



INSTALLATION MANUAL
VENGEANCE FRONT BUMPER
PRODUCT NUMBER: D575X
APPLICATION: 2022 FORD BRONCO RAPTOR



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

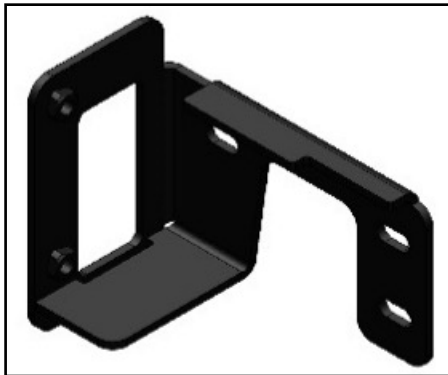
Before you begin the installation process of your new Fab Fours product, we suggest laying out all materials and parts on a pad or protective surface.

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.

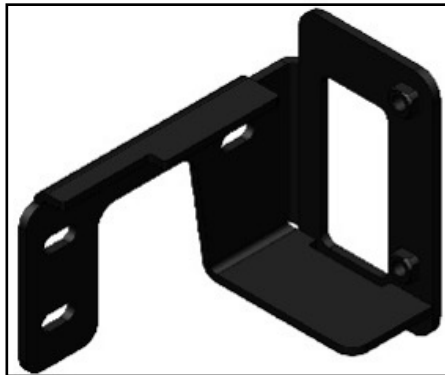
PROVIDED MATERIALS



22934 - BUMPER SHELL



22935 - DS MOUNT BRACKET



22936 - PS MOUNT BRACKET

61632 -
EPOXY QTY:2

61784 -
ACC COVER



TOOLS REQUIRED

- PANEL PRY TOOL
- UTILITY KNIFE
- RULER
- MARKER
- SMALL RECIPROCATING SAW
- 15MM SOCKET WRENCH
- 15MM OPEN END WRENCH.
- 5/8 SOCKET WRENCH
- 5/32" ALLEN WRENCH
- 1/4" DRILL BIT
- 10MM SOCKET WRENCH
- T30 TORX BIT
- T40 TORX BIT

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 | D525X-IM

FAB FOURS IDENTIFICATION	COMPONENT DESCRIPTION	QTY
50372-HW	7/16"-14 x 1.25", Hex head cap screw, Zinc, Grade 8	4
50372-HW	7/16"-SAE, Lock Washer, Zinc, Grade 8	4
50372-HW	7/16"-SAE, Flat Washer, Zinc, Grade 8	4
50372-HW	M6 x 1.0, BLACK STAINLESS, BUTTON HEAD CAP SCREW	8
50372-HW	M6, STAINLESS STEEL, FENDER WASHER	8
50372-HW	M6 x 1.0, STAINLESS STEEL, NYLOCK NUT	2

