



**INSTALLATION MANUAL**  
**HYBRID FRONT BUMPER**  
**PRODUCT NUMBER: TB24**  
**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



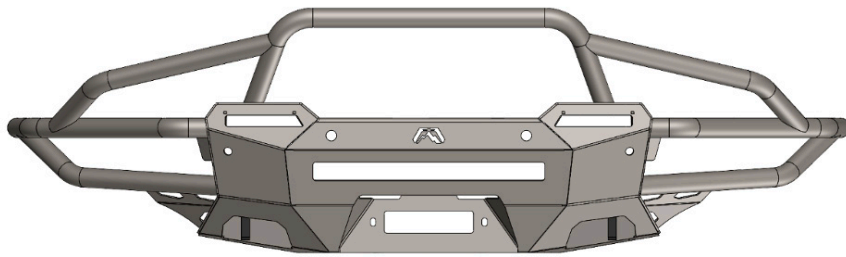
# GETTING STARTED

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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



23346 - BUMPER SHELL



23290 DS BRACKET  
QTY: 1



23291 PS BRACKET  
QTY: 1



23297 DS NUT STRIP  
QTY: 1



23298 PS NUT STRIP  
QTY: 1



22573 LIGHT BAR  
L-BRACKETS QTY: 2

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.

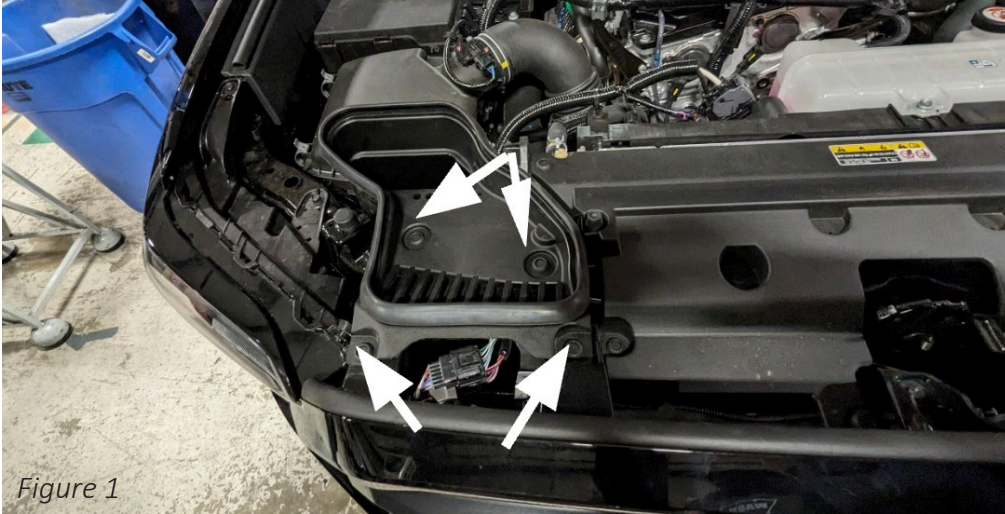


## HARDWARE KIT | 50479-HW

ID #	COMPONENT DESCRIPTION	QTY
50479-HW	1/4"-20 X 1", HEX HEAD CAP SCREW, YELLOW-ZINC, GRADE 8	2
50479-HW	1/4"-20, HEX NUT, YELLOW-ZINC, GRADE 8	2
50479-HW	1/4"-SAE, FLAT WASHER, YELLOW-ZINC, GRADE 8	4
50479-HW	1/4"-SAE, LOCK WASHER, YELLOW-ZINC, GRADE 8	2
50479-HW	7/16"-USS, FLAT WASHER, YELLOW-ZINC, GRADE 8	6
50479-HW	7/16"-SAE, LOCK WASHER, YELLOW-ZINC, GRADE 8	6
50479-HW	7/16"-14 X 1.5", HEX HEAD CAP SCREW, YELLOW-ZINC, GRADE 8	6
50479-HW	BLACK NYLON PLASTIC PLUG	4

