



**INSTALLATION MANUAL**  
**HYBRID FRONT BUMPER - NO WINCH**  
**PRODUCT NUMBER: TB24-0304**  
**APPLICATION: 2024 TOYOTA TACOMA**



## **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.

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### **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.

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### **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



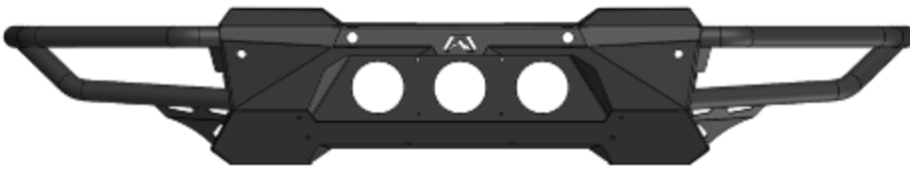
# GETTING STARTED

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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.

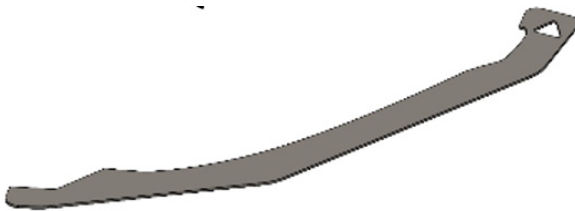
# PROVIDED MATERIALS



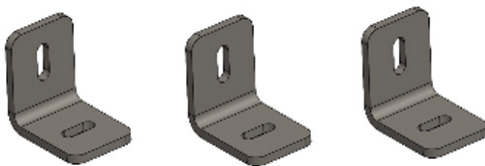
23293 - BUMPER SHELL



23322 QTY: 1



23304 QTY: 1



23323 QTY: 3



23398 QTY:1

23399 QTY:1

61632 EPOXY QTY:2

## REQUIRED TOOLS

- 10MM SOCKET WRENCH
- 17MM SOCKET WRENCH
- 3/4" SOCKET WRENCH
- 3/4" BOX END WRENCH
- 7/16" SOCKET WRENCH
- 7/16" BOX END WRENCH
- PHILLIP'S HEAD SCREWDRIVER
- FLAT HEAD SCREWDRIVER
- LONG SOCKET EXTENSION
- PLYERS
- RECIPROCATING SAW
- BODY PRY TOOL
- PAINTER'S TAPE
- PERMANENT MARKER
- 1" WIDE RULER
- BUBBLE LEVEL
- LASER LEVEL & TRIPOD (HIGHLY RECOMMENDED)

## 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.

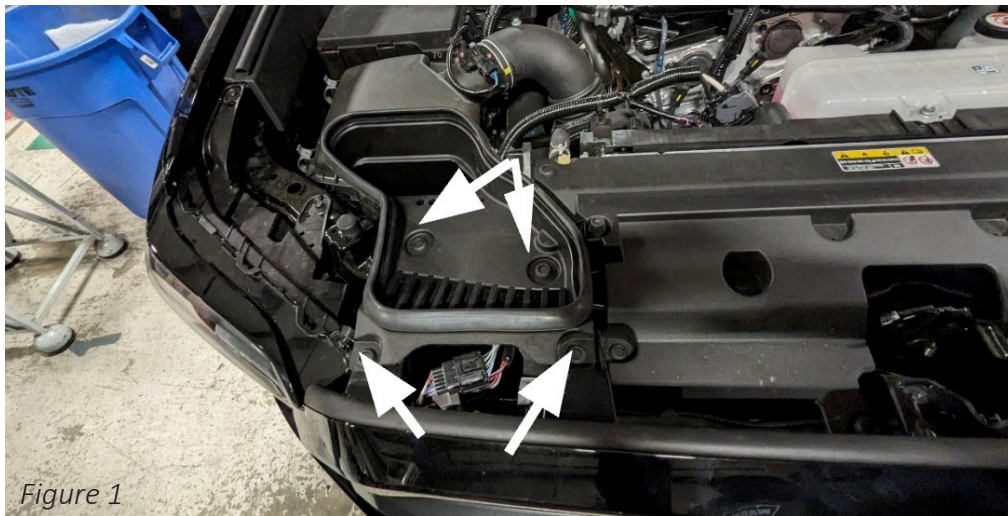


## HARDWARE KIT | 50503-HW

ID #	COMPONENT DESCRIPTION	QTY
50503-HW	7/16-14 YELLOW ZINC HHCS GRADE 8	6
50503-HW	7/16 YELLOW ZINC USS WASHER	6
50503-HW	1 3/4" TUBE CAP	2
50503-HW	1/4"-20 X 1", HHCS , ZINC, GR8	5
50503-HW	1/4"-20 X , HEX NUT , ZINC, GR8	5
50503-HW	1/4"-SAE X , FLAT WASHER , ZINC, GR8	10
50503-HW	1/4"-SAE X , LOCK WASHER , ZINC, GR8	5

# DISASSEMBLY

1. Using the panel pry tool remove the four (4) push pins in the air intake scoop. To release the pins, depress the center. (Figure 1-4)