DISSASSEMBLY

1. Using the panel pry tool remove the (19) push pins attaching the bash plate to the bumper. Figure 1

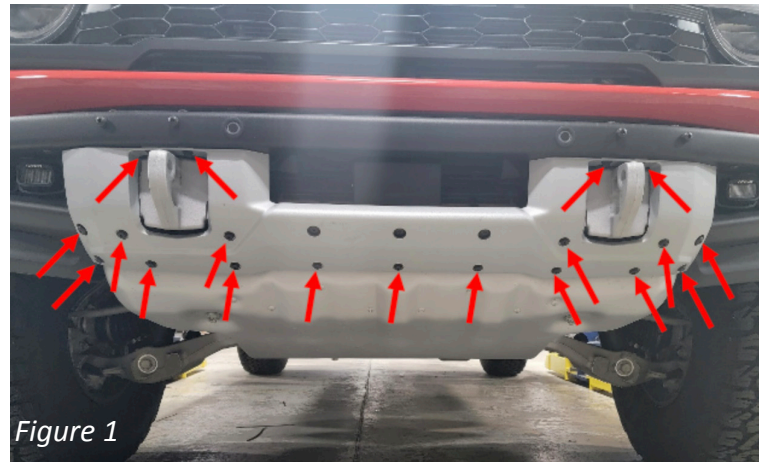


Figure 1

2. Using T40 Torx bit remove the three (3) screws in the bash plate to remove it from the bumper. Figure 2

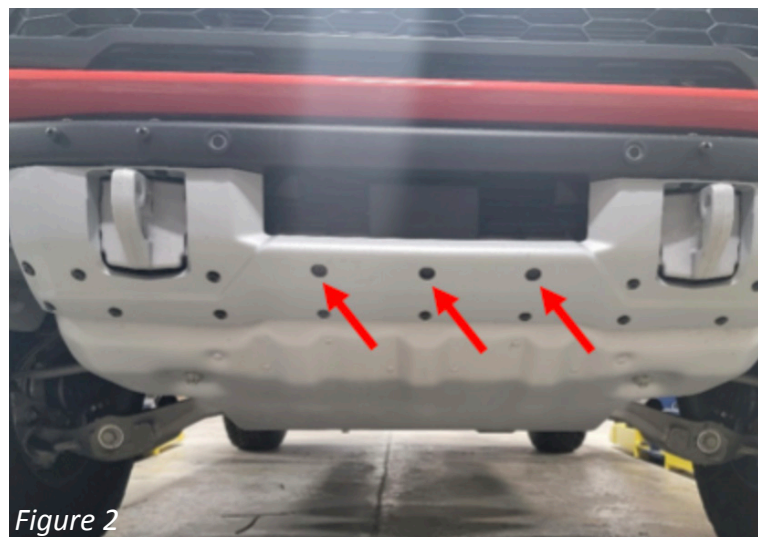


Figure 2

3. Using a 15mm socket wrench remove the six (6) bolts that attach the factory bumper to the frame. Figure 3



Figure 3

4. Disconnect the electrical connector behind the driver side valance below the headlight to separate the sensor harness from the vehicle.

5. The factory bumper can now be removed from the vehicle.

6. Remove the OEM electrical harness from bumper by removing the push pins. Figure 4-5

NOTE: Document the location of each sensor housing for reference when reinstalling into your bumper.



Figure 4



Figure 5

7. Remove the sensor from the sensor housing by expanding both sides of the sensor housing and lifting. (Figure 6-7) NOTE: Sensors are extremely delicate and must be handled with care! Do not push on face of sensors to remove!



