



**INSTALLATION MANUAL**  
**PREMIUM FRONT BUMPER**  
**PRODUCT NUMBER: A615X**  
**APPLICATION: 2024 CHEVROLET HD**



## **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

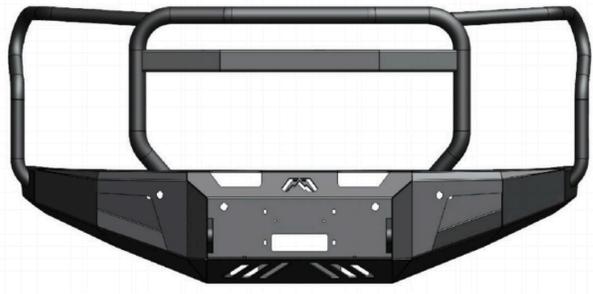
# GETTING STARTED

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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



23150 - BUMPER SHELL



22226



22227



23151



20296  
QTY:4

## REQUIRED TOOLS

- 7MM SOCKET WRENCH
- 10MM SOCKET WRENCH
- 15MM SOCKET WRENCH
- 18MM SOCKET WRENCH
- 7/16" SOCKET WRENCH
- 7/16" COMBINATION WRENCH
- 9/16" SOCKET WRENCH
- 3/4" SOCKET WRENCH
- 3/4" COMBINATION WRENCH
- 18MM COMBINATION WRENCH
- T10 STAR HEAD SOCKET WRENCH
- WIRE CUTTERS
- PLYERS
- BODY PRY TOOL

## 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 | 50233-HW

IDENTIFICATION NUMBER	COMPONENT DESCRIPTION	QTY
50233-HW	3/8"-16 X 1", HEX HEAD CAP SCREW, YELLOW-ZINC, GRADE 8	4
50233-HW	3/8", FLAT WASHER, YELLOW-ZINC, GRADE 8	4
50233-HW	3/8", LOCK WASHER, YELLOW-ZINC, GRADE 8	4
50233-HW	1/4"-20 X 1", HEX HEAD CAP SCREW, YELLOW-ZINC, GRADE 8	4
50233-HW	1/4", FLAT WASHER, YELLOW-ZINC, GRADE 8	8
50233-HW	1/4", LOCK WASHER, YELLOW-ZINC, GRADE 8	4
50233-HW	1/4"-20, HEX NUT, YELLOW-ZINC, GRADE 8	4
50233-HW	1/2"-13, HEX NUT, YELLOW-ZINC, GRADE 8	8
50233-HW	1/2", FLAT WASHER YELLOW-ZINC, GRADE 8	8
50233-HW	1/2", LOCK WASHER, YELLOW-ZINC, GRADE 8	8
50233-HW	1 3/8", GROMMET, PLASTIC, MM9307K81	4

# INSTALLATION

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1. Using a T10 Torx bit, remove the two (2) screws in the hood latch handle to remove it. Figure 1

