



INSTALLATION MANUAL
FRONT BUMPER
PRODUCT NUMBER: N67
APPLICATION: 2024 TOYOTA LAND CRUISER



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

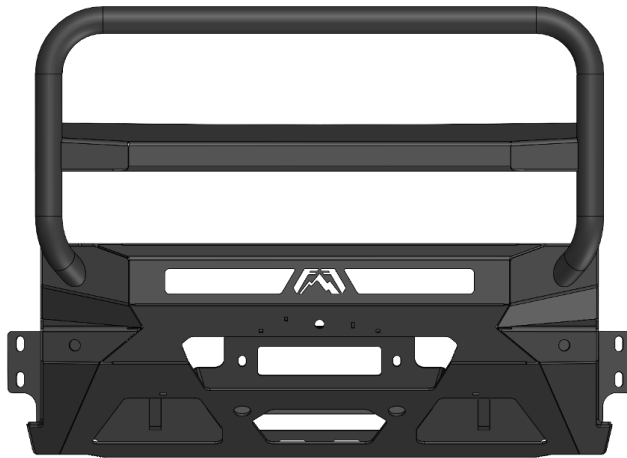
FOUNDER, FAB FOURS

GETTING STARTED

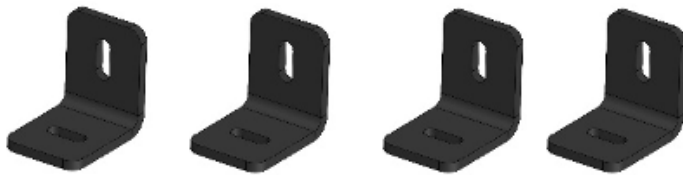
Before you begin the installation process of your new Fab Fours product, we suggest laying out all materials and parts on a pad or protective surface.

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



23400 – FRONT BUMPER



23305 – L-BRACKETS QTY:4



23405 – DS STIFFENER



23406 – PS STIFFENER

61632 – EPOXY PACKETS QTY:2

REQUIRED TOOLS

- PRY TOOL
- ALAN KEY SET
- 10MM SOCKET
- 17MM SOCKET
- 7/16" SOCKET
- 5/8" SOCKET
- 11/16" SOCKET

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 | 50506-HW

ID #	COMPONENT DESCRIPTION	QTY
50506-HW	7/16-14X1.5" YELLOW ZINC HCS, GRADE 8	10
50506-HW	7/16-14 YELLOW ZINC HEX NUT, GRADE 8	10
50506-HW	7/16 USS YELLOW ZINC FLAT WASHER, GRADE 8	20
50506-HW	1/4-20X1" YELLOW ZINC HCS, GRADE 8	8
50506-HW	1/4-20 YELLOW ZINC HEX NUT, GRADE 8	8
50506-HW	1/4 YELLOW ZINC FLAT WASHER, GRADE 8	16
50506-HW	#10-24 18-8 SS BHCS	2
50506-HW	#10-24 18-8 SS NYLOCK HEX NUT	2
50506-HW	#10 18-8 SS FLAT WASHER	4

DISASSEMBLY

1. Open the hood and remove the 8x push pins holding the plastic grill cover to the radiator support and grill. Remove the plastic grill cover. Figure 1.



Figure 1.

2. Remove the 3x 10mm bolts holding the top of the grill to the radiator support. Figure 2.

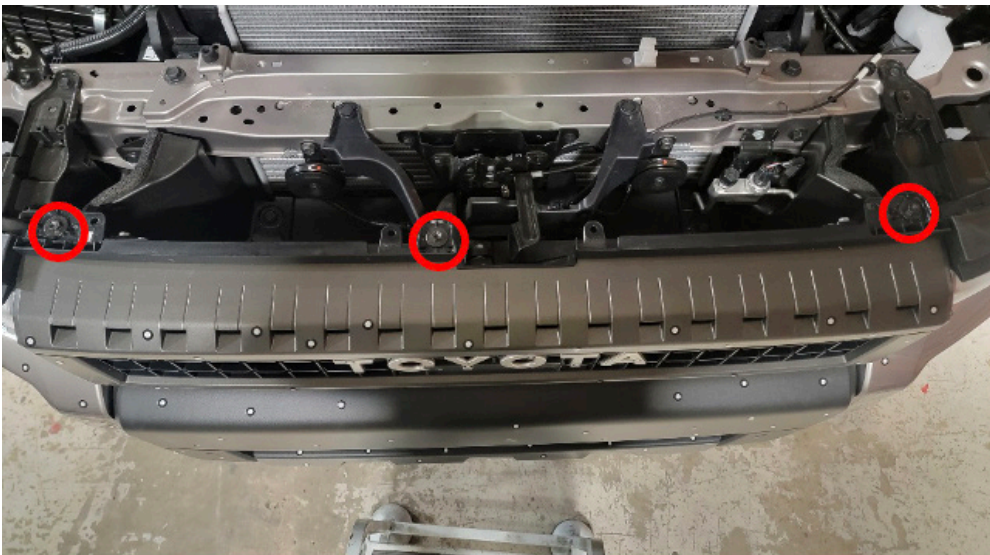


Figure 2.

