



INSTALLATION MANUAL
PREMIUM REAR BUMPER
PRODUCT NUMBER: W655X
APPLICATION: 2024 FORD F-150



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

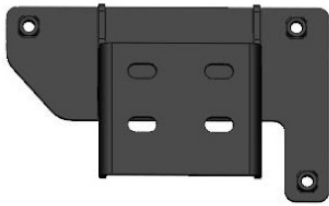
Before you begin the installation process of your new Fab Fours product, we suggest laying out all materials and parts on a pad or protective surface.

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.

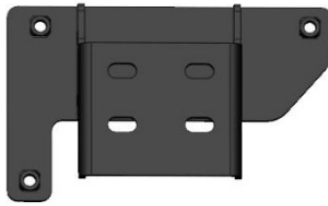
PROVIDED MATERIALS



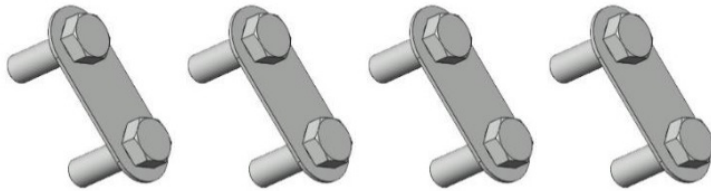
23435 - BUMPER SHELL



22416 - PS BRACKET



22417 - DS BRACKET



20296 - QTY 4

61632 - EPOXY PACKETS QTY: 2



W6551 EXPLODED VIEW

REQUIRED TOOLS

- BODY PRY TOOL
- 10MM SOCKET WRENCH
- 13MM SOCKET WRENCH
- 5/8" SOCKET WRENCH
- 3/4" SOCKET WRENCH
- NEEDLE NOSE PLIERS
- SILVER MARKER
- METAL CUTTING TOOL
- BLACK PAINT

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 | 50515-HW

ID #	COMPONENT DESCRIPTION	QTY
50515-HW	7/16"-14 X 1.25", HEX HEAD CAP SCREW, YELLOW-ZINC, GRADE 8	6
50515-HW	7/16"-SAE, LOCK WASHER, YELLOW-ZINC, GRADE 8	6
50515-HW	7/16"-SAE, FLAT WASHER, YELLOW-ZINC, GRADE 8	6
50515-HW	1/2"-13, HEX NUT, YELLOW-ZINC, GRADE 8	8
50515-HW	1/2"-SAE, FLAT WASHER, YELLOW-ZINC, GRADE 8	8
50515-HW	1/2"-SAE, LOCK WASHER, YELLOW-ZINC, GRADE 8	8
50515-HW	LICENSE PLATE NUT	2

INSTALLATION

1. Disconnect the trailer plug. (Figure 1)



Figure 1

2. Using needle nose pliers, release the plastic clips inside the bumper that attach the plastic step pad to the top of the metal portion of the bumper and lift on the step pad to remove it. (Figure 2-3)