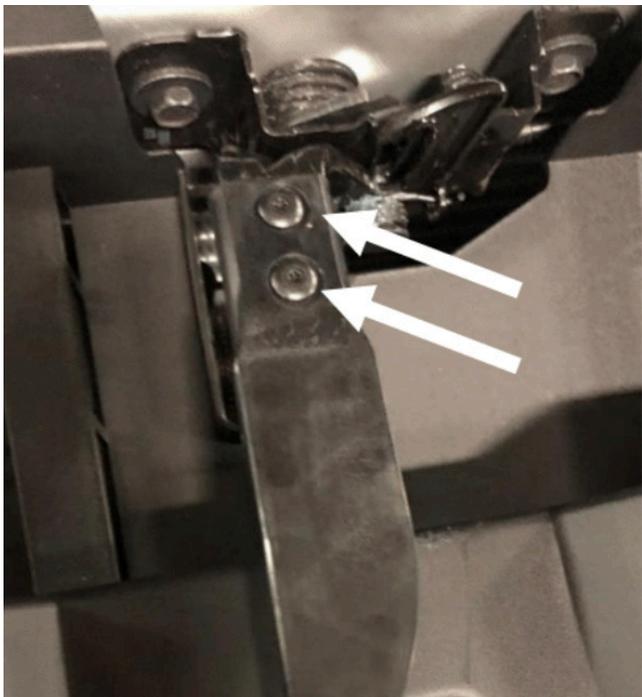


Figure 1

2. Using a panel pry tool, remove the nine (9) push pins retaining the under-hood cowl. Figure 2

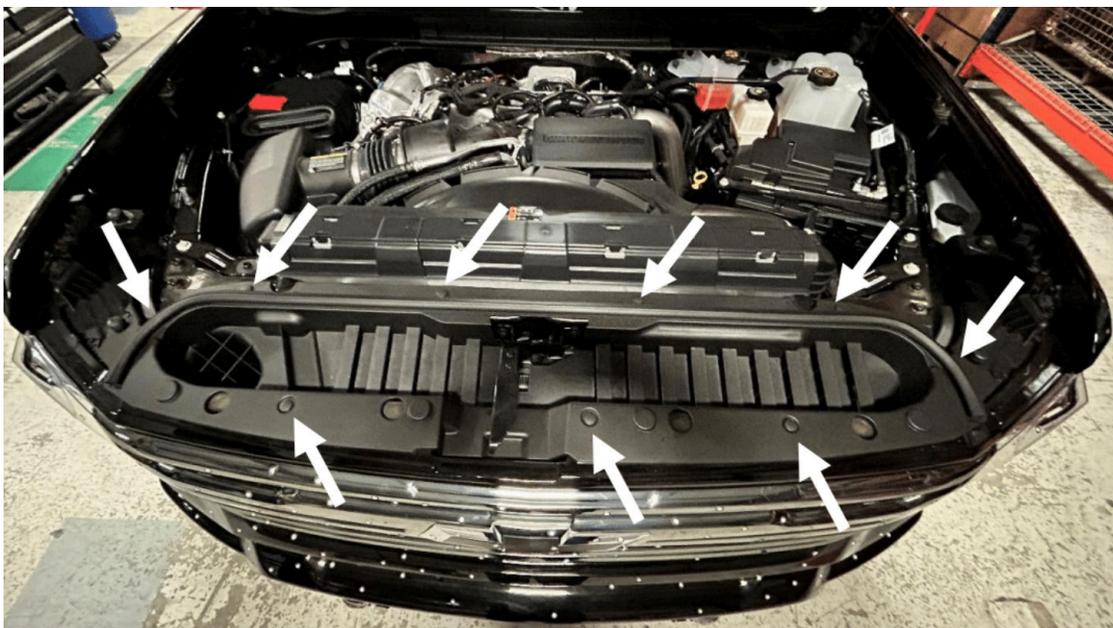


Figure 2

3. Using a T10 torx bit and panel pry tool, remove the screws and push pins from the inner fender liners to remove them from the vehicle. Figure 3



Figure 3

4. Using a panel pry tool, pull outward on the fender flares at the front near the bumper to access the fascia screws. Figure 4

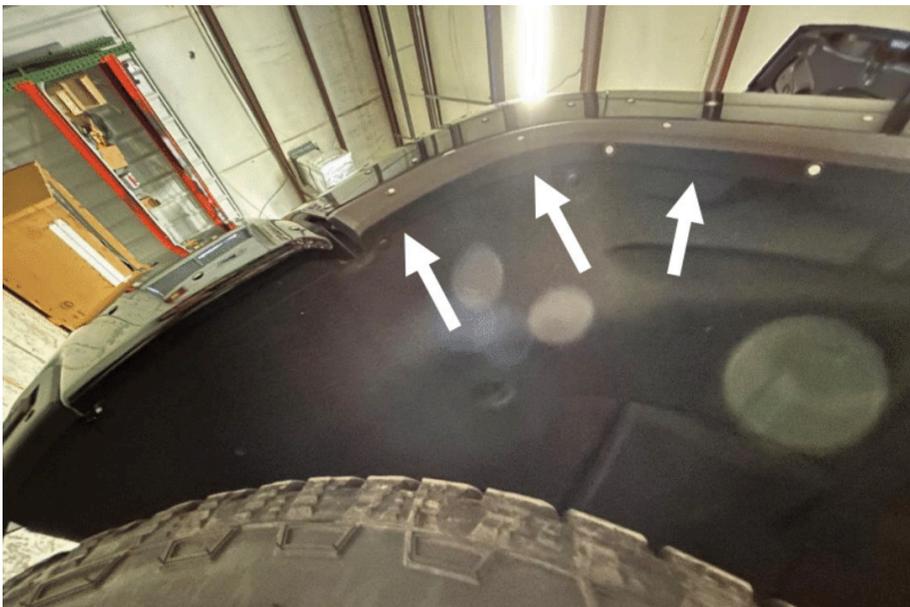


Figure 4

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5. Using a 7mm socket wrench, remove the screw holding the fascia to the fender on each side of the vehicle. Figure 5