3. Remove the skid plate trim piece. Use a 10mm socket to remove the 2x bolts on the sides and a pry tool to remove the 1x push pin in the center. Once the trim is removed, you will have access to remove 2x 10mm holding the bumper on to the lower supports. Remove the 2x bolts using a 10mm socket. Figure 3.

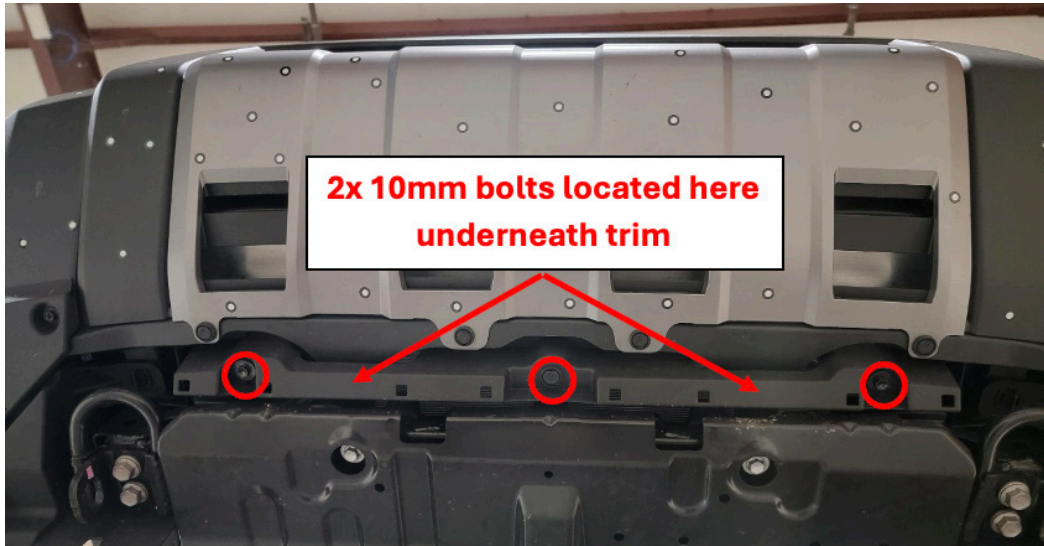


Figure 3.

4. Remove the lower mud flaps/air dams from the driver and passenger side of the bumper. Remove the 3x 10mm bolts on the bottom, and 2x push pins in the wheel wells to remove the flaps from the truck. Figure 4-5.



Figure 4-5

5. Remove the driver and passenger side tow hook air dams by removing the 2x twist push pins. Remove the 2x 10mm bolts at the lower portion of the bumper wings. Figure 6.

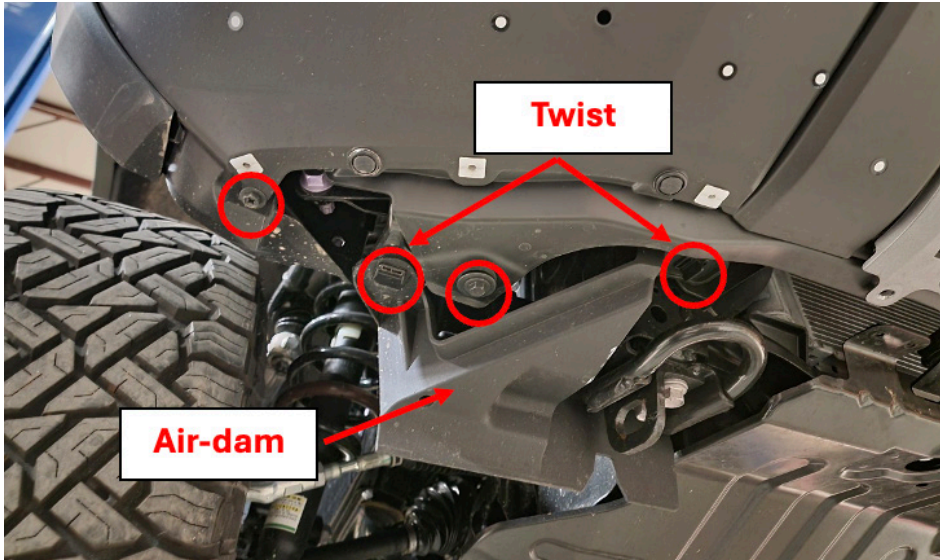


Figure 6.

