



INSTALLATION MANUAL
PREMIUM REAR BUMPER
PRODUCT NUMBER: W6351
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.

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

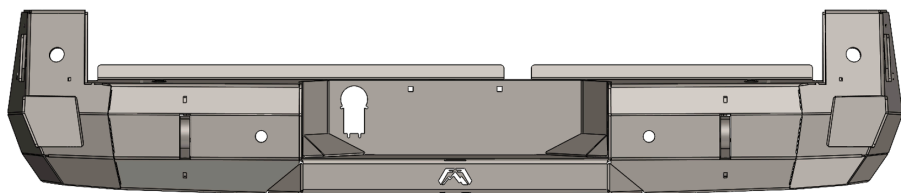
FOUNDER, FAB FOURS

GETTING STARTED

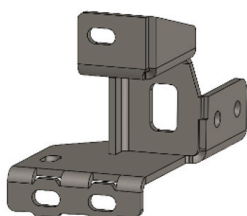
Before you begin the installation process of your new Fab Fours product, we suggest laying out all materials and parts on a pad or protective surface.

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.

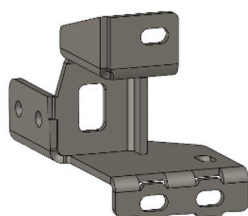
PROVIDED MATERIALS



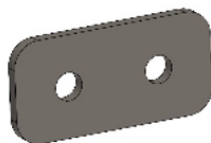
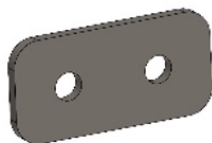
23317 - BUMPER SHELL



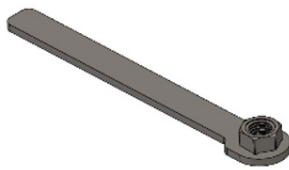
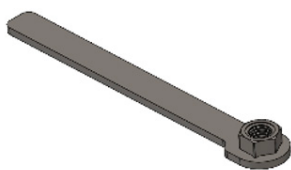
23318



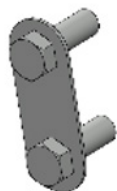
23319



23320 QTY: 2



23324 QTY: 2



20296 QTY: 4

61632 EPOXY QTY:2

61784 PLASTIC SHEET QTY: 2

REQUIRED TOOLS

- BODY PRY TOOL
- 13MM SOCKET WRENCH
- 10MM SOCKET WRENCH
- 7/16" SOCKET WRENCH
- 7/16" COMBINATION WRENCH
- 3/32 ALLEN WRENCH
- 11/32 SOCKET WRENCH
- FLAT SCREW DRIVER
- 1/4" & 3/16" DRILL BIT & DRILL
- ANGLE GRINDER WITH METAL CUT-OFF WHEEL
- BOX CUTTER OR RAZOR BLADE

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 | 50494-HW

IDENTIFICATION NUMBER	COMPONENT DESCRIPTION	QTY
50494-HW	PLASTIC LICENSE PLATE NUT	2
50494-HW	FLUSH MOUNT PLASTIC PLUG	6
50494-HW	#10-24 X ¾" BLACK BUTTON HEAD CAP SCREW	4
50494-HW	10-24 CLIP ON BARREL NUT	4
50494-HW	¼"-20 X 1" HEX HEAD BOLT ZINC	6
50494-HW	¼"-20 NYLOCK HEX NUT ZINC	6
50494-HW	¼" FLAT WASHER ZINC	12
50494-HW	1/2"-13 X 4", HHCS , ZINC, GR8	4
50494-HW	1/2"-13 X 1", HHCS , ZINC, GR8	4
50494-HW	1/2-13 FINISHED HEX NUT STL ZINC	10
50494-HW	1/2 SAE FLAT WASHER GRADE 8 Z&Y	18
50494-HW	8-32 X 3/4 BUTTON SOCKET CAP ALLOY ZINC	4
50494-HW	#8-32 X NYLOCK, HEX NUT , ZINC, GR2	4
50494-HW	#8-SAE FLAT WASHER	4

DISASSEMBLY & INSTALLATION

1. From under the truck unplug bumper wire harness and trailer plug. Bumper harness is located on rear driver side of truck. Press black tab to release gray lever on connector, then rotate lever to fully disconnect harness. (Figure 1)

