



INSTALLATION MANUAL
VENGEANCE FRONT BUMPER
PRODUCT NUMBER: V595X
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.



TABLE OF CONTENTS

2	SAFETY / DISCLAIMER
3	TABLE OF CONTENTS
4	A MESSAGE FROM THE OWNER
5	GETTING STARTED
6	PROVIDED MATERIAL
8	INSTALLATION
22	CONTACT

A MESSAGE FROM THE OWNER



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.

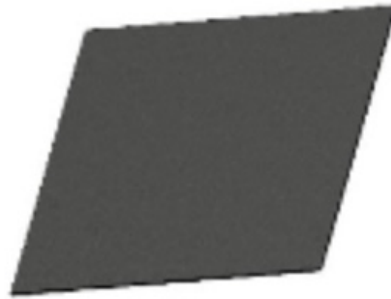
PROVIDED MATERIALS



23071 - BUMPER SHELL



21871 - LIGHT BAR L-BRACKETS
QTY:2



61784 - ACC FILLER PANEL
(PLASTIC SHEET)

61632 - EPOXY PACKETS QTY:2

50421-HW - HARDWARE KIT

TOOLS REQUIRED

- PANEL PRY TOOL
- FLAT HEAD SCREWDRIVER
- SILVER MARKER
- DRILL
- UTILITY KNIFE
- MEASURING TAPE
- 1/4" DRILL BIT
- E6 TORX SOCKET
- 1/8" ALLEN WRENCH
- 8MM SOCKET WRENCH
- 11MM SOCKET WRENCH
- 15MM SOCKET WRENCH
- 18MM SOCKET WRENCH
- 7/16" SOCKET WRENCH
- 7/16" COMBINATION WRENCH

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 | 50421-HW

IDENTIFICATION NUMBER	COMPONENT DESCRIPTION	QTY
50421-HW	1/4"-20 X 1", HEX HEAD CAP SCREW, ZINC, GRADE 8	2
50421-HW	1/4"-20, HEX NUT, ZINC, GRADE 8	2
50421-HW	1/4"-SAE, FLAT WASHER, ZINC, GRADE 8	4
50421-HW	1/4"-SAE, LOCK WASHER, ZINC, GRADE 8	2
50421-HW	10-24 X 3/4", SOCKET HEAD CAP SCREW, BLACK SS	2
50421-HW	10-24, CLIP ON BARREL NUT	2
50421-HW	1 3/8", GROMMET, PLASTIC, MM9307K81	4
50421-HW	BLACK PLASTIC PLUG	4

