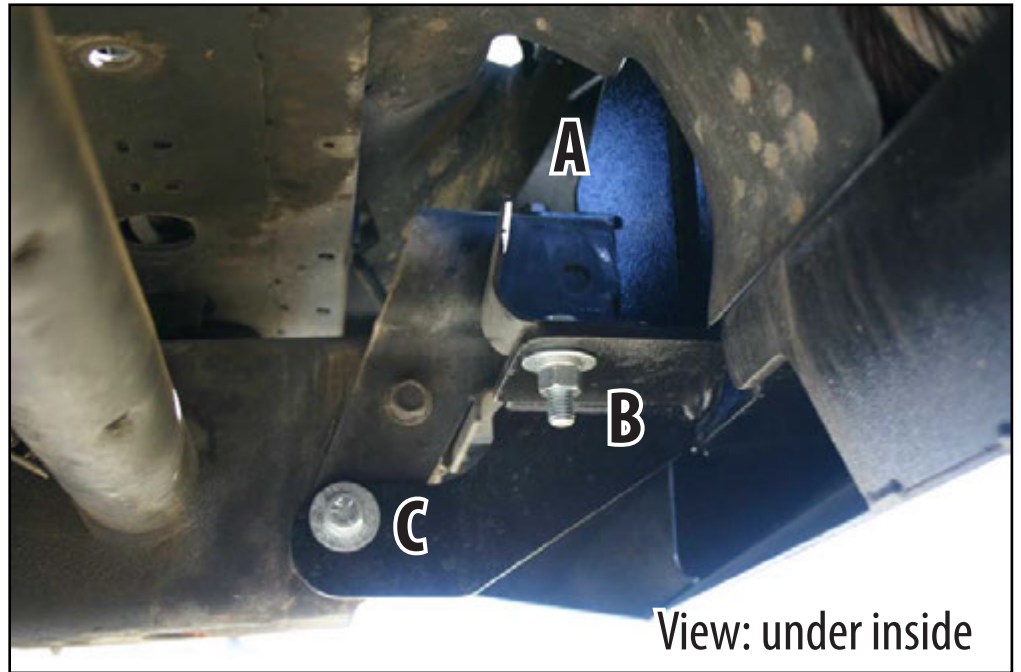
Bracket install

Install driver and passenger side bumper brackets using (2) 1/2" flat washers, 1/2" hex bolt, 1/2" lock washer, and 1/2" nut at locations B & C.