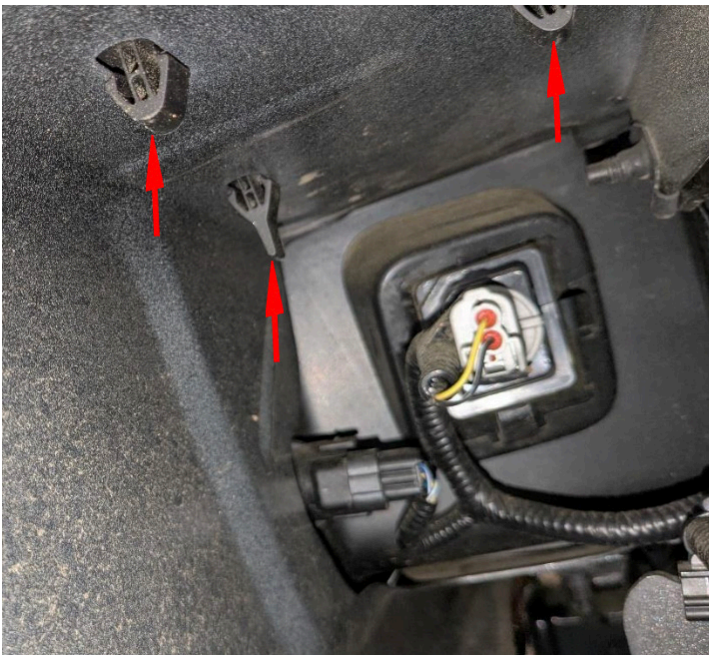


Figure 2



Figure 3

3. Using a 10mm socket wrench, remove the body ground on the main bumper wiring harness. (Figure 4)



Figure 4

4. Disconnect the main bumper wiring harness plug under the bed. (Figure 5)

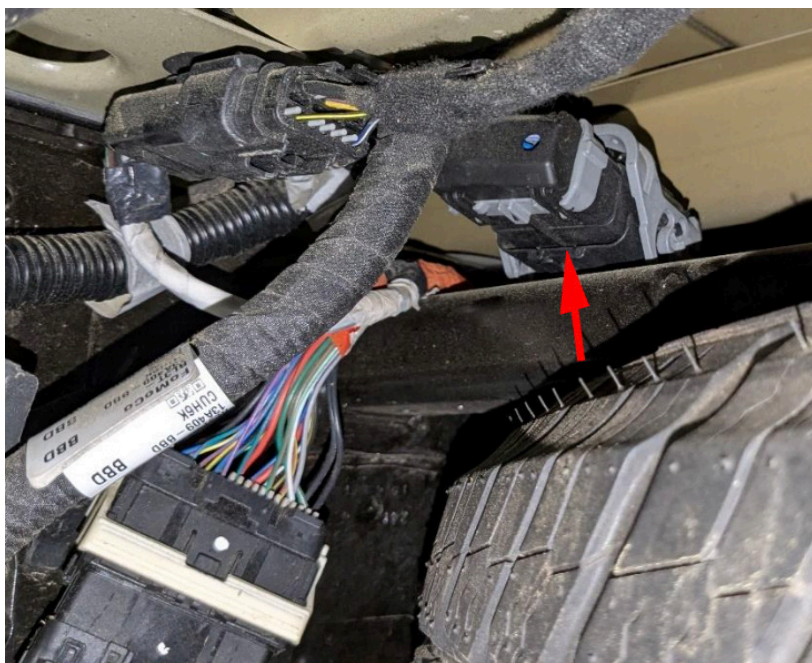


Figure 5

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5. Using a 13mm socket wrench, remove the two (2) screws from under the center step pad. (Figure 6)



Figure 6

6. Using a 13mm socket wrench, remove the screws on the inside of each frame rail. (Figure 7)



Figure 7

7. Using a 13mm socket wrench, remove the two (2) screws on the outside of each frame rail. (Figure 7)

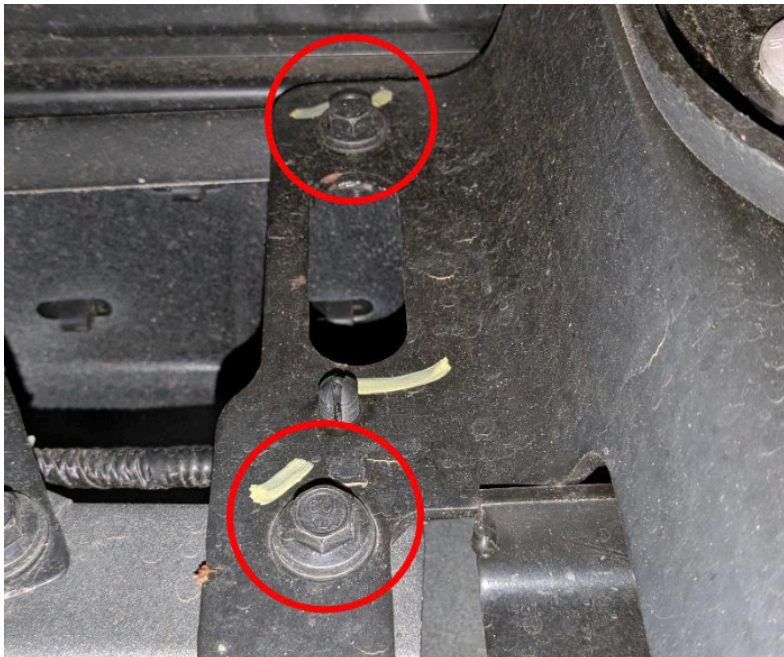


Figure 7

8. With assistance, remove the factory bumper from the vehicle.
9. Using a panel pry tool, depress the clips on the trailer plug and spare tire access cover to remove them from the bumper. (Figure 8)



Figure 8

10. Mark each parking sensor's location in the bumper as Driver outer (DO), Driver inner (DI), Passenger outer (PO), Passenger inner (PI). Remove the sensor from the sensor housing by expanding both sides of the sensor housing and lifting. (Figure 9-10)

NOTE: Sensors are extremely delicate and must be handled with care! Do not push on the face of sensors to remove!