INSTALLATION

1. Remove the plastic tow hook covers by pulling on them to release the clips. Figure 1



Figure 1

2. Disconnect the bumper electrical harness connected to the inside of the driver side frame rail. Figure 2



Figure 2

3. If applicable, remove the adaptive cruise control (ACC) sensor from its mounting bracket. Figure 3



Figure 3

4. If applicable, disconnect the electrical connector from the ACC sensor. Figure 4



Figure 4

5. Using an E6 torx socket remove the three (3) studs that attach the ACC bracket to the vehicle. Figure 5

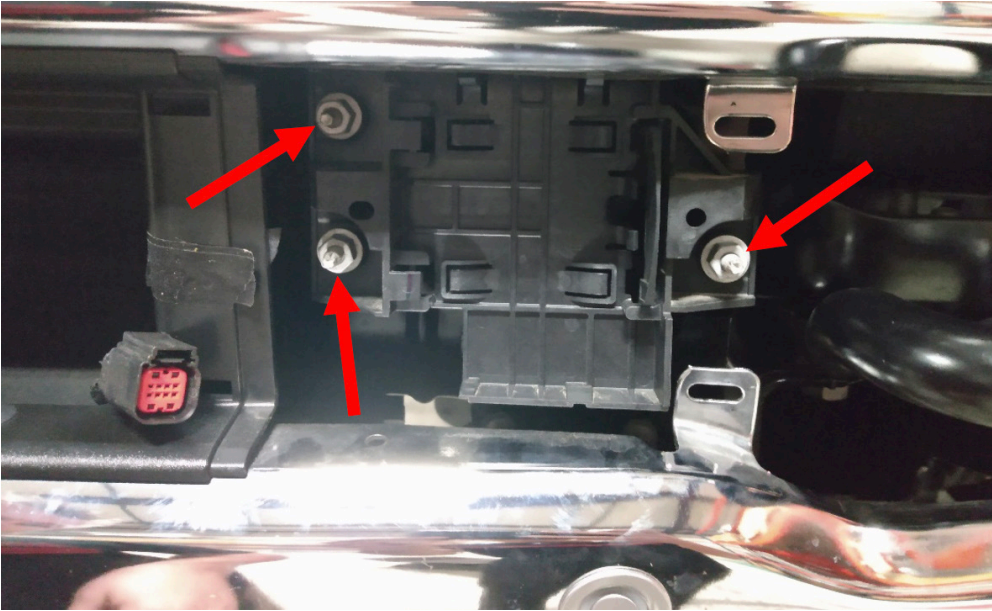


Figure 5

6. Using an 18mm socket wrench, remove the eight (8) bolts that attach the bumper to the tow hook brackets. Figure 6

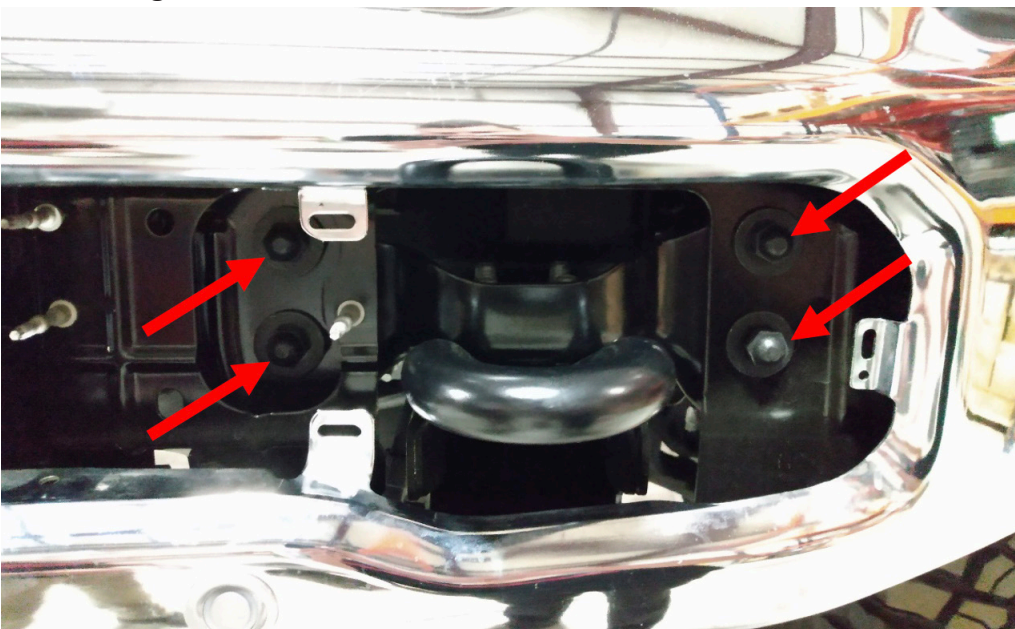


Figure 6

7. Using a 15mm socket wrench, remove the two (2) bolts per side that attach the bumper reinforcement brackets to the frame. Figure 7

