



INSTALLATION MANUAL
PREMIUM FRONT BUMPER
PRODUCT NUMBER: A595X
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



23084 - BUMPER SHELL



23085 - DS MOUNTING BRACKET



23086 - PS MOUNTING BRACKET

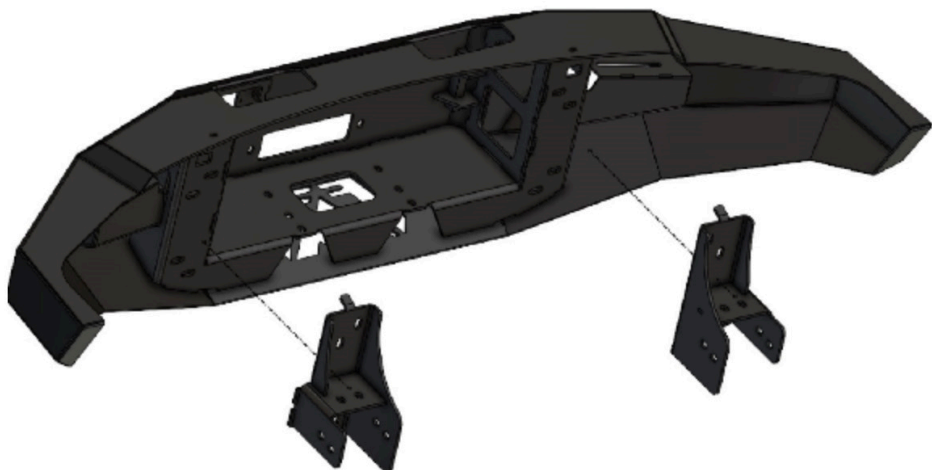


61784 - ACC FILLER PANEL (PLASTIC SHEET)



20296 - BOLT STRIP QTY:4

61632 - EPOXY PACKETS QTY:2



TOOLS REQUIRED

- PANEL PRY TOOL
- TAPE MEASURE
- SILVER MARKER
- DRILL
- 5/16" 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
- 3/4" COMBINATION WRENCH
- 3/4" DEEP SOCKET 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 | 50433-HW

IDENTIFICATION NUMBER	COMPONENT DESCRIPTION	QTY
50433-HW	1/2"-13 X 2.0" HEX BOLT, YELLOW-ZINC, GRADE 8	12
50433-HW	1/2"-SAE, LOCK WASHER, YELLOW-ZINC, GRADE 8	20
50433-HW	1/2"-SAE, FLAT WASHER, YELLOW-ZINC, GRADE 8	32
50433-HW	1/2"-13, HEX NUT, YELLOW-ZINC, GRADE 8	20
50433-HW	10-24 X 3/4", SOCKET HEAD CAP SCREW, BLACK SS	2
50433-HW	10-24, CLIP ON BARREL NUT	2
50433-HW	1 3/8", RUBBER GROMMET	4
50433-HW	BLACK PLASTIC PLUG	4
50433-HW	1/2" BOLT RETAINER	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