# 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)

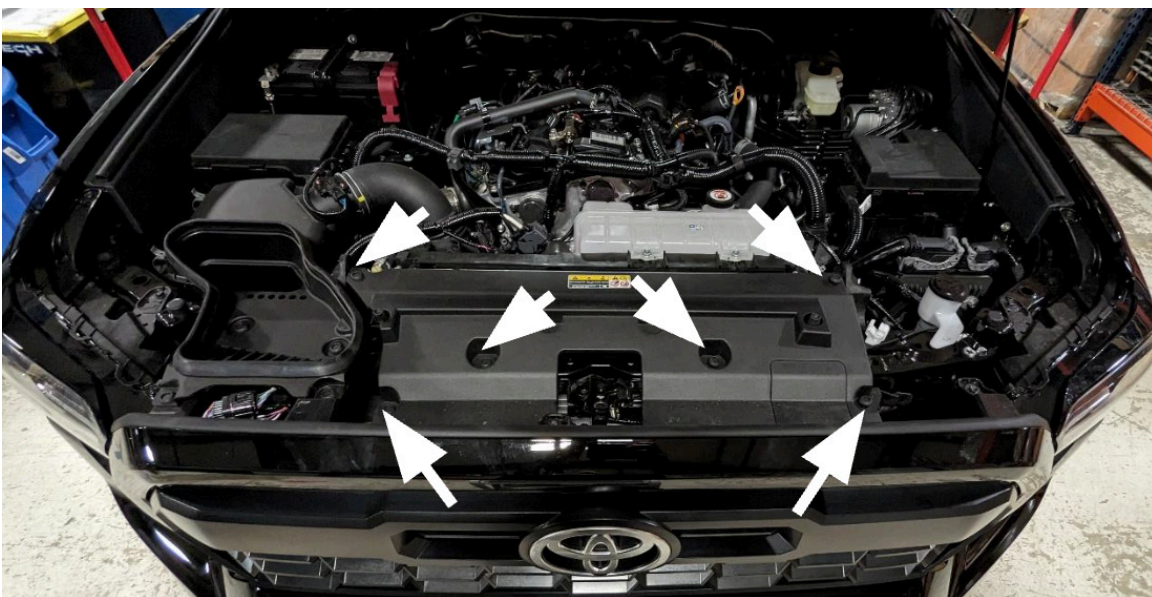


Figure 5



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

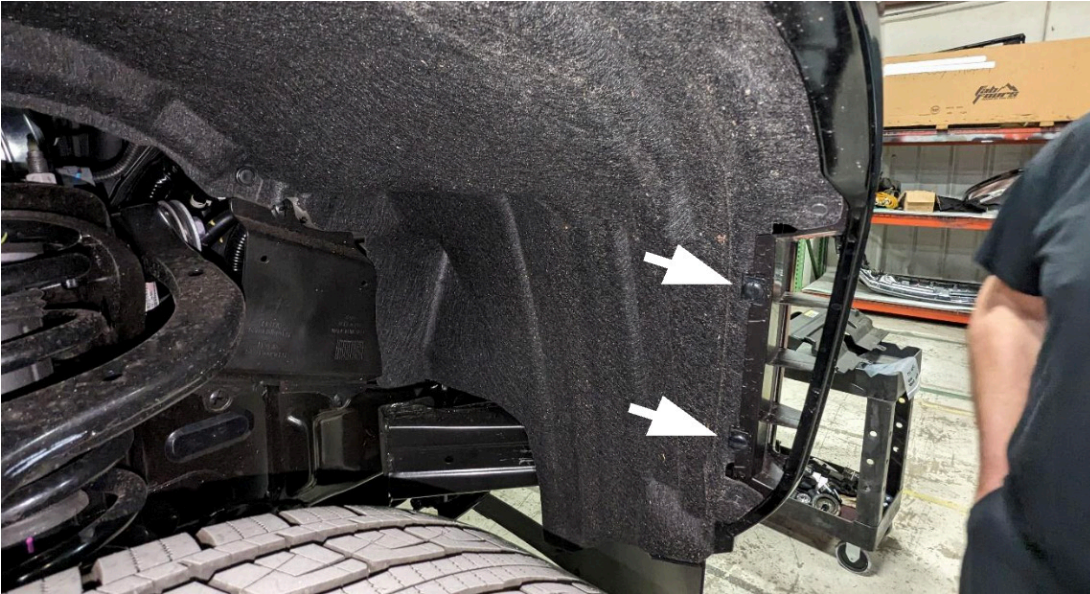


Figure 6

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)

