



INSTALLATION MANUAL
VENGEANCE FRONT BUMPER
PRODUCT NUMBER: D655X
APPLICATION: 2024 FORD F150



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 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

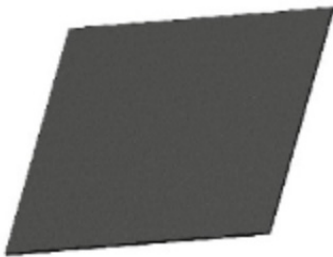
Before you begin the installation process of your new Fab Fours product, we suggest laying out all materials and parts on a pad or protective surface.

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



23349 - VENGEANCE FRONT BUMPER



61784 - PLASTIC SHEET

61632 EPOXY QTY:2

REQUIRED TOOLS

- 7/16" SOCKET/WRENCH
- 1/2" SOCKET/WRENCH
- 3/4" SOCKET/WRENCH
- 8MM SOCKET WRENCH
- 13MM SOCKET WRENCH
- 18MM SOCKET WRENCH
- BODY PRY TOOL
- CUTTING TOOL

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 | 50498-HW

IDENTIFICATION NUMBER	COMPONENT DESCRIPTION	QTY
50498-HW	1/4"-20 X 1", YELLOW ZINC HEX BOLT, GRADE 8	2
50498-HW	1/4"-20, YELLOW ZINC HEX NUT, GRADE 8	2
50498-HW	1/4" YELLOW ZINC FLAT WASHER, GRADE 8	4
50498-HW	1/4" YELLOW ZINC LOCK WASHER	2
50498-HW	1/4"-20 X 3/4", STAINLESS STEEL BUTTON HEAD BOLT	2
50498-HW	1/4" STAINLESS STEEL NYLOCK HEX NUT	2
50498-HW	1/4" STAINLESS STEEL FLAT WASHER	4
50498-HW	5/16" YELLOW ZINC LOCK WASHER	2
50498-HW	5/16" YELLOW ZINC HEX BOLT, GRADE 8	2
50498-HW	5/16" YELLOW ZINC HEX NUT	2
50498-HW	5/16" YELLOW ZINC FLAT WASHER	4
50498-HW	1/2"-13 X 1.25", YELLOW ZINC HEX BOLT, GRADE 8	6
50498-HW	1/2"-13, YELLOW ZINC HEX NUT, GRADE 8	6
50498-HW	1/2" YELLOW ZINC FLAT WASHER, GRADE 8	12
50498-HW	1/2" YELLOW ZINC LOCK WASHER, GRADE 8	6
50498-HW	1 3/8" RUBBER GROMMET	6
50498-HW	PLASTIC PLUG	6

DISASSEMBLY & INSTALLATION

1. Locate and disconnect the wire harness on the passenger side frame. Figure 1.



Figure 1

2. Use an 8mm socket wrench to remove the two bolts on both sides of the truck that attach the valence to the fender well. Carefully pull the valence off the truck by disconnecting the clips along the top of the valence. Figure 2.



Figure 2

3. From underneath the truck, use an 18mm socket wrench to remove the three (3) mounting nuts from both sides of the trucks frame horns. Figure 3.