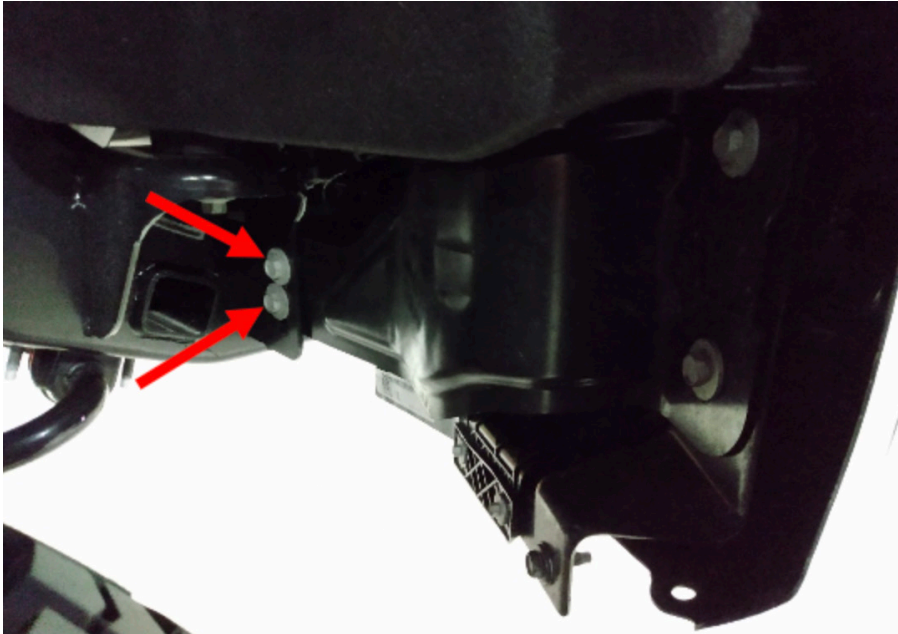


Figure 7

8. Using a body panel pry tool, remove the two (2) push pins attaching the shroud to the grille. The bumper can now be removed from the vehicle. Figure 8



Figure 8

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9. Using an 18mm socket wrench, remove the eight (8) bolts attaching the tow hooks to the frame and remove the tow hooks. Figure 9

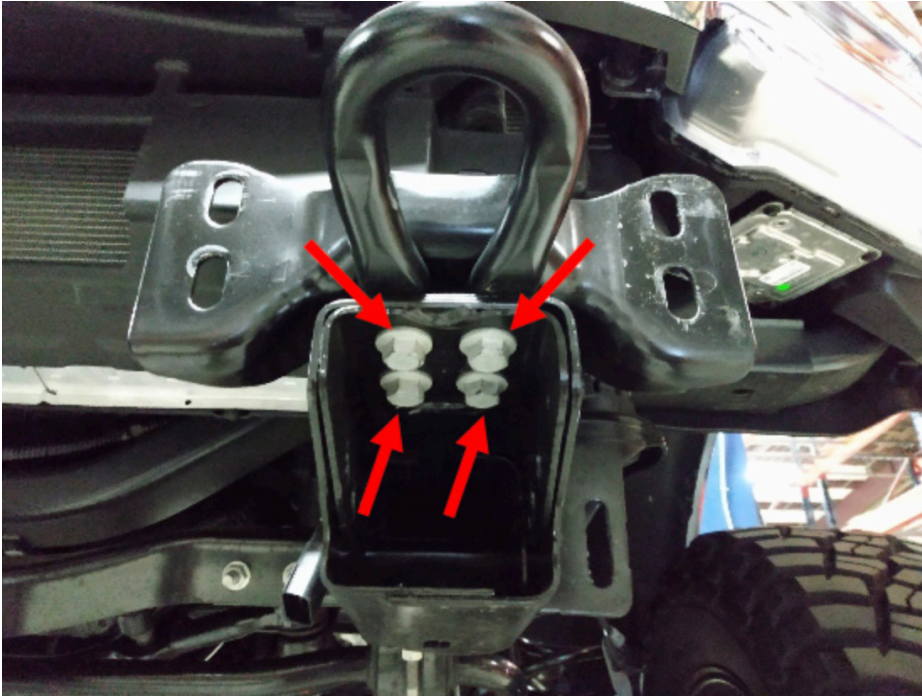


Figure 9

10. Using an 18mm socket wrench, remove the eight (8) nuts attaching the underrun guards to the bottom of each frame rail. Figure 10