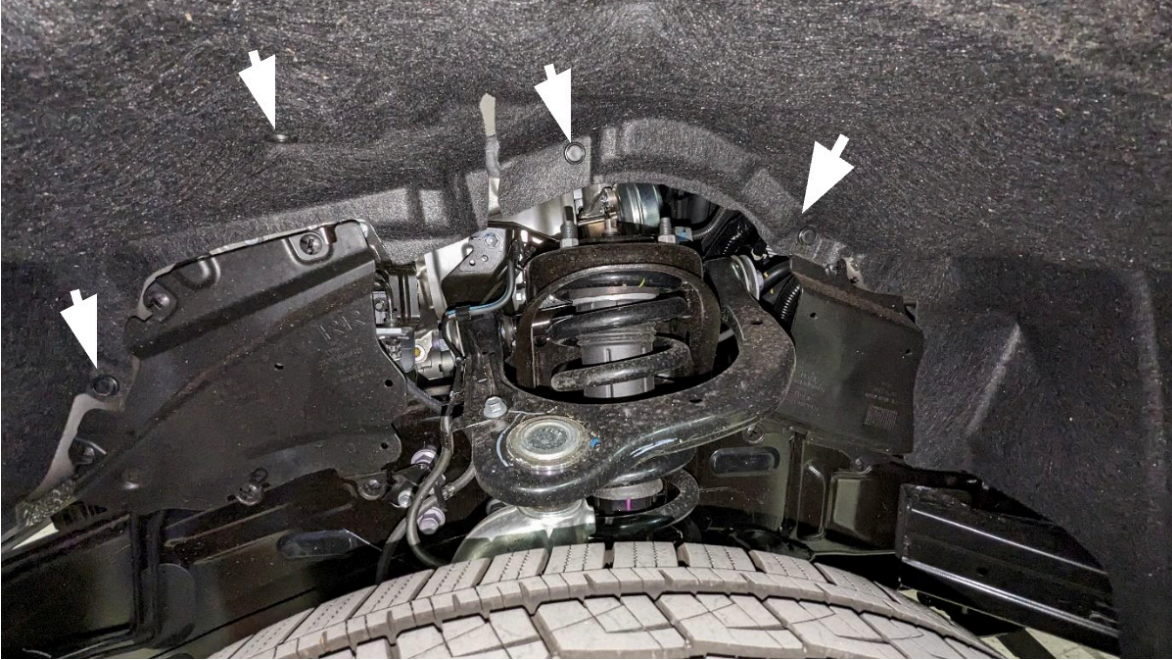


Figure 8

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

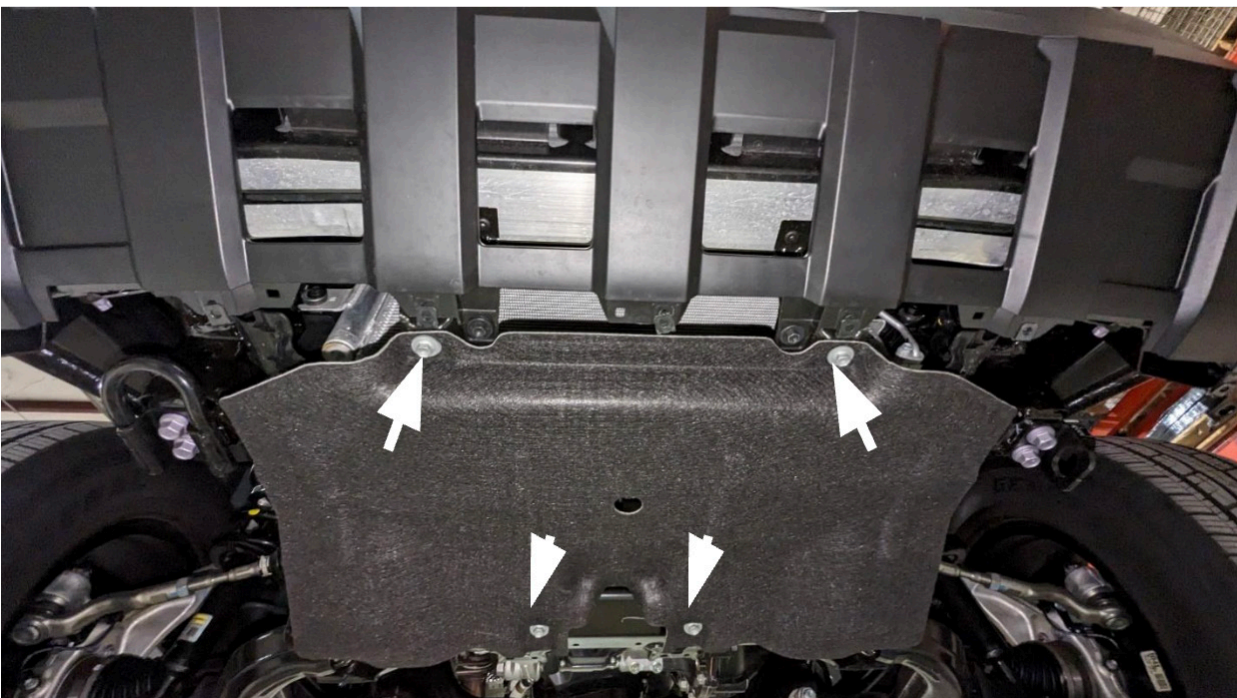


Figure 9



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)