Figure 9

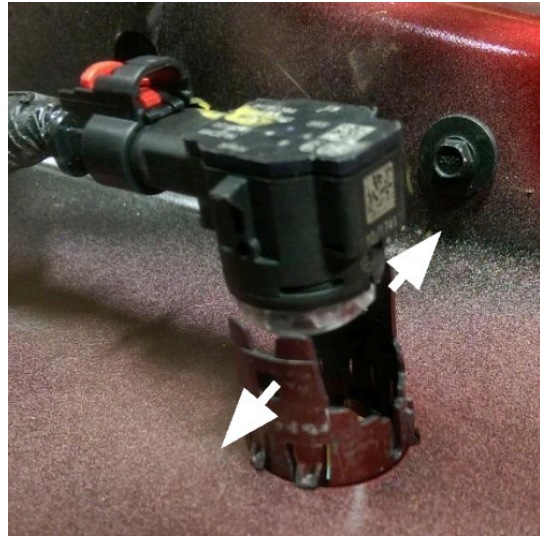


Figure 10

11. Remove the sensor housing from the bumper by depressing the four (4) tabs while pulling outward from the outside of the bumper. (Figure 11-12)

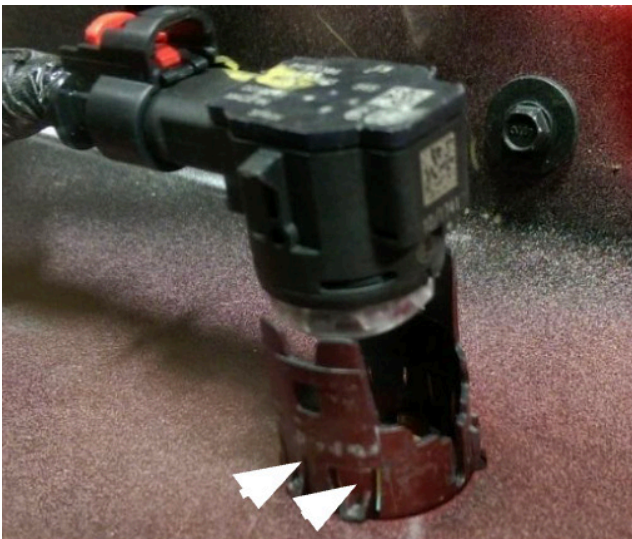


Figure 11



Figure 12

12. Disconnect the wiring harness from the tag lights, then remove the tag lights from the bumper by depressing the tabs around the light. (Figure 13)



Figure 13

13. Using a silver marker, make a line on the step plate as shown. Using a cutting tool, cut along the previously marked line. Touch up bare metal with paint to prevent rusting. (Figure 14-15)



Figure 14



Figure 15

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14. Using a cutting tool, trim the three (3) tabs off the tag lights as shown. (Figure 16)