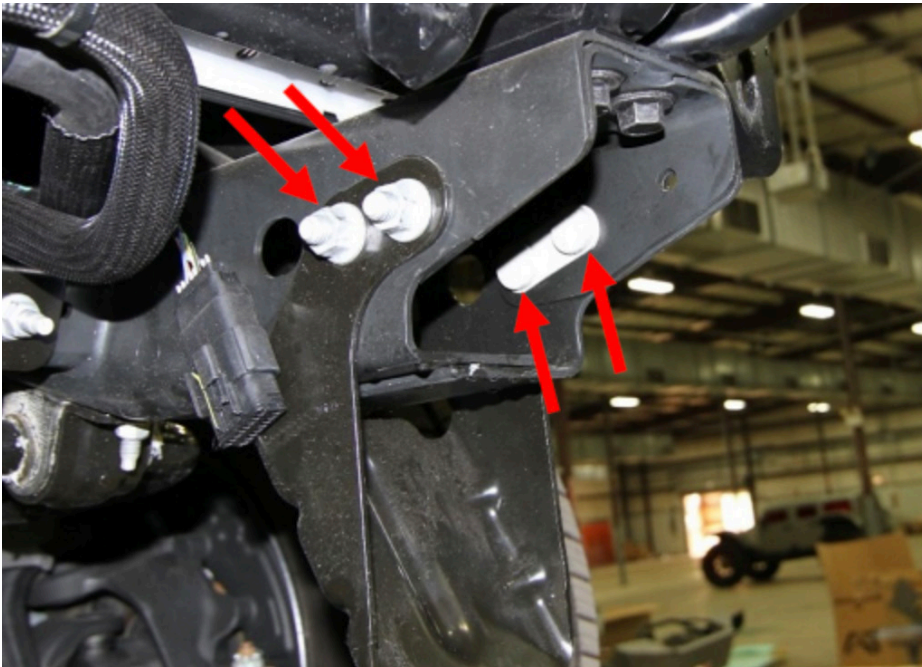


Figure 10

11. Using an 8mm socket wrench, remove the four (4) screws in each fog light bracket to remove them from the bumper. Figure 11

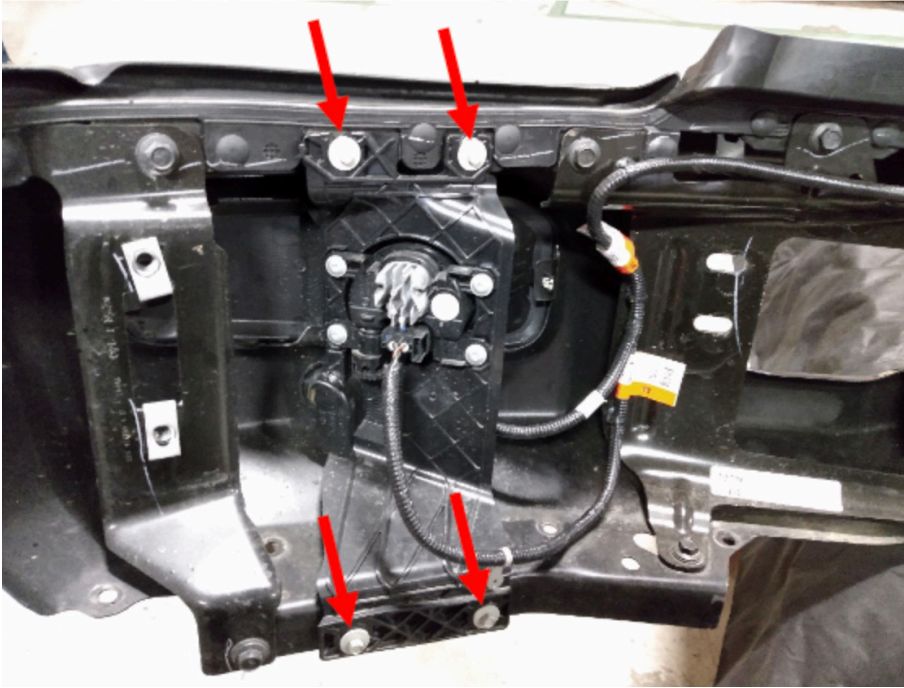


Figure 11

12. Using a panel pry tool, remove the push pin clip. Figure 12



Figure 12

13. Reinstall the parking sensor housings into their respective locations and orientations in the Fab Fours bumper (Part#: 23071). Apply the provided epoxy on the inside of the bumper around the sensor housing to hold them in place. Figure 13-16