Figure 6

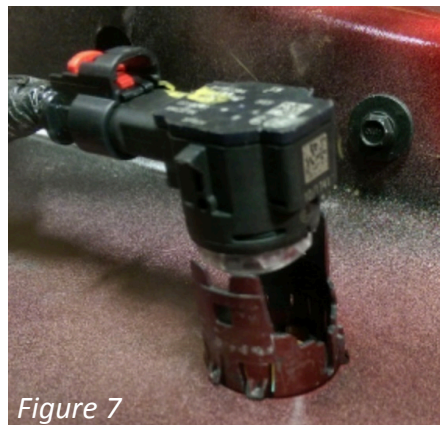
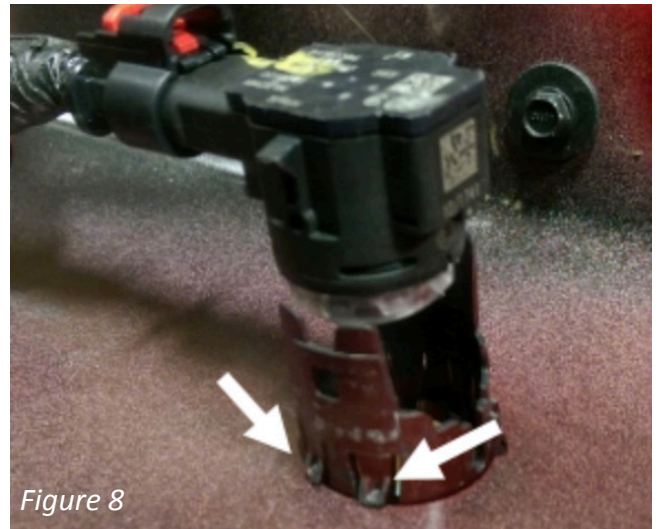
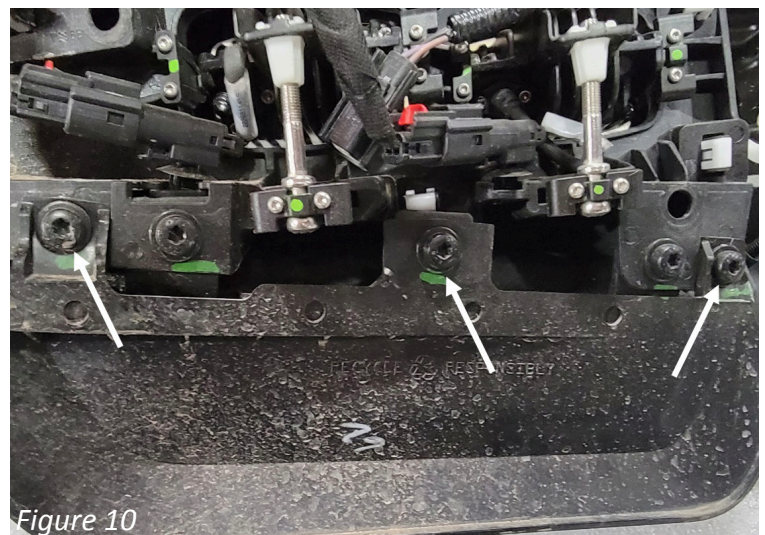


Figure 7

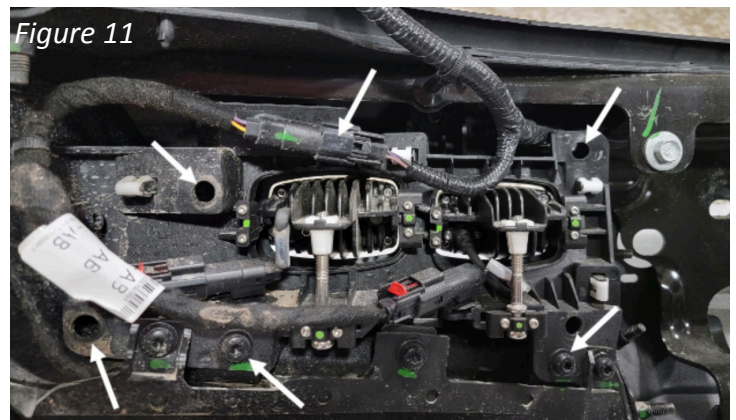
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8. Remove the sensor housing from the bumper by depressing the four (4) tabs while pulling outward from the outside of the bumper. (Figure 8-9)



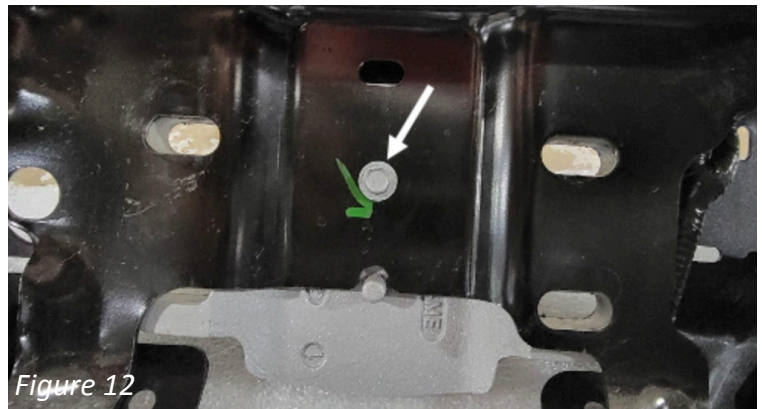
9. Using a T30 Torx bit, remove the three (3) screws in the bumper valances on each side of the bumper top remove them. Figure 10