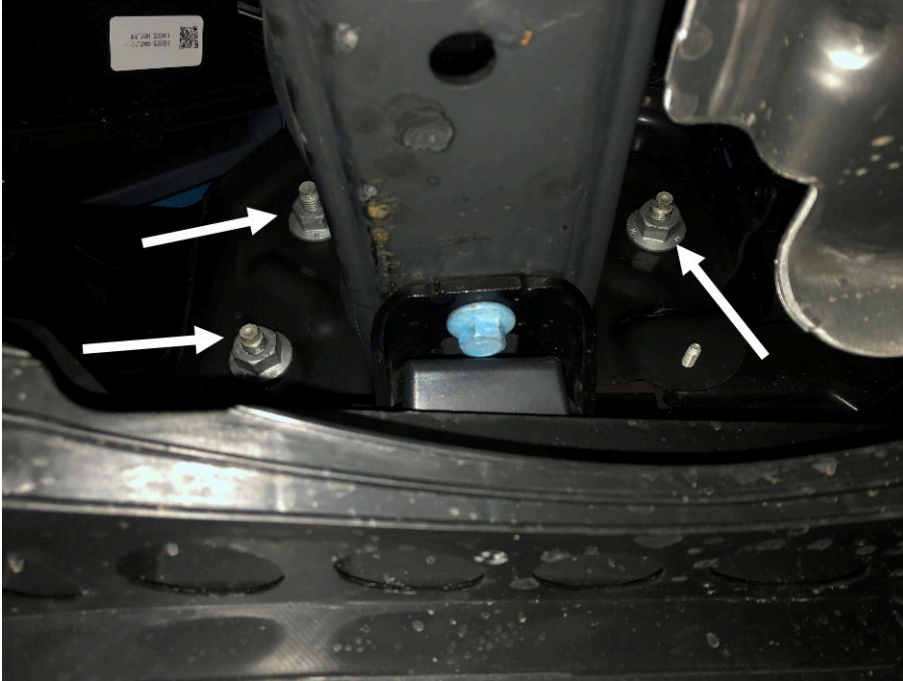


Figure 3

4. If equipped, remove the front air dam skirt from the lower louver system. Use a body pry tool to disconnect the clips long the air dam boarder. Figure 4.



Figure 4

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5. Use an 8mm socket wrench to remove the four bolts holding the lower louver system to the frame. Use a cutting tool to trim the front face off of the louver system. Reinstall the louver system onto the frame again. Figure 5-6.



Figure 5



Figure 6

6. With the OEM bumper removed: Remove the mount plates, fog light bracket brackets and wing structure to access the wiring harness and sensor housings. Carefully remove the sensor from their housings by gently pushing the housing clips outward while pushing the sensor out of the bumper. Figure 7.



Figure 7

7. Remove and label the sensor housings by compressing the locking clips and pushing the housing of the bumper shell. Figure 8.

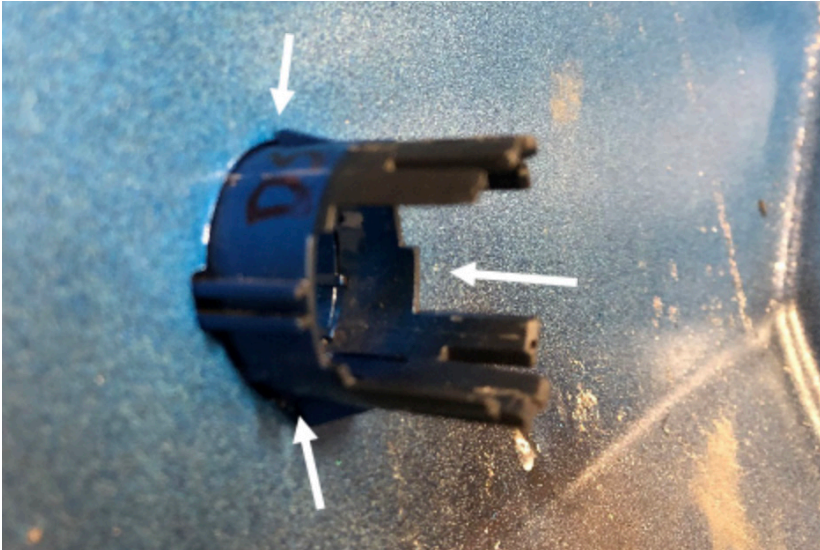


Figure 8

8. If your truck is equipped with Adaptive Cruise Control (ACC) remove the sensor from the OEM bumper and set aside for later install.

9. Use an 18mm socket wrench to remove the two (2) bolts holding the tow hooks onto the frame. Remove the tow hooks from the truck. Figure 9.



Figure 9

10. Take the sensor housings removed during step 7 and install them into their respective holes making sure to put the correct housing back into its OEM location. Figure 10.



Figure 10

11. Run the wire harness through the bumper making sure to keep the plug on the passenger side. Carefully install each sensor into its respective housings. Use the provided epoxy packs to secure the housings and sensors in place. Figure 11.



Figure 11

14. If installing a 20" Single row light bar: Do so now using the slots in the mounting brackets to position the bar as desired.

15. With assistance, hold the bumper up to the mounts and use the 1/2" yellow zinc nuts, flat and lock washers (50498-HW). Figure 14.



Figure 14

16. Align bumper with truck as desired and fully tighten all mounting hardware and plug in all the sensors and harnesses.

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