Figure 13



Figure 14



Figure 15



Figure 16

14. Using an E6 socket and 11mm combination wrench, remove the three (3) nuts from the ACC sensor bracket. Figure 17



Figure 17

15. Using a panel pry tool, remove the ACC bracket mounting studs from their plastic sockets. Figure 18

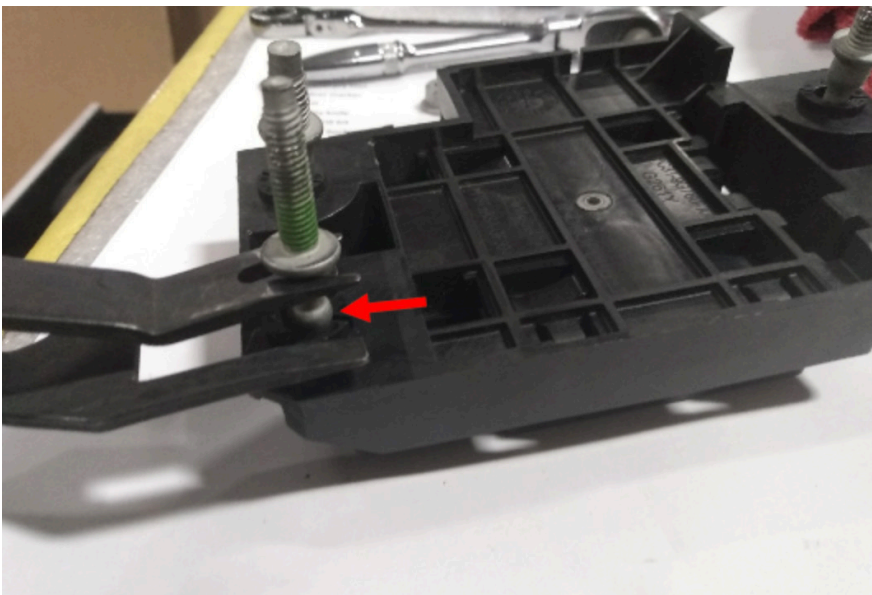


Figure 18

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16. Using a panel pry tool and flat head screwdriver, remove the ACC bracket mounting stud sockets. Figure 19



Figure 19

17. Reinstall the mounting studs, sockets, and locking nuts on the opposite side of the ACC mounting bracket by reversing the steps used to remove them. Figure 20

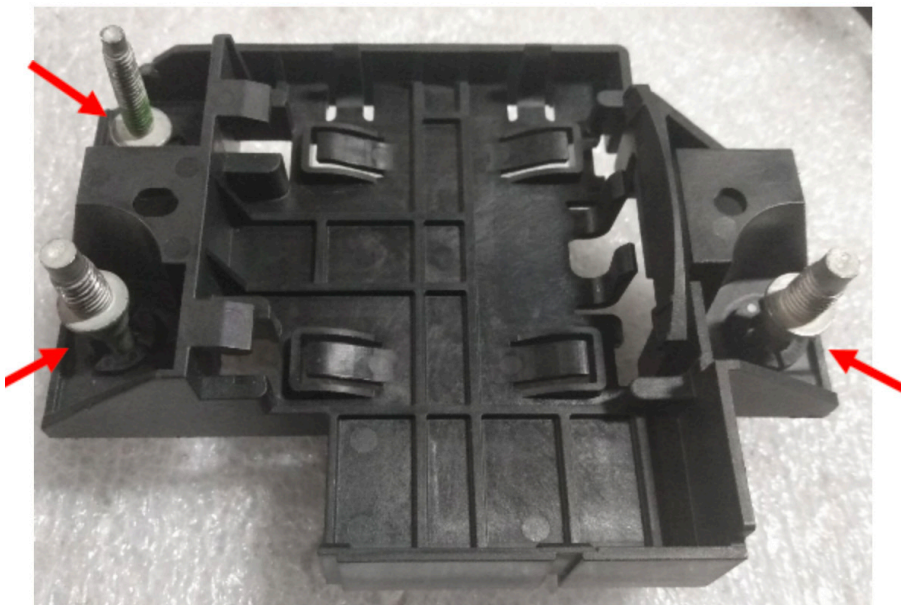


Figure 20

18. Using the cutout and two (2) holes in the bumper shell as a guide, trace the profiles onto the smooth side of the provided black plastic sheet (Part#: 61784) with a marker. Then, make another mark offsetting the previous mark by at least 1/4". Figure 21-22