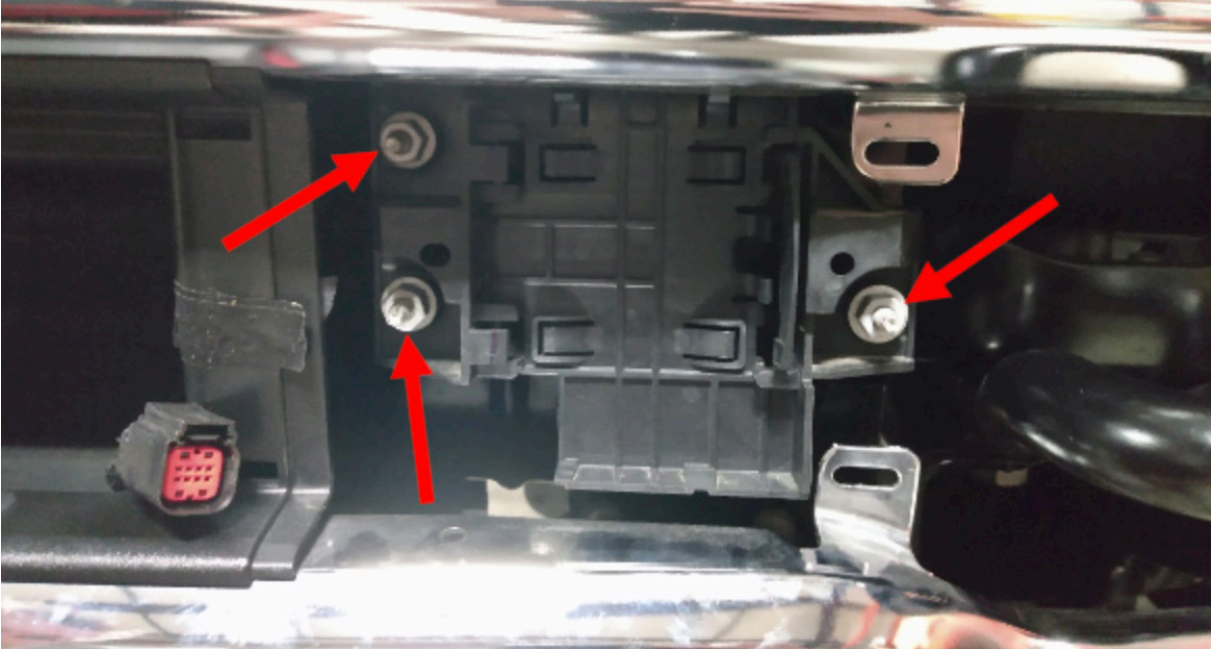


Figure 5

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

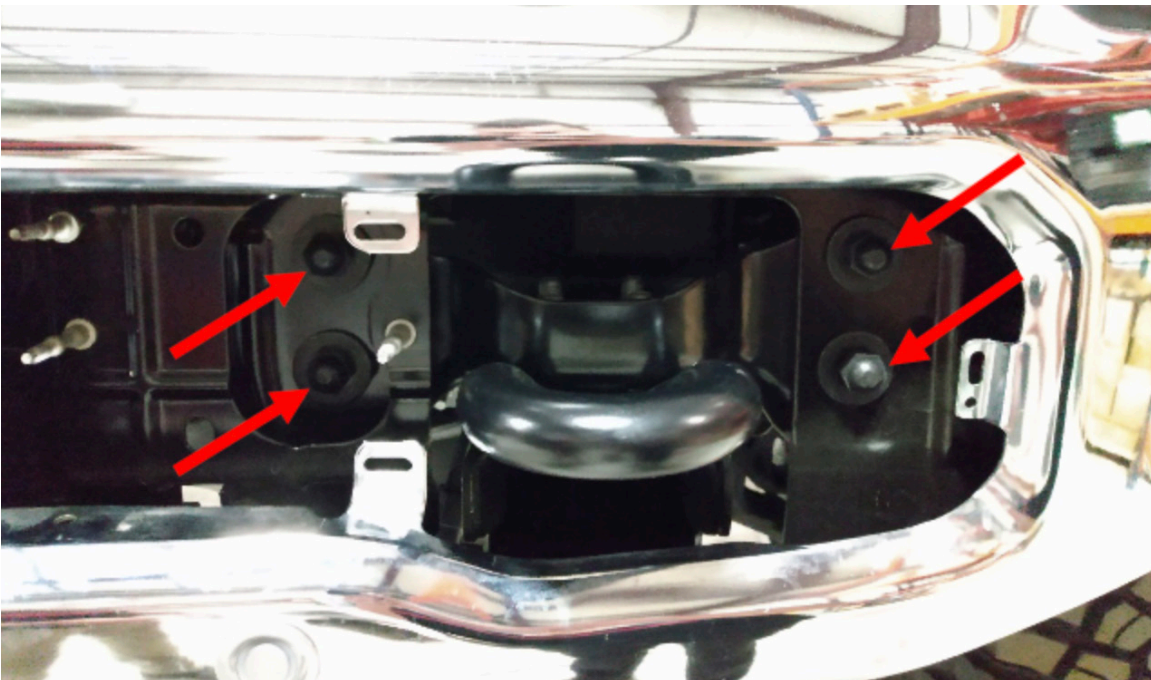


Figure 6

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

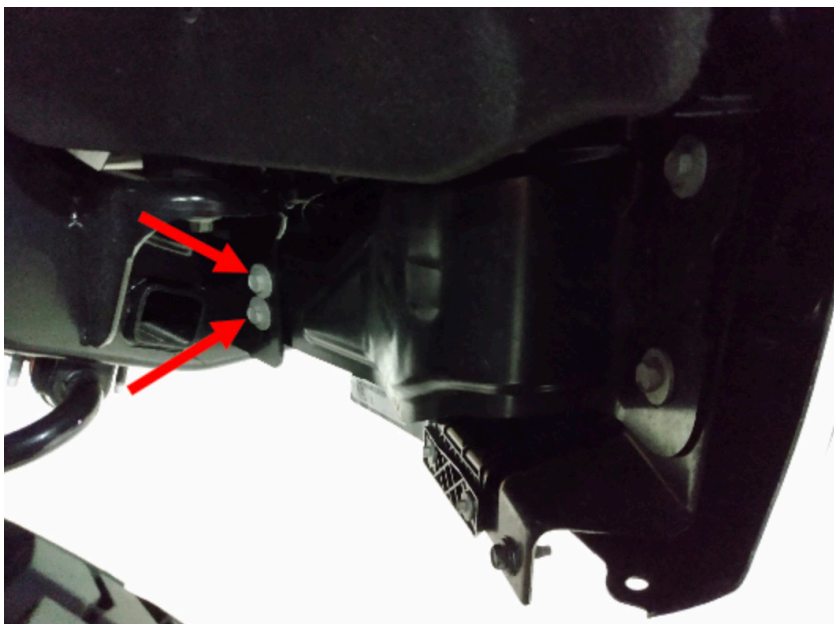


Figure 7

