



Installation Instructions

Yukon XL 1500 Winch Bumper

Product Number: H2340-H2342
Application: '07-'12 GMC Yukon XL 1500

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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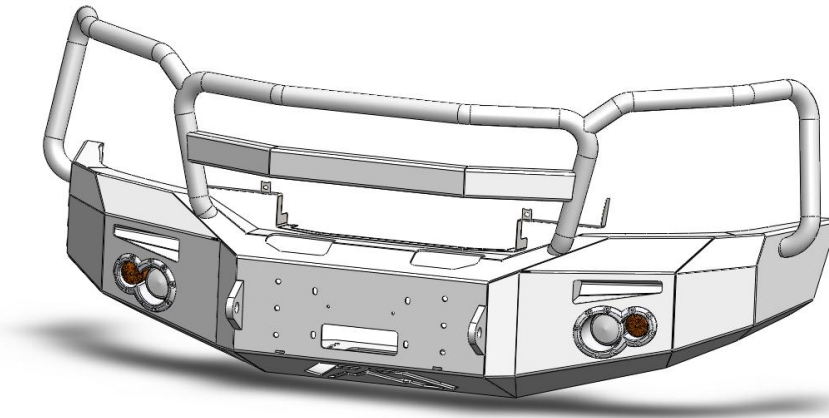
I. Overview

Congratulations on your purchase of the industries' best and most stylish GMC Yukon XL Winch Bumper! This bumper has been **engineered** for strength while keeping the weight down. It can accept the Warn 12K winch... and look cool doing it.

This product has also been **engineered** to allow alignment in three directions so you will end up with a very professional fit.

Your bumper was designed in 3-D, fabricated, and powder coated... all in the U.S.A.

Enjoy the fit and finish of a quality GMC Yukon XL Winch Bumper from Fab Fours Inc!





Installation Instructions









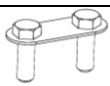



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II. Tools Required

- | | |
|--|---|
| <ul style="list-style-type: none"> <input type="checkbox"/> Multi meter or circuit test light <input type="checkbox"/> Socket Wrench With Extensions <input type="checkbox"/> 5/32" and 1/8" Allen Wrenches <input type="checkbox"/> 3/4", 7/32", 7mm, 10mm, and 19mm Socket, 22mm deep socket | <ul style="list-style-type: none"> <input type="checkbox"/> Needle Nose Pliers <input type="checkbox"/> 19mm, 3/4", and 3/8" Open End Wrench <input type="checkbox"/> Phillips Screwdriver <input type="checkbox"/> #3 Square driver <input type="checkbox"/> Drill with 3/8" bit <input type="checkbox"/> Air saw or Rotary tool |
|--|---|

III. Package Contents

	QTY	DESCRIPTION	FAB FOURS PART NUMBER
	x 1	GMC Yukon XL Front Bumper	H235X-B
	x 1	Yukon XL Driver Mounting Bracket	20244
	x 1	Yukon XL Passenger Mounting Bracket	20245
	x 1	Grille Remounting Bracket	20371
	x 1	Driver Fog Light Mounting Bracket	20318-08
	x 1	Passenger Fog Light Mounting Bracket	20318-09
	x 2	Fab Fours Fog Light	61349
	x 2	Fab Fours Running light, Turn indicator	61350
	x 4	Stud Plate	20296
	x 1	HDLA Hardware Kit	HDLA-HW
	x 1	H235X Hardware Kit	H235X-HW
	x 1	H235X Instruction Manual	H235X-IM



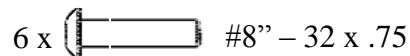
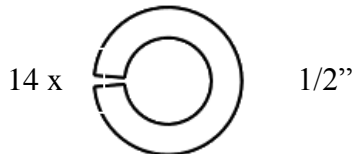
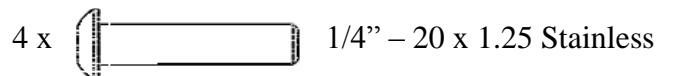
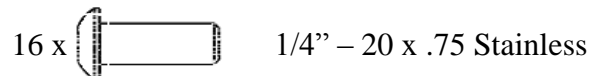
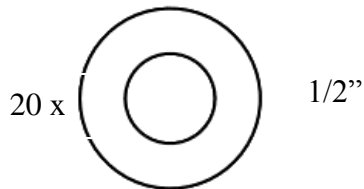
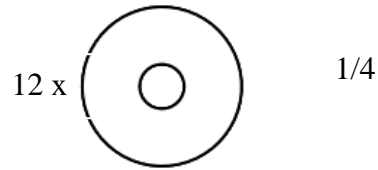
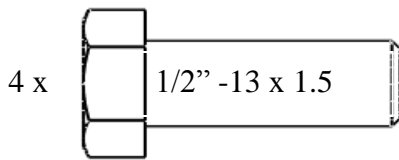
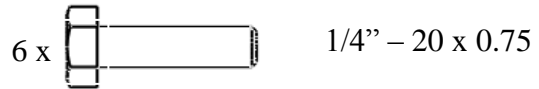
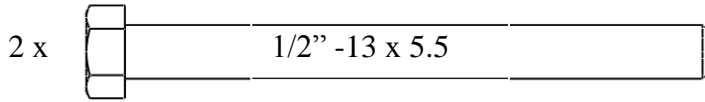
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Bumper Hardware

HDLA Hardware





Installation Instructions Yukon XL 1500 Winch Bumper

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Vehicle Preparation

1. Remove two (2) plastic push clips with a small screwdriver or plastic rivet removal tool, and two (2) screw fasteners with a 7mm socket and ratchet from the front of each wheel well as shown below:

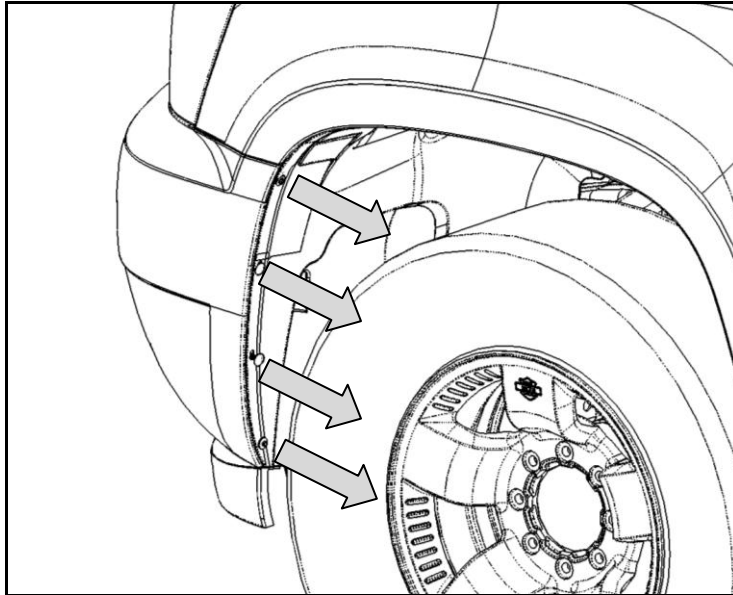


Figure 1 - WHEEL WELL FASTENER LOCATIONS

2. Remove the two screw fasteners attaching the plastic bumper cover to the truck from underneath with a 10mm socket. Repeat for other side. See image below for location:

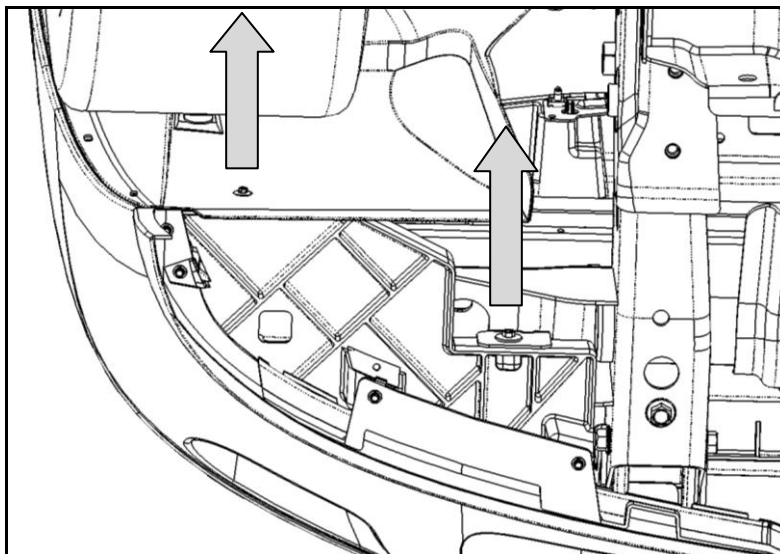


Figure 2 - LOWER FASTENER LOCATION - VIEW FROM BELOW



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3. Open the hood and remove the six (6) fasteners attaching the bumper and grille to the radiator core support with a 10mm socket :

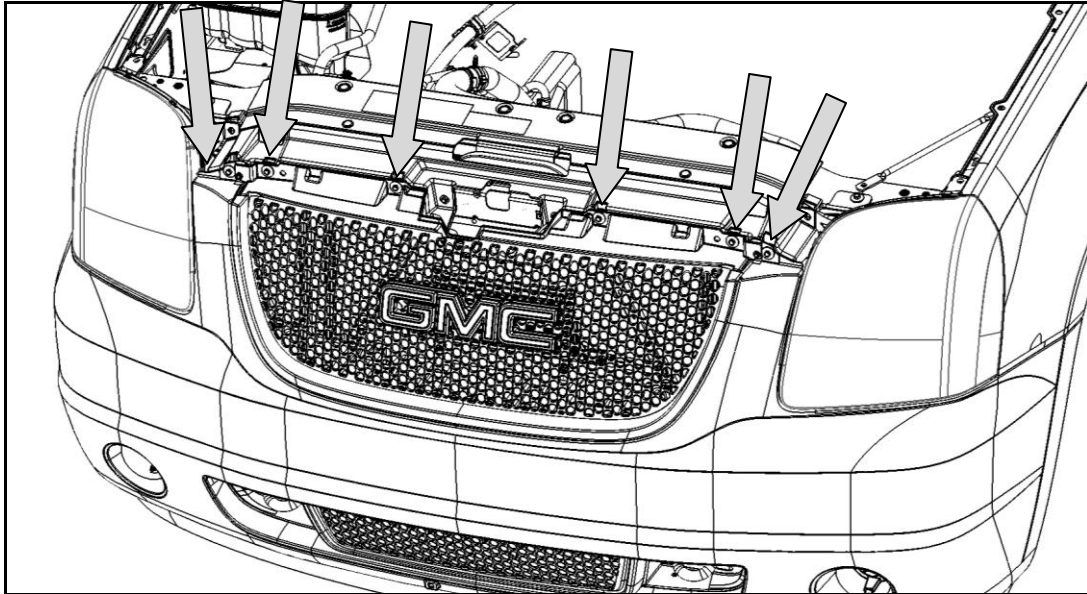


Figure 3 - GRILLE FASTENER REMOVAL

4. Reaching behind the bumper cover at the outer corner, firmly pull the cover outward to release it from the fastening clips. Repeat for other side

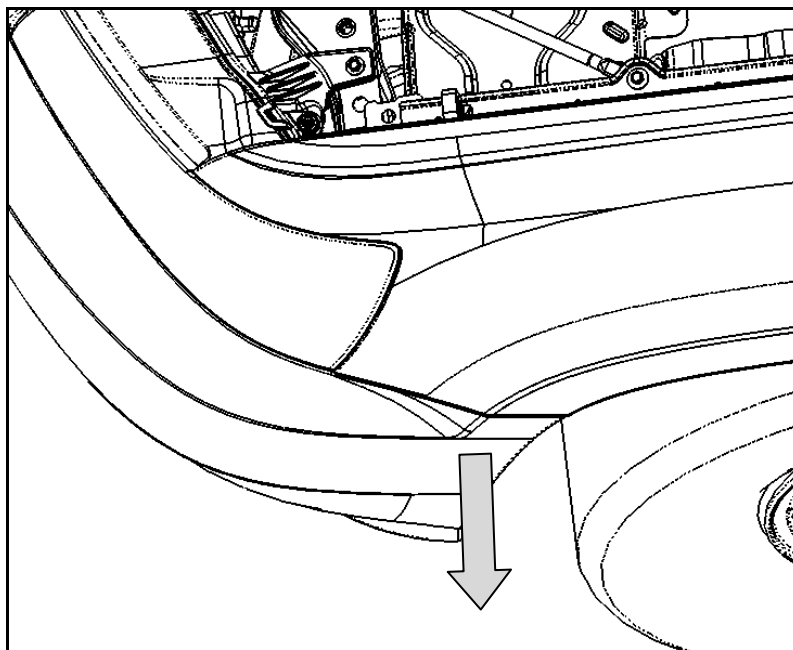


Figure 4 - CORNER CLIP RELEASE



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5. Pull forward on the bumper cover to remove it from the truck.