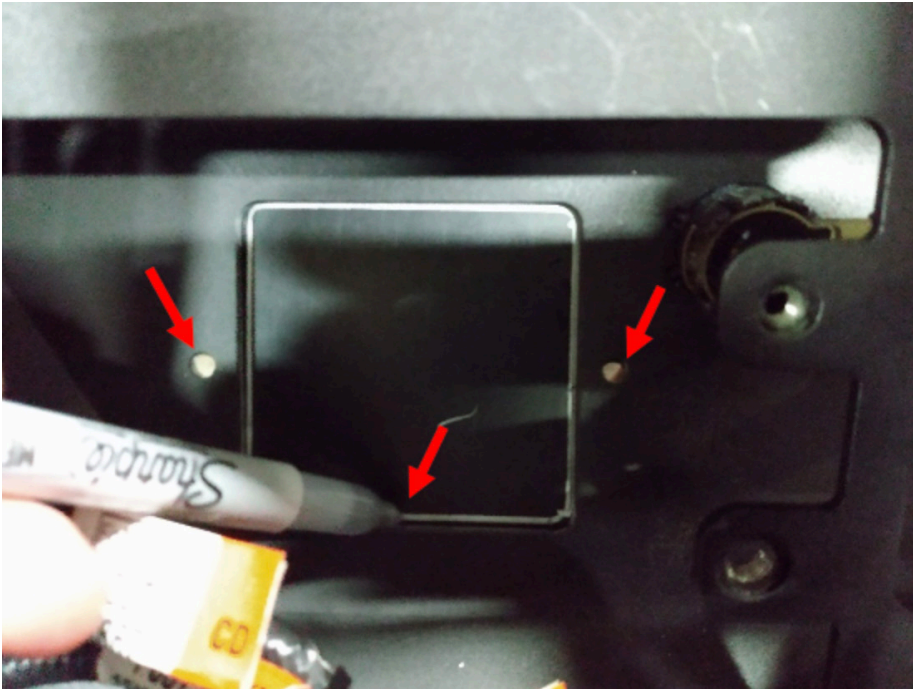


Figure 21

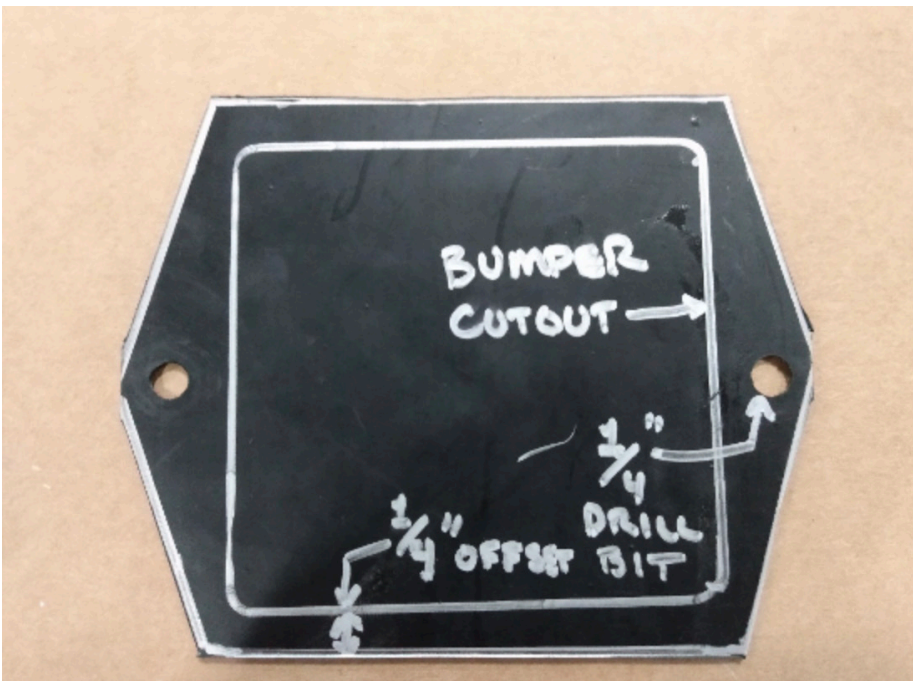


Figure 22

19. Using a utility knife, cut along the offset line. Then, using a 1/4" drill bit drill out the two (2) marked holes. Figure 23