2. Using the panel pry tool remove the six (6) push pins in the air intake scoop. (Figure 5)

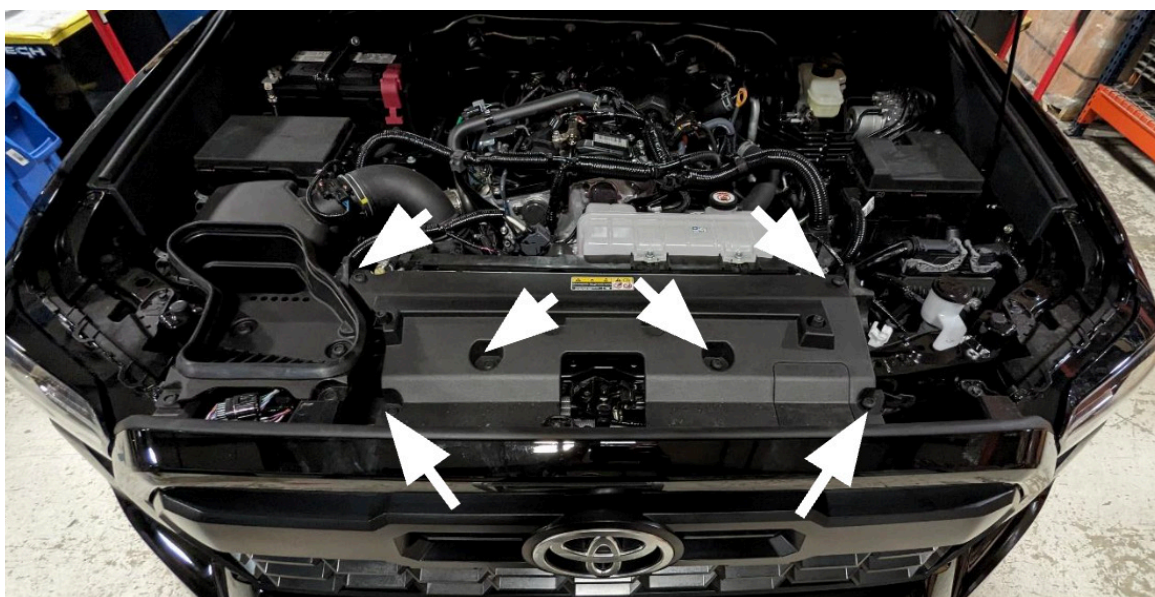


Figure 5



3. Using a flathead screwdriver remove the two (2) plastic pins in the fender liner at the air duct. (Figure 6)



Figure 6

4. Using a 10mm socket wrench remove the (12) screws across the fender liner. (Figure 7)



Figure 7



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5. Using a panel pry tool remove the four (4) push pins across the fender liner. The fender liner can now be removed. (Figure 8)