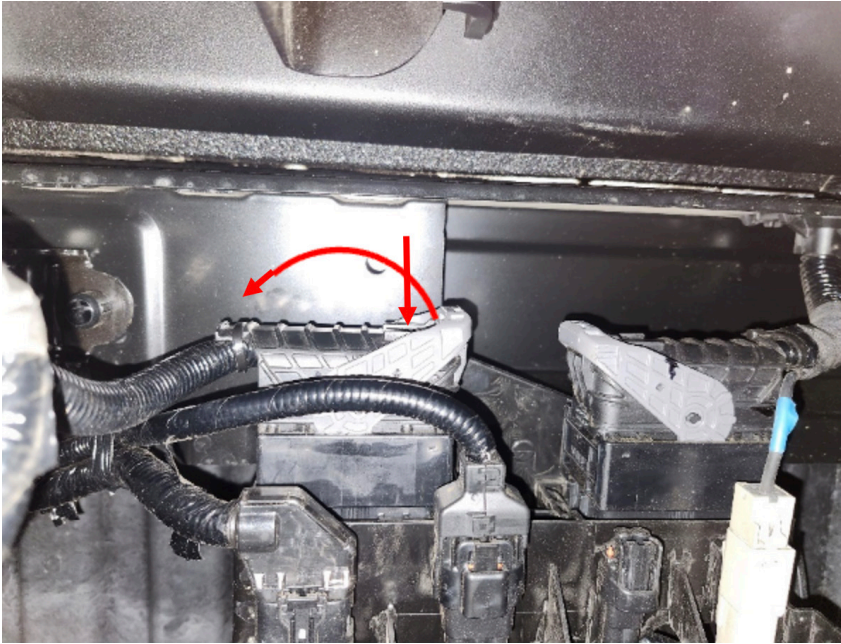


Figure 1

2. Use body pry tool to remove plastic covers on top of bumper and on bumper hitch step. (Figure 2 & 3)



Figure 2



Figure 3

3. Use a 13mm socket wrench to remove 3 bolts per side on top of bumper and 2 nuts on step of bumper. (Figure 4 & 5) Once bolts are removed, bumper can be removed from truck.



Figure 4

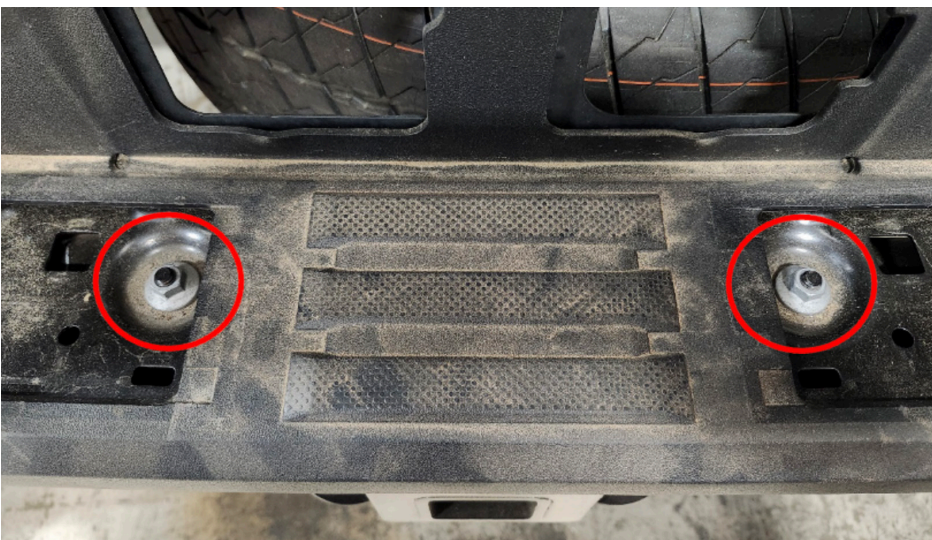


Figure 5

4. Unplug license plate tag light and remove from OEM bumper.
5. Press in the two clips on the trailer plug and push out to remove it from the bumper.