6. Loosen the driver and passenger side fender trim by removing the 4x push pins and 1x 10mm bolt on the side of the wheel wells. Figure 7.



Figure 7.

-
7. Carefully pull the driver and passenger fender trim away from the truck to reveal the bumper fasteners underneath. Figure 8.



Figure 8.

8. Remove the 1x 10mm bolt and 1x push pin from underneath the fender trim to loosen the bumper. Figure 9.

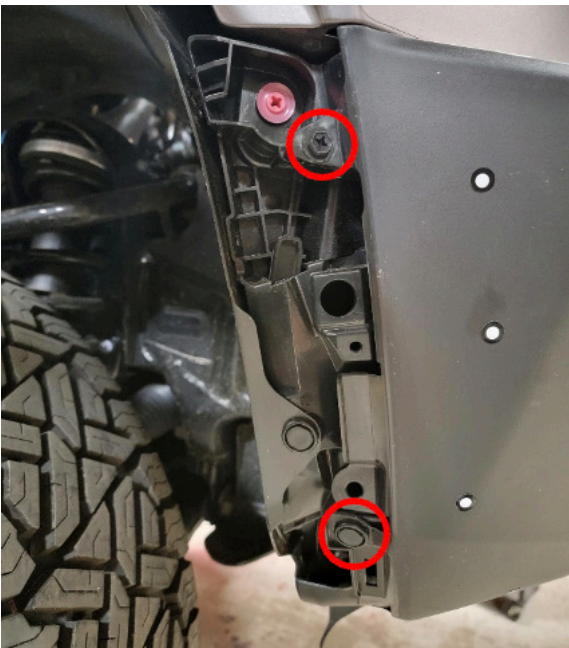


Figure 9.

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9. Starting from the outside working your way towards the grill, carefully pull the bumper fascia away from the truck. Careful firm tugs at each clip location will release the fascia from the truck. Unplug the sensor harness and remove the fascia. Figure 10.



Figure 10.

10. Once the bumper fascia is removed, remove the push pins in the driver and passenger side air-dams from the crash bar . Figure 11.



Figure 11.

11. Remove the crash bar by using a 17mm socket to remove the 4x bolts on each frame rail. Figure 12.

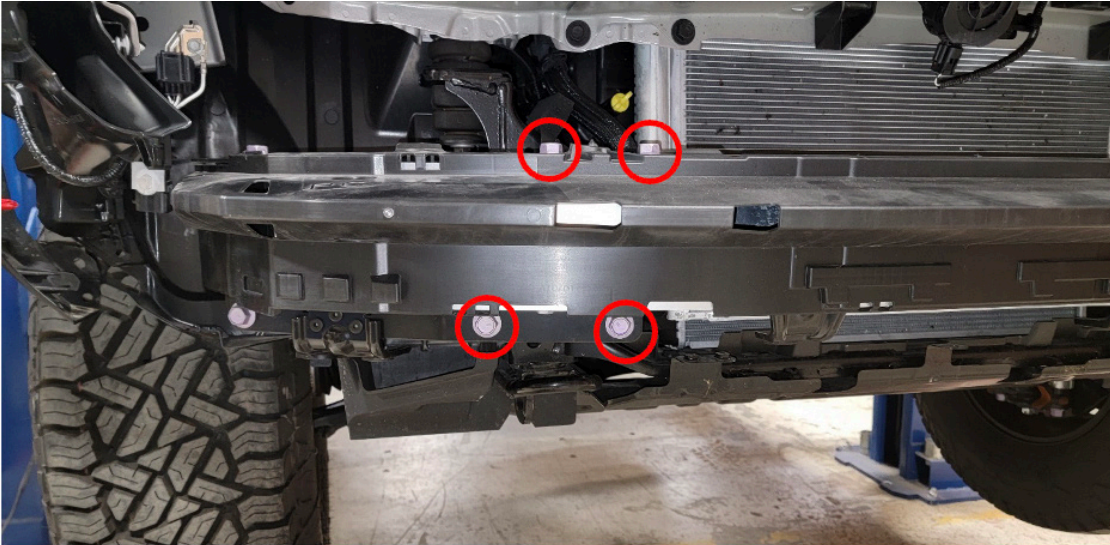


Figure 12.