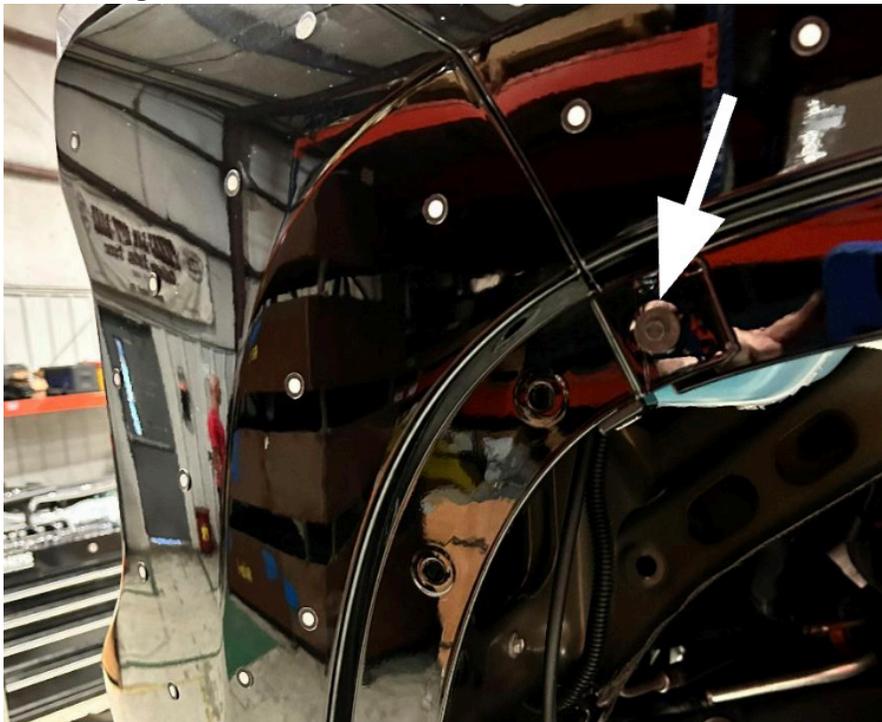


Figure 5

6. Using a panel pry tool and your hands, carefully pull outward on the fascia starting from the edge against the fender to remove it from the vehicle. Figure 6



Figure 6

7. Using a 10mm socket wrench, remove the four (4) screws along the top of the grille. Figure 7



Figure 7

8. Using a 10mm socket wrench, remove the two (2) screws along the bottom of the grille. Figure 8

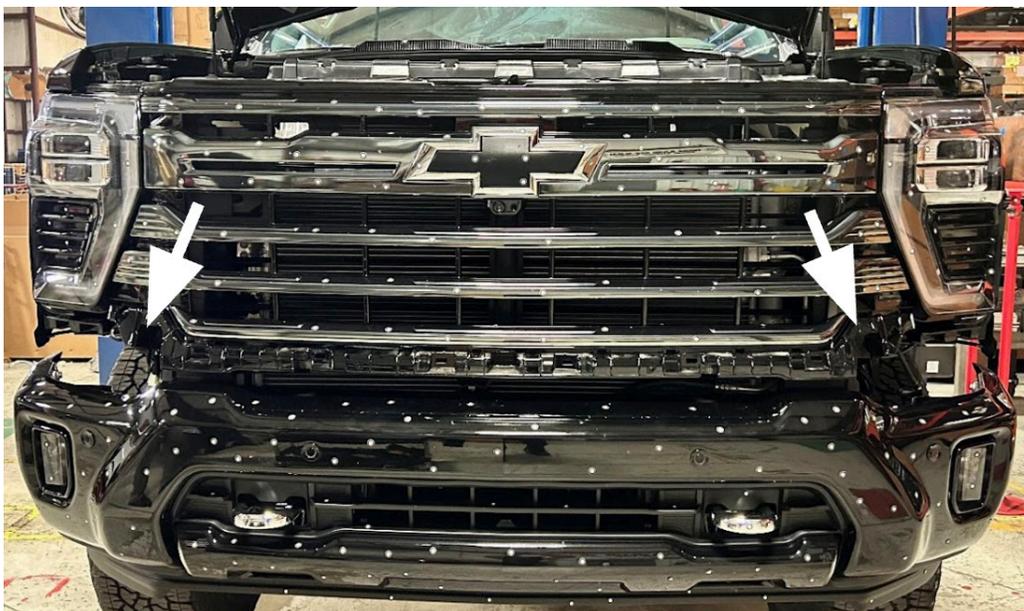


Figure 8

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9. If applicable, disconnect the grille camera wiring harness and remove the grille from the vehicle.  
Figure 9