6. Using body pry tool remove all plastic pins from inside of left and right side of bumper to remove inner plastic layer of bumper. (Figure 6 & 7)

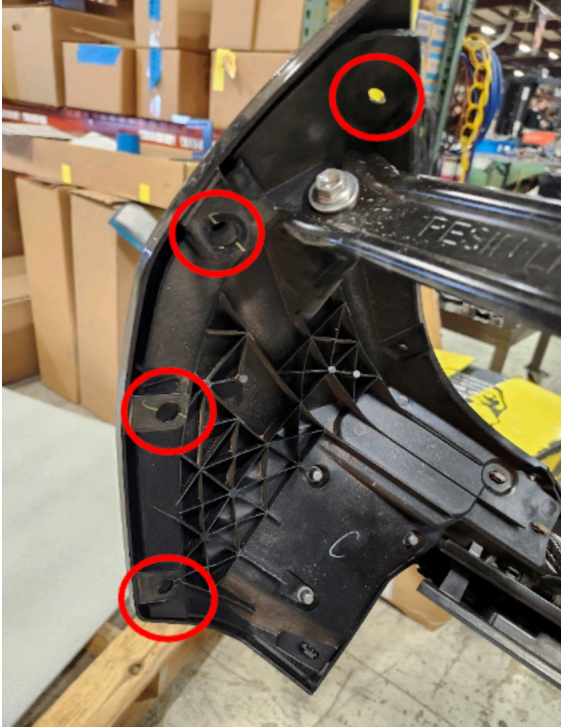


Figure 6



Figure 7

7. If equipped, remove the blind spot sensors from the OEM bumper using a 10mm socket wrench to remove the three bolts. (Figure 8) Be sure to note the side of the truck that sensor is removed from before unplugging and removing.

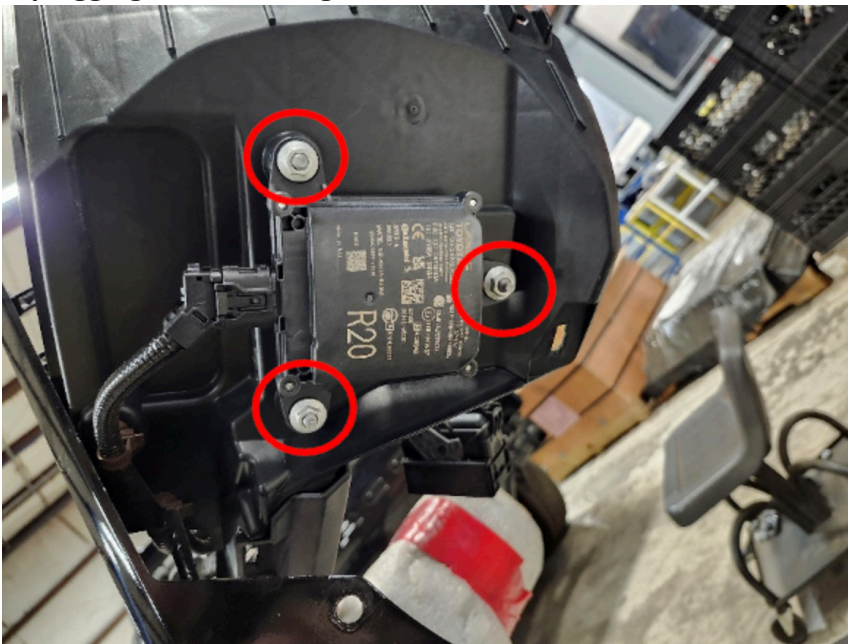


Figure 8

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8. Mark the location and orientation of all four (4) sensors in bumper. Unclip each sensor from its housing and remove from bumper but carefully prying clips open and pulling out sensor. (Figure 9)