12. Remove the OR tow hooks using a 17mm socket to remove the 2x bolts. Set bolts aside for bumper install. Figure 13.

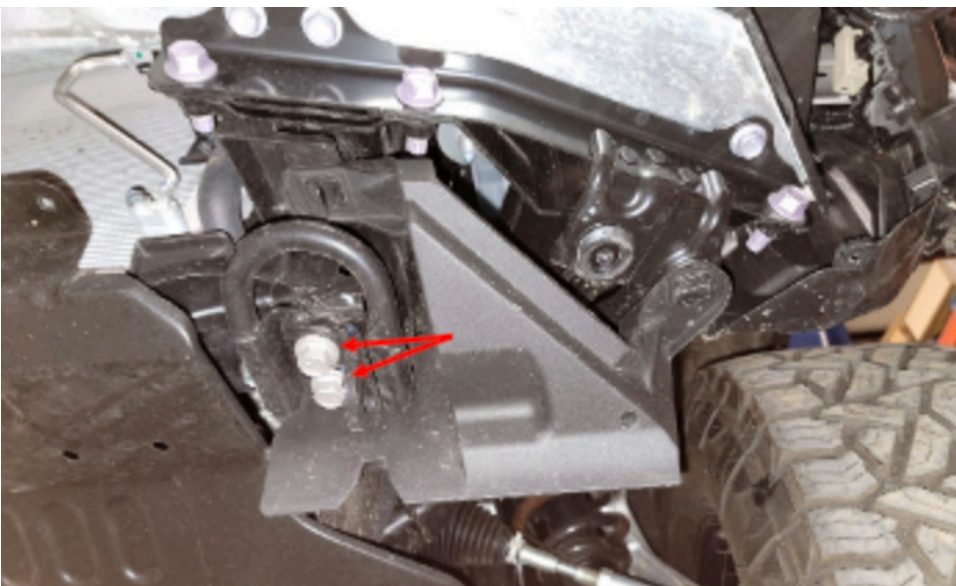


Figure 13.

13. Start to disassemble the OE bumper fascia by removing the front camera. Do this using a Philips head screw driver to remove the 2x screws holding it in place. Unplug the camera from the harness and set aside for installing in new bumper. Figure 14.



Figure 14.

14. Remove the 2x parking sensors from the bumper by carefully pulling the 2x black clips away from the sensor and moving the sensor up out of the housing. Once the sensor is removed from the housing, carefully use a cutting or prying tool to peel the housing off the of the bumper fascia. Figure 15-16.

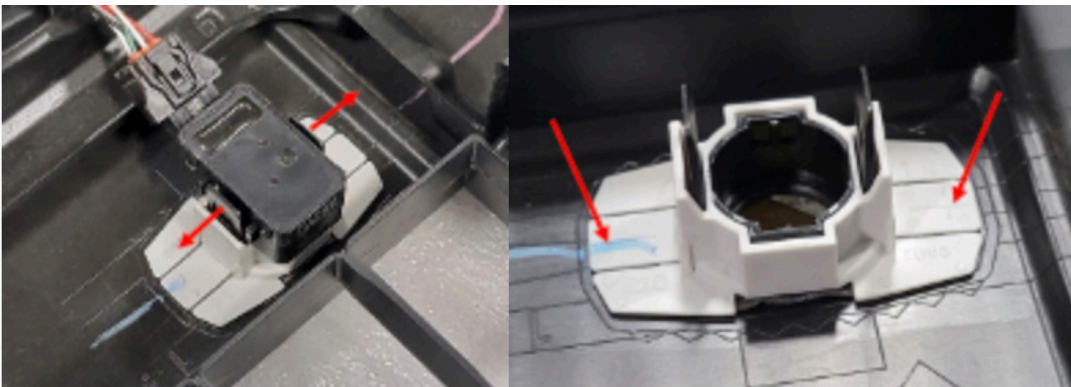


Figure 15-16.

15. Remove the lower fascia covering by removing the 4x push pins from the front, then the 2x Philip head screws, 2x white retaining clips and 6x body clips from the back. Figure 17-18.



Figure 17-18

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16. Remove the center mesh fascia from the bumper by removing the 5x Philips head screws above the mesh and corners, the 4x white retaining clips, and surrounding body clips. Figure 19-20.