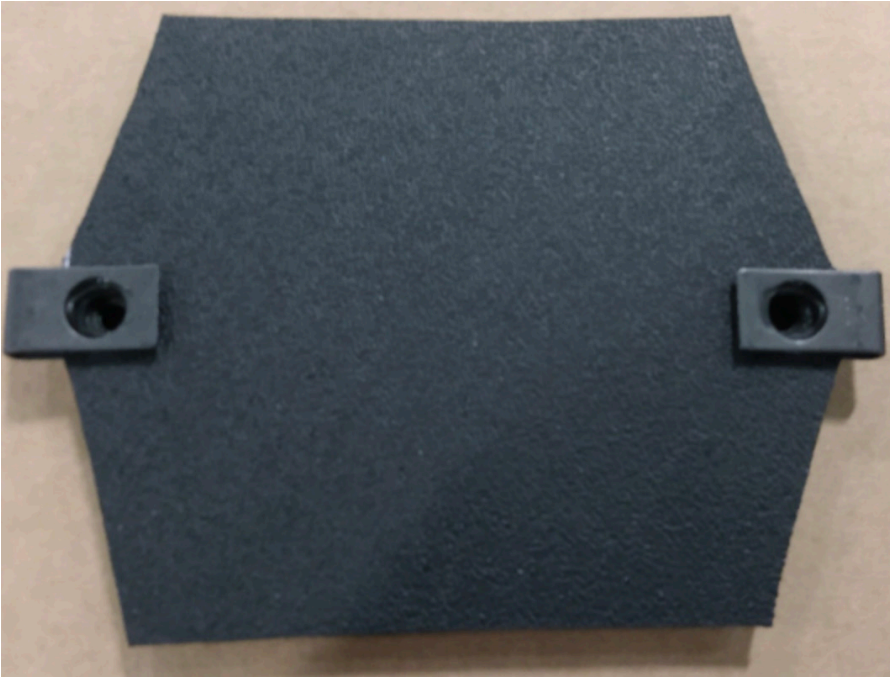


Figure 23

20. Using a 1/8" Allen wrench, install the plastic sheet with the provided #10 black stainless screws and barrel nuts. Figure 24