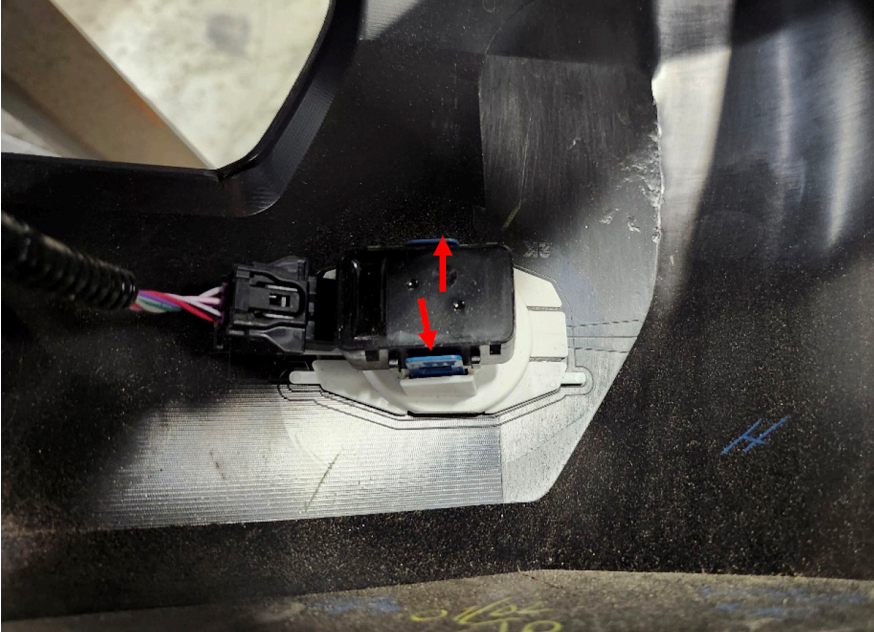


Figure 9

9. Remove sensor housings from bumper by carefully prying sensor and separating adhesive from inside of bumper surface. A box cutter or razor blade may be helpful to separate adhesive.

10. Using epoxy packets (61632) install sensor housings into new bumper (23317) in same locations and orientation as OEM bumper. Allow epoxy to dry and then install sensors.

-
11. Using three (3) ¼" bolts, ¼" nuts and six (6) flat washers (50494-HW), install blind spot monitoring sensors into bumper (23317) by aligning three holes in sensor with holes in brackets on inside of bumper. Use 7/16" socket and wrench to tighten. (Figure 10)

Note: Top mounting hole goes on inside of bumper bracket, bottom holes go on outside of bumper bracket.

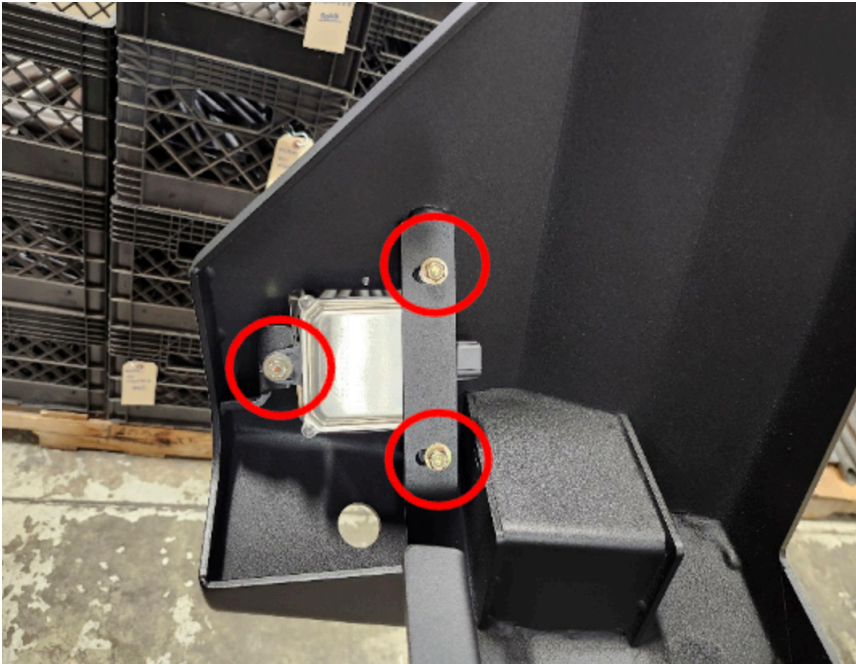


Figure 10

12. Once blind spot monitor is installed, hold black plastic sheet (61784) over sensor opening and mark appropriate size to fully cover opening and mark mounting holes in bumper on plastic sheet. (Figure 11)