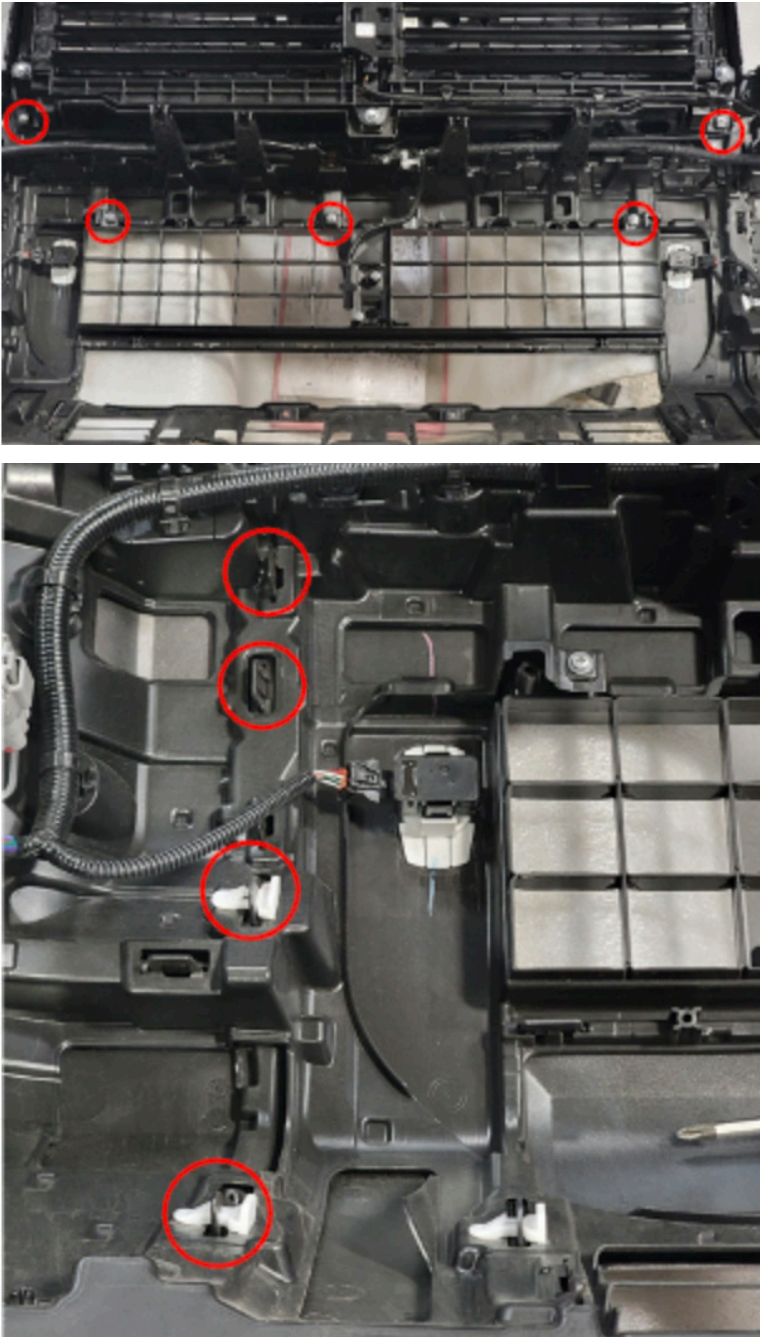


Figure 19-20

17. Next, remove the top and bottom side bumper wing fascia covers (fog light face and lower bumper wings). Start by removing the driver and passenger side fog lights. Figure 21.)

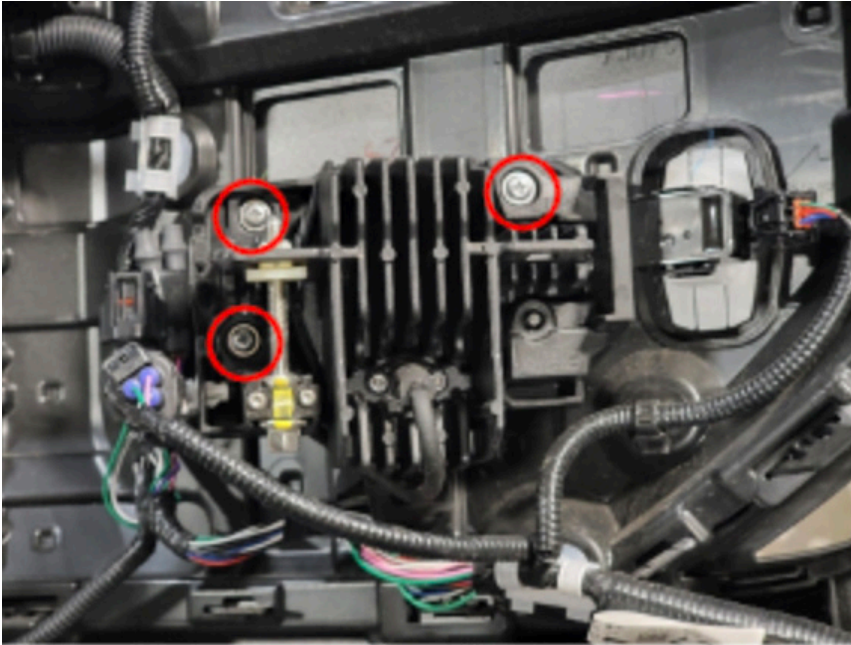


Figure 21.

