



INSTALLATION MANUAL
PREMIUM REAR BUMPER
PRODUCT NUMBER: W5951
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

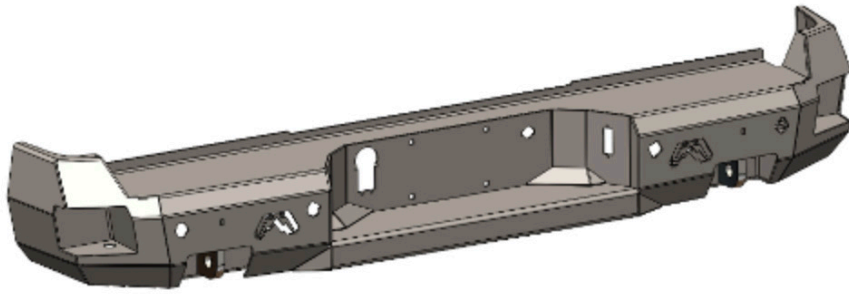
FOUNDER, FAB FOURS

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



23076 - W5951 PREMIUM REAR BUMPER



23077- W5951 PREMIUM
REAR PS MOUNT BRACKET



23078 - W5951
PREMIUM REAR DS
MOUNT BRACKET

TOOLS REQUIRED

- 21MM SOCKET WRENCH
- 13MM SOCKET WRENCH
- 15MM SOCKET WRENCH
- 24MM SOCKET WRENCH
- 3/4" SOCKET WRENCH
- 3/4" OPEN END WRENCH
- STRAIGHT SCREWDRIVER
- PICK
- ELECTRICAL TAPE

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 | W2850-HW

IDENTIFICATION NUMBER	COMPONENT DESCRIPTION	QTY
W2850-HW	1/2" LICENSE PLATE NUT	2
W2850-HW	#8-32 X 3/4" STAINLESS CAP SCREW	8
W2850-HW	#8-32 NYLOCK HEX NUT	8
W2850-HW	#8 FLAT WASHER ZINC	8
W2850-HW	1/2"-13 X 1 1/2" HEX CAP BOLT GRADE 8	8
W2850-HW	1/2" 13 HEX NUT, ZINC, GRADE 8	8
W2850-HW	1/2" SAE LOCK WASHER, ZINC, GRADE 8	8
W2850-HW	1/2" SAE FLAT WASHER GRADE 8	16

DISASSEMBLY + INSTALLATION

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 nuts and bolts from vehicle frame. (Figure 4) These will be reused for installation.



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) These will be reused for installation.



Figure 5

NOTE: If truck is NOT equipped with parking sensors, skip to step 10.

6. Remove wire harness from OEM bumper. Be sure to note orientation of wire harness for installation into new bumper.
7. Remove sensors and sensor housings from OEM bumper, noting location of each.
8. Install sensor housings into new bumper. Use provided epoxy to secure housings into bumper.
9. Once epoxy has dried, install sensors into housings and plug in harness to sensors.
10. Install the tag lights into side holes. Mount lights so they are oriented towards license plate mounting face. Use two (2) #8-32 screws, flat washers, and nylon nuts (W2850-HW) per light to secure lights into bumper.

11. Use pick tool to remove silver clips from trailer plug. Insert plug into bumper. While holding in place, insert clips into plug and use straight screwdriver to bend clips until they are fully seated into plug. (Figure 6&7)



Figure 6

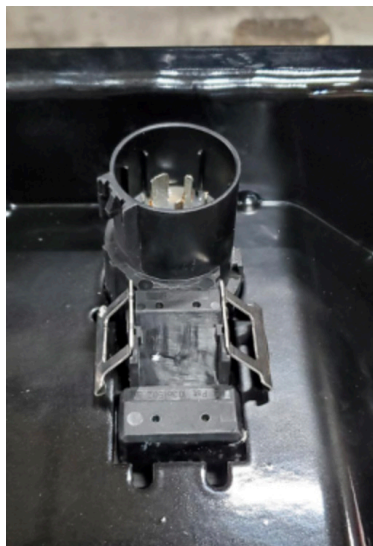


Figure 7

12. Transfer spare tire lock from OEM bumper to new bumper.

13. Next use provided terminals to splice into both wires on factory tag light harness. Repeat for both sides (Figure 8)



Figure 8

14. Crimp provided spade connectors onto new tag lights and connect spade connectors to blue splices installed in step 13. Secure connections with electrical tape.

15. Using 24mm socket, and 15mm socket, attach 23077 mounting bracket to passenger side to frame with bolt strips and nuts removed in steps 4 & 5. Repeat on driver side with 23078 bracket. Use level to ensure brackets are generally the same position. (Figure 9 & 10)

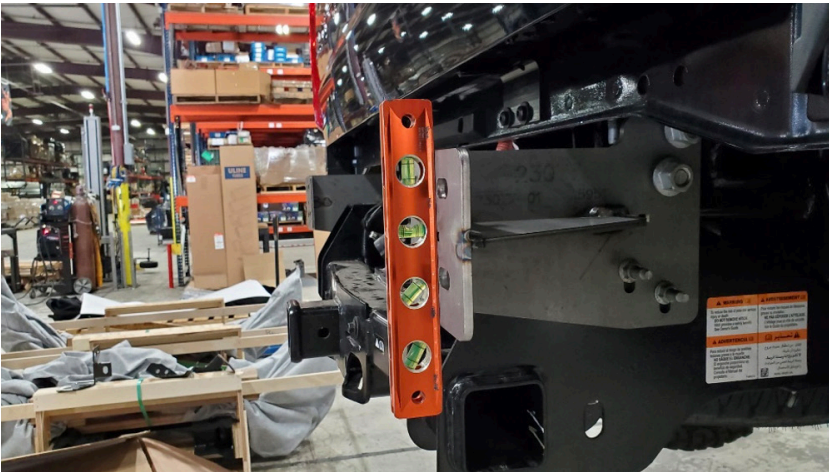


Figure 9



Figure 10

16. With assistance, line up bumper on truck with 23077 and 23078 mounting brackets. Attach bumper with $\frac{1}{2}$ " bolts, flat washers, lock washers and $\frac{1}{2}$ " hex nuts (W2850-HW). (Figure 11)



Figure 11

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17. Align bumper with truck and tighten all nuts and bolts, using $\frac{3}{4}$ " socket wrench and $\frac{3}{4}$ " open end wrench.
 18. Reconnect trailer plug and sensor harness (if equipped).

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