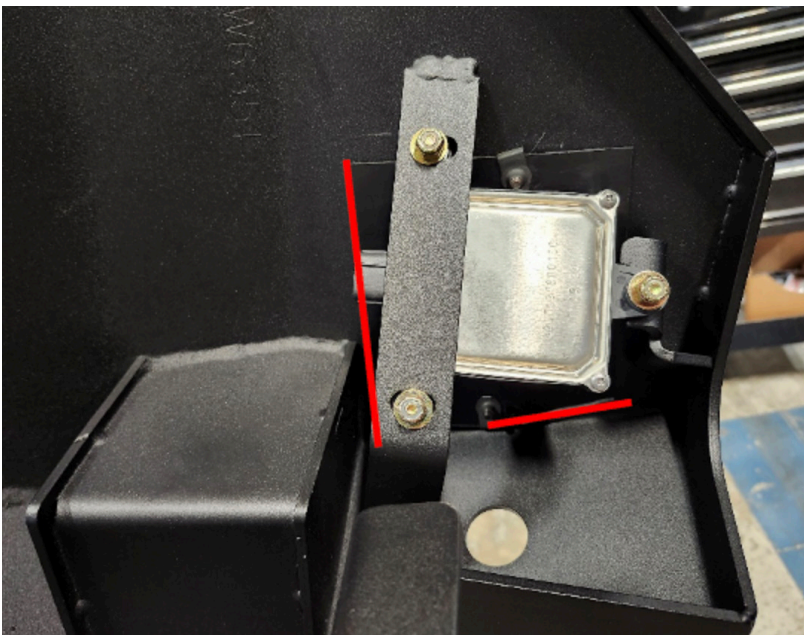


Figure 11

13. Using box cutter or razor blade, cut plastic sheet to appropriate size. Use ¼" drill bit to drill bolt holes in marked locations.

14. Using black two (2) #10 button head bolts and clip on barrel nuts (50494-HW) fasten plastic sheet into inside of bumper. (Figure 12) Note: plastic sheet width may need to be adjusted to fit clip on barrel nut.



Figure 12

15. Install license plate tag light into new bumper by clipping into bracket. (Figure 14)

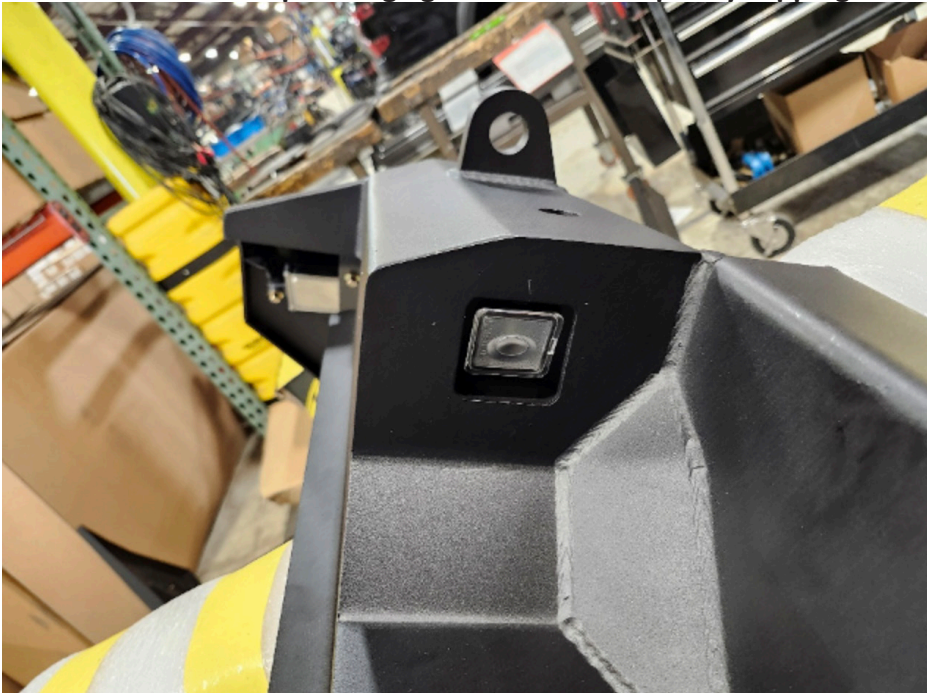


Figure 14

16. Install the trailer plug into the bumper by first removing the silver clips from the plug using a straight screwdriver.