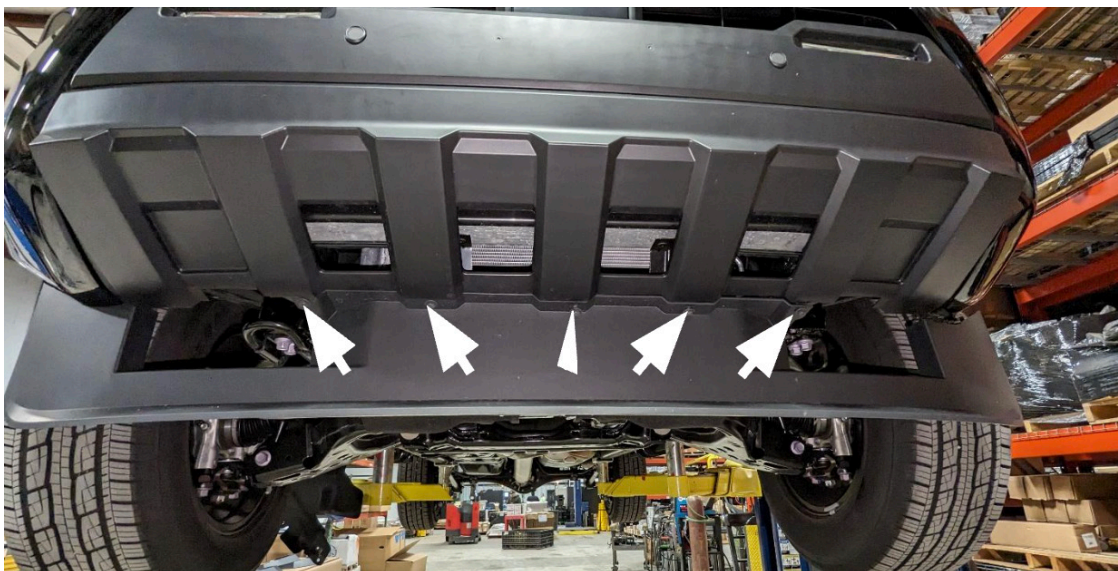


Figure 10

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)

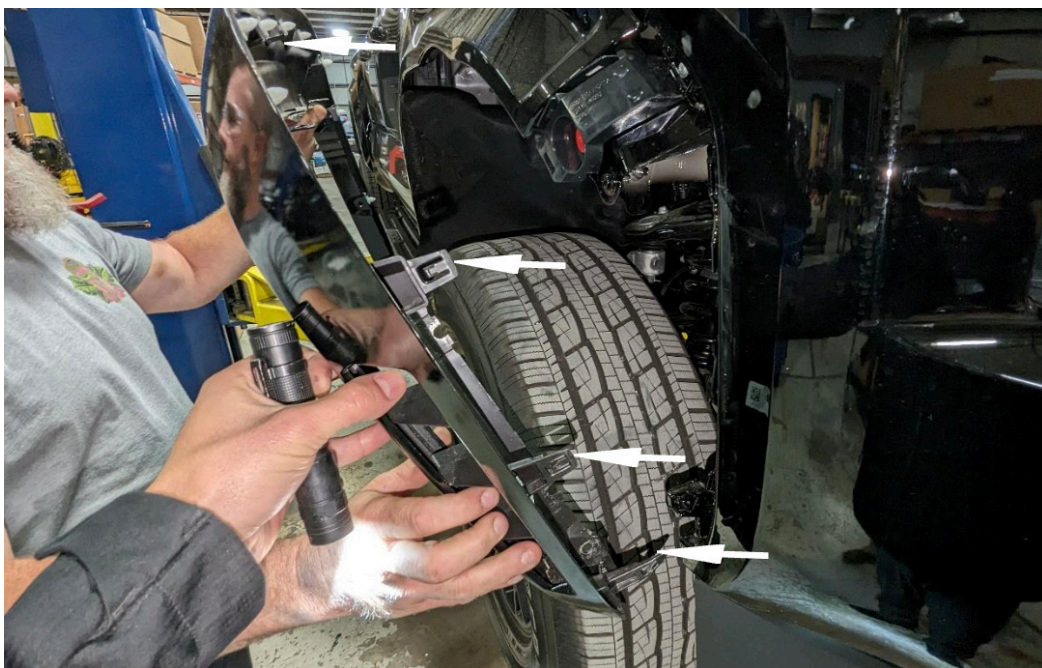


Figure 11



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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)

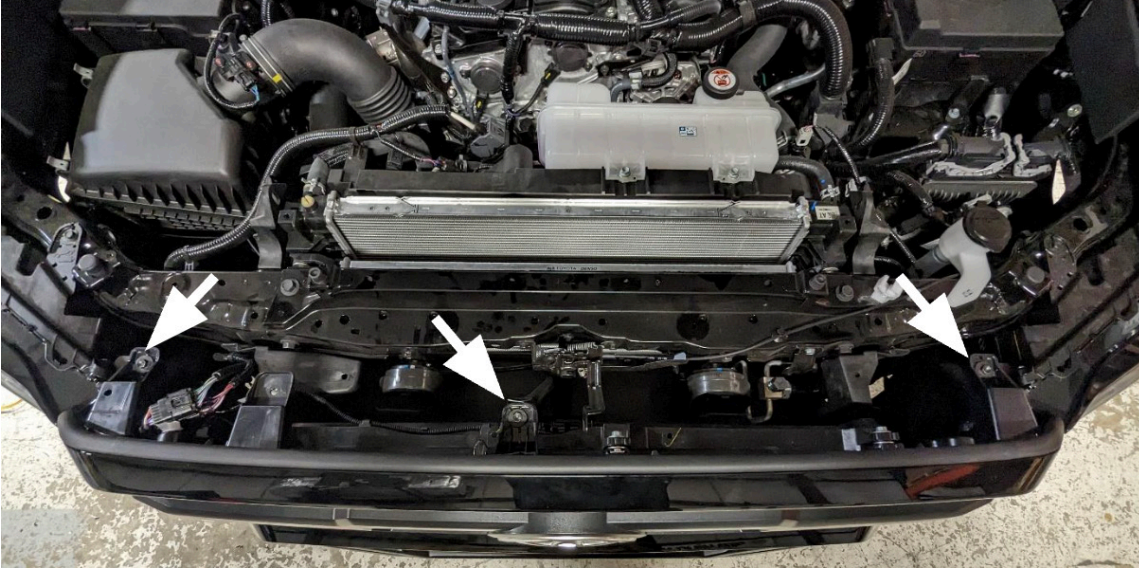


Figure 14

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)