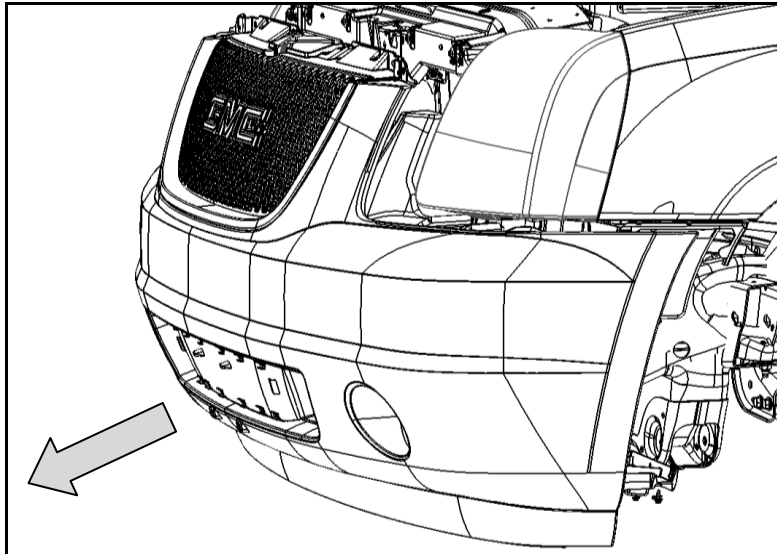


Figure 5 – BUMPER COVER REMOVAL

6. If your vehicle is equipped with fog lights, the wiring harness must be disconnected from both lights before the bumper cover can be set aside.
7. Set the bumper cover aside. This part will later be modified to re-fit the grille with your new Fab Fours heavy duty bumper.
8. Remove the bumper cover clipping brackets from the bottom of the fenders with a 10mm socket:

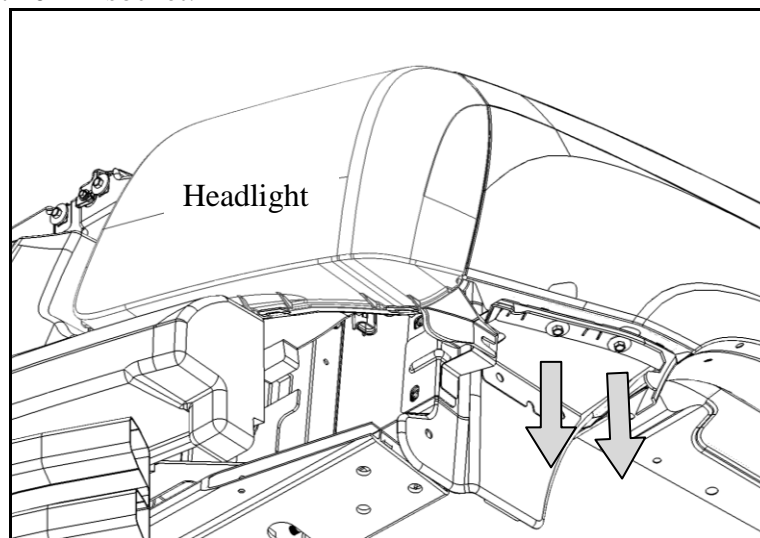


Figure 6 - CLIPPING BRACKET REMOVAL



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9. With a 22mm socket and breaker bar, loosen the two main push bar mounting screws. Pull the push bar forward away from the truck:

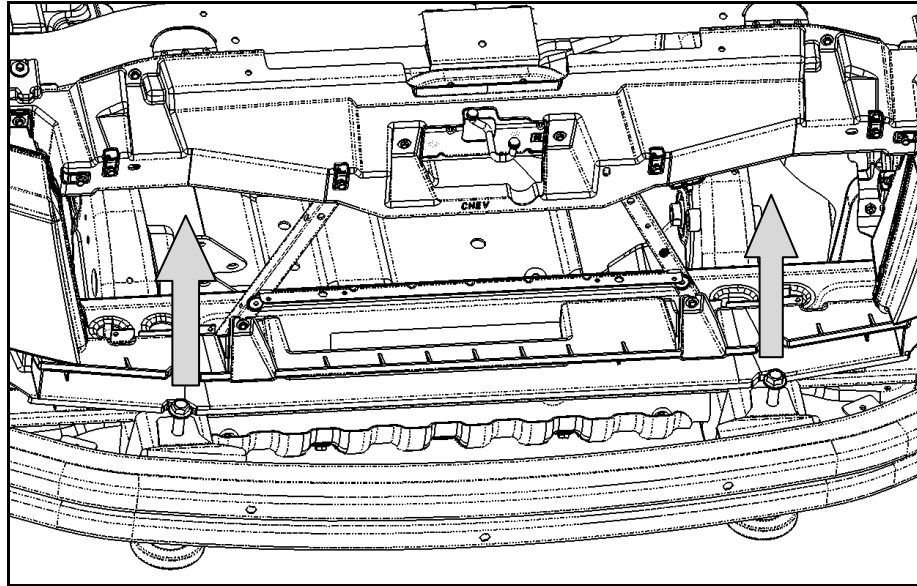


Figure 7 - PUSH BAR MOUNTING SCREWS

10. Use a ratchet, 19mm socket, and 19mm wrench to remove the tow hooks from inside the frame ends:

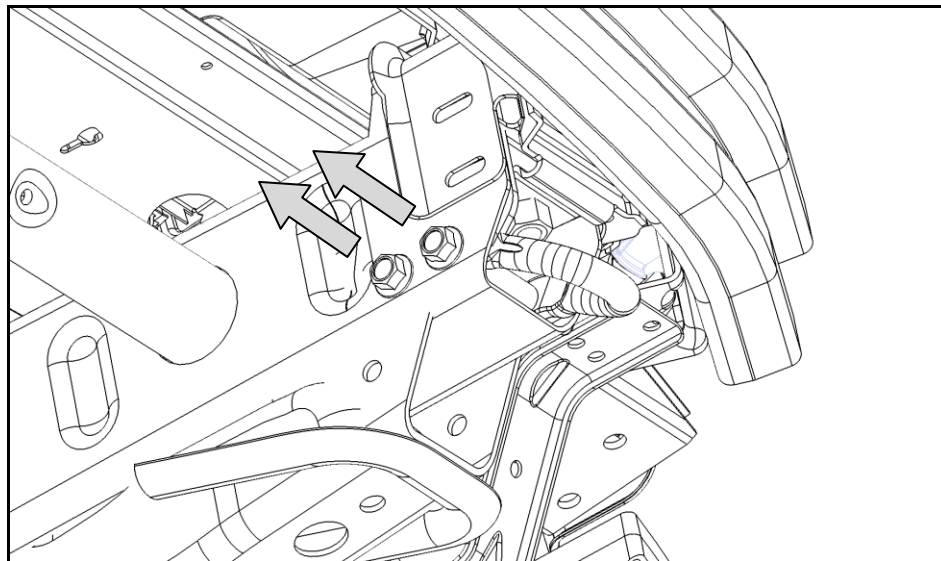


Figure 8 - TOW HOOK REMOVAL



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11. Use a ratchet and 10mm socket to remove the headlight to access the turn indicator wiring; Remove the two top fasteners and loosen the outer fastener. Repeat for both sides.