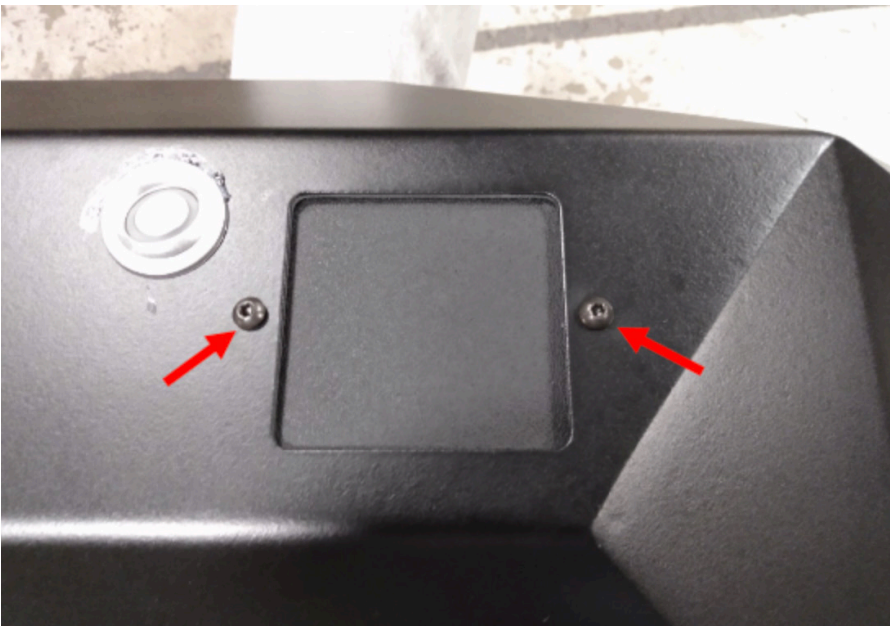


Figure 24

21. Using an E6 socket install the ACC bracket with sensor into the bumper. Figure 25

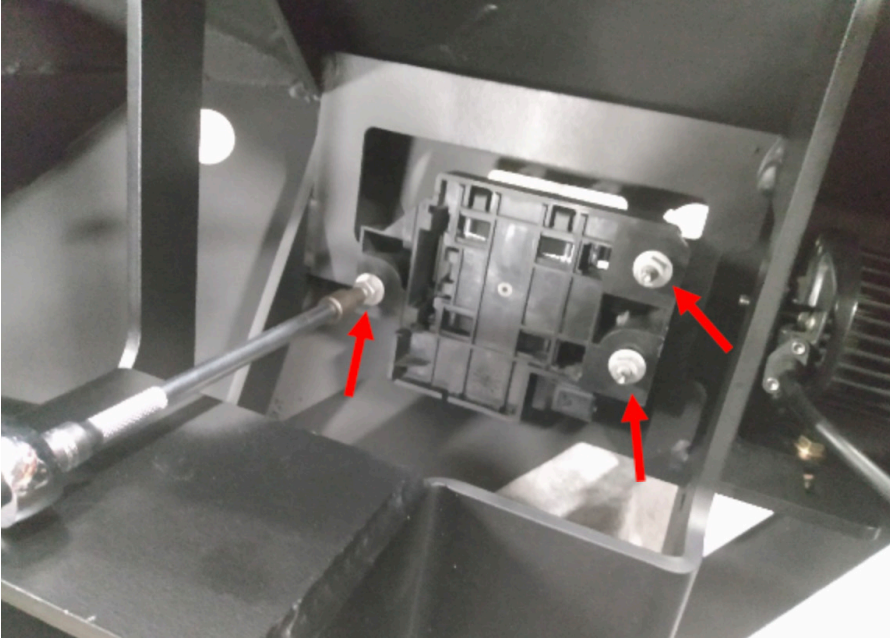


Figure 25

22. If applicable, install a 20" lightbar using the two (2) provided L-brackets (part#:22352) and 1/4" screws, flat washers, lock washers, and nuts. Figure 26



Figure 26

23. If applicable, install lights in the wings of the bumper per the lighting manufacturer's instructions and with their provided hardware.

24. With assistance, hold the bumper up to the vehicle and reinstall the four (4) previously removed underrun guard bolt strips. Figure 27-28

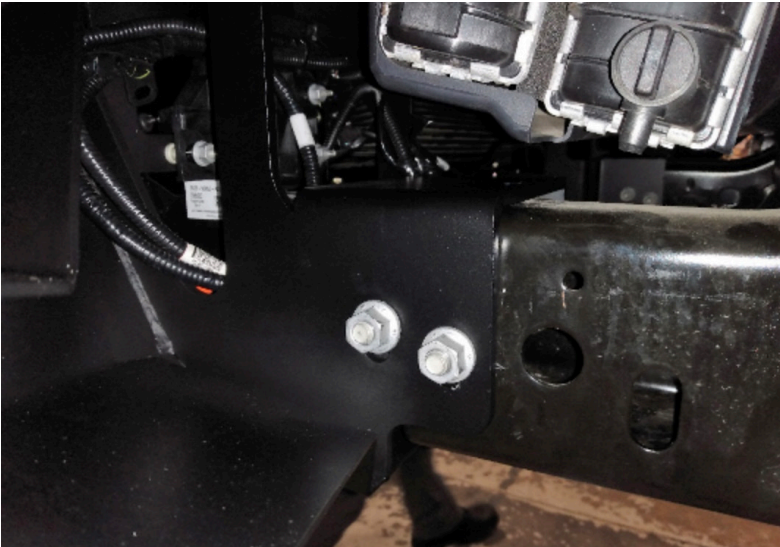


Figure 27

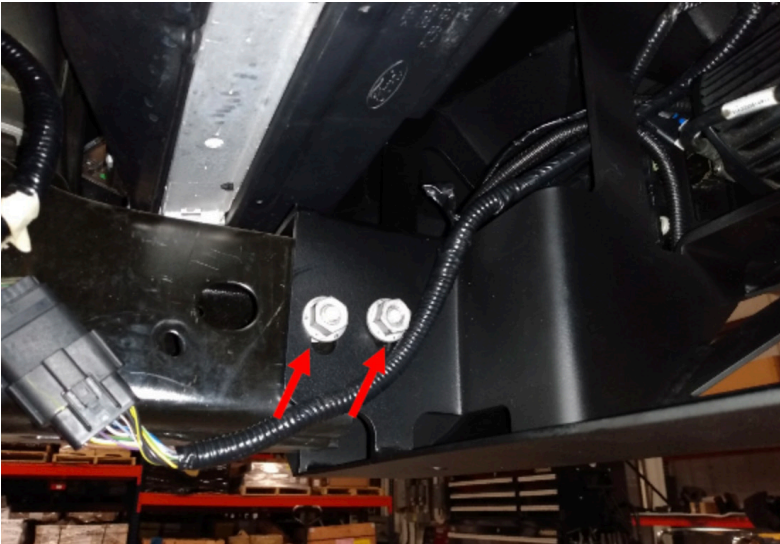


Figure 28

25. Using an 18mm socket wrench, tighten the hardware installed in the previous step. Then, reconnect the bumper wiring harness. Figure 29



Figure 29

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