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

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

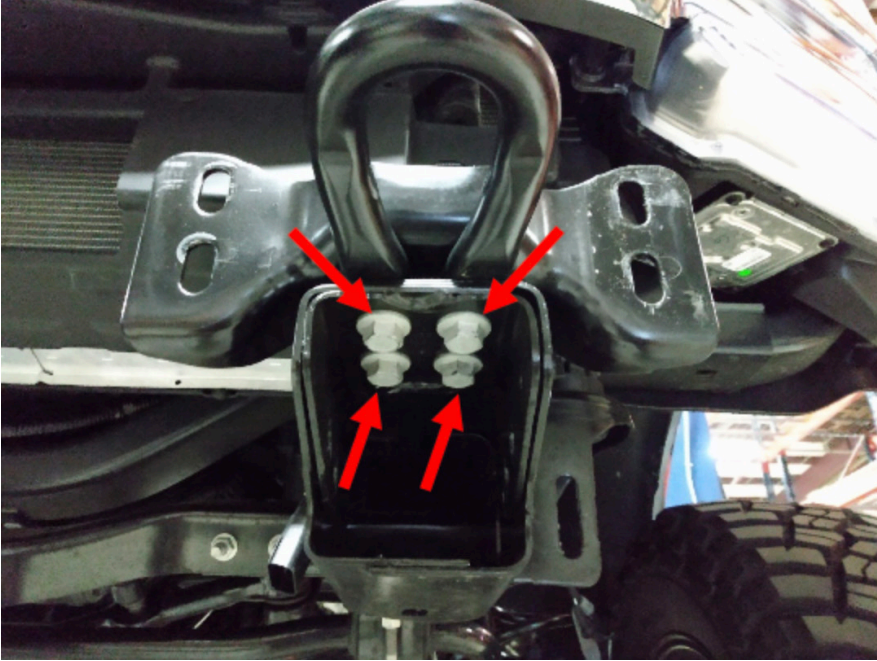


Figure 9

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

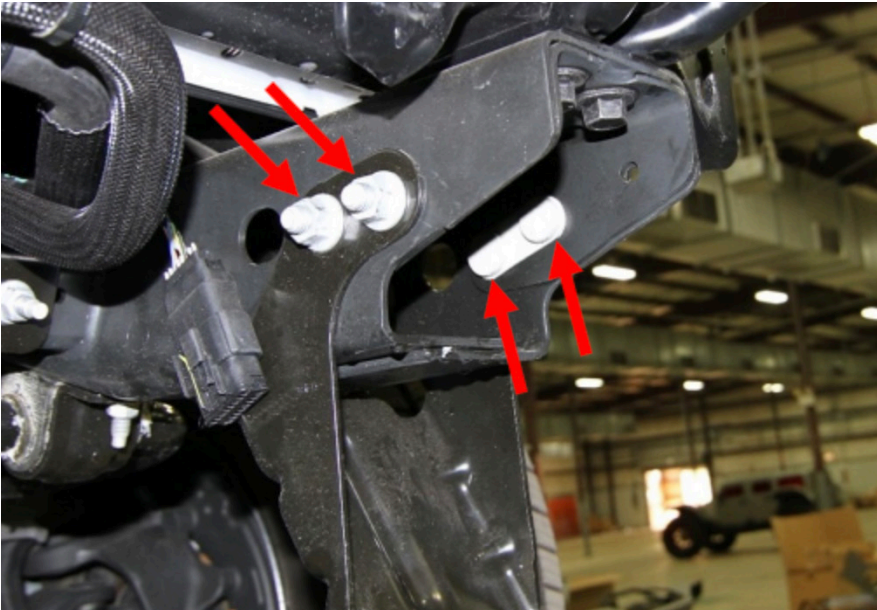


Figure 10

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