Figure 9

10. Using a 15mm socket with extension, remove the four (4) bolts between the bumper and frame horns. Figure 10-11

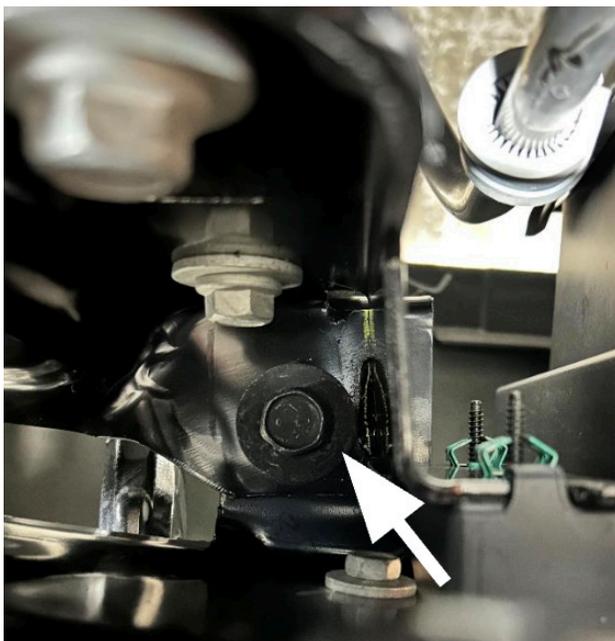


Figure 10

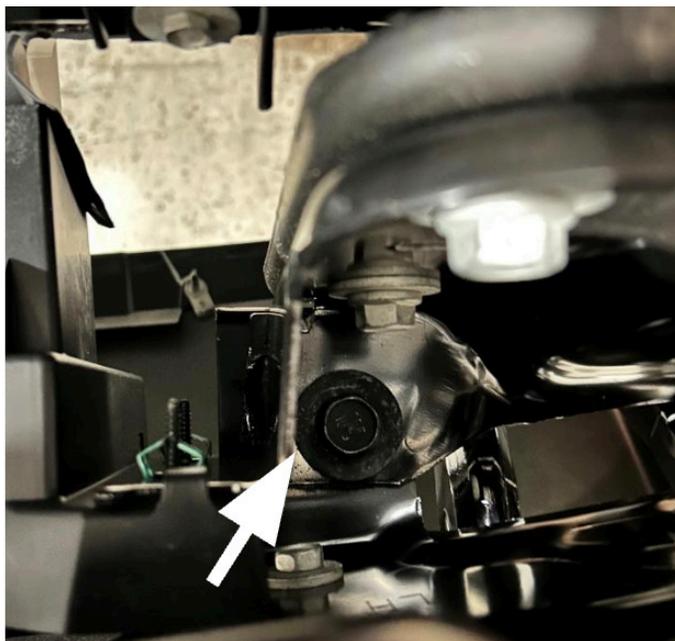


Figure 11

11. Using a 15mm socket wrench, remove two (2) bolts in each of the two (2) bumper reinforcement brackets from the frame. Figure 12