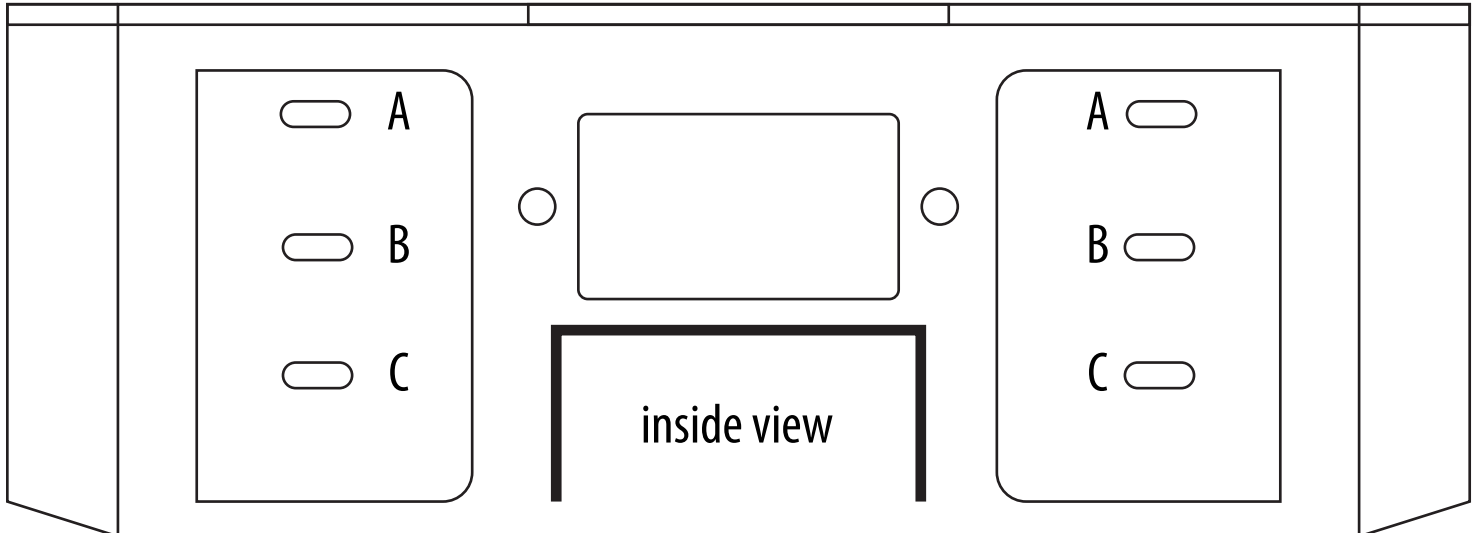
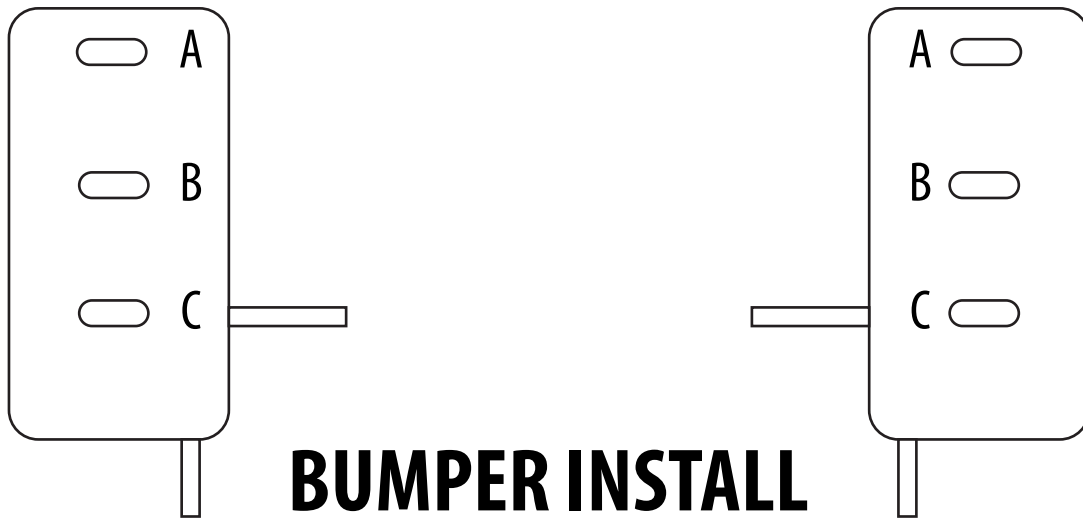
Use factory bolt at location A.

NOTE:

If Installing a 40 Series Bumper, skip this step and refer to the 40 Series supplement page at this time.



Font view of brackets mounted on vehicle



- 1) Carefully lift bumper and line bolts up to the mounting flanges. Slide flat washer, lock washer over each bolt and another flat washer then thread on $\frac{1}{2}$ nut. Tighten finger tight until final alignment is finished. Repeat for other side.
- 2) Adjust the bumper to achieve good visual alignment as follows:
 - A. Adjust "castor" and in/out with mounting bracket.
 - B. Adjust left/right and up/down with the intermediate mount bolts.
- 3) Tighten all fasteners, beginning with frame mounts. Then tighten all mount-to-bumper fasteners.
- 4) Trim inner-fender liners to match bumper if desired.

IRON CROSS AUTOMOTIVE INC. 40 SERIES BUMPER

Installation Supplement Page

When installing the brackets for the 40 Series Front Bumper, it is necessary to remove this bracket from the truck frame rail.



For the 40 Series Front Bumper, install the brackets below. The drop portion of the bracket goes inside the frame rail. The tabs on the back side of the brackets goes over the top of the frame rail. The bumper then is installed to these brackets as described in the instruction sheet.

