



Installation Instructions

Chevy and GMC HD Rear Bumper

Product Number: T1250
'99 - 06 Chevy and GMC HD Trucks

SAFETY

Your safety and the safety of others is very important.

- In order to help you make informed decisions about safety, we have provided installation instructions and other information.
- These instructions alert you to potential hazards that could hurt you or others.
- Please do a job safety analysis (JSA) before each task to identify potential hazards for your situation and remove/protect against them.
- You must use your own good judgment, and take your time.

Read and understand all safety precautions and instructions before installing this product.

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.

Injury hazard

Failure to observe these instructions could lead to severe injury or death.

- Always** remove jewelry and wear eye protection.
- Always** use extreme caution when jacking up a vehicle for work. Set emergency brake and use tire blocks. Locate and use the vehicle manufacturers designated lifting points. Use jack stands.
- Always** use appropriate and adequate care in lifting components into place.
- Always** insure components will remain secure during installation and operation.
- Always** wear safety glasses when installing this kit. A drilling operation will cause flying metal chips. Flying chips can cause serious eye injury.
- Always** use extreme caution when drilling on a vehicle. Thoroughly inspect the area to be drilled (on both sides of material) prior to drilling, and relocate any objects that may be damaged.
- Always** use extreme caution when cutting and trimming during fitting.
- Always** tighten all nuts and bolts securely per installation instructions.
- Always** route electrical cables carefully. Avoid moving parts, components that become hot and rough or sharp edges.
- Always** insulate and protect all exposed wiring and electrical terminals.
- Always** perform regular inspections and maintenance on mounts and related hardware.





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I. Parts List

- T1250 GM HD rear replacement bumper
- T1250-HW fastener kit
- Tag Light
- 2 License plate mounting inserts
- 2 Reverse lights, mounting grommets, and wire pigtails
- 4 Backup sensor grommets and plugs
- Instruction Manual

II. Tools Required

- Socket Wrench with Extension
- 9/16", 3/4", 13/16", 15mm, 18mm, & 22mm Sockets
- 9/16", 3/4", 7/8", 15mm, 18mm, & 22mm Box End Wrench
- Flat Head Screwdriver

III. Vehicle Preparation

1. Remove license plate, and OEM license plate lights. If equipped, unplug back-up sensor harness.
2. Remove the two fasteners connecting the hitch to the stock bumper located on either side of the receiver with an 18mm socket.
3. Remove the fasteners connecting the bumper mounts to the frame. This requires removing one bolt from the bottom of the frame (22mm) and three bolts from the side of the frame (18mm and 15mm). Save hardware for reuse.
4. Remove OEM bumper by pulling it rearward away from the truck.
5. Remove OEM Spare Tire Access Cover from the OEM bumper. Set aside for reinstallation.





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I. Installation

1. Replace OEM bumper with the Black Steel rear bumper assembly. Use the OEM stud plate as well as the 3/8" bolts, washers, lock washers and nuts provided in the T1250-HW kit to fasten the bumper to the frame rail in the OEM mounting locations. Do not fully tighten
2. Use the provided spacers (may be in the hardware kit or welded to the bumper) to offset the bottom of the bumper from the hitch mounting flange. Fasten with the provided 9/16" screws, washers, lock washers, and nuts. Do not fully tighten
3. Level and align the bumper in relation to the truck bed. Fully tighten all fasteners.
4. Reinstall OEM 14mm screws connecting the hitch to the bottom of the frame with the 14mm nuts and washers in the T1250-HW fasteners kit.

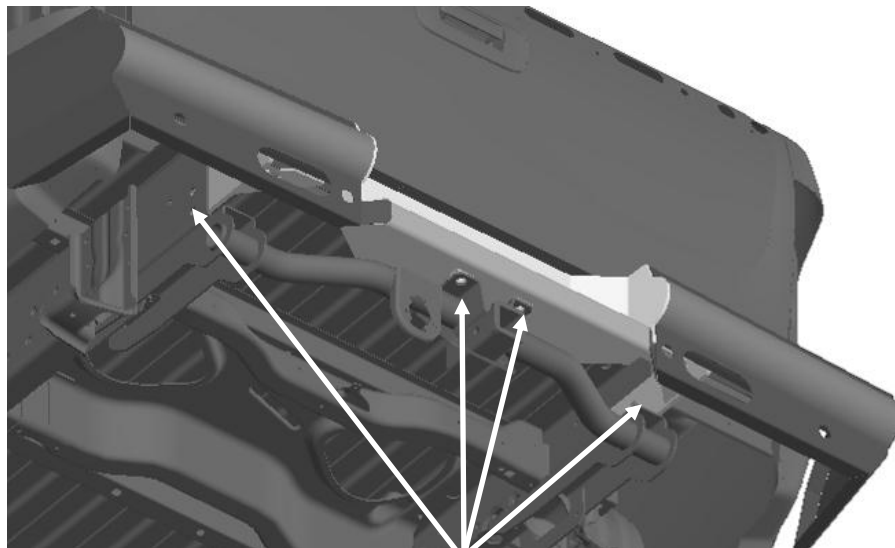


Figure 1 – Fastener Locations

5. Slowly lower the tailgate to ensure there will be no interference. If required, loosen the frame bolts / hitch bolts and adjust alignment of the bumper.
6. Install tag light into the 1 1/4" hole provided in the center section. The powder coating may need to be removed from the hole for proper grounding. Connect wire into the hot wire of OEM tag light circuit. Verify operation.
7. Reinstall license plate with provided plastic inserts



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8. Install grommets into sensor holes. If equipped, insert sensors from the back side. If not equipped, install provided plugs into the grommets.
9. Insert light grommets into oval cut-outs and press lights in from the front. Wire as desired.
10. Secure all loose wiring and harnesses to the frame or bumper with zip ties.

II. Maintenance/Care

- Periodically check and tighten all fasteners.
- Stripped, fractured, or bent bolts or nuts need to be replaced.