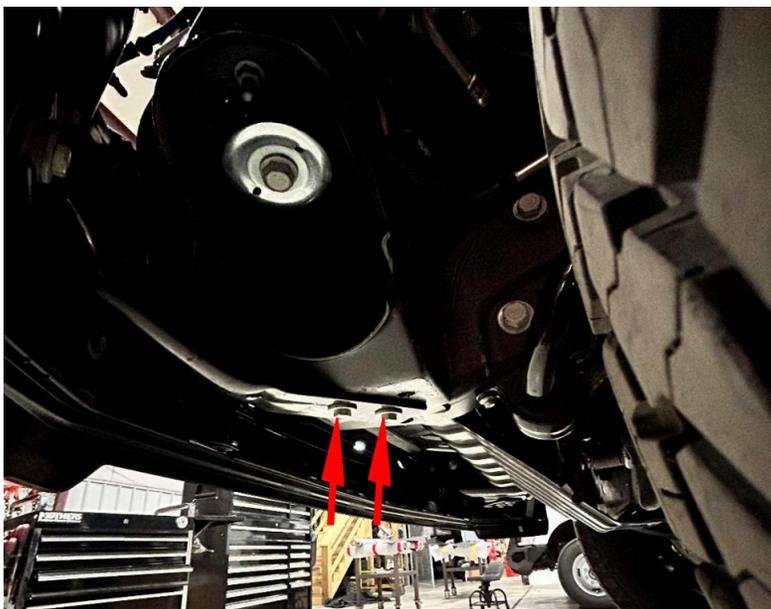


Figure 12

12. Disconnect the bumper wiring harness to finish removing the bumper from the vehicle. Figure 13



Figure 13

13. Using an 18mm socket wrench, remove the eight (8) bolts per bumper bracket. Figure 14-15

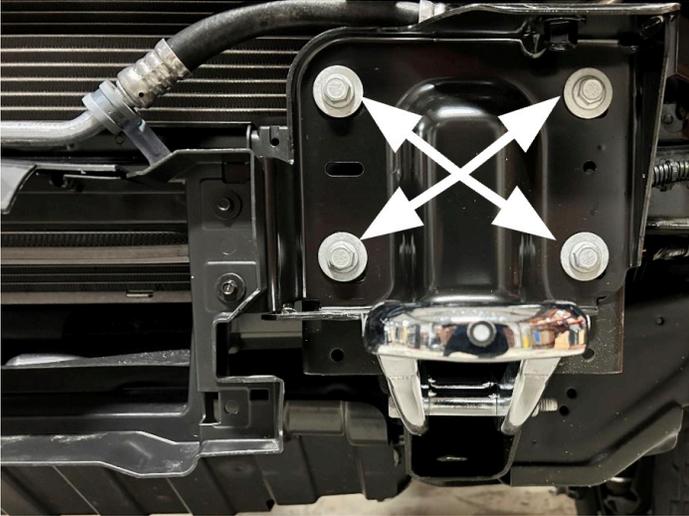


Figure 14

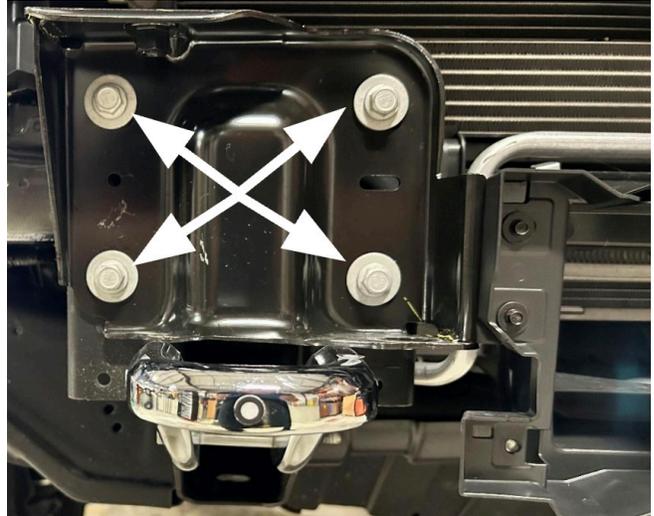


Figure 15

14. Using an 18mm socket and combination wrench, remove the two (2) bolts per tow-hook to remove them from the vehicle. Figure 16

