



INSTALLATION MANUAL
VENGEANCE REAR BUMPER
PRODUCT NUMBER: E5951
APPLICATION: 2023 FORD SUPER DUTY



IMPORTANT SAFETY GUIDE | Your safety and the safety of others is very important.

In order to help you make informed decisions about safety, we have provided the following warnings, safety precautions, installation instructions, and other important information to 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. Use own good judgment and take your time.

Check packaged materials immediately upon arrival to ensure that all listed parts are included and undamaged.

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

SENSORS FIELD OF VIEW MAY BE ALTERED WITH USE OF THE REPLACEMENT BUMPER.

WARNINGS

- Failure to observe the following warnings and instructions provided in this manual could lead to severe injury and/or death.
- For professional installation only. Careless installation and/or operation can result in serious injury, death, and/or equipment damage. All liability for installation and use rests with the user or consumer.
- Fab Fours, Inc. only approves installing this product according to these written instructions with the hardware provided. Failure to install according to these instructions will invalidate the warranty. This includes, but is not limited to, using alternative installation methods, hardware, or materials.
- This product is for off road use only.

SAFETY PRECAUTIONS

- 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 ensure 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 a vehicle. Always disconnect power before welding. Thoroughly inspect the area to be drilled (on both sides of material when possible) prior to drilling, and relocate any objects that may be damaged.
- Always use extreme caution when welding a vehicle. Thoroughly inspect the area to be welded (on both sides of material when possible) prior to welding, and relocate any objects that may be a fire hazard. When welding in a cab, make sure the interior surfaces are covered (e.g., welding blanket) and a fire extinguisher is at hand.
- 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.
- Perform regular inspections and maintenance on mounts and hardware.

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A MESSAGE FROM THE FOUNDER



Fab Fours' was born out of a passion for customizing vehicles and a love of the outdoors. Our engineering team uses the latest 3D design software to turn new product ideas into reality. In our factory, designs come to life with the combination of cutting edge technology for metal cutting and forming and an American workforce that puts its' heart and pride into every product.

From design and manufacturing, to quality and delivery, Fab Fours' mission is to be the market leader for steel truck and jeep accessories. We make sure a quality product is delivered on time, more than expected, better than expected to our customers.

Enjoy your new Fab Fours product. Welcome to the family!

Greg Higgs

FOUNDER, FAB FOURS

GETTING STARTED

Before you begin the installation process of your new Fab Fours product, we suggest laying out all materials and parts on a pad or protective surface.

Failure to fully account for all components before beginning installation may leave vehicle immobile until part is acquired. Refer to the next pages as an inventory check.

PROVIDED MATERIALS



23079 - E5951 REAR BUMPER



20217-15 - SPACER

61648 - LIGHT STRIP

61632 - EPOXY (QTY 2)

TOOLS REQUIRED

- 21MM SOCKET WRENCH
- 13MM SOCKET WRENCH
- 15MM SOCKET WRENCH
- 24MM SOCKET WRENCH
- FLAT HEAD SCREWDRIVER

ASSISTANCE

We recommend two people perform the installation as items are heavy and may need to be held in place while installing.

ORGANIZATION

Disassemble the vehicle where you can catalog and store everything. We suggest labeling and bagging all the OEM bolts when removing from the vehicle. Failure to keep track of parts could lead to an inability to properly reinstall components.