10. Using a T30 Torx bit, remove the five (5) screws from each factory fog light housing to remove them from the bumper. Then, disconnect the pig tail connector from the main vehicle harness. Figure 11



11. Using a 10mm socket wrench, remove the screw from each factory tow hook and remove them from the bumper. Figure 12



12. Remove the intercooler shroud from the vehicle by depressing the tabs around the perimeter of the shroud and then separating the shroud from the intercooler. Figure 13



PREINSTALLATION

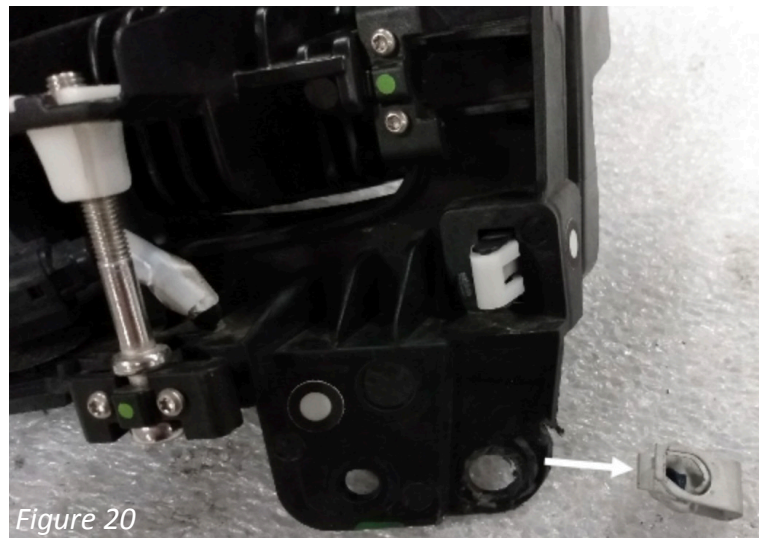
1. Using a small reciprocating saw, trim the factory fog light housings along the lines shown.
Figure 14-17



2. The finished cut light should look like the images shown. Figure 18-19



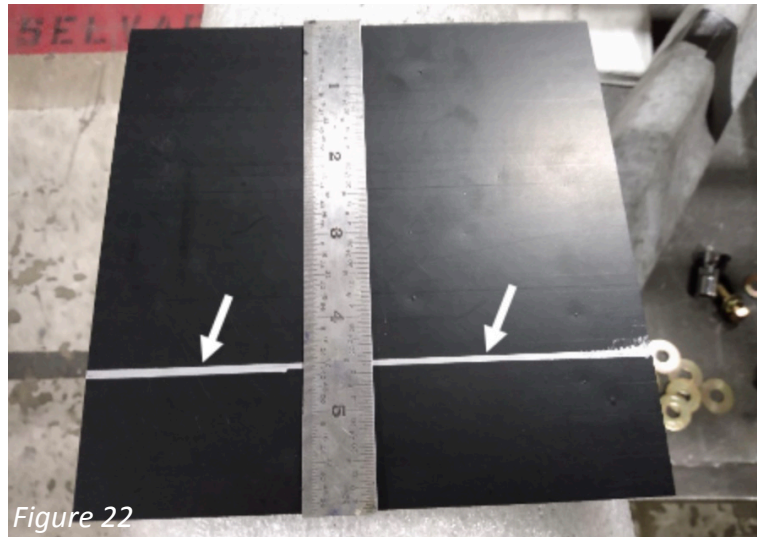
3. Using a pry tool, remove any remaining speed nuts on the factory fog lights. Figure 20