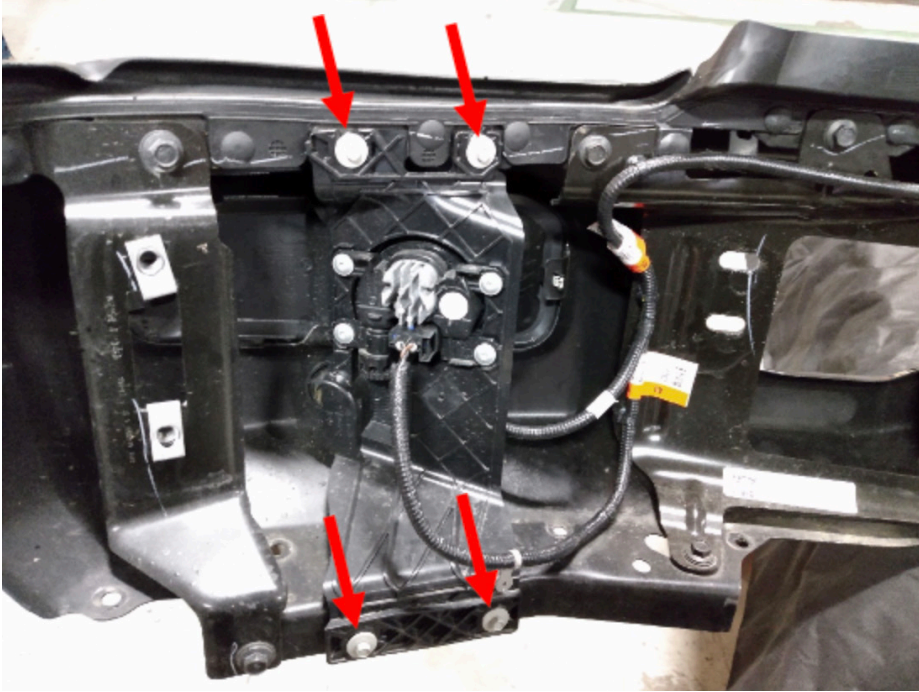


Figure 11

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

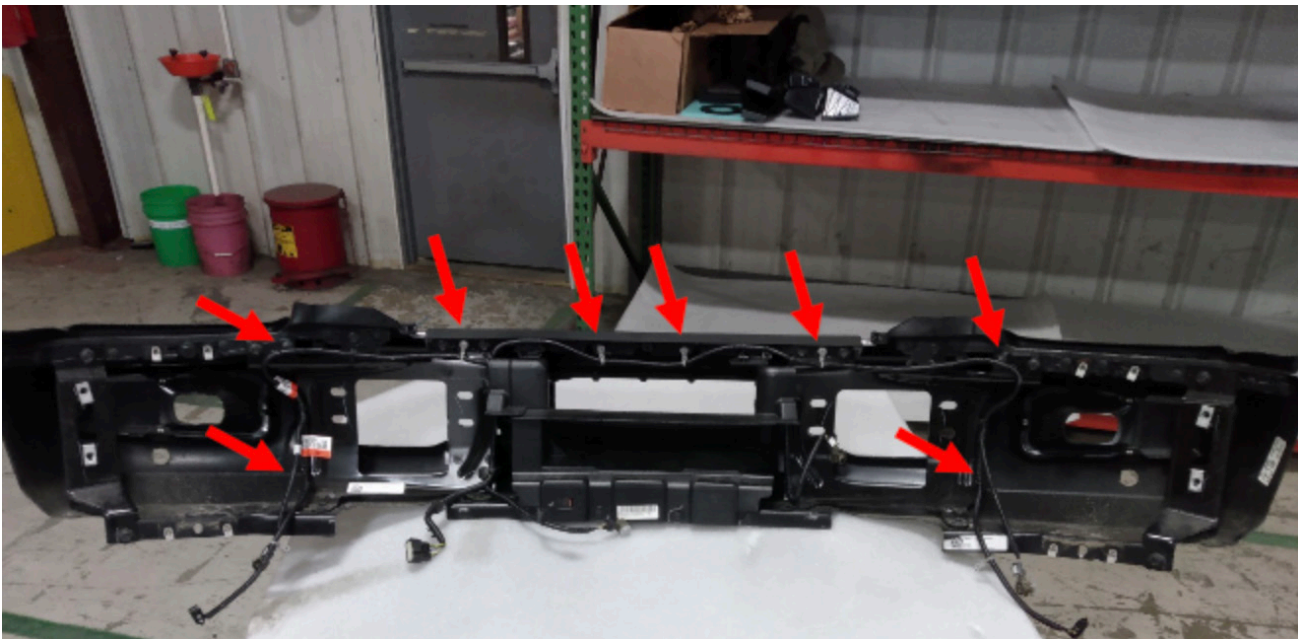


Figure 12

-
13. Using an E6 socket and 11mm combination wrench, remove the three (3) nuts from the ACC sensor bracket. Figure 13