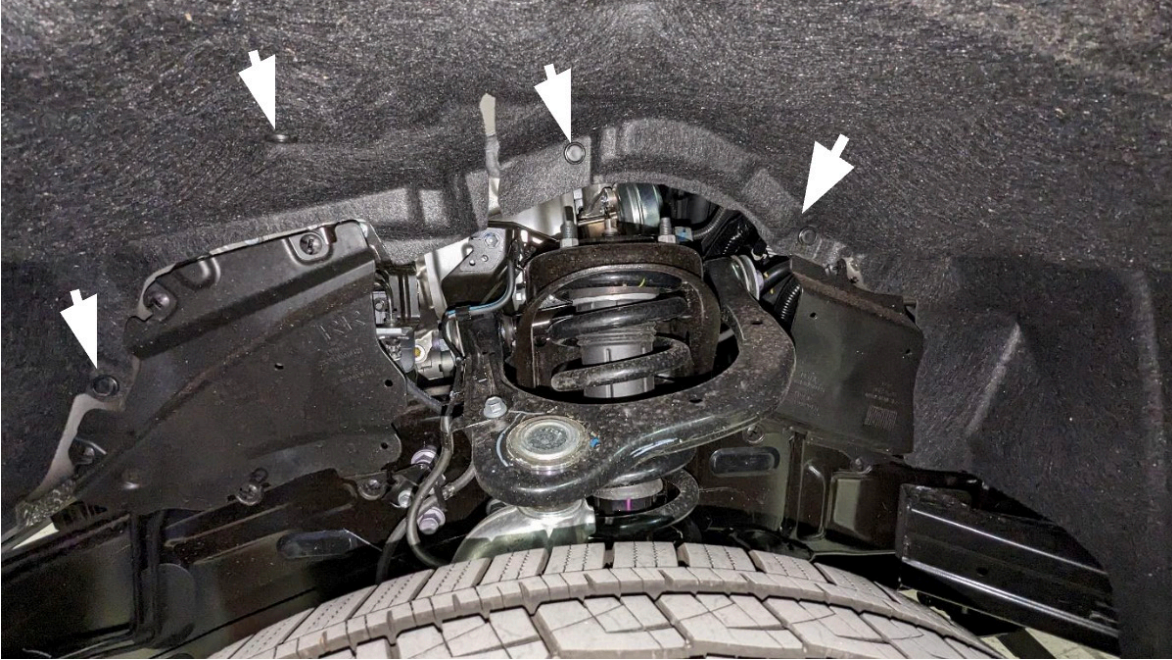


Figure 8

6. Using a 10mm socket wrench, remove the four (4) screws from the skid plate. (Figure 9)

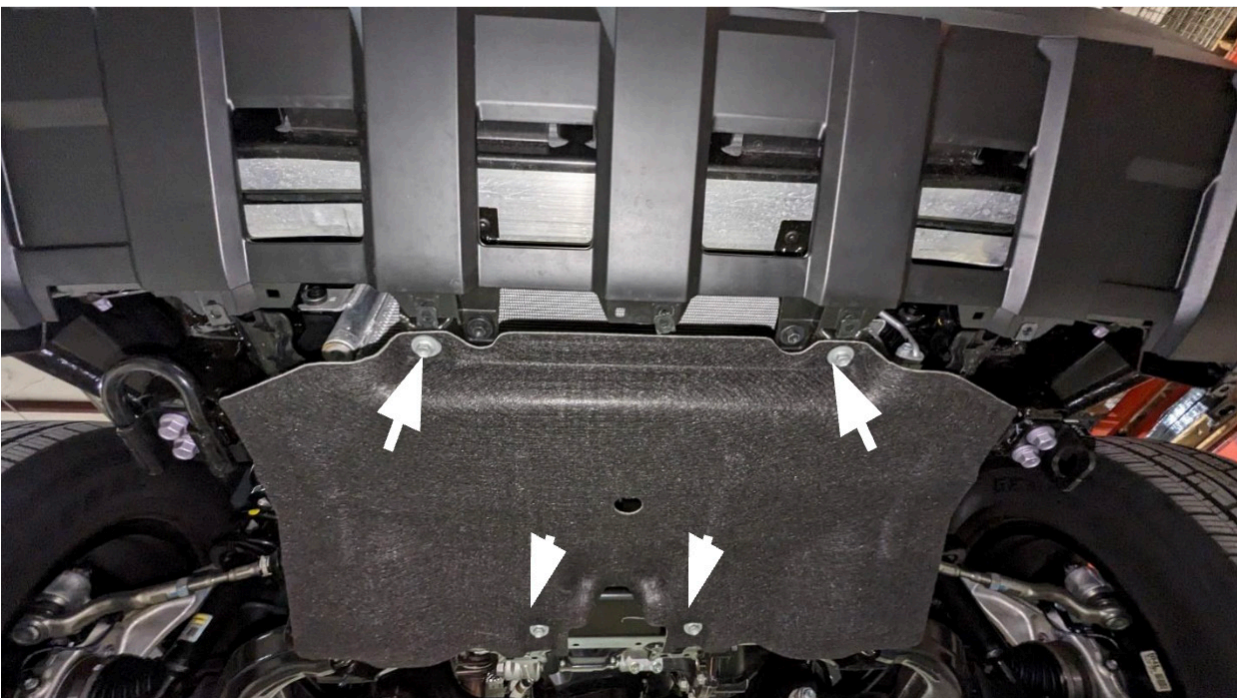


Figure 9



7. If equipped, use a 10mm socket wrench to remove the five (5) screws in the air dam then remove the air dam from the vehicle. (Figure 10)

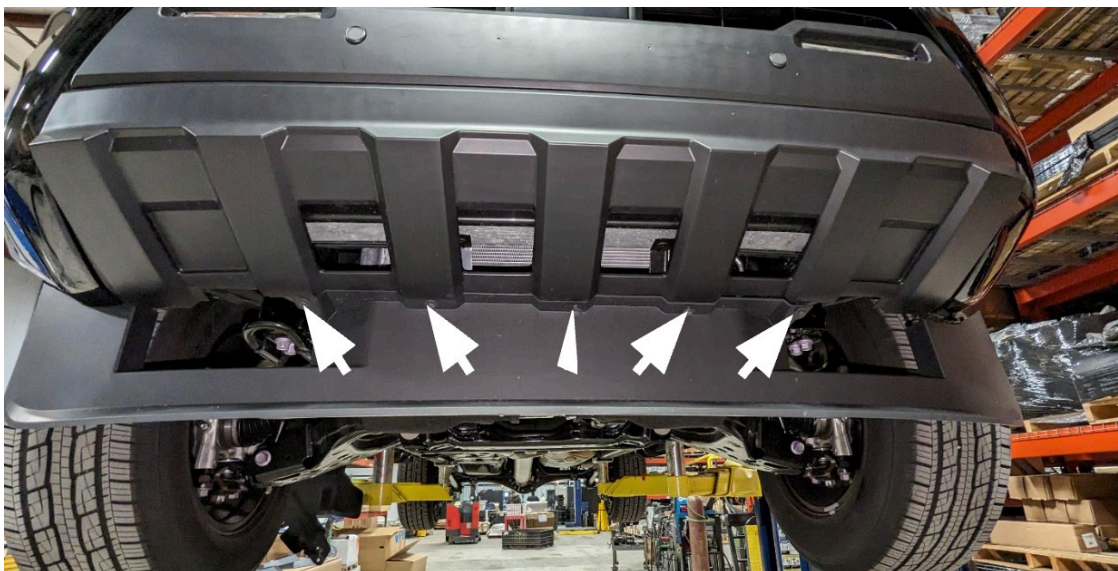


Figure 10

8. Release the three (3) clips at the front of the fender flares then pull outward to release the rest of the push pins to remove the flare from the vehicle. (Figure 11)

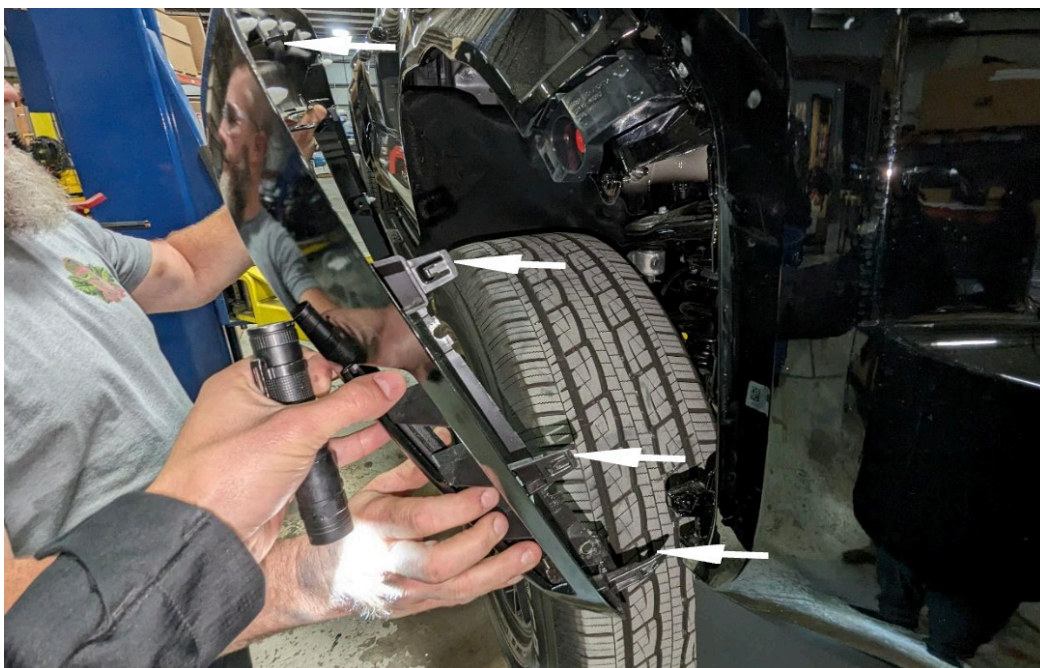


Figure 11



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9. Using a Phillips head screwdriver, remove the screw in the front bumper cover. (Figure 12)