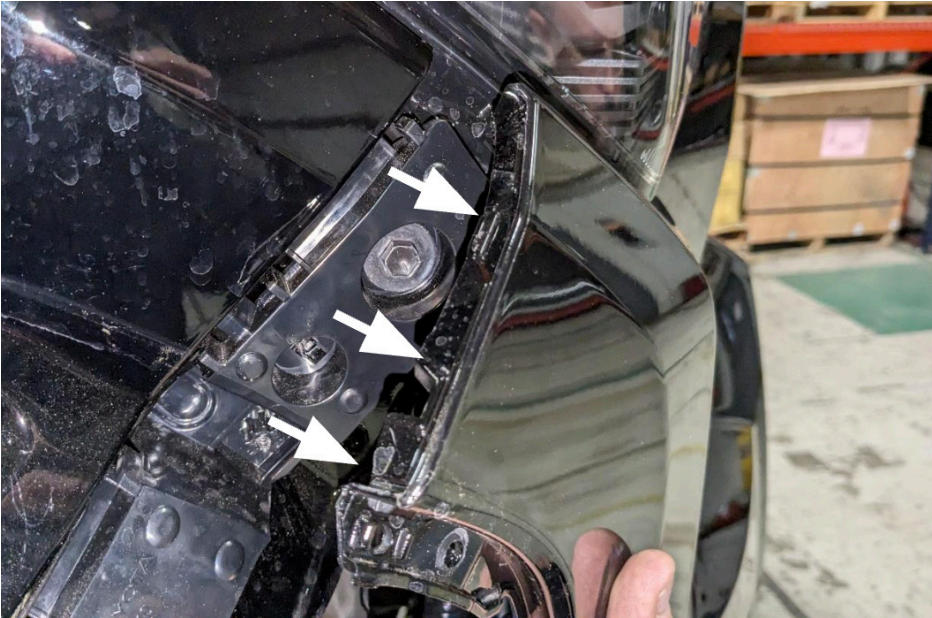


Figure 16

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



Figure 17

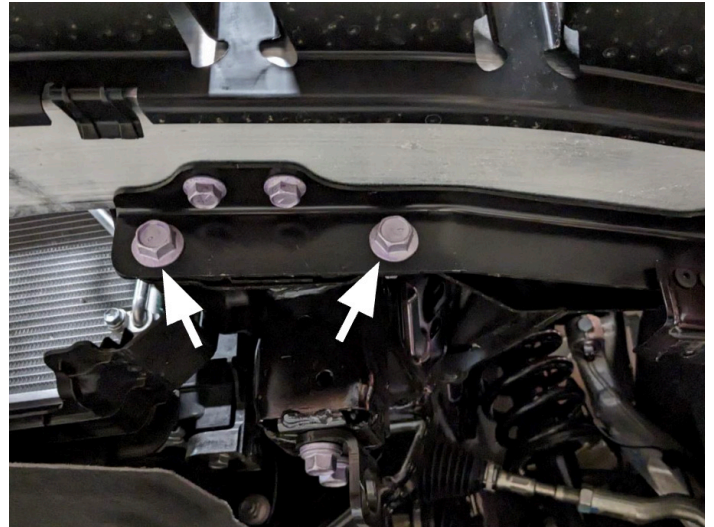


Figure 18



15. Using a 10mm socket wrench, remove the five (5) 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

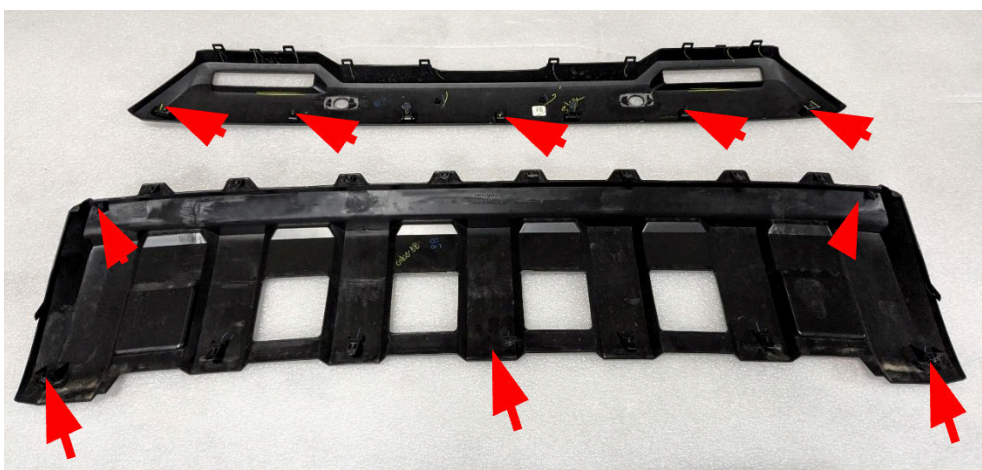


Figure 21



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17. 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

18. 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

19. Using a small reciprocating saw, cut along the profile shown below. Then, mirror the cut on the driver's side. (Figure 24 on next page)

**\*\* Note:** when cutting close to the fog light, only cut through the outer most layer and not into the fog light housing.