18. Release the body clips from the inside of the bumper holding the fog light face and lower bumper faces onto the bumper frame. Figure 22.

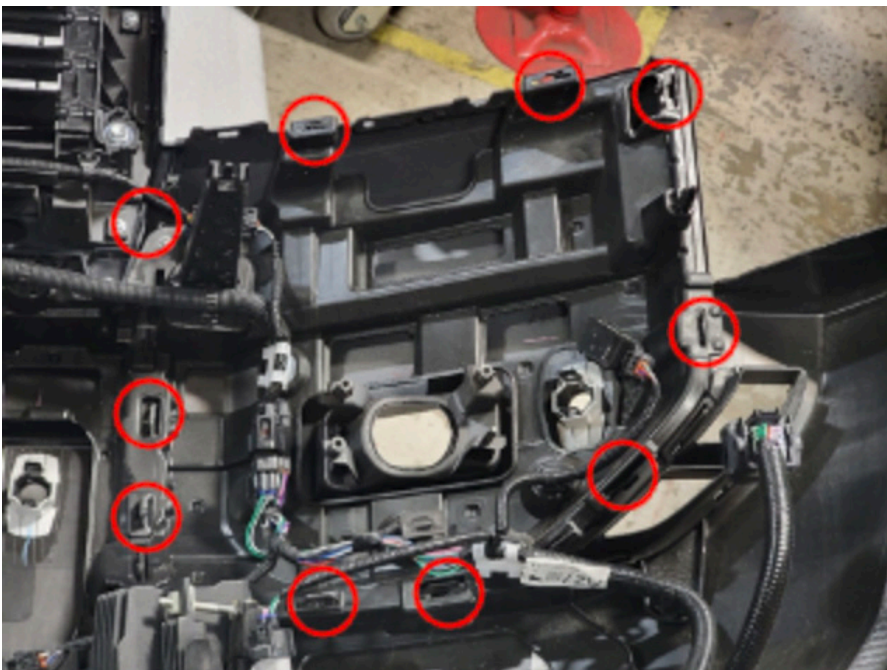


Figure 22.

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19. Once complete, the bumper frame should look like Figure 23 and be ready for trimming. Figure 23.

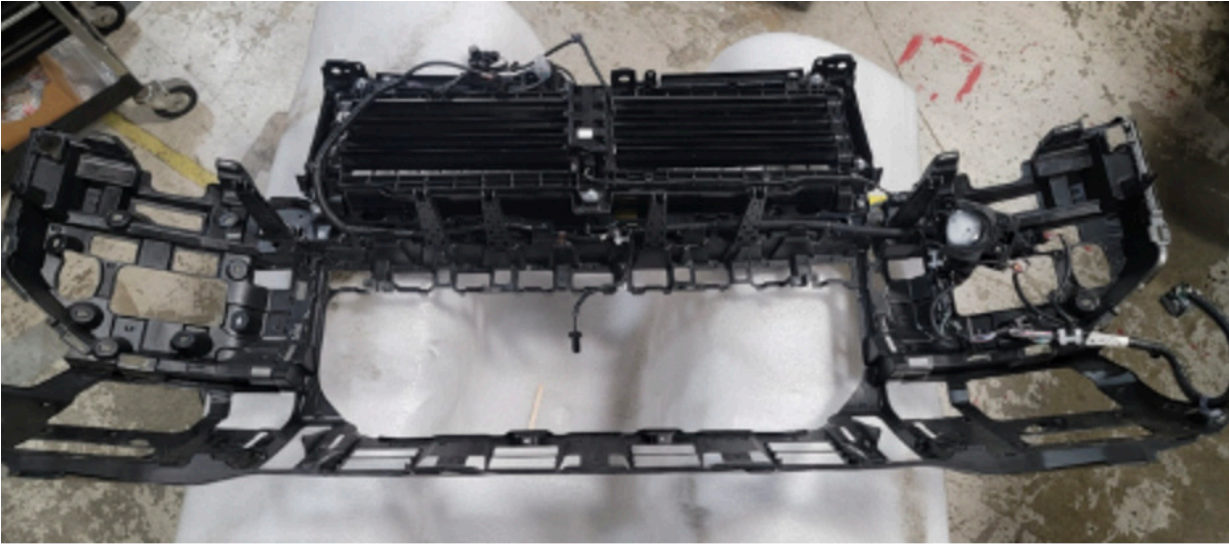


Figure 23.