Figure 12

10. Using a 10mm socket wrench, remove the two (2) screws at the bottom of the bumper cover.(Fig. 13)



Figure 13



11. Using a 10mm socket wrench, remove the three (3) screws along the top of the grille. (Figure 14)

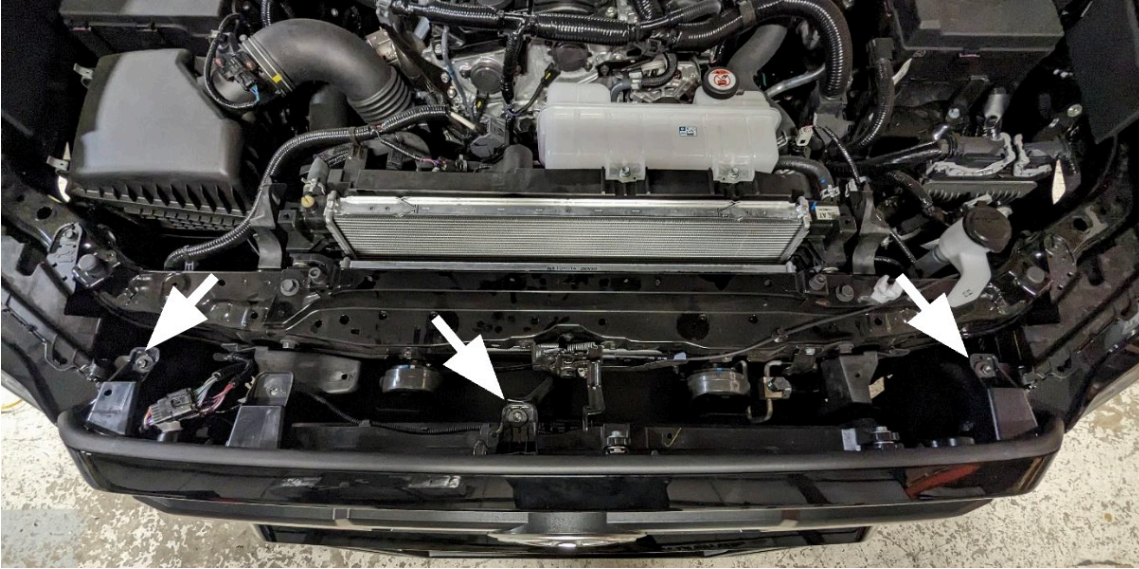


Figure 14

12. If equipped, disconnect the two (2) electrical connectors. (Figure 15)



Figure 15



13. Pull outward on the bumper cover where it meets the fender to release the clips. Then, work your way across the front of the bumper cover releasing the clips to remove the cover from the vehicle. (Figure 16)