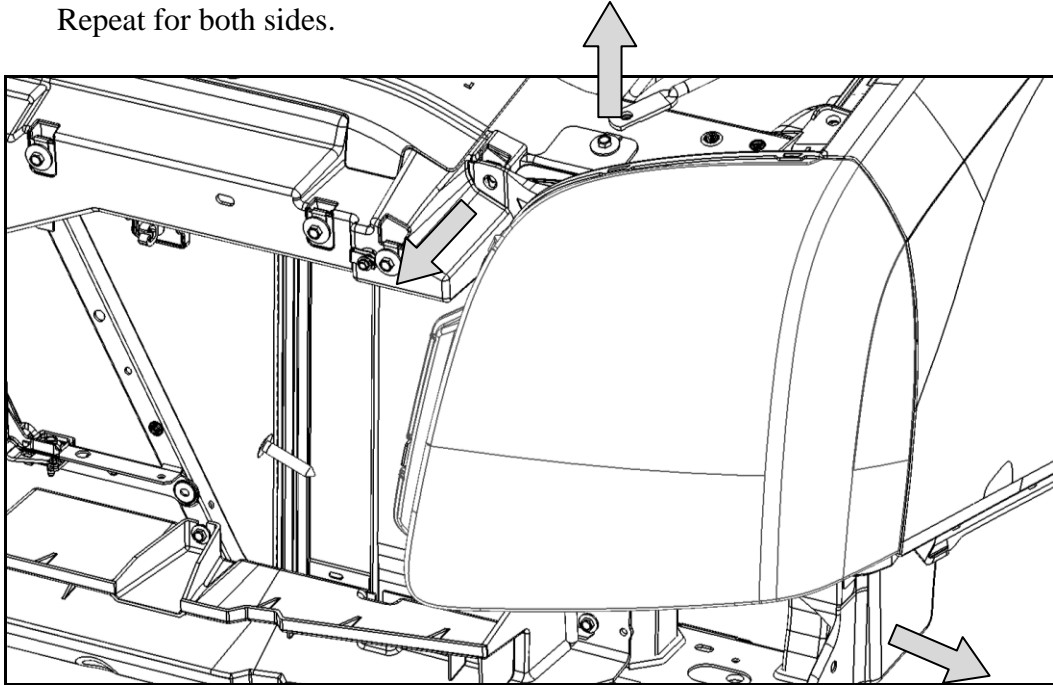


Figure 9 – HEADLIGHT REMOVAL

12. The disassembly of the vehicle is now complete. Proceed to the Grille Modification section of this instruction manual to prepare the OEM grille to fit with your Fab Fours bumper.



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IV. Grille Modification

NOTE: Reinstalling the OEM grille section with your Fab Fours bumper requires you to cut the bumper cover and grille surround into separate pieces. **READ THIS ENTIRE SECTION CAREFULLY BEFORE PROCEEDING.** Failing to do so may affect the quality of the final installation of your bumper.

1. Remove the grille insert by careful pressing the plastic tabs inwards, allowing them to be pulled from the bumper. Using a small flat blade screwdriver or similar tool can be useful when loosening the tabs.

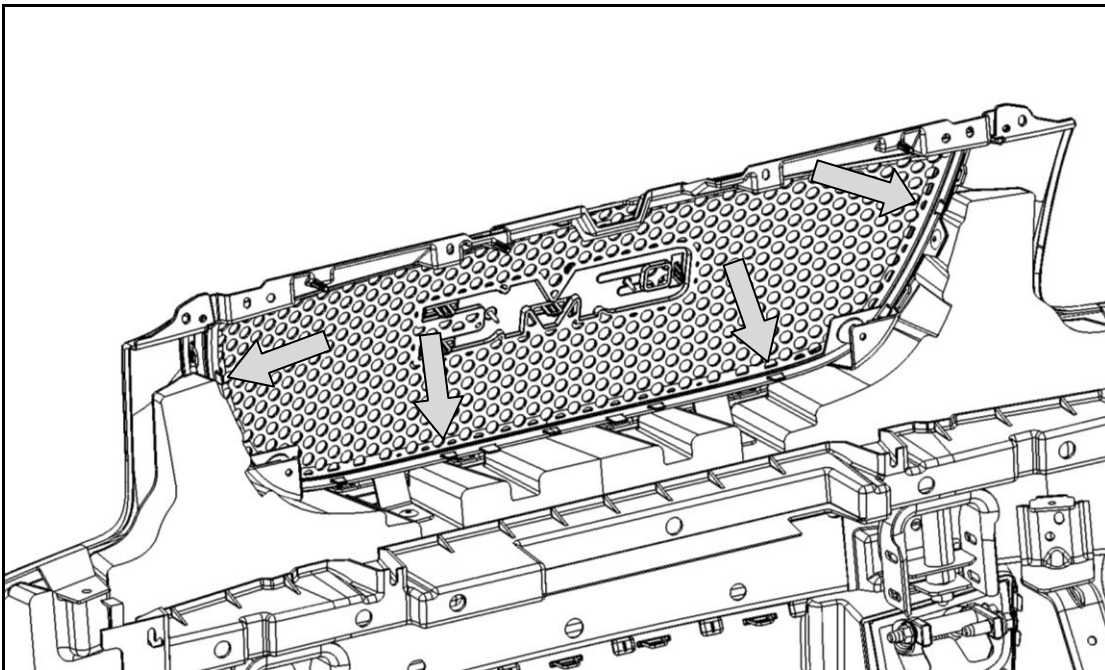


Figure 10 – GRILLE PANEL TAB REMOVAL



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2. Remove the foam core support from the bumper cover by unscrewing the six (6) self-tapping plastic screws with a #3 square drive bit.