# MARKING & CUTTING

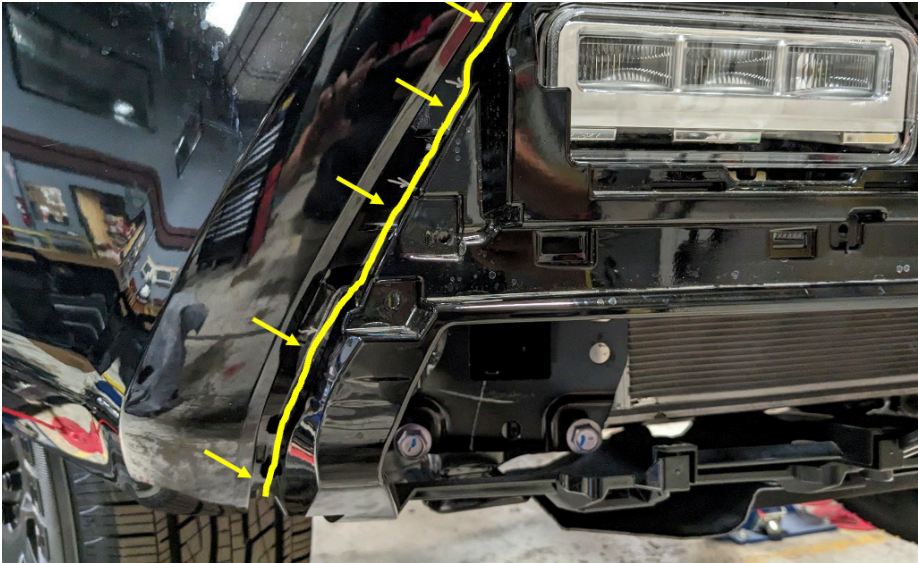


Figure 24

20. Using a small reciprocating saw, trim the outer most portion of the fog light housing as shown. (Figure 25)

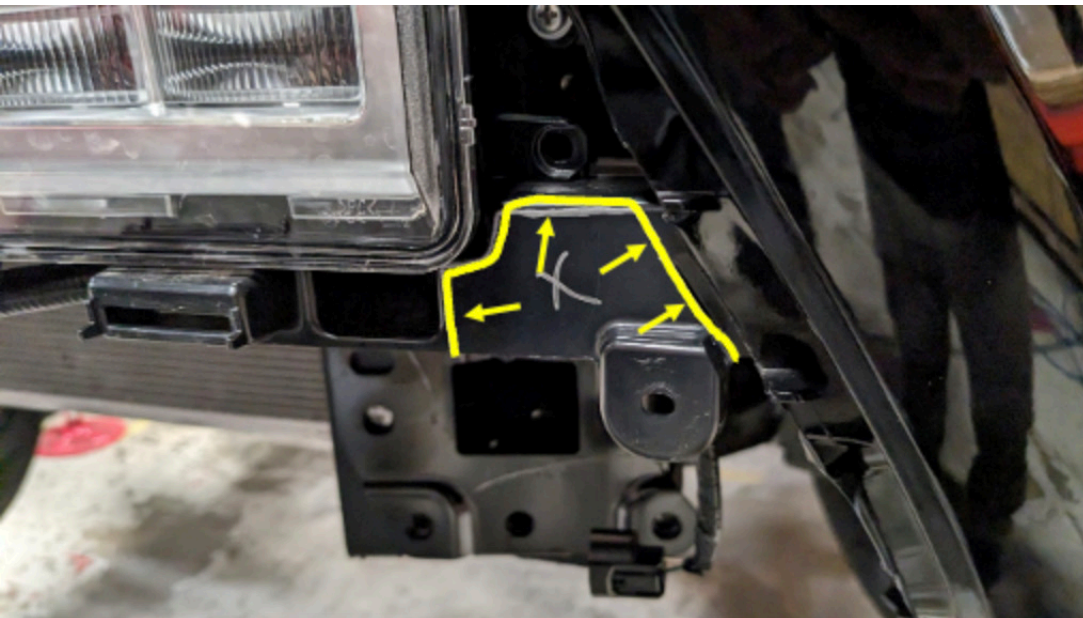


Figure 25



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21. Using a grinder, remove the vertical ribs across the tops of the plastic structure below the ACC sensor. (Figure 26)

