



Installation Instructions

Ford Raptor Vengeance Tube Front

Product Number: D4371, D4372
Application: 2017+ Ford Raptor

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 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 new purchase of the industries' best and most stylish front bumper available for the 2017 Ford Raptor. This bumper has been designed to be lightweight and easily customized with the industry's highest quality accessories.

Your front bumper designed in 3-D from digitized data, CNC laser cut, fabricated, and powder coated... all in the U.S.A.

Enjoy the fit and finish of a quality Vengeance Ford Raptor Front Bumper from Fab Fours Inc.





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Parts List

- D437X replacement bumper
- 50103-HW fastener kit
- Instruction manual

Tools Required

- Socket wrench with extension (ratcheting wrenches may also be convenient)
- 8mm, 11mm, 13mm, 15mm, 21mm, 9/16 and 5/8" sockets and box end wrenches
- E6 External torx socket
- Flat head screw drivers
- Floor jack and wood block.

II. Removal of OEM Bumper

Note: Save all OEM parts until installation is complete!

- A. From underneath the front of the truck remove the six (6) fasteners attaching the OEM skid plate to the truck with a 13mm and 15mm socket. And set aside along with metal spacer at back of skid plate; see below:





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- B. Using a flathead screwdriver, carefully remove center plastic piece, indicated by oval in the center of the OE bumper.



Figure 1a



Figure 1b

- C. Using 21 mm socket, remove the three nuts per side, two are located under the plastic center piece (ref. fig. 2a-b) and the third accessible from the back of the frame (ref. fig. 2c). If front OEM bumper contains sonar (ref. fig. 2b), remove three nuts with 11 mm. If your bumper includes a radar device, remove it now using an E6 external torx socket. Unplug the device.





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Figure 2a



Figure 2b



Figure 2c

- D. Remove two 8mm bolts one per side that hold on the bumper side support bars from the truck side leaving the support bars attached to the bumper.**
- E. At this time, carefully pull away bumper and remove the rubber shroud connectors along the top.**
- F. Pull rubber covers off the tow hooks.**





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- G. If your vehicle model includes a louver system for the intercooler located between the frame mounts, the shroud must be removed. Special care must be taken not to damage louvers when cutting around the base of the rectangular shroud, a cut off wheel is recommended.



Figure 4 (Louver w/ shroud cut away at base)





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III. Pre-Installation

NOTE: The following installation steps apply to the installation of the front bumper. **PLEASE READ THE ENTIRE MANUAL BEFORE ATTEMPTING INSTALLATION.** Ignoring these steps will increase your probability of scratching the vehicle during product installation.

- A. **Remove the bumper from the shipping carton. Lay all items out on a blanket to prevent damage to the powder coating.**
- B. **If you are installing aftermarket lights, do the wiring for those now and install them into the bumper. (But don't plug them in until after bumper install)**





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IV. Front Bumper Installation

- A. Use painter's tape to tape off the valence of your truck to help prevent scratching the paint.
- B. Using the supplied hardware, the provided nut plates (21271) and a 5/8 socket, mount the bumper to your truck but do not fully tighten. There will be 6 bolts. The nut plates can be installed by going over the frame as shown below.



- C. Adjust the height of the bumper to the truck and tighten the bolts. (Fab Fours recommends 1/4 profile gap.)
- D. Re-install factory skid plate using OEM hardware, and supplied spacers if necessary to ensure the skid plate is not rubbing the bumper.
- E. Enjoy your new Front Bumper from Fab Fours!





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Maintenance/Care

- Periodically check and tighten all fasteners.
- Stripped, fractured, or bent bolts or nuts need to be replaced.
- After washing of the vehicle make sure to fully dry all surfaces

V. Contact Information

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