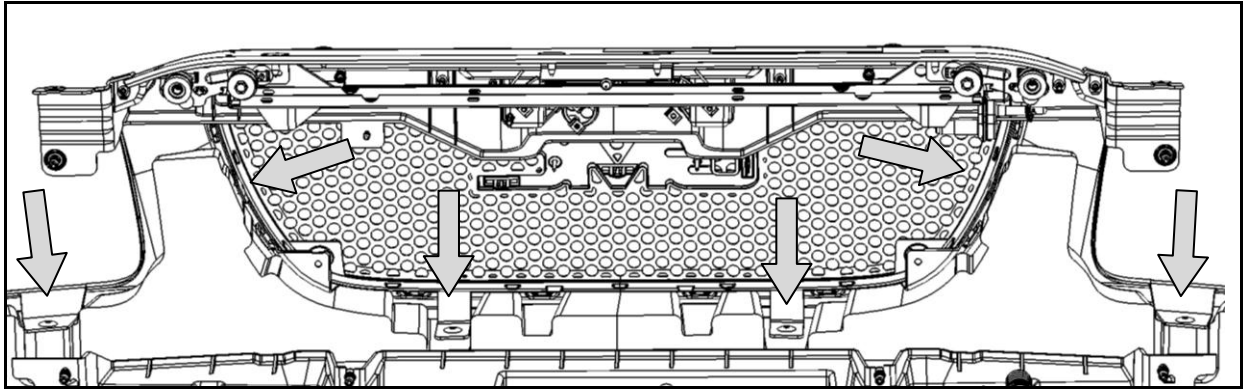


Figure 111 - FOAM FASTENER REMOVAL

3. Attach the Fab Fours provided grille mounting bracket to two center foam mounting holes as shown below. Use the 1/4" hardware with nyloc nuts and fender washers

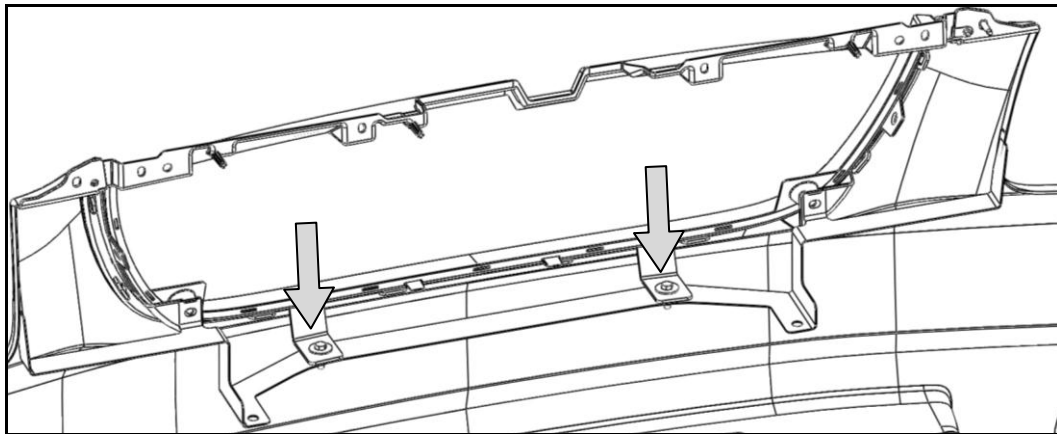


Figure 122 - BRACKET ATTACHMENT - VIEW FROM REAR, ABOVE

4. Drill through the bumper face at the outer mounting holes with a 3/8" drill bit to allow the remaining 1/4" hardware to be fitted:

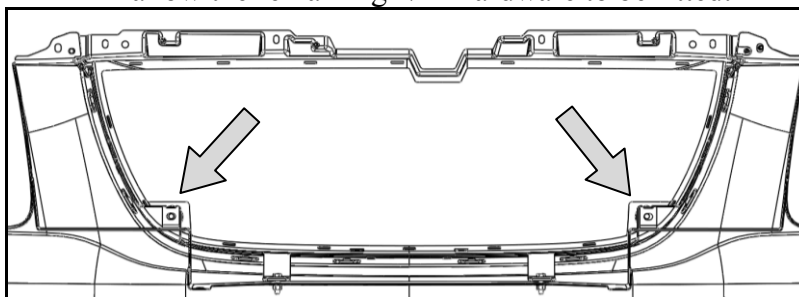


Figure 133 - DRILLING LOCATIONS - VIEW FROM INSIDE



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5. Fasten the grille bracket at the drilled holes at the outside of the bracket with ¼” screws, fender washers, and nyloc nuts.
6. With a body saw or rotary tool, cut the bumper section off of the grille, following the existing body line (See Bold line on image below). Be very careful when trimming not to damage the paint on the grille. The bumper section will not be reused.