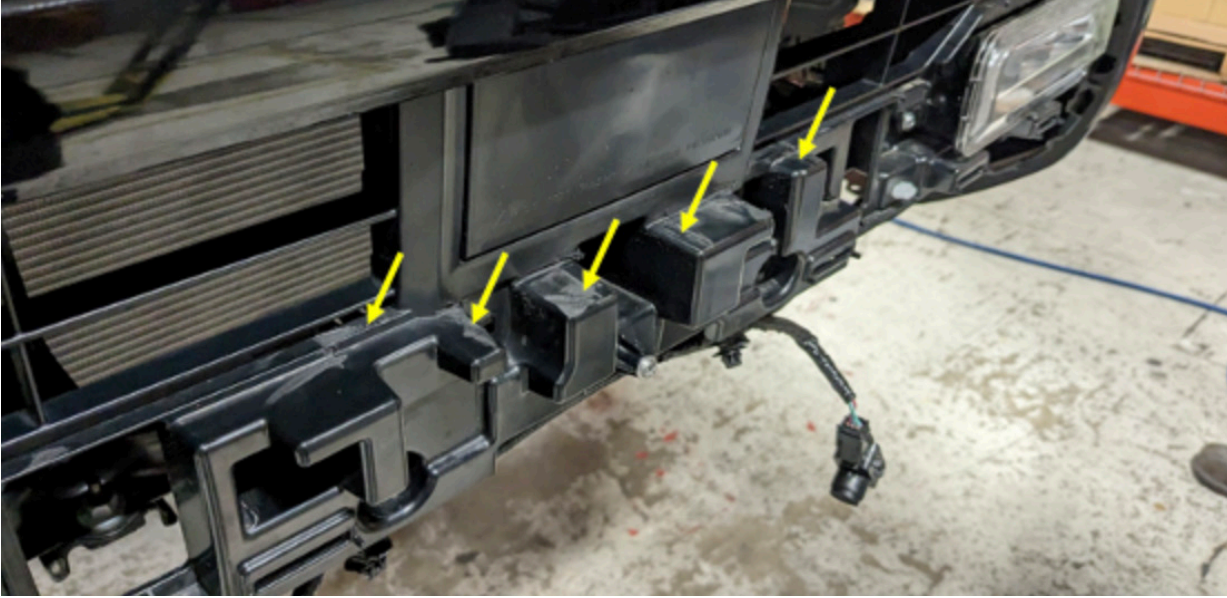


Figure 26

22. Using a grinder, remove any stiffening ribs left behind. (Figure 27)



Figure 27



**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 28)**



*Figure 28*

**24. Place roughly 10-12 inches of painter's tape on both sides of bumper as shown in figure 29. Extend tape around fender flares.**



*Figure 29*

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**NOTE: If not using a leaser level skip to step 28**

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 30



Figure 30

26. Use a marker to transfer laser mark onto painters' tape on both sides of bumper. Figure 31.



Figure 31



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

28. Trace curve of bumper below headlight using marker. (Figure 32)



Figure 32

29. Using 1" ruler, draw straight line down body line just in front of fender flare. (Figure 33)



Figure 33

30. 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 34.

31. Circle lines 4, 9, and 14. Using ruler, measure from top line and make marks on these three (3) lines. Measurements shown in Figure 34 underlined in red.



Figure 34

32. Use metal template (23304) to trace line across bumper at marks made in step 28. (Figure 35)



Figure 35



# INSTALLATION

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33. 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.

34. Using the provided epoxy, attach the OEM parking sensor housings back in the orientation and position from which they were removed from the OEM bumper into the new bumper. (Figure 36)

35. If installing a lightbar do so now using the two (2) provided brackets (22573) and 1/4" hex head cap screws, flat washers, lock washers and nuts. (Figure 36)