20. Mark a line shown below around the center part of the bumper (driver and passenger sides) as shown below for trimming. Figure 24.

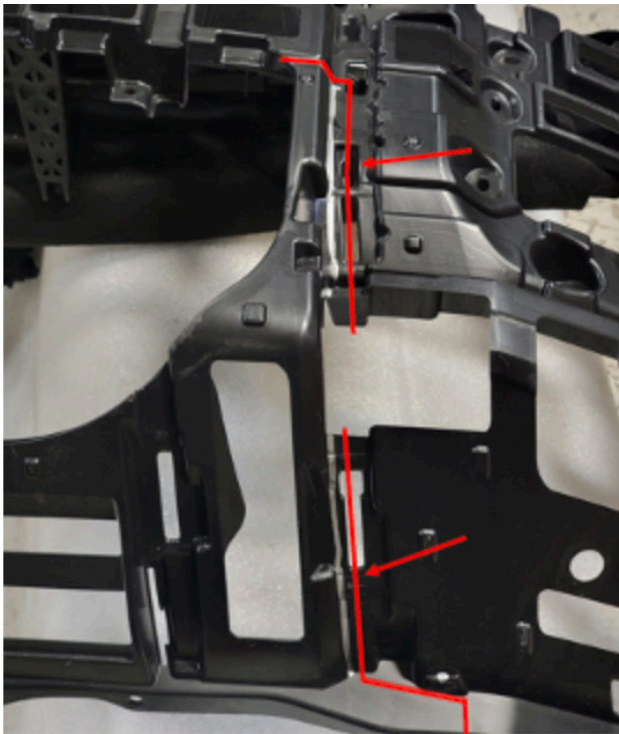


Figure 24.

21. Take the center section removed in step 16 and mark lines for trimming. Trim at the top of the mesh and at the transition seam line as shown. Figure 25-26.

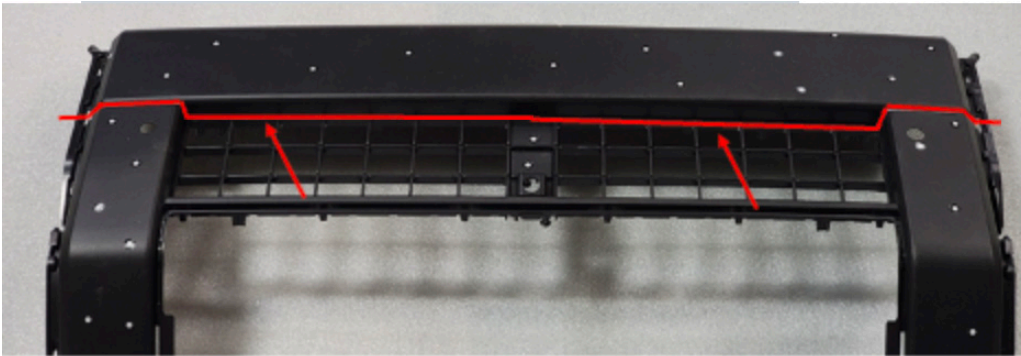


Figure 25.

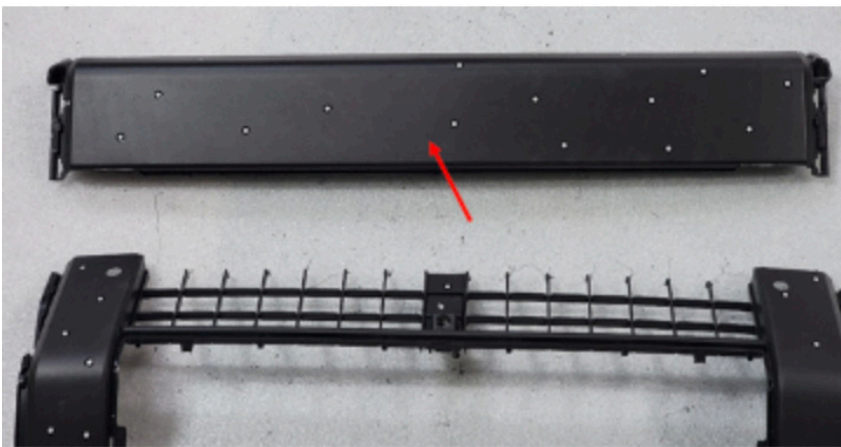


Figure 26.

22. Reverse steps 16-18 to reassemble the bumper fascia for install onto the truck. Install the fascia back onto the truck by reversing steps 1-9 (minus lower air-dams). Figure 27.



Figure 27.

ASSEMBLY

23. Install the camera removed in step 13 into your Fab Fours bumper using the 2x #10 button head screws, washers and nylock hex nuts from the provided hardware. Figure 28.