Figure 13

14. Using a panel pry tool, remove the ACC bracket mounting studs from their plastic sockets. Figure 14

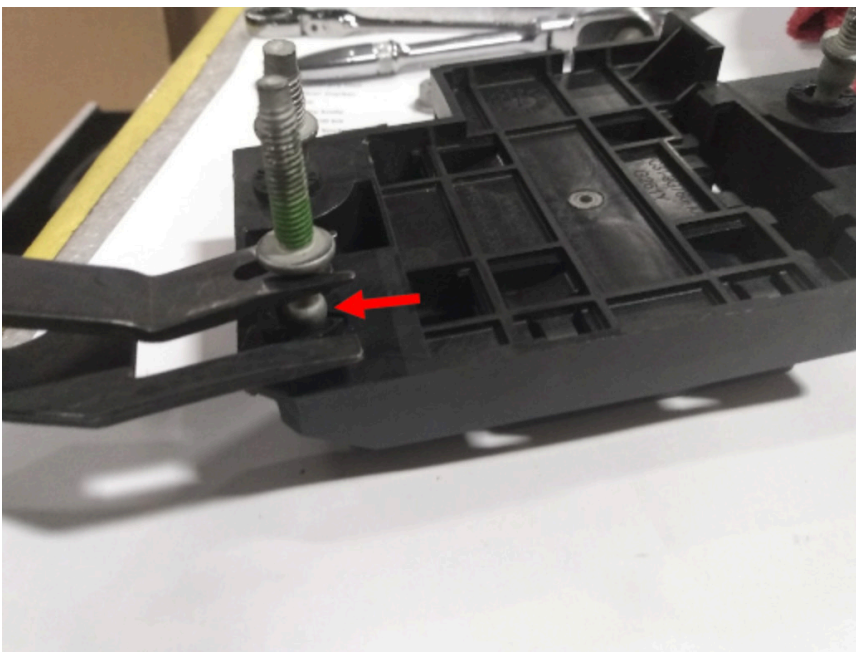


Figure 14

15. Using a panel pry tool and flat head screwdriver, remove the ACC bracket mounting stud sockets.
Figure 15

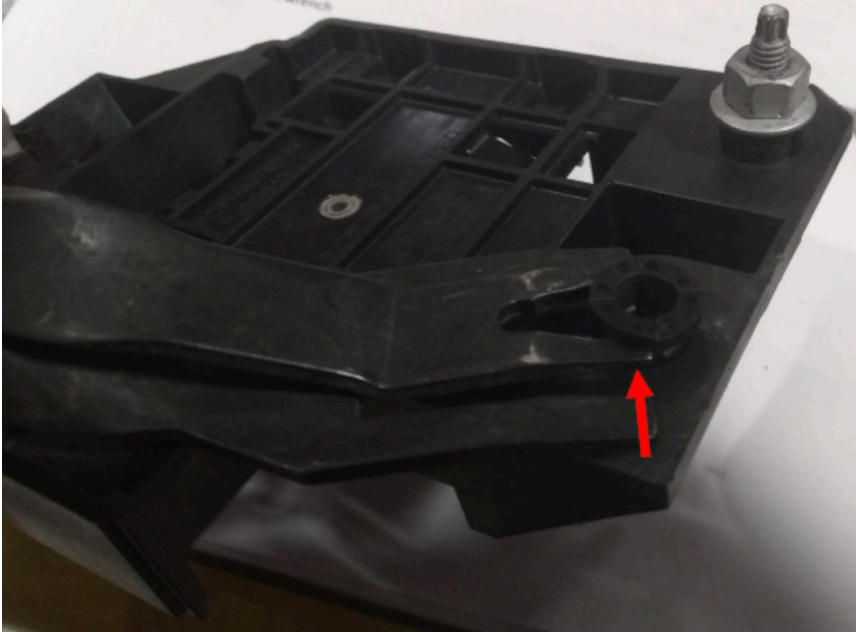


Figure 15

16. 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 16

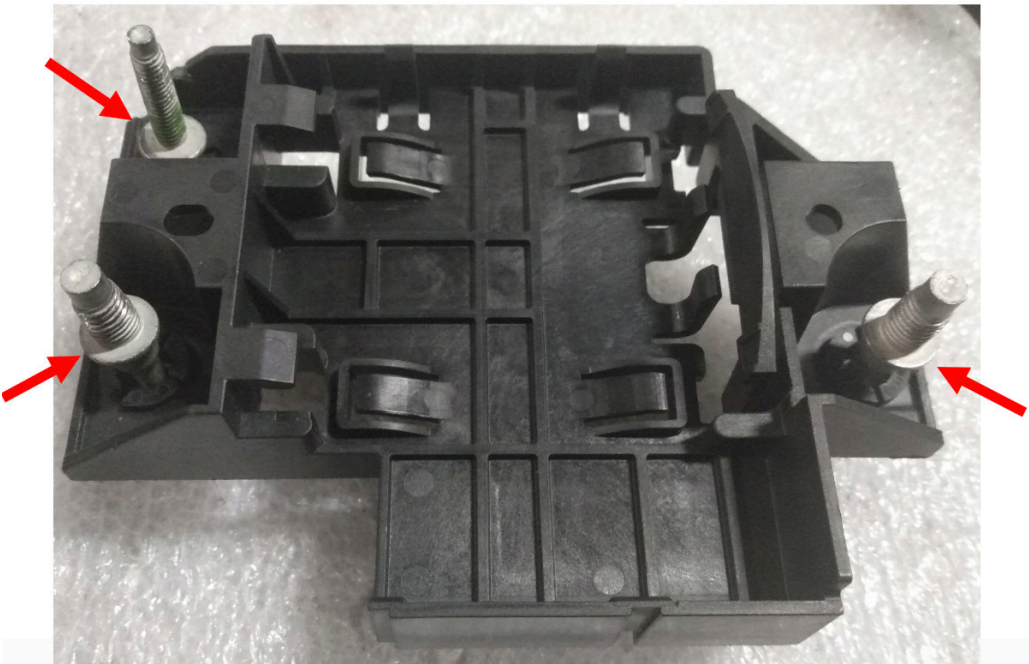


Figure 16

17. Using a silver marker, trace the window opening and two (2) holes in the front face of the bumper onto the smooth side of provided black plastic sheet (Part#: 61784). (Figure 17)