4. Using a 5/32" Allen wrench and the provided M6 black stainless screw and flat washers, install the modified factory fog light housings into the bumper shell using the three outer most holes left in the housing. (part#: 22934). Figure 21



5. Using a utility knife, trim the provided black plastic ACC cover on one side down to 4.5". (part#: 61784). Figure 22



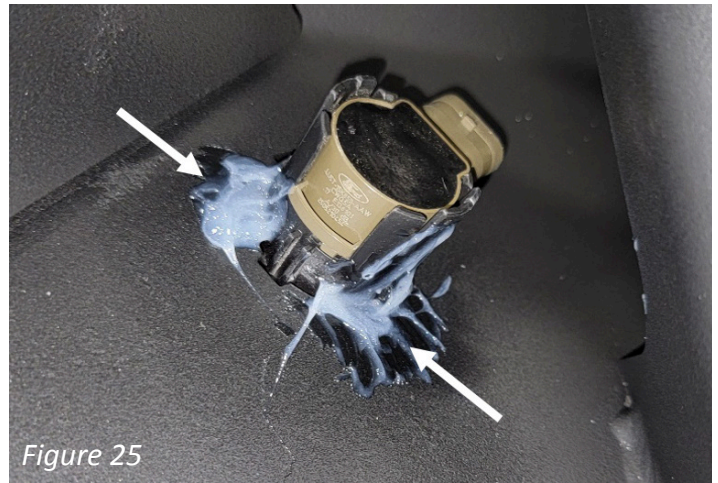
6. Place the previously trimmed ACC cover inside the bumper and center it over the square cutout. Using a marker, locate the two (2) mounting holes for the ACC cover and transcribe them onto the cover. Use a 1/4" drill bit to make two (2) holes in the ACC cover where previously marked. Figure 23



7. Using a 5/32" allen wrench and 10mm socket, install the ACC cover to the bumper with the remaining provided M6 black stainless screws, flat washers, and nuts. Figure 24



8. Insert the parking sensor housings into the bumper shell in the same orientation and position in which they were removed from the factory bumper. Then, use the provided epoxy around the perimeter of the housing inside the bumper to fix them in place. Make sure the epoxy has fully cured before proceeding. Figure 25

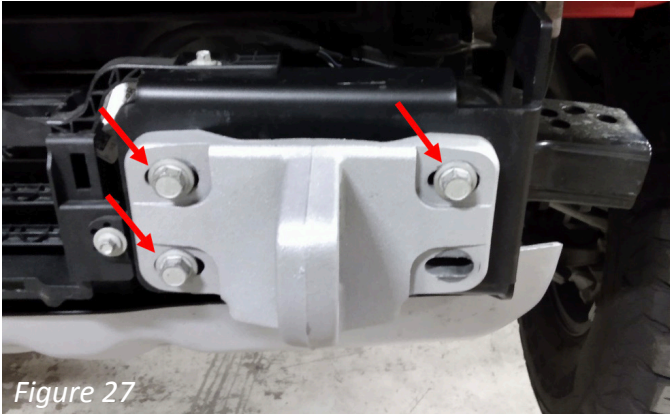


9. Reinstall the parking sensor harness into the bumper shell reconnecting the sensors and fog lights. Use the provided zip tie slots along the top edge of the bumper to secure the harness up tight to the top face of the bumper shell. Be sure to not allow the harness to cross in front of the ACC sensor. Figure 26