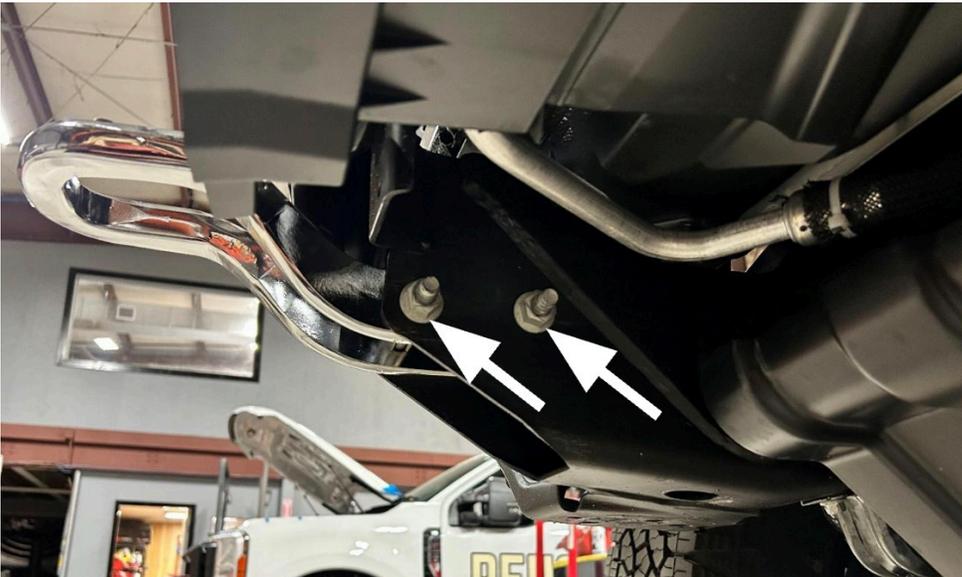


Figure 16

15. If applicable, remove the block heater plug from the OEM bumper by pushing in on the locking nut and turning counterclockwise. Then, using a panel pry tool, remove the rest of the harness from the bumper and set aside. Figure 17



Figure 17

16. Using a 7mm and 13mm socket wrench, deconstruct the OEM bumper to gain access to the parking sensors. Figure 18



Figure 18

17. Disconnect the bumper wiring harness from each fog light. Figure 19



Figure 19

18. Carefully remove the four sensors and sensor housings from the bumper by spreading the housing clips out and pushing the sensor out simultaneously. (Figure 20)

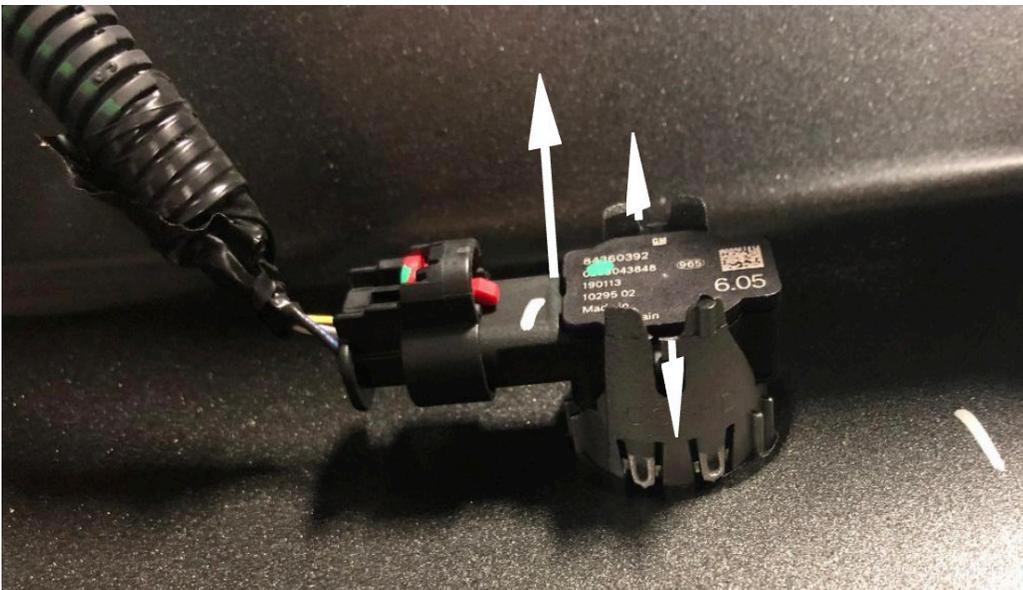


Figure 20

19. Remove the sensor housings from the bumper by pressing the retainer clips in on the sides and pushing the housing out. (Figure 21)