17. Hold the plug into the bumper and use a marking tool to mark the four (4) holes in the bumper. Use a 3/16" drill bit to drill holes in the plug. Use four (4) #8 bolts, washers and nylock nuts (50494-HW) to fasten trailer plug into bumper. (Figure 15)

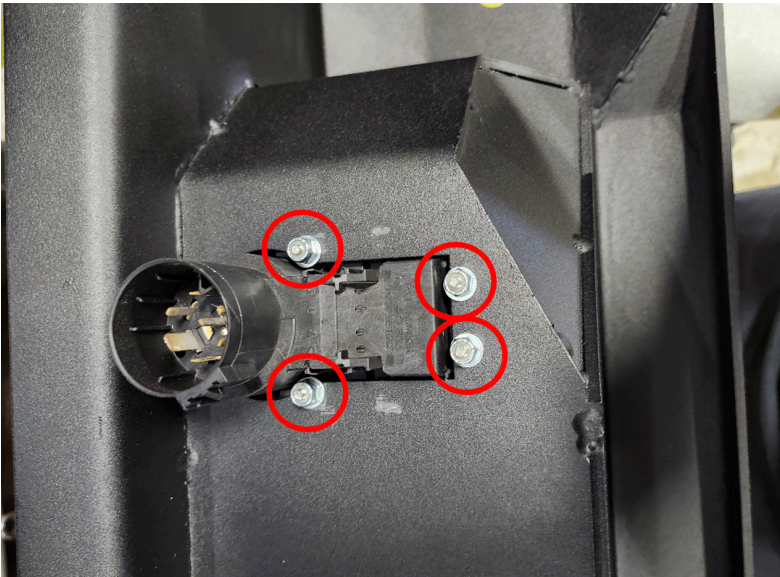


Figure 15

18. Connect all sensors and tag light to bumper wire harness.

19. Using cutoff wheel, remove small flange with stud from OEM bumper. (Figure 16)



Figure 16

20. Remove two (2) rear most plastic plugs on inside and outside of frame using hammer and straight screwdriver. Repeat for both sides of truck. (Figure 17)