Figure 16

15. Reinstall the spare tire access cover by pressing it into place on the new bumper. (Figure 17)

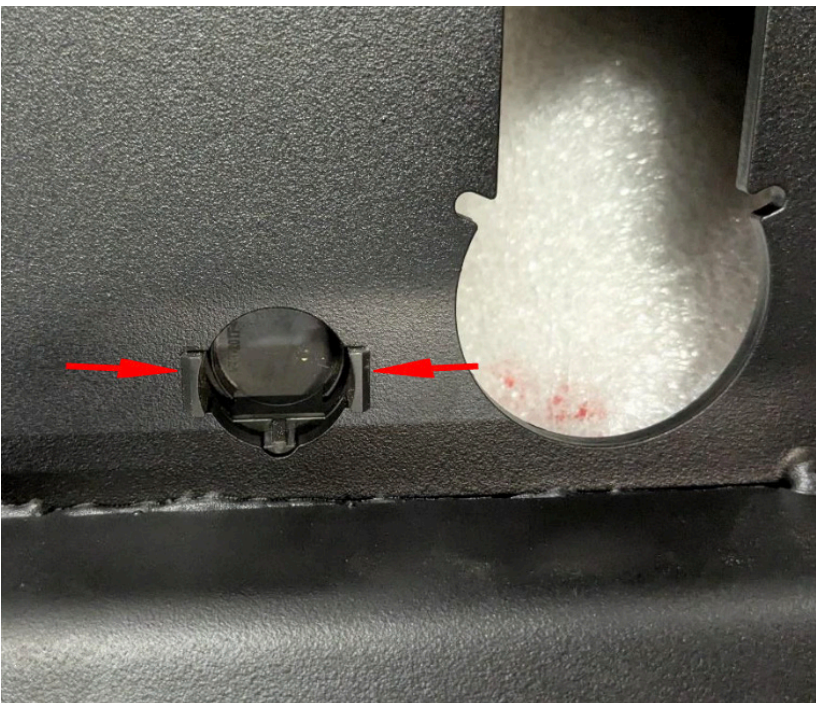


Figure 17

16. Reinstall the trailer plug by spreading the metal tabs and pushing it into the cutout in the bumper until the metal tabs engage. (Figure 18-19)



Figure 18

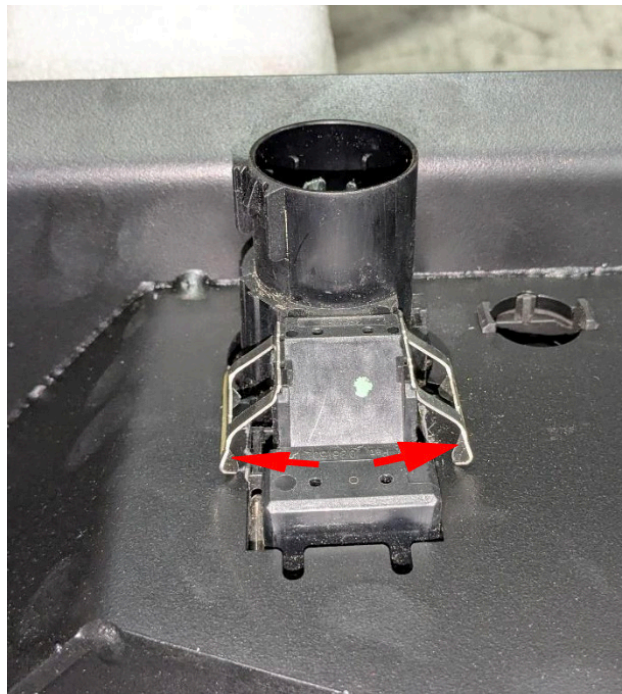


Figure 19

17. Reinstall the tag lights into the position in the new bumper which they were removed from the OE bumper. Use the provided epoxy to adhere them to the inside of the bumper. (Figure 20-21)



Figure 20



Figure 21

18. Reinstall the parking sensor housings into the new bumper in the same location from which they were removed. Reinstall the parking sensors back into their respective housing and align the connector with the etch bumper as shown. Use the provided epoxy to affix the sensor housings to the bumper shell. (Figure 22-24)