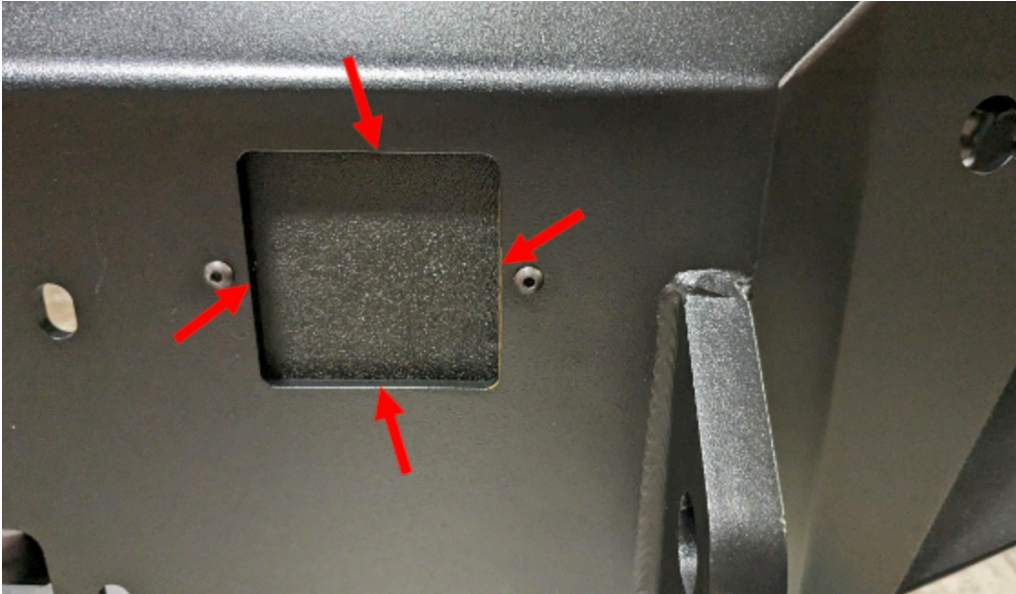


Figure 17

18. Using a tab measure and marker, offset the previously marked line on the black plastic sheet by $\frac{5}{8}$ ". Then, using a knife, cut along the offset line. (Figure 18)