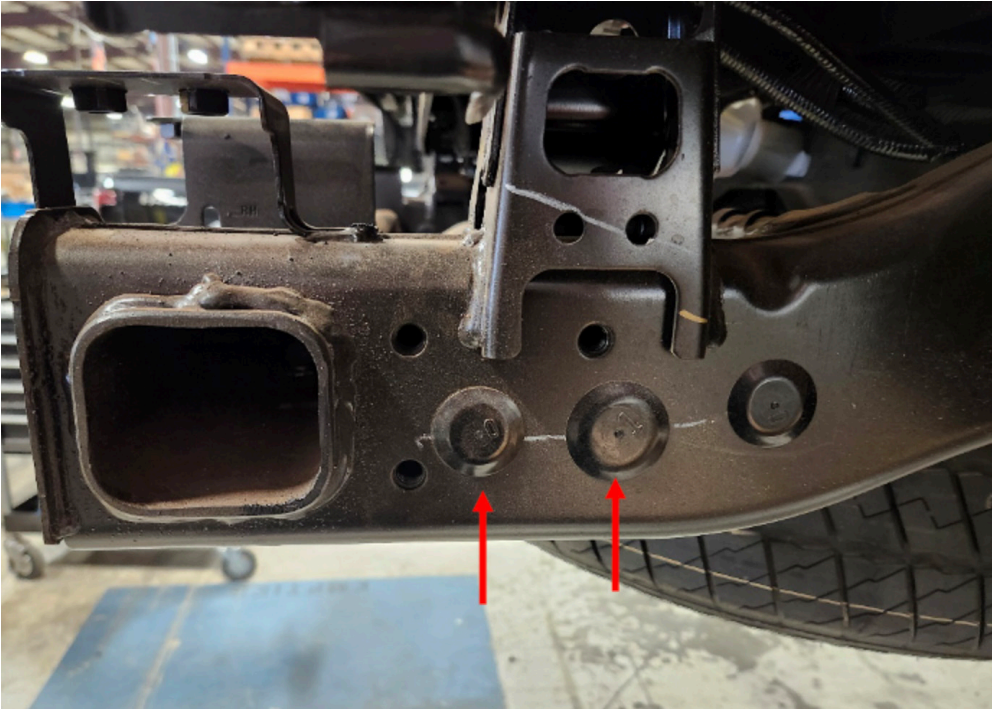


Figure 17

21. Place intermediate brackets (23318 for PS & 23319 for DS) over rear trailer hitch cross bar as shown in (Figure 18)

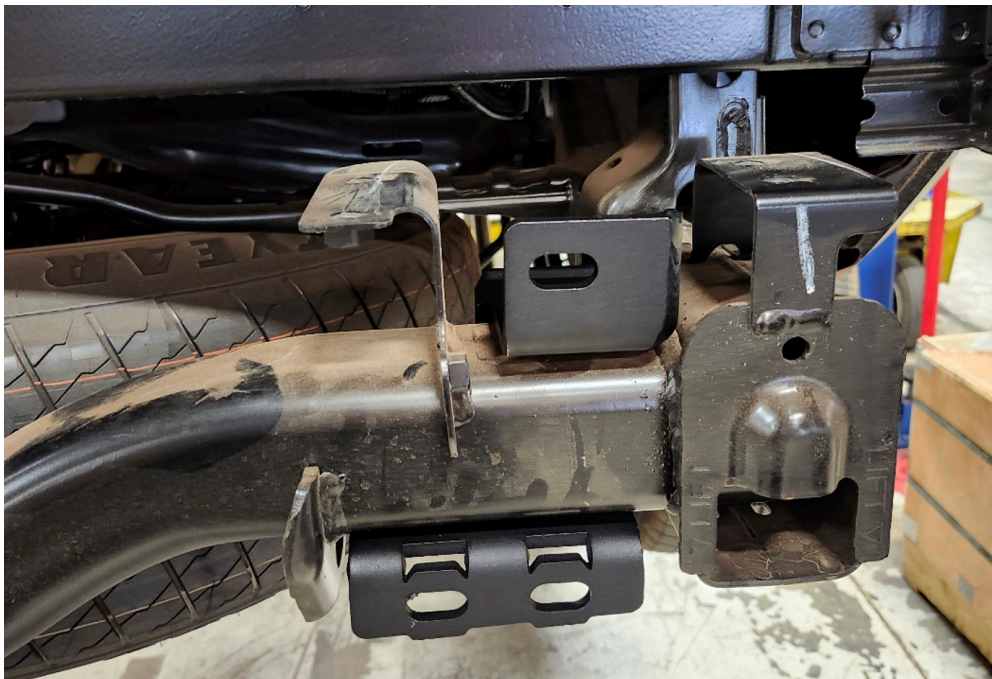


Figure 18

22. Insert 4" long ½" bolt with flat washer (50494-HW), through bracket and frame and through flat backer plate (23320) on outside of frame and thread on flat washer and ½" nut (50494-HW). DO NOT TIGHTEN. (Figure 19 & 20)



Figure 19

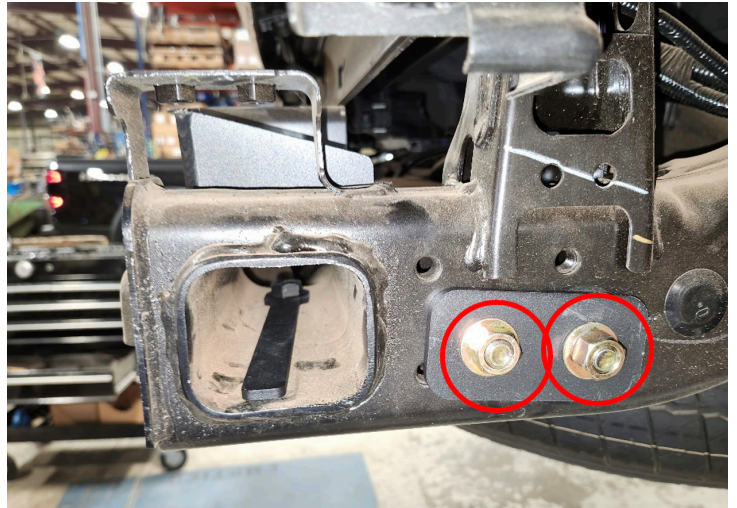


Figure 20

23. Place nut strip (23324) into end of frame over hole in bottom of frame. Insert 1 ½" long ½" bolt with washer (50494-HW) through slot in bottom of bracket. (Figure 21 & 22) DO NOT TIGHTEN. Note: Hole tab may need to be removed from inside frame using long screwdriver and hammer.



Figure 21



Figure 22

24. With assistance, lift the bumper (23317) onto the mounts and use a 13mm wrench to fasten bumper to truck with two (2) OEM bolts per side. **DO NOT TIGHTEN.** Note: Bumper may need to be tilted toward rear of truck slightly as installed to clear bottom of intermediate brackets (23318 & 23319) (Figure 23)



Figure 23

25. Place bolt strip (20296) through two (2) holes in bumper bracket from inside bumper. Thread on ½" nuts with washers (50494-HW). (Figure 24) Repeat for opposite side.