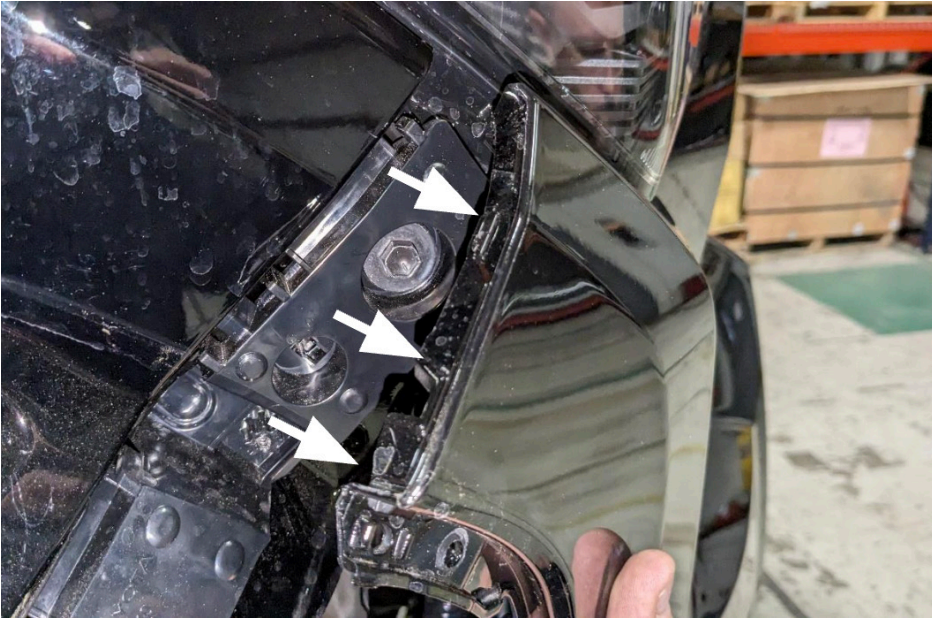


Figure 16

14. Using a 17mm socket wrench, remove the eight screws from the crash bar at the frame horns. (Fig. 17-18)



Figure 17

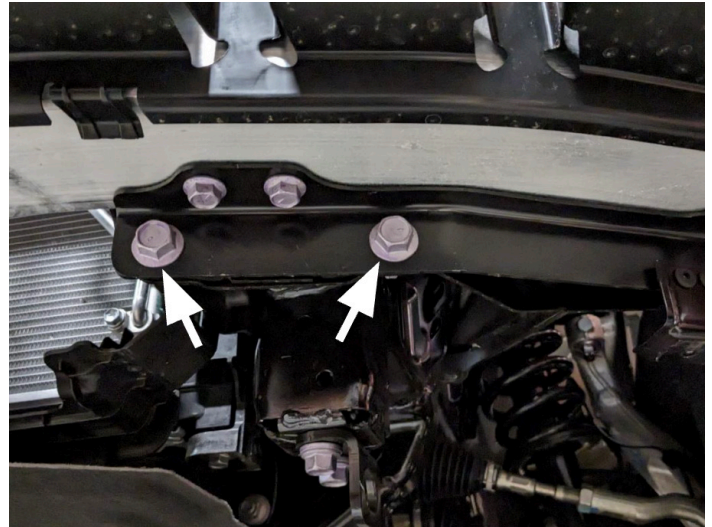


Figure 18



15. Using a 10mm socket wrench, remove the three (3) lower screws attaching the louvers to the front fascia. (Figure 19)

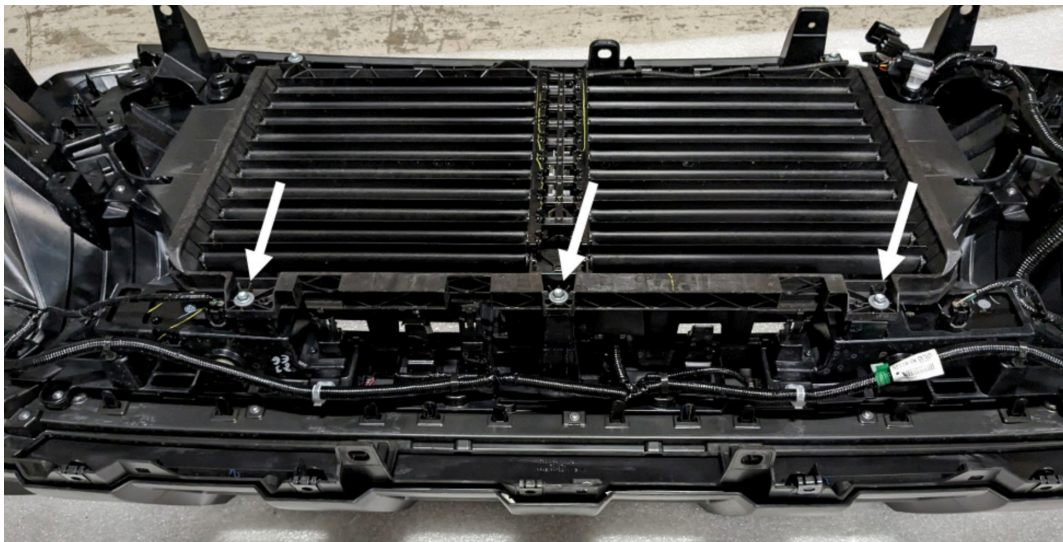


Figure 19

16. Using a Phillips head screwdriver, remove the (10) screws attaching the upper and lower bumper valance at the bottom of the fascia. (Figure 20-21)



Figure 20

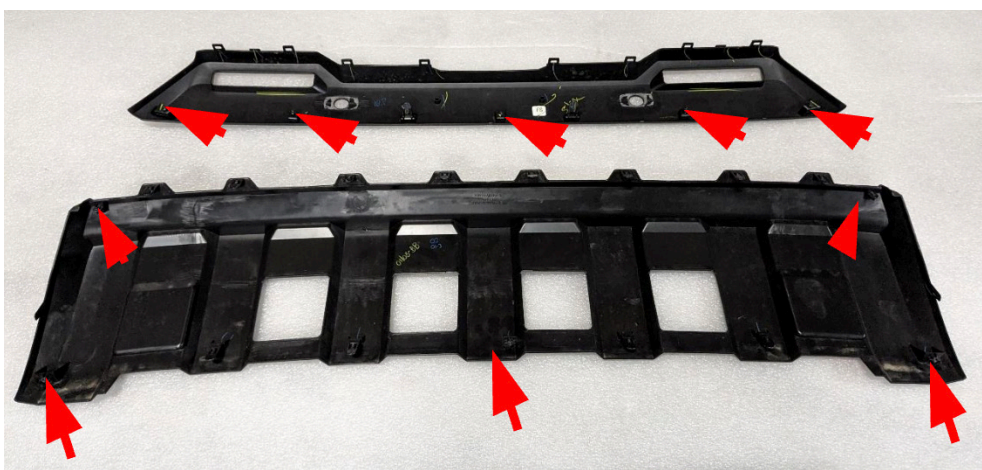


Figure 21



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17. Note and mark location and orientation of all sensor housings and sensors before removing from bumper.

18. Using a razor blade, remove the two (2) parking sensor housings from the upper valance by cutting through the double-sided tape. (Figure 22)