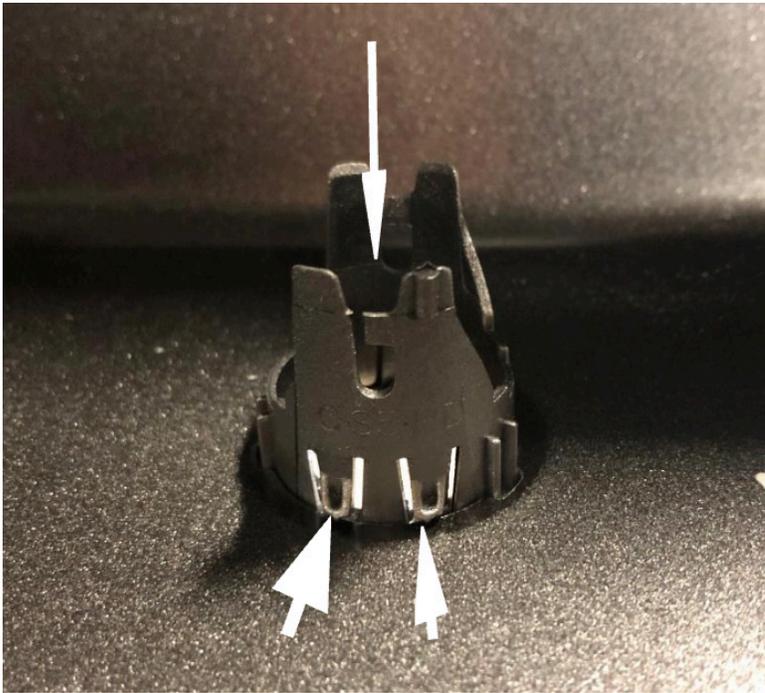


Figure 21

20. Reinstall the parking sensor housings into the new bumper shell in the same orientation and position from which they were removed. (Figure 22)



Figure 22

21. Reinstall the park sensors into their respective housings with the sensor harness. Note, the outer sensors will need the covers at the base of the harness connectors removed. (Figure 23-24)



Figure 23



Figure 24

22. If applicable, install lighting using the lighting manufacturers provided hardware. (Figure 25)

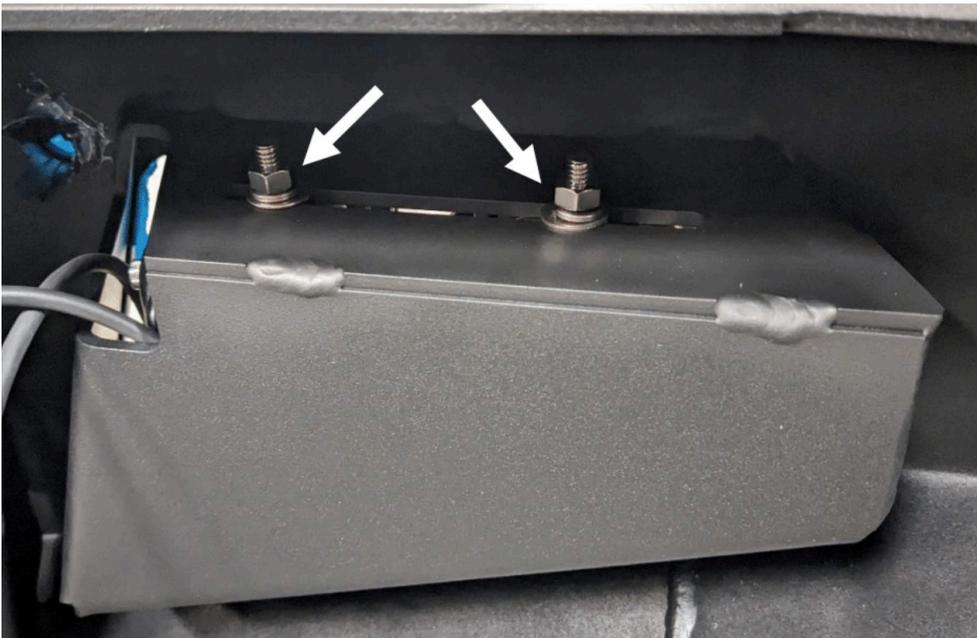


Figure 25

23. If applicable, install your winch using the winch manufacturers provided hardware. (Figure 26)



Figure 26

24. Install the provided frame mounting brackets (DS Part#: 22226 / PS Part#: 22227) to the frame rails using the previously removed hardware. Tighten the hardware with a 15mm socket and combination wrench and 18mm socket and combination wrench. (Figure 27-28)