Figure 24

26. Insert 1 ½" bolt with washer (50494-HW) through top hole top hole in bumper bracket and intermediate bracket. Thread on ½" nut with washer onto bolt. (Figure 25) Repeat for opposite side.

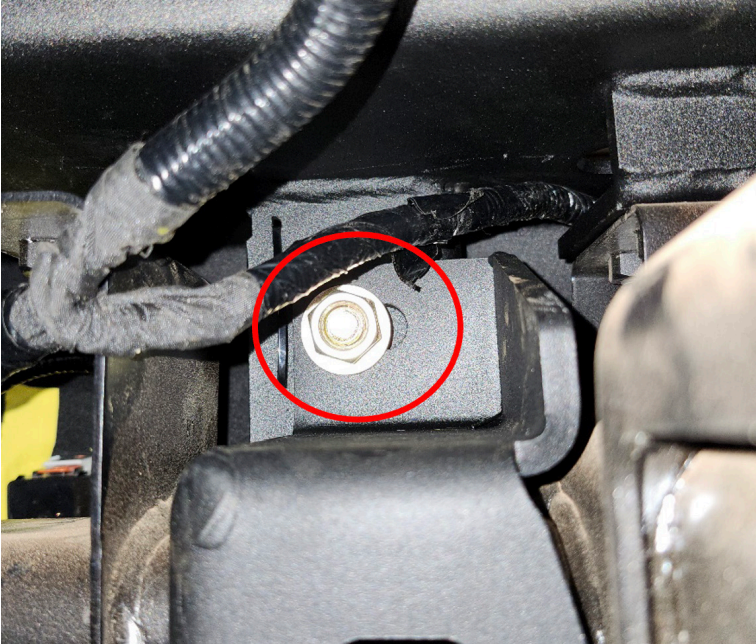


Figure 25

27. Adjust side to side alignment of bumper as needed. Tighten all ½" hardware with ¾" wrench and socket, starting with bolts mounting intermediate brackets to the frame. Then tighten OEM bolts in top of bumper using 13mm socket.

28. Plug in the sensor harness from step 1 and install the two (2) plastic license plate nuts (50494-HW) by pushing them into the bumper. (Figure 26)

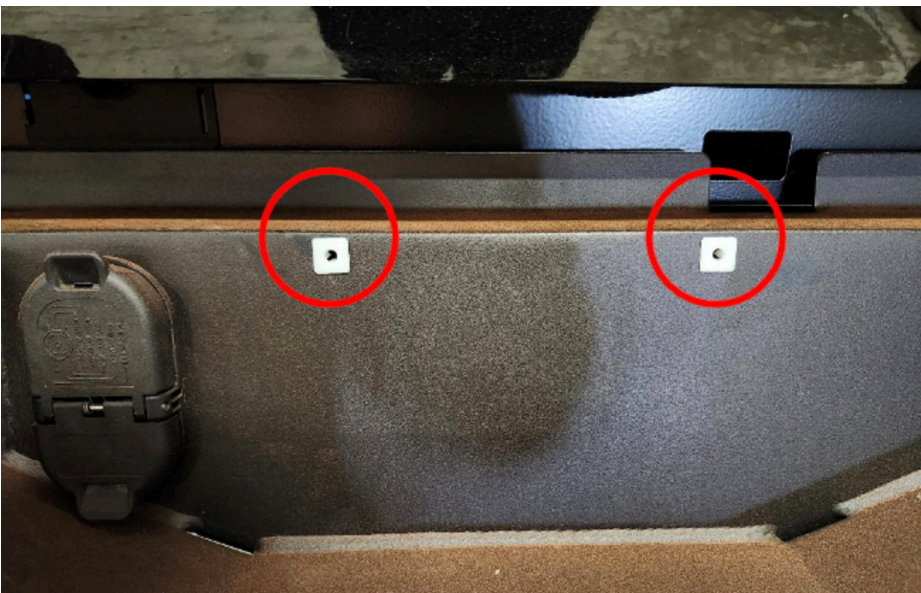


Figure 26

29. Install two (2) flush mount plastic plugs (50494-HW) per side into bolt pass through holes on top of bumper. (Figure 27)



Figure 27

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