Figure 22

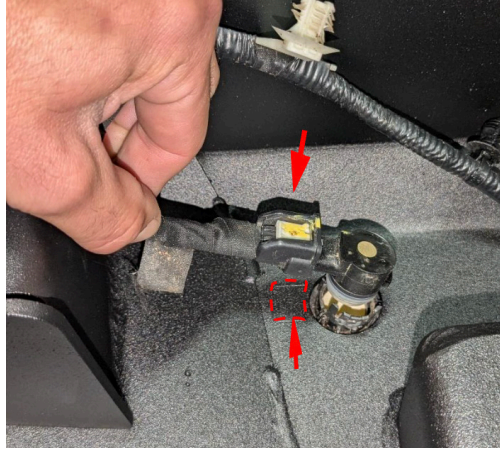


Figure 23

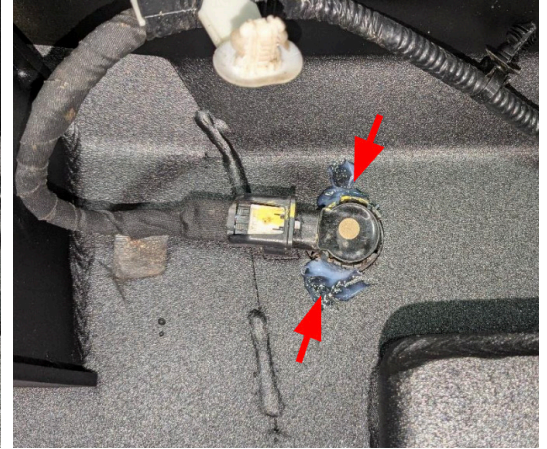


Figure 24

19. Reconnect the bumper wiring harness to the tag lights, parking sensors, and trailer plug.

20. Install the passenger's side intermediate bracket (Part#: 22416) to the frame of the vehicle using three (3) of the provided 7/16" hex head cap screws, lock washers and flat washers. Tighten the previously installed hardware using a 5/8" socket wrench. Repeat on the drivers' side with (Part#: 22417). (Figure 25-27)

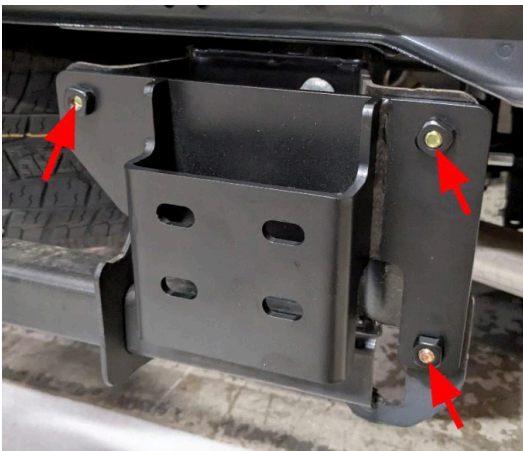


Figure 25

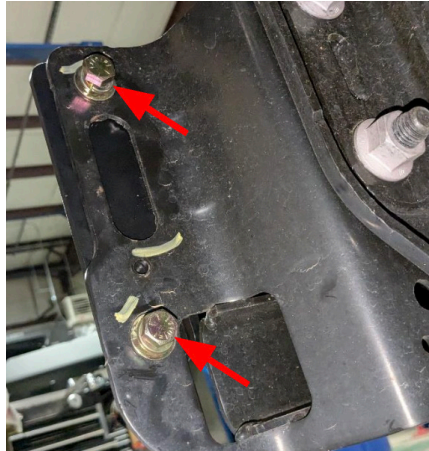


Figure 26



Figure 27

- 21. Install the four (4) provided bolt strips (Part#: 20296) into the previously installed intermediate brackets. (Figure 28)**



Figure 28

- 22. Install the bumper shell (Part#: 23435) onto the intermediate brackets. Install the eight (8) provided 1/2" hex nuts, lock washers, and flat washers onto the previously installed bolt strips. Align the bumper with the vehicle and tighten the 1/2" hardware with a 3/4" socket wrench. (Figure 29)**

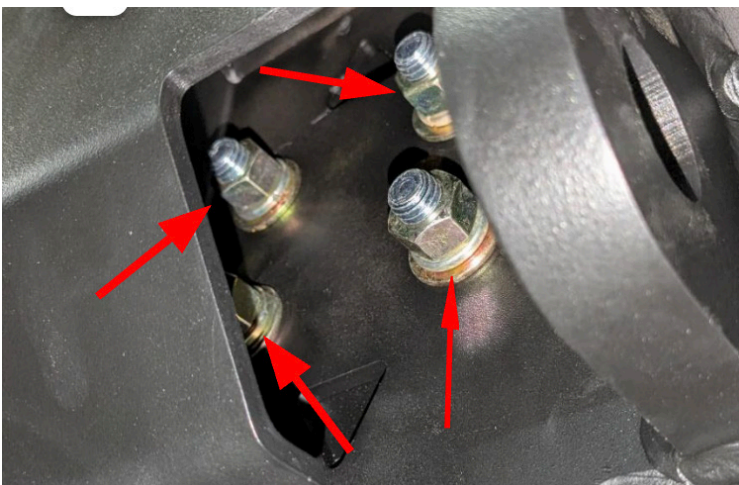


Figure 29

- 23. Reconnect the bumper wiring harness to the vehicle and reattach the harness ground using a 10mm socket wrench.**

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