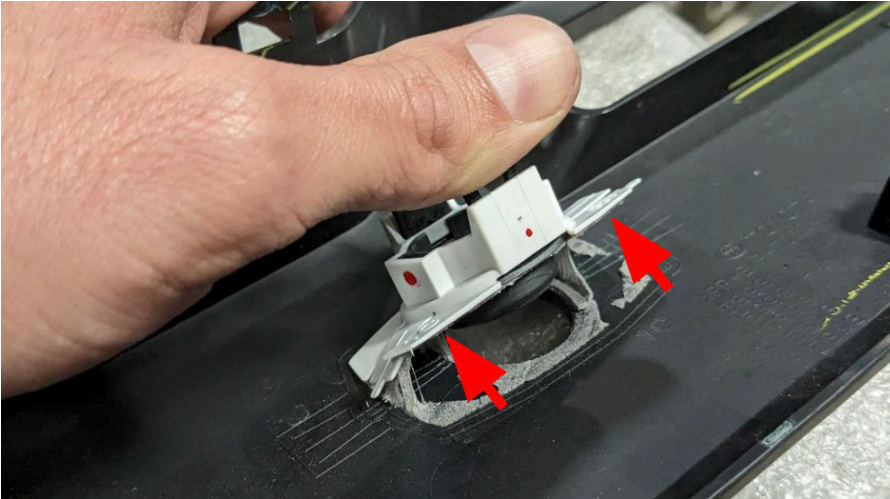


Figure 22

19. Remove outer sensors and sensor housings from bumper using razor blade as shown in step 18.

20. Remove OEM fog lights by unplugging and removing Phillips head screws from front of lights.

21. Using a 17mm socket wrench, remove the two (2) tow-hooks at the bottom of the frame rails. Keep the hardware for later. (Figure 23)



Figure 23

22. Reassemble grill and valance to truck by reversing steps 1-13, with the exception of connecting the vehicle wire harness (step 12)

# MARKING & CUTTING

23. Place level on flat part of bottom of truck frame rails. Level truck front to back and side to side using floor jacks. (Figure 24)



Figure 24

24. Place roughly 10-12 inches of painter's tape on both sides of bumper as shown in figure 25. Extend tape around fender flares.



Figure 25

**NOTE:** If not using a leaser level skip to step 25



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25. Setup laser level on tripod pointing toward front of truck. Set laser line height roughly  $\frac{1}{2}$ " below lower line on adaptive cruise control face. Figure 26

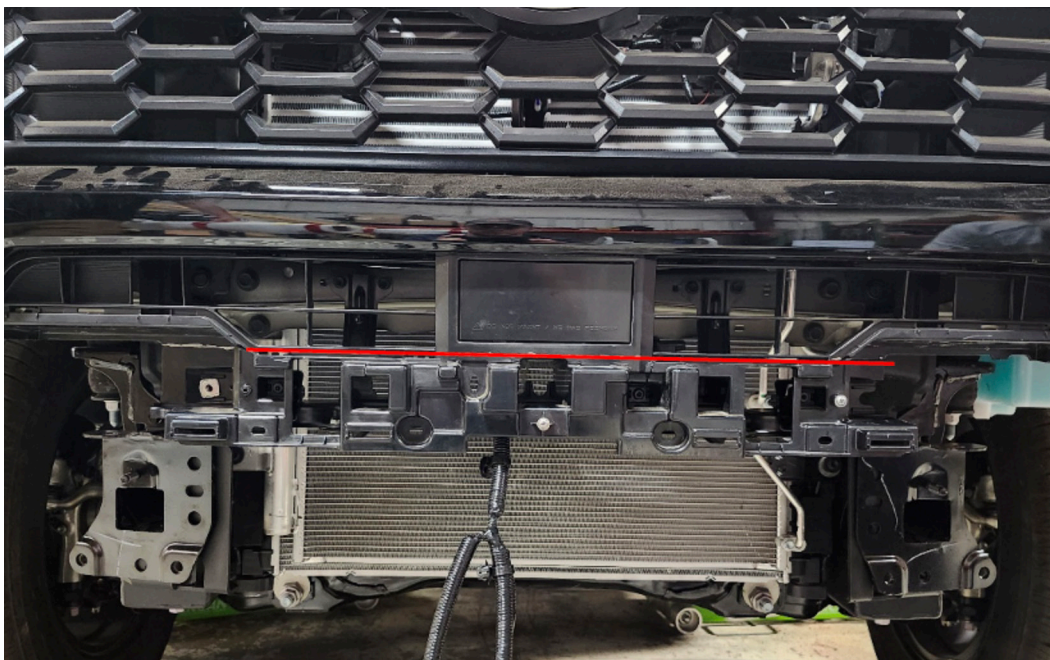


Figure 26

26. Use a marker to transfer laser mark onto painters' tape on both sides of bumper. Figure 27.



Figure 27

27. Use reciprocating saw to cut outer portions of bumper and fender flare on drawn line.



28. Cut middle of grill structure along laser level line. At center of grill cut roughly 45 degrees leaving middle mount for louvers. Figure 28 & 29

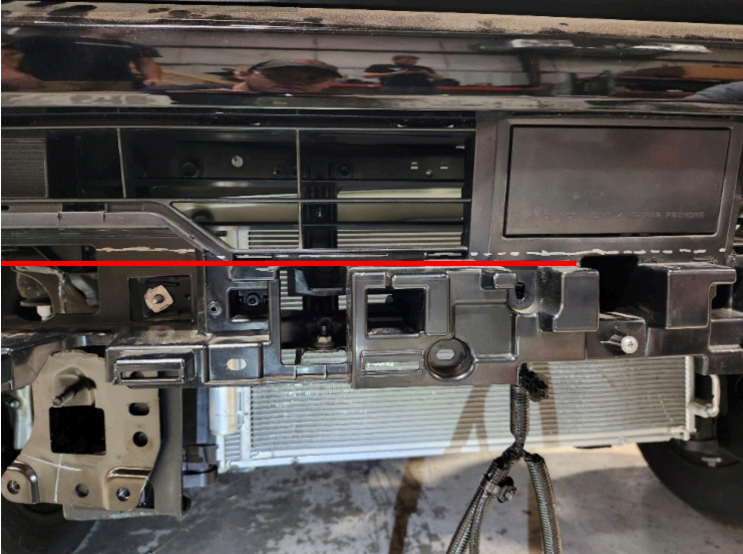


Figure 28



Figure 29

**NOTE:** If NOT using a laser level follow the following steps. If using laser level, skip to step 33

29. Trace curve of bumper below headlight using marker. (Figure 30)



Figure 29



30. Using 1" ruler, draw straight line down body line just in front of fender flare. (Figure 31)



Figure 31

31. Using 1" ruler draw fifteen (15) parallel lines across front of bumper exactly 1" apart. Number lines 1-15 starting closer to vehicle wheel well. Figure 32.