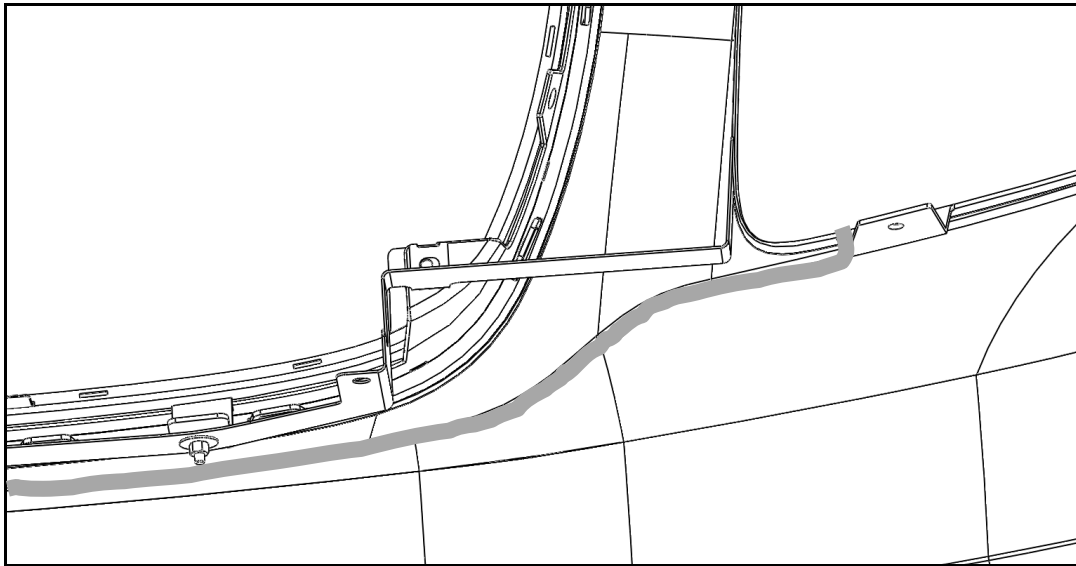


Figure 144 - TRIM LINE -VIEW FROM REAR, BELOW

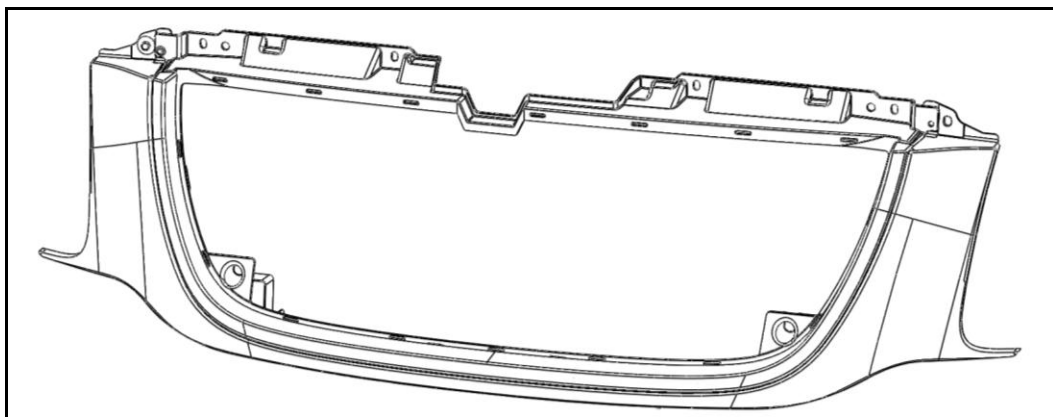


Figure 155 - TRIMMED GRILLE

7. The grille surround is now ready for the installation process with your new Fab Fours bumper. Do not reattach the grille insert to the surround at this time. Proceed to the Lights and Wiring section to complete the electrical installation of your Fab Fours bumper components.



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V. Lights and Wiring Installation

1. With the headlights removed, tap into the turn indicator wiring with the supplied tap connectors.
2. The turn indicator wiring harness may be installed at this time. To do so, remove the wiring harness and bulb socket from the lens housing. See below for wire color guide.

WIRE COLORS:

	<u>WIRE</u>	<u>OEM COLOR</u>	<u>FAB FOURS COLOR</u>
TURN SIGNALS	Running	Brown	→ White
	Turn	White/Blue (Pass)	→ Red
	Ground	Black	→ Green
FOG LIGHT	Power	Purple	→ Red
	Ground	Black	→ Green

3. Tuck the Fab Fours provided wiring and bulb out of the way until the installation of the Fab Fours bumper is complete.
4. Replace headlights in reverse order of removal. Be sure to route newly installed Fab Fours wiring away from sharp edges down to the bumper area.
5. Tap into OEM fog light harnesses on each side of the vehicle using two supplied tap connectors.
6. Connect the supplied fog lamp wiring harnesses to tap connectors following wire color guide above.
7. Tuck OEM fog light harness and Fab Fours supplied wiring out of the way until completion of the bumper installation.



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8. Install turn indicators into the plastic light insert using three self-tapping screws as shown below:

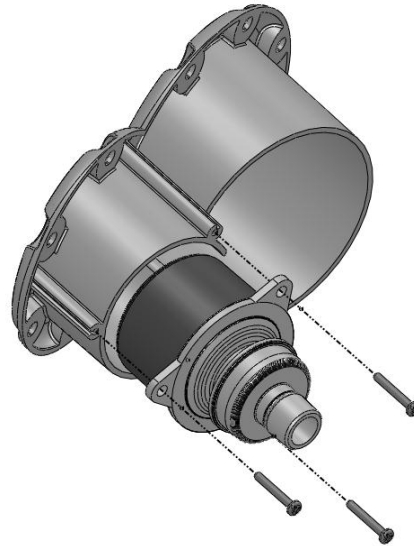


Figure 166 – Turn Signal Installation

9. Install the light inserts with turn indicators into the cutout in the bumper. Use the $\frac{3}{4}$ " length $\frac{1}{4}$ " stainless steel button head, $\frac{1}{4}$ " washers and hex nuts to fasten the insert through the holes shown below. Do not use the two holes closest to the center of the bumper at this time. Use washers only on the nut side (inside the bumper). Use needle nose pliers to tighten nuts with limited access.

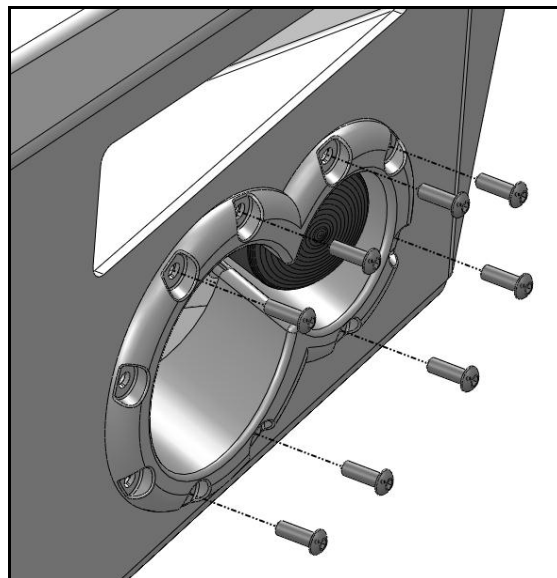


Figure 177 – Light Insert Installation



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10. Install the Fab Fours fog lights onto the mounting brackets as shown below using the #8 button head screws, washers, and nylock hex nuts.

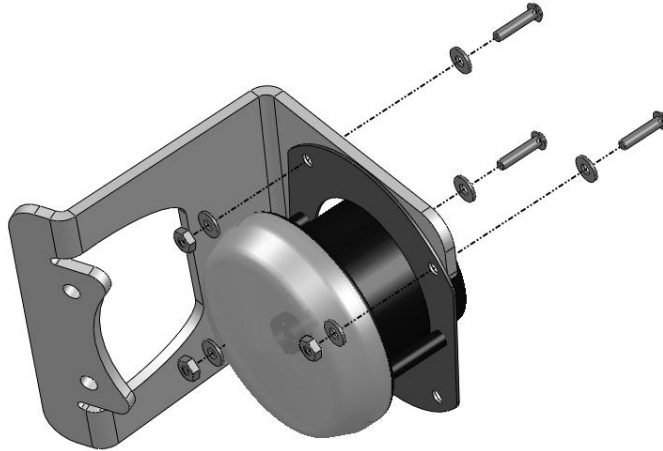


Figure 188 - Fog Light to Bracket Installation

11. Install the fog light and bracket into the bumper using the remaining two holes available in the light insert. Use the 1-1/2" length 1/4" stainless steel button heads with 1/4" washers and nylock nuts:

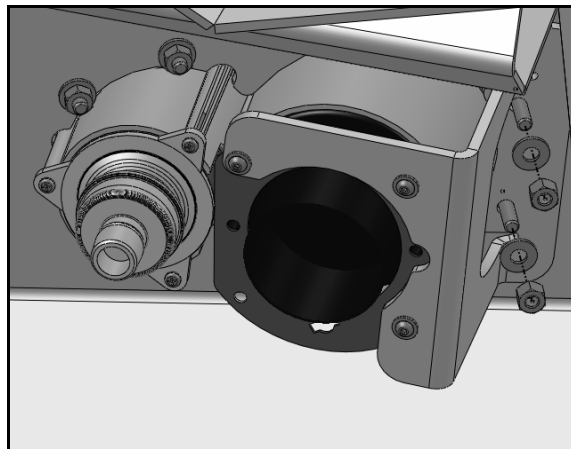


Figure 19 - Fog Light Installation

12. Repeat steps 7-10 for other side.

❑ Do not connect wiring harnesses to lights until bumper is installed.