Figure 28.

24. If installing a 20" light bar: Use the provided L-brackets PN 23305 to attach the light to the mounts with the provided 1/4" hex head bolts, washers and nylock hex nuts. Figure 29.



Figure 29.

25. Use the provided epoxy packets to place the sensor housings removed in step 14 into your Fab Fours bumper. Hold the housings in place using tape or your hands until the epoxy cures (>5 minutes). Figure 30.

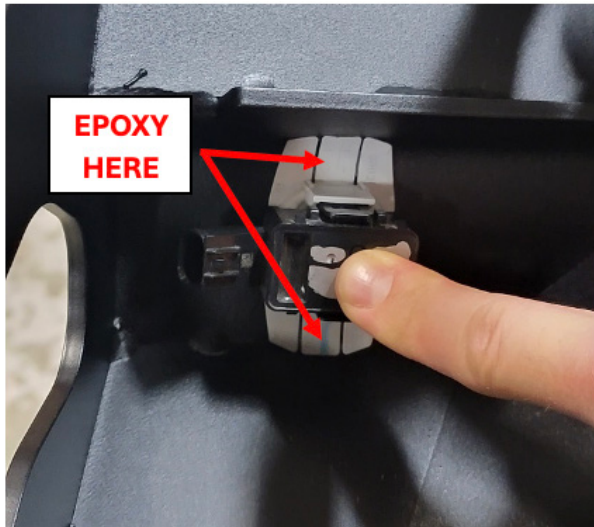


Figure 30.

26. With assistance, hold the bumper up to the mounts being careful to get the bumper around the fascia installed. Use the OE hardware removed during step 12 along with the provided 7/16" hex head bolts, washers, and hex nuts to attach your fab fours bumper to the truck frame. Figure 31-33.



Figure 31



Figure 32

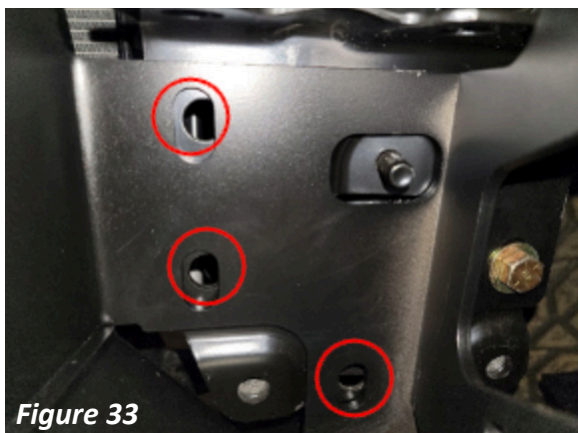


Figure 33

27. Install the stiffener brackets (23405 and 23406) onto the lower mounting brackets using the provided 1/4" yellow zinc hex head bolts, washers and nuts. Figure 34..

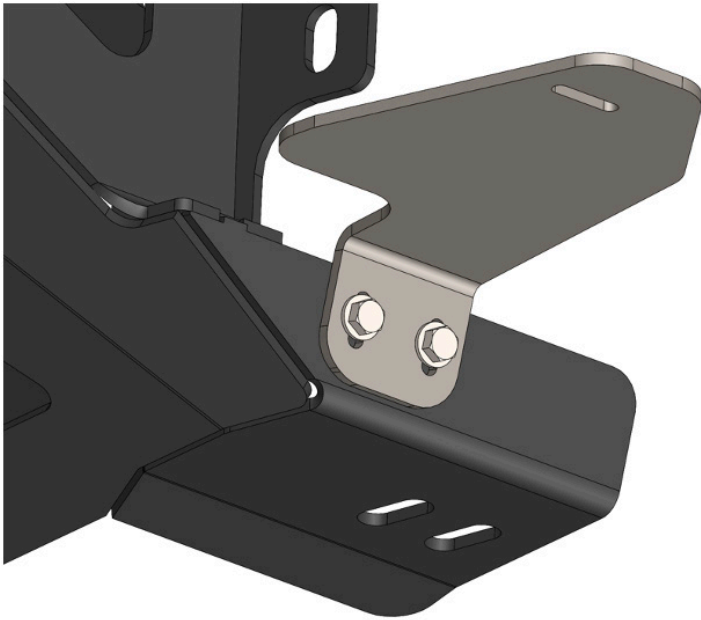


Figure 34.

28. Use a single 1/4" bolt with washers and nuts to fasten the lower bumper fascia to the brackets installed in step 27. Figure 35.



Figure 35.

29. Fully tighten all mounting hardware and plug in the camera and driver/passenger side sensors installed in step 23 and 25 respectively.

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