HARDWARE KIT | TXX50-HW

IDENTIFICATION NUMBER	COMPONENT DESCRIPTION	QTY
TXX50-HW	1/2" LICENSE PLATE NUT	2
TXX50-HW	1-3/8", GROMMET, PLASTIC, MM9307K81	4
TXX50-HW	ROUND BLACK PLASTIC PLUG	4

DISASSEMBLY

1. Locate trailer plug and main wire harness plug behind rear bumper and disconnect. (Figure 1)



Figure 1

2. Using 13mm socket wrench, remove two (2) bolts located on either side of receiver hitch tube. (Figure 2)



Figure 2

3. Using 21mm socket, unbolt OEM bolts from bumper (two per side) and remove bumper from truck. (Figure 3)



Figure 3

4. Remove OEM bracket by using 24mm socket to remove three (3) M16 bolts from vehicle frame. (Figure 4)



Figure 4

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5. Remove OEM bumper support by using 15mm socket to remove two (2) M10 bolts from vehicle hitch. (Figure 5)



Figure 5

6. Remove the tag lights from the OEM bumper by depressing the three (3) tabs and then unplugging the wiring harness by depressing the tab on the connector. Note the orientation in which the light is removed. It will be reinstalled in the same location and orientation into the new bumper. (Figure 6)



Figure 6

7. If equipped, remove the sensor from the sensor housing by expanding both sides of the sensor housing and lifting. (Figure 7-8)

NOTE: Sensors are extremely delicate and must be handled with care! Do not push on face of sensors to remove!

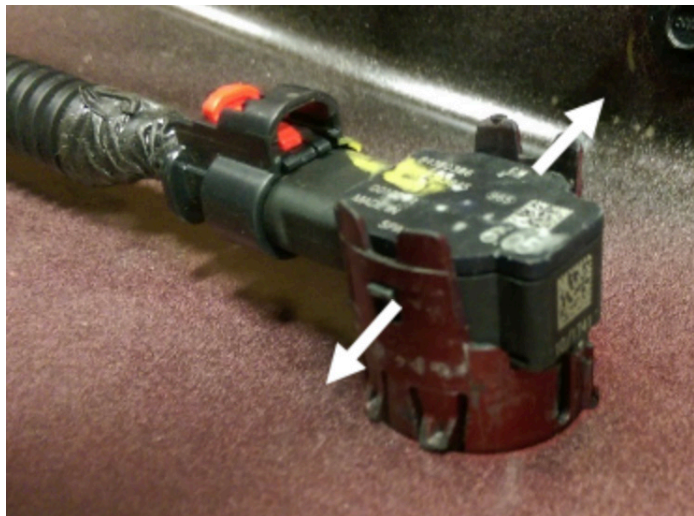


Figure 7

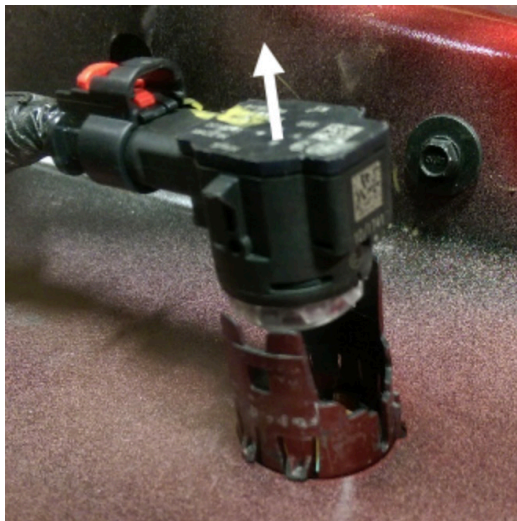


Figure 8

8. Remove the sensor housing from the bumper by depressing the tabs while pulling outward from the outside of the bumper. (Figure 9-10)