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VI. Bumper Installation

- **Optional:** If installing winch and roller fairlead into bumper, do it at this time. Follow the winch manufacturer's instructions for installation. If you are installing a winch with a pulling capacity of 12,000 lbs., the front face mounting holes must be used.

If not installing a winch, a license plate may be installed onto the front face of the bumper (Hardware not included).

1. Install intermediate mount onto the frame rail using bolts, washers, lock washers and nuts provided in the hardware kit. Use the 5.5" bolts in the OEM push bar mounting location (shown in the top view) and the 1.5" bolts in the tow hook mounting holes (Shown in bottom view). The offset portion of the bracket should face the outside of the truck. **DO NOT FULLY TIGHTEN**, repeat for other side.

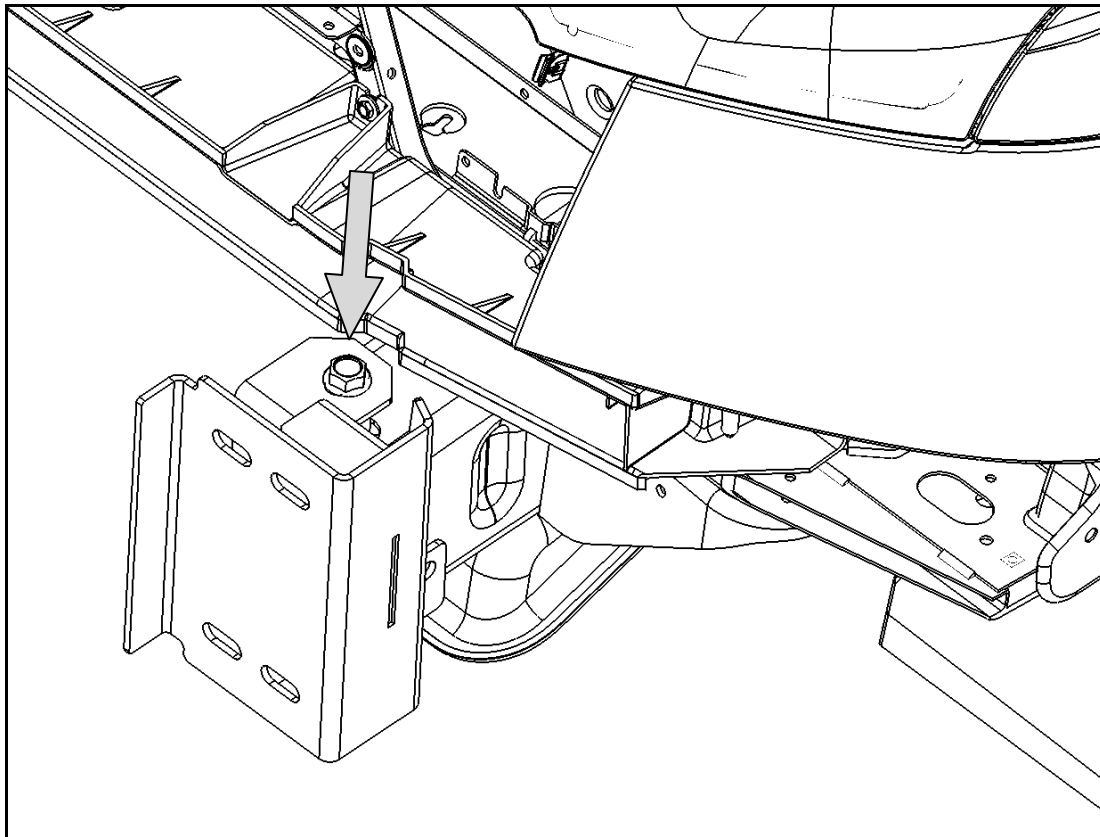


Figure 20 – INTERMEDIATE BRACKET INSTALLATION – TOP VIEW



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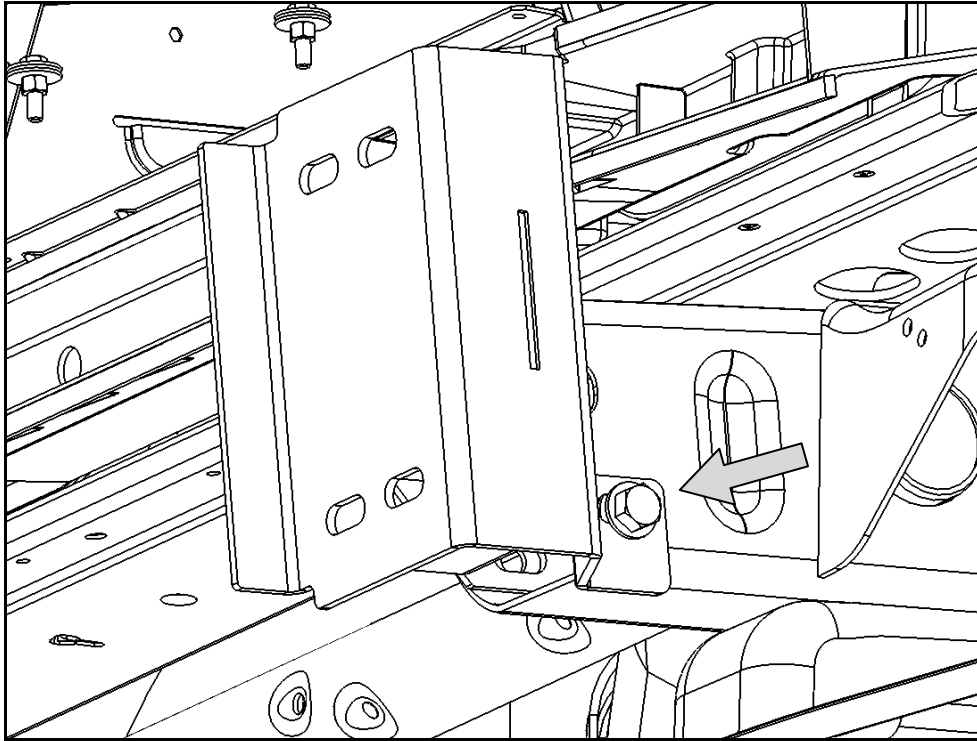


Figure 191 - INTERMEDIATE BRACKET INSTALLATION - BOTTOM VIEW

2. Refit the modified grille surround to the bumper, locating the Fab Fours provided grille mounting bracket onto the top of the foam core support shell housing. Reattach it at the top corners with the OEM screws and align the outside edges with the surface of the headlight. Drill through the support shell with a 3/8" bit to mount the lower mounting bracket as shown below. Attach with provided 1/4" bolts, fender washers, and nyloc nuts.