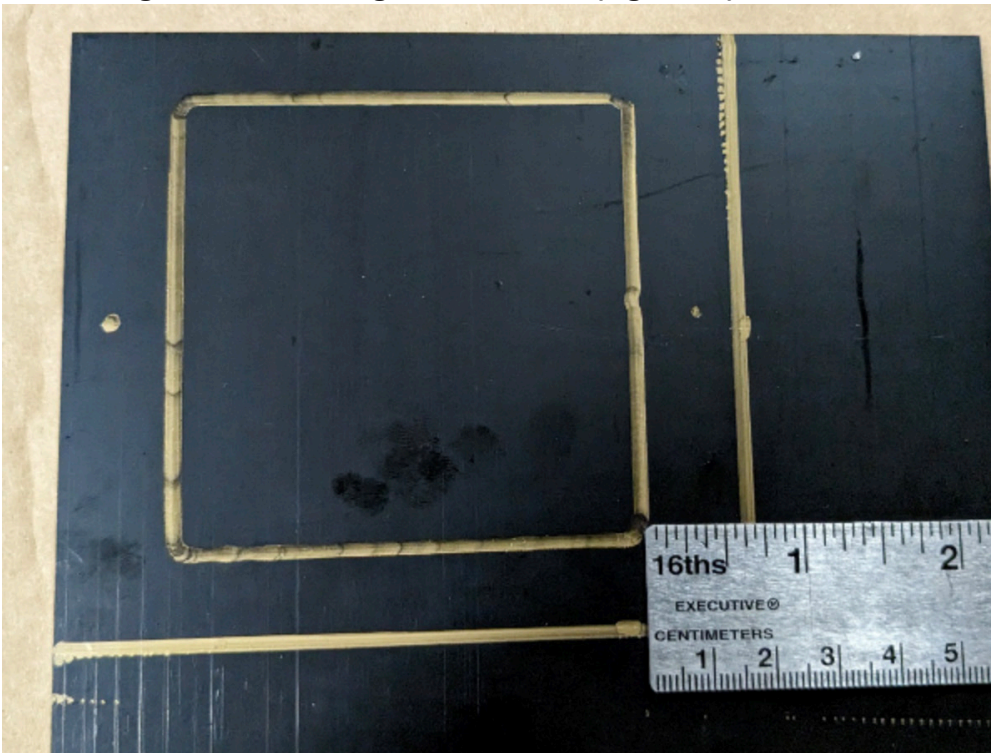


Figure 18

19. Use a 5/16" drill bit, drill out the two (2) previously marked holes in the black plastic sheet.

20. Install the two (2) provided barrel nuts onto the black plastic sheet. (Figure 19)

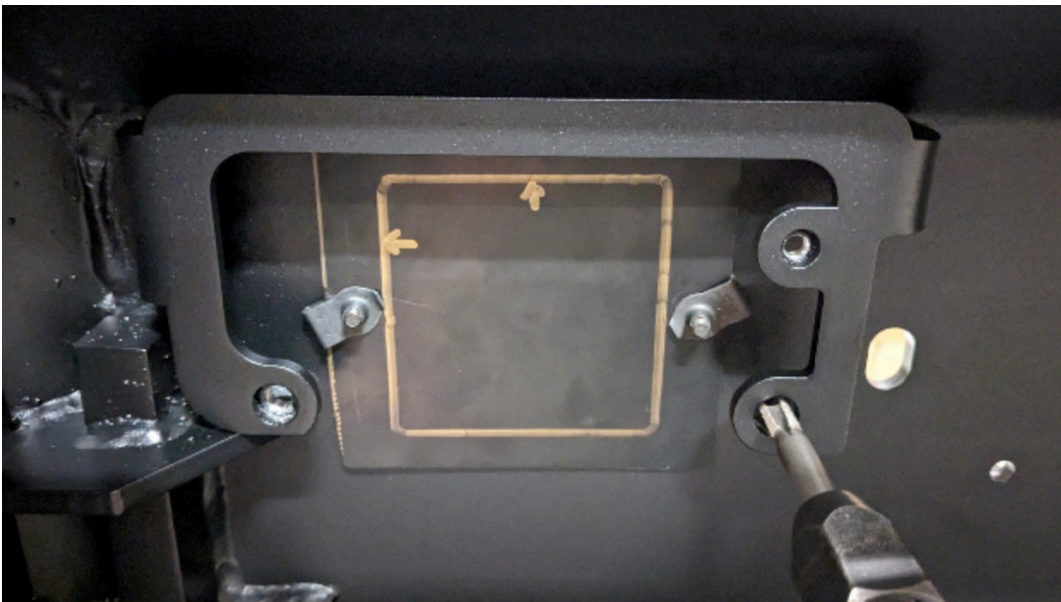


Figure 19

21. Using a 1/8" Allen wrench, install the sheet in the bumper using the two (2) provided #10 black screws. (Figure 20)



Figure 20

22. Using an E6 socket install the ACC bracket with sensor into the bumper making sure to keep the sensor face parallel with the front face of the bumper. Figure 21

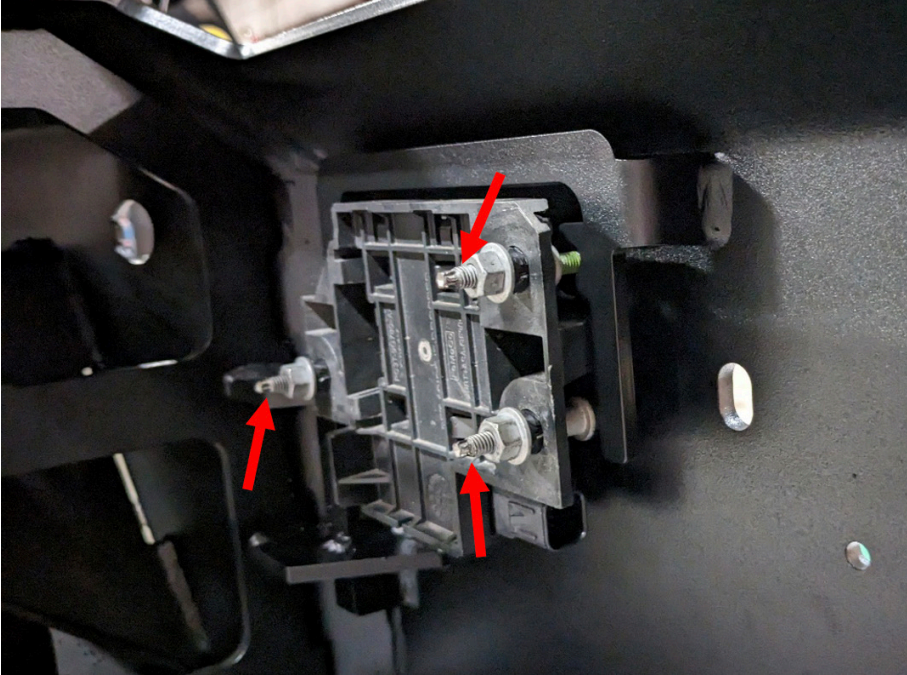


Figure 21

23. Using the four (4) provided 1/2" bolt retainers, install the four (4) provided 1/2" bolt strips into the bumper mounting flanges. Figure 22