32. Circle lines 4, 9, and 14. Using ruler, measure from top line and make marks on each line. Measurements shown in Figure 32 underlined in red.



Figure 32

33. Use metal template (23304) to trace line across bumper at marks made in step 28. (Figure 33)



Figure 33

34. Repeat steps 25-29 on opposite side of truck and use reciprocating saw to cut outer portions of bumper and fender flare on drawn lines.
35. Cut center grill right below grill opening in small channel in plastic. Continue cut straight across toward outside of truck to meet up with cut made in step 30. (Figure 34) Note: Do not cut center most part of grill until reading next step.



Figure 34



**36. At center of grill cut roughly 45 degrees leaving middle mount for louvers. (Figure 35)**



*Figure 35*

**37. Using 10mm wrench, remove center mounting brackets by removing four (4) bolts in center brackets. Figure 36**



*Figure 36*

# ASSEMBLY

38. Install replacement louver bracket (23300) in place of OEM brackets removed in step 33. Use 10mm wrench to tighten OEM bolts. (Figure 37) Before tightening, center bracket's middle mounting hole with center mount of louver.

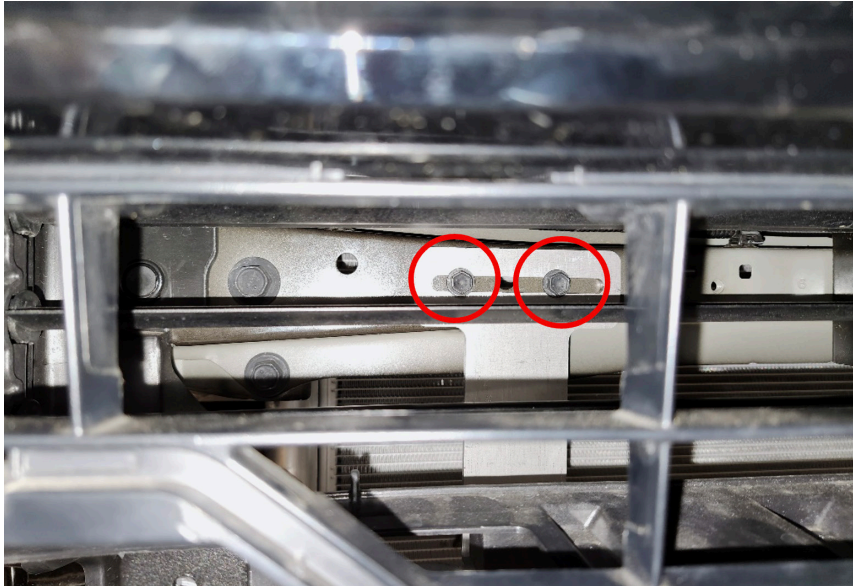


Figure 37

39. Using  $\frac{1}{4}$ " bolts,  $\frac{1}{4}$ " nuts and washers, install three (3) L-brackets (23305) attaching truck louvers to replacement louver bracket (23300). Outside L-brackets face towards truck, middle L-bracket points away from truck. For middle L-bracket, reuse OEM bolt and captive nut to attach louver to L-bracket. (Figures 38 & 39)

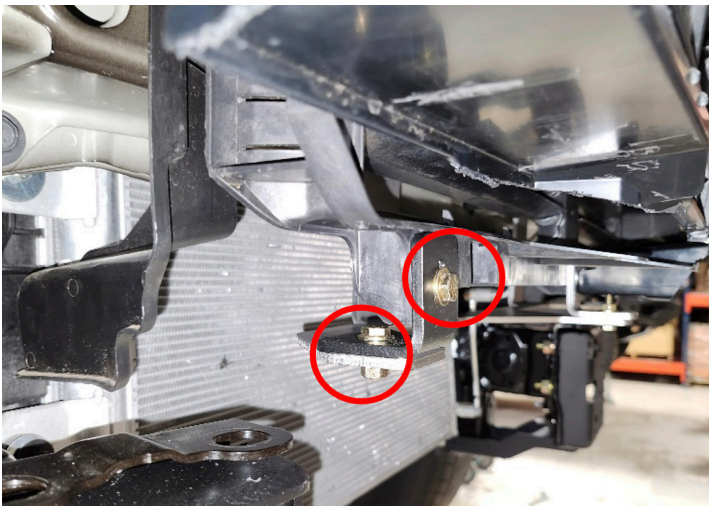


Figure 38

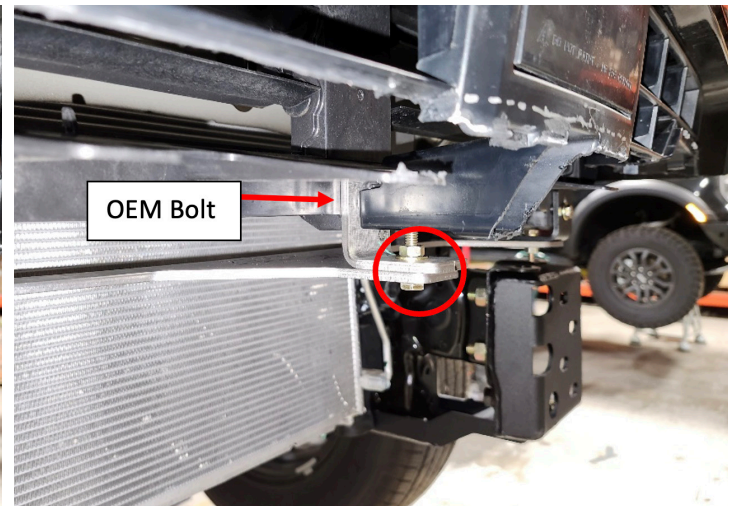


Figure 39



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40. Using 7/16" socket and wrench, and 10mm socket, tighten all bolts on louver replacement bracket.
  41. If installing lights: Do so at this time using the manufacturer's instructions.
  42. Use the provided epoxy to install the sensor into the Fab Fours bumper. Tape can be used to hold the sensors in place while the epoxy cures. Figure 40