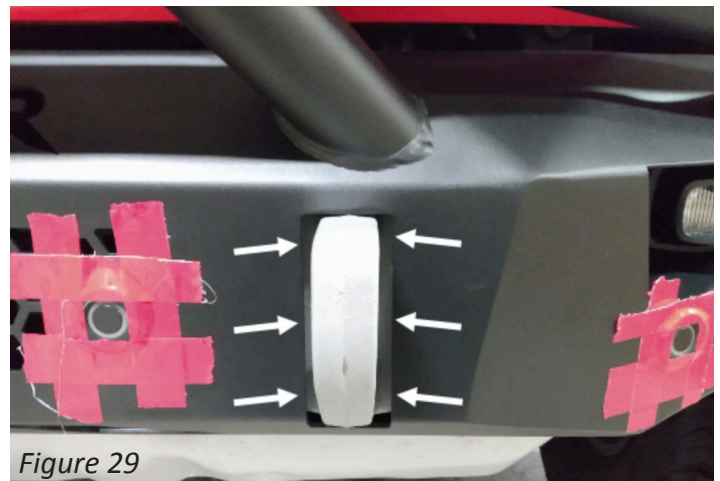
INSTALLATION

1. Reusing the factory bumper mounting bolts, loosely reinstall the factory tow hooks with the provided bumper mounting brackets (part#: DS: 22935 / PS: 22936). Align the notch in the top of the brackets with the louver mounting flange. Figure 27-28



2. With the bumper mounting brackets finger tight, hold the bumper shell up to the vehicle and adjust the bracket width to fit snugly to the inside of the shell mounts and the tow hooks to be centered in the shell cutouts.

Remove the shell and tighten the tow hook mounting bolts using a 15mm socket wrench. The bracket width can also be achieved by premeasuring the width of the bumper shell mounts and setting the width of the separate mounting brackets accordingly. Figure 29



3. Reinstall the bumper shell to the vehicle using a 5/8" socket wrench and the four (4) provided 7/16" hex head cap screw, lock washers, and flat washers in the bumper mounting brackets. Figure 30-31

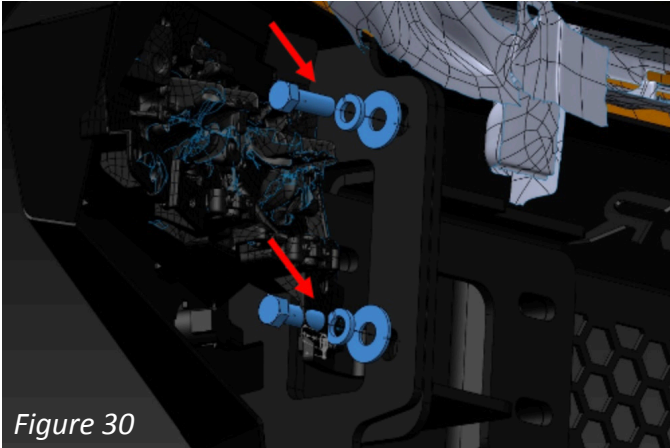


Figure 30

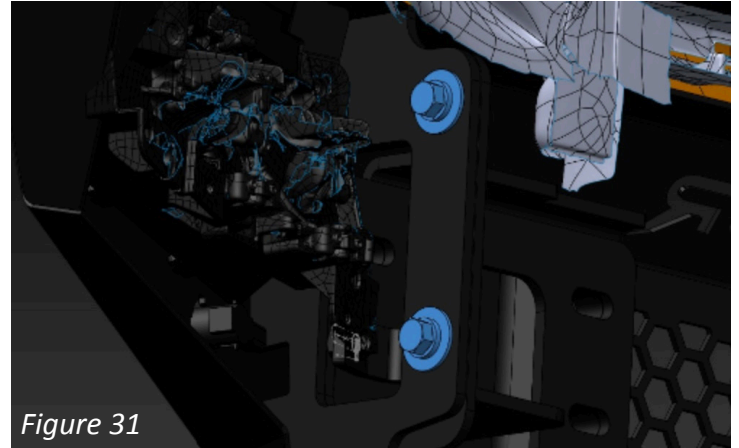


Figure 31

4. Reconnect the OEM sensor harness to the vehicle. Figure 32



Figure 32

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