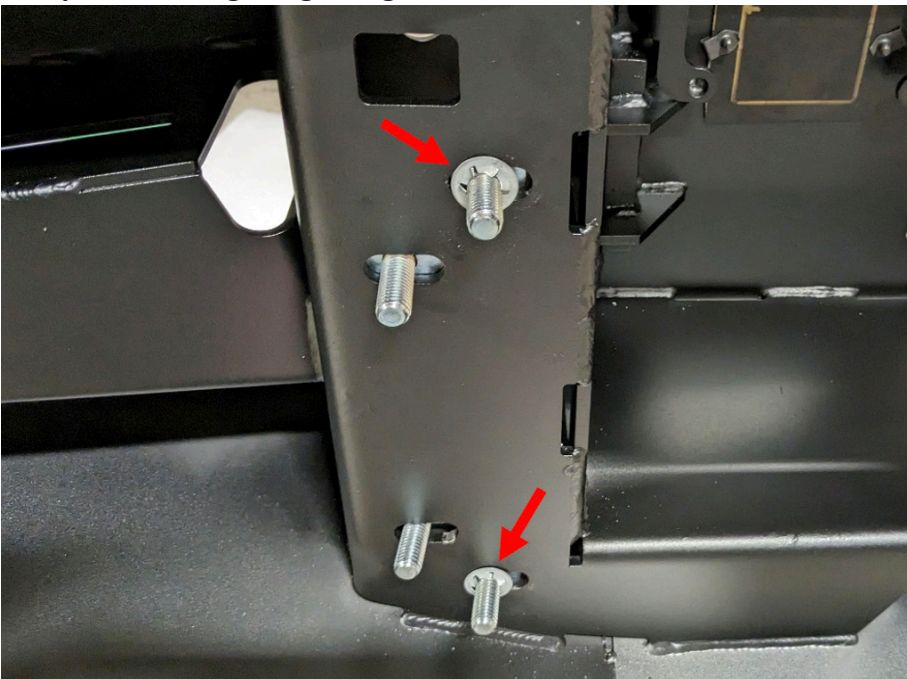


Figure 22

-
24. Reinstall the parking sensor housing into the new bumper in the same position and orientation in which they were removed from the OEM bumper. Use the provided epoxy and popsicle stick to adhere the housing to the bumper. Figure 23



Figure 23

25. Reinstall the parking sensor to their respective housing, ACC sensor connector, and wiring harness into the bumper. Figure 24



Figure 24

-
26. If installing a winch and fairlead, do so now per the winch manufacturer's directions.
27. If installing lighting, do so now per the lighting manufacturer's directions.
28. With the provided (12) 1/2" bolts, flat and lock washers, and nuts, install the two (2) provided mounting brackets to the frame rails. Part#: 23085 is the driver's side and Part#: 23086 is the passenger side. (Figure 25)

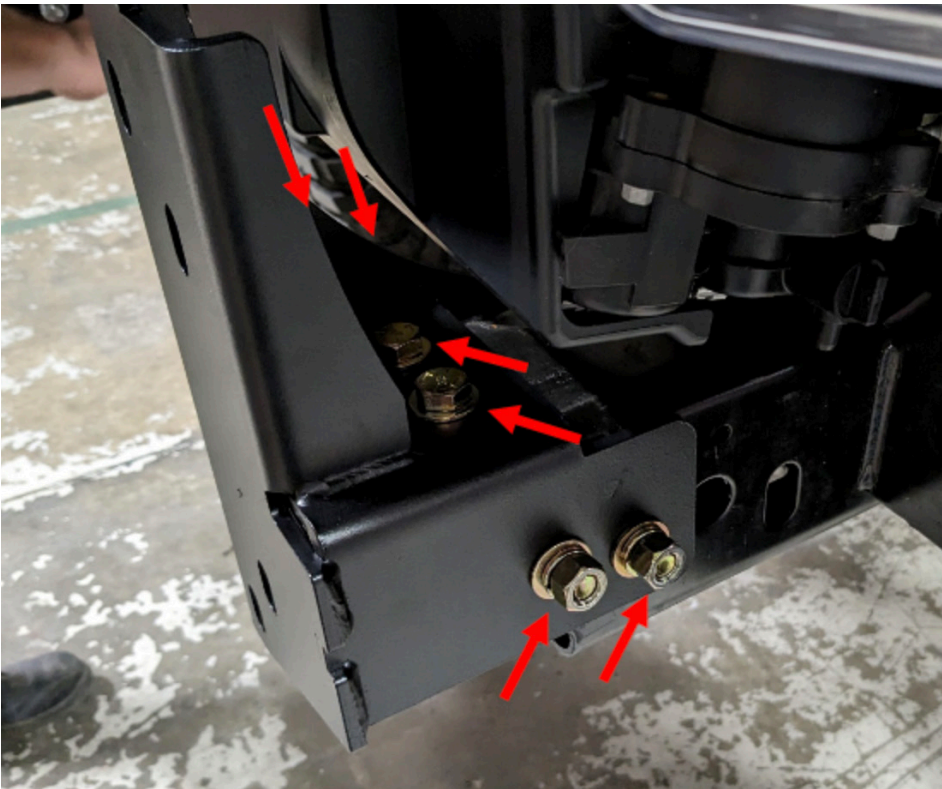


Figure 25

29. Use a 3/4" combination and socket wrench to tighten the previously installed 1/2" hardware in the brackets.
30. With assistance, lift the bumper into place on the vehicle and use the tabs at the top of the brackets to hang the bumper to ease installation.

31. Install the remaining 1/2" flat washers, lock washers, and nuts to the previously installed bolt strips. Align the bumper with the vehicle and then use a 3/4" socket wrench to tighten the bumper to the brackets. (Figure 26-27)



Figure 26



Figure 27

32. Reconnect the bumper wiring harness to the vehicle. (Figure 28)



Figure 28

INSTALLATION COMPLETE

CONTACT INFORMATION

**FAB FOURS INC.
2213 INDUSTRIAL PARK ROAD
LANCASTER, SC 29720**

PHONE: (866) 385-1905

FAX: 970-385-1914

EMAIL: SUPPORT@FABFOURS.COM

FABFOURS.COM



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

- GREG HIGGS