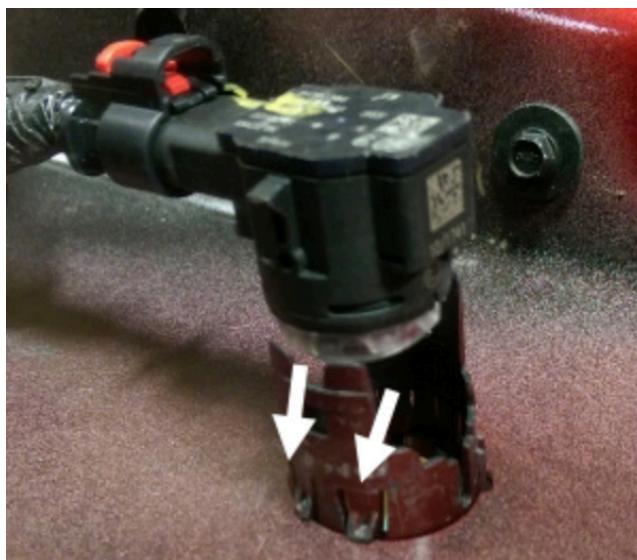


Figure 9



Figure 10

INSTALLATION

9. Reinstall sensor housings into new bumper in the same position and orientation which they were removed. Use provided epoxy to secure housings into bumper. (Figure 11)

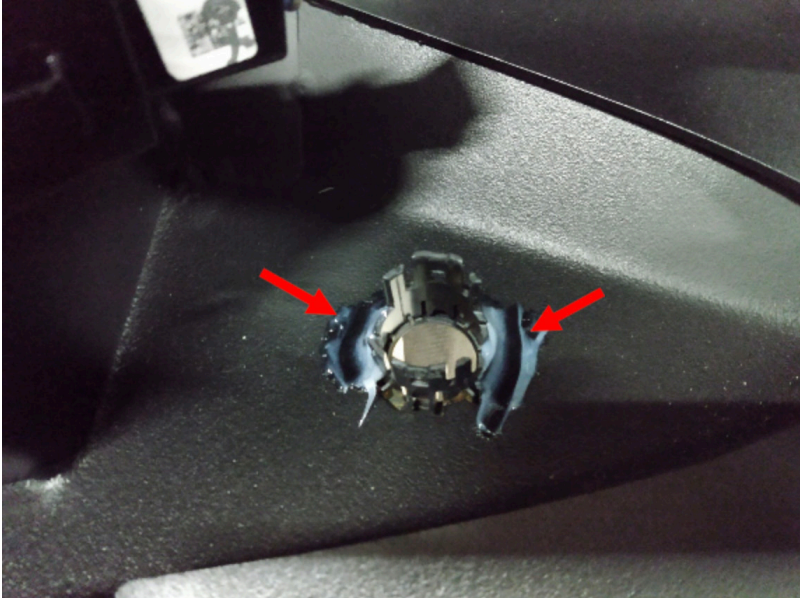


Figure 11

10. Once epoxy has dried, install sensors into housings and plug in harness to sensors. (Figure 12)



Figure 12

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11. Reinstall the tag lights into the new bumper in the same position and orientation that they were removed from the OEM bumper. Push the lights into the holes to the sides of the center step until the locking tabs engage. (Figure 13)



Figure 13

12. Reinstall trailer plug into the new bumper. While holding in place, use straight screwdriver to pry clips outward until they slip over bumper shell. (Figure 14)



Figure 14

13. If desired, the provided LED strip light can be installed inside the bumper shell to backlight the Fab Fours logo cutout. If installing the light, tap the LED strip light wiring into the tag light wiring. Light wiring is not polarity dependant.

14. Using the provided epoxy, attach the provided spacer (Part#: behind the spare tire access lock. (Figure 15)



Figure 15

15. With assistance, hold the new bumper (Part#: 23079) up to the vehicle and reinstall the previously removed hardware from the side of the frame rails. (Figure 16)



Figure 16

16. Using a 24mm socket wrench and a 15mm socket wrench, tighten the bumper mounting hardware installed in the previous step while aligning the bumper with the vehicle.

17. Reconnect the trailer plug electrical connector. (Figure 17)



Figure 17

18. Reconnect the wiring harness to the vehicle. (Figure 18)



Figure 18

INSTALLATION COMPLETE

CONTACT INFORMATION

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**“IF YOU’RE LOOKING FOR MORE OF THE SAME,
THEN YOU’VE COME TO THE WRONG PLACE.”**

- GREG HIGGS