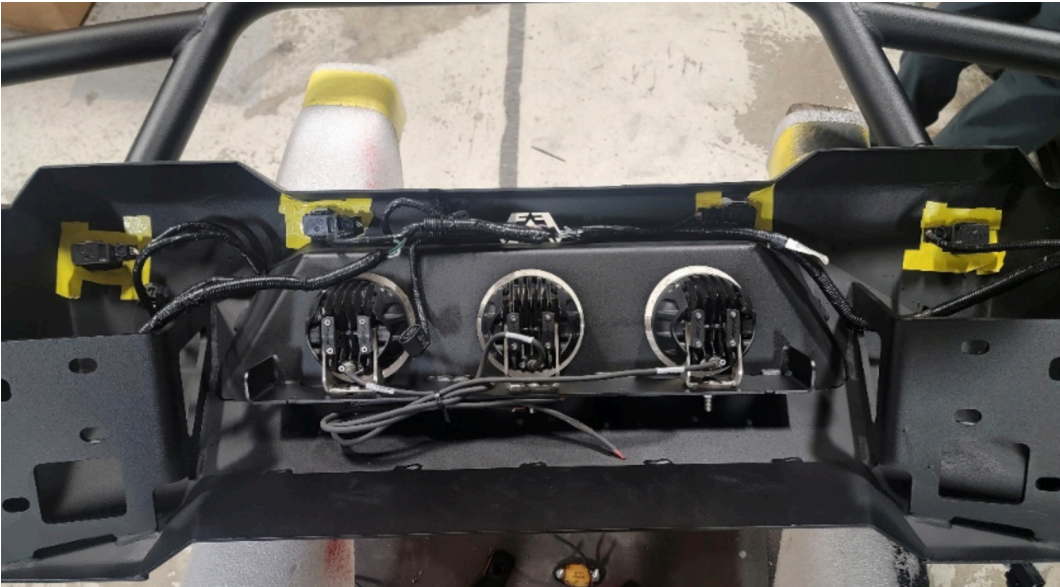


Figure 40

43. Before holding the bumper to the truck for installation, place the nut plates (23398 and 23399) in the driver and passenger side mounts respectively. Figure 41-42.

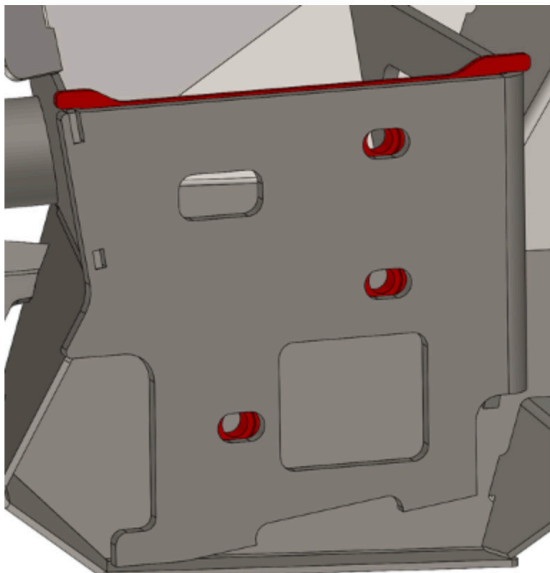


Figure 41

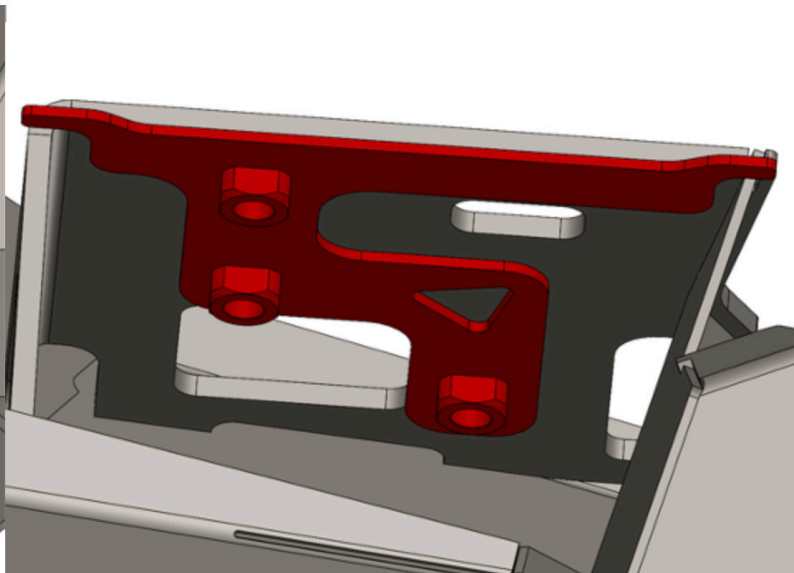


Figure 42

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44. With assistance, hold the bumper up to the truck and use the provided 7/16" yellow zinc 6X (six) HHCS to fasten the bumper in place. Adjust the bumper to desired position and fully tighten in place.
  45. Plug in the sensor harness and enjoy your Fab Fours bumper.

**INSTALLATION COMPLETE**



# CONTACT INFORMATION

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**FABFOURS.COM**



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

**- GREG HIGGS**

