



Installation Instructions BX1639 GMC 2500 Van 2000

Serial No.

The front bumper and lower plastic fascia are removed for baseplate installation. All holes need to be drilled. Use Loctite with all bolts.



1. Remove the two bolts from the bottom of the bumper and remove bumper from vehicle.

4. Mark and drill the two bottom holes (1/2") for each bracket. Use the 1/2" hardware as shown on page 3.



2. Remove the Hex head screws from the plastic bumper fascia connecting it to the bumper.

5. Insert all wire nuts through the slot on the outside of each frame. Hand tighten only.



3. Hold the appropriate side bracket to the inside of the frame. Place the bracket butted against the lip of the bumper.

6. Once the bottom bolts are installed, drill the four inside bolts. Use 1/2" hardware as shown on page two. Hand tighten only.

Automatic



7. Once both pieces have been installed, bolt the main weldment to them using the 1/2" hardware as shown in the drawing on page 3. Once all bolts have been started tighten according to the chart in the General Instruction Sheet.
8. Replace the main bumper.



9. Hold the plastic fascia piece up to attachment tabs and mark area needed to be trimmed so it can be replaced to its original position.

Tools Required

Loctite
21mm Wrench

10mm Wrench
1/2" Drill Bit

3/4" Wrenches
Utility Knife

Parts List

Ref. No.	Qty.	Part No.	Description
1	1	61-5523	Weldment, Base Plate, BX1639
2	1	61-5524	Weldment, Bracket, DS, BX1639
3	1	61-5525	Weldment, Bracket, PS, BX1639
4	20	201-0051	1/2-13 x 1 1/2 Bolt, Hex Grd. 5, ZP
5	20	203-0012	1/2 Lock Washer, ZP
6	8	202-0005	1/2-13 Nut, Hex, ZP
7	12	61-4029	1/2-13 Whiz Nut, ZP, With 10 Inch Wire