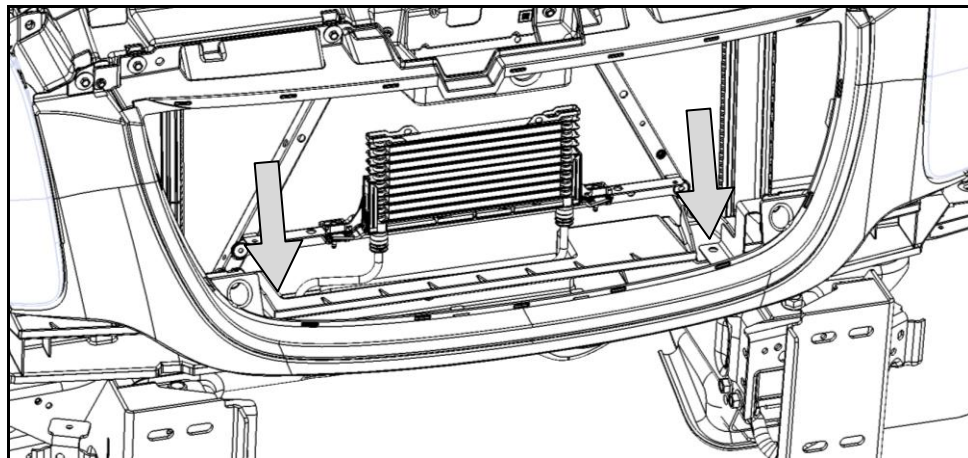


Figure 202 - DRILLING LOCATIONS



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3. Insert the studs into the slots on the mounting brackets from the back side as shown below:

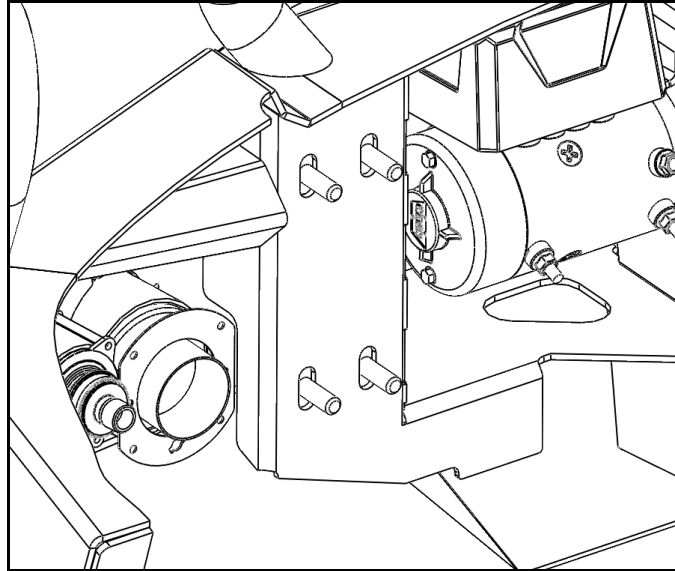


Figure 213 – STUD PLATE ORIENTATION

4. With the help of others or a lifting device, lift and align the bumper mounts with the frame mounts. With the bumper fully supported, install four nuts, washers, and lock washers per side onto the studs from underneath the vehicle. **DO NOT FULLY TIGHTEN**



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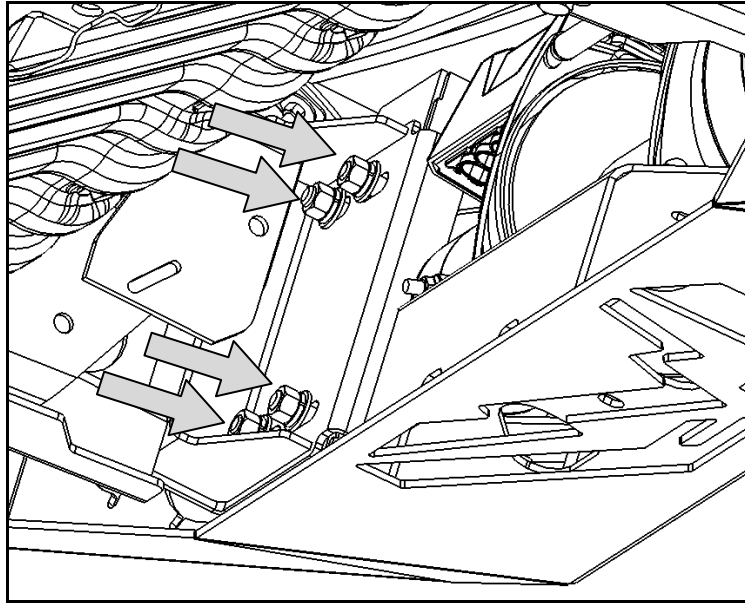


Figure 224 – BUMPER ATTACHMENT – VIEW FROM BOTTOM

5. Adjust the bumper to achieve good visual alignment as follows:
 1. Adjust in/out bumper alignment with mounting bracket to frame hardware.
 2. Adjust up/down and left/right alignment with bumper to mounting bracket hardware

NOTE: Fab Fours recommends a **MINIMUM** gap of 3/8” at the outer fenders and headlights to prevent paint damage in normal operation.

6. Tighten all fasteners fully; beginning with frame mounts. Then tighten all mount-to-bumper fasteners.
7. **OPTIONAL:** Trim the inner fender liners to match the higher clearance of your Fab Fours bumper. This can be done with a body saw, rotary tool, or sharp utility knife (New blade strongly recommended). **USE CAUTION WHEN PERFORMING ANY CUTTING OPERATION TO PREVENT VEHICLE DAMAGE OR PERSONAL INJURY.**
8. **OPTIONAL:** Hardware and mounting provisions are provided to reattach the inner fender liner to you Fab Fours bumper if desired. It is recommended that vehicles that perform in severe duty environments or spend a significant amount of time off-highway that the inner fender liner **NOT** be attached to the Fab Fours bumper, as it may cause damage to the inner fender liner mounting due to chassis flex.



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9. Connect wiring harnesses to lights as shown in wiring diagram.
10. Verify proper operation of lights. **Note:** Turn indicators should be dim during “running” condition and flash bright for turn.

VII. Maintenance/Care

- Periodically check and tighten all fasteners.
- Stripped, fractured, or bent bolts or nuts need to be replaced.
- Keep all surfaces free of dirt, road grime, and standing water to ensure finish longevity.



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More than expected... Better than expected