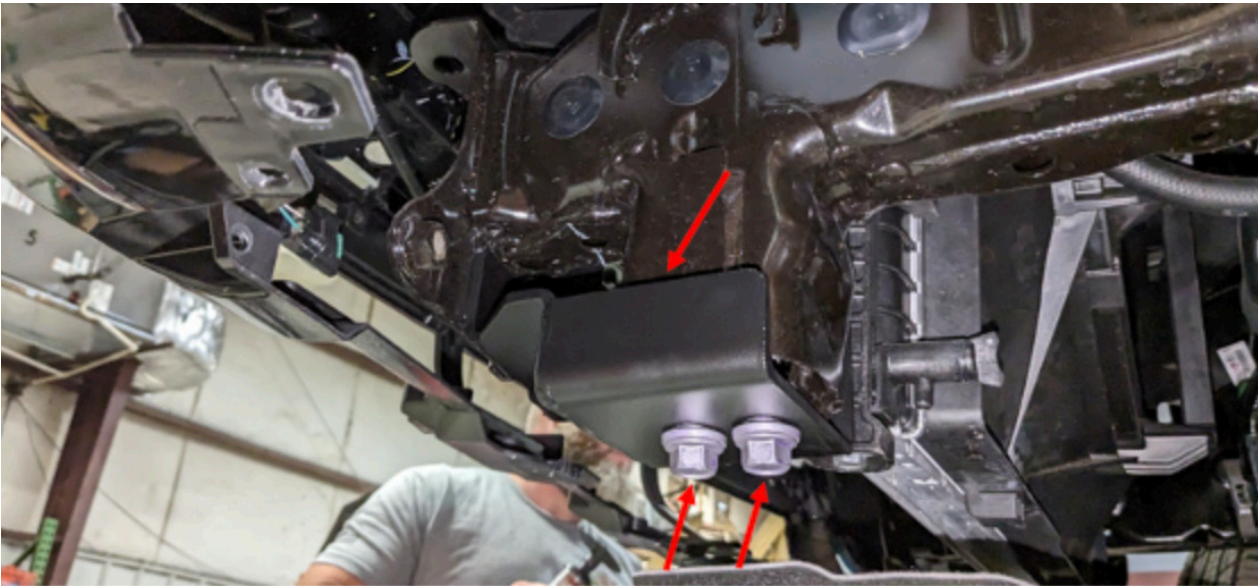


Figure 36

36. If installing a winch, do so now per the attached Warn winch installation guide.

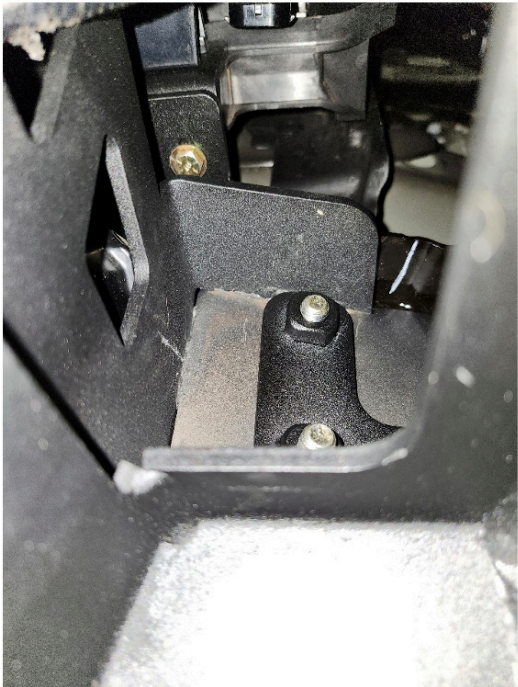
**\*\* Note: To make winch operation easier, rotate the clutch handle forward 90 degrees to be accessible through the hand hole next to the D-ring.**

**37. Loosely install the two (2) provided frame reinforcement brackets behind the frame horns (DS: 23290 / PS: 23291) reusing the OEM hardware that was removed previously. (Figure 37)**



*Figure 37*

**38. Place the two (2) provided nut plates inside of the winch mount through the winch access holes beside the d-rings (DS: 23297 / PS: 23298). (Figure 38 & 39)**



*Figure 38*



*Figure 39*



39. Using a 5/8" socket wrench and extension, install the three (3) 7/16" hex head cap screws, flat washers, lock washers and nuts per side through the previously installed reinforcement brackets, frame horns, and into the nut plates. Using a 17mm socket wrench, tighten the previously installed OEM screws in the bottom of the frame rail. (Figure 40)

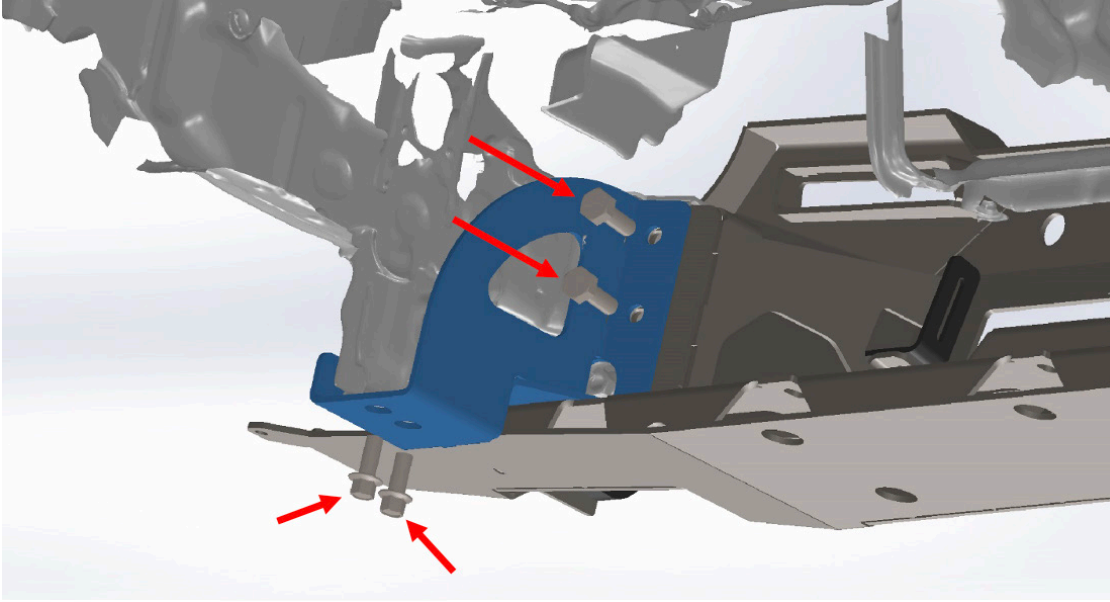


Figure 40

40. Install the four (4) provided black plastic plugs into the winch bolt access holes in the bottom of the winch mount shell. Note: epoxy may be required to keep them in place. (Figure 41)



Figure 41

# 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**