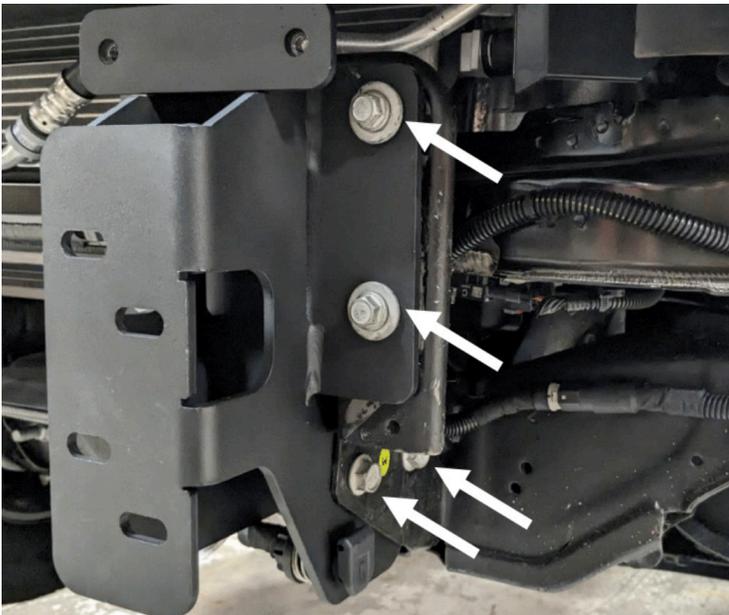


Figure 27

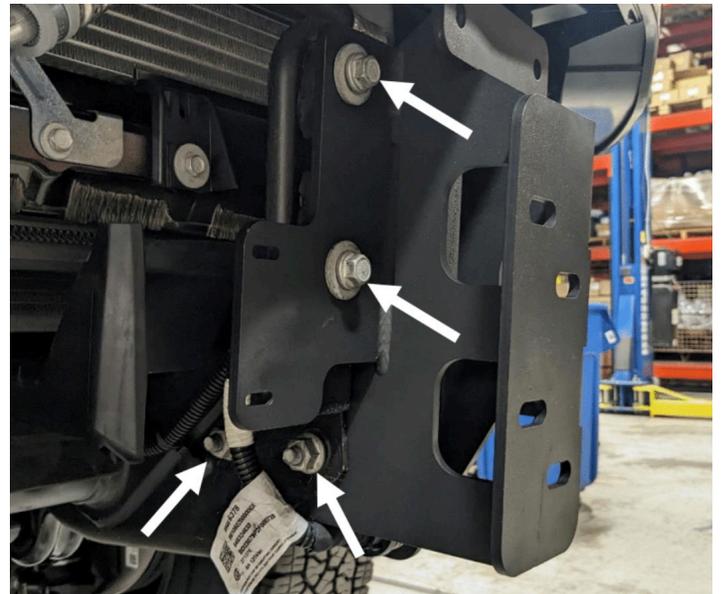


Figure 28

25. Reverse the process in step 15 to install the heater plug into the driver side mounting bracket. Reconnect the heater plug wiring harness before mounting the bumper. (Figure 29)

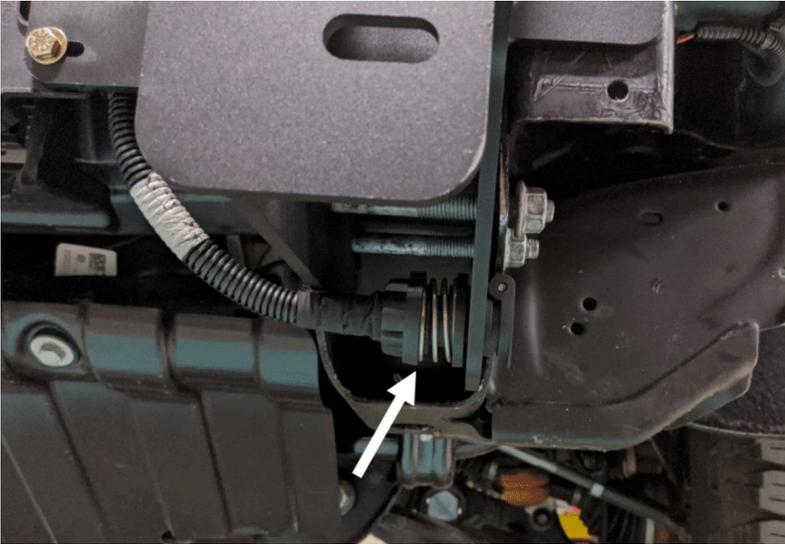


Figure 29

26. Install the provided backer strip (Part#: 23151) by installing two (2) of the provided 3/8" bolts, lock washers and flat washers on one side. Then, push the backer strip towards the other brackets and install the remaining 3/8" hardware. Use 9/16" socket wrench to tighten the previously installed hardware. (Figure 30-31)



Figure 30



Figure 31

27. Install the four (4) provided bolt strips (Part#: 20296) into the bumper. (Figure 32)



Figure 32

**\*\*Note:** The four (4) inner slots on the mounting brackets and the provided 1/4" hardware is not used for this installation. (Figure 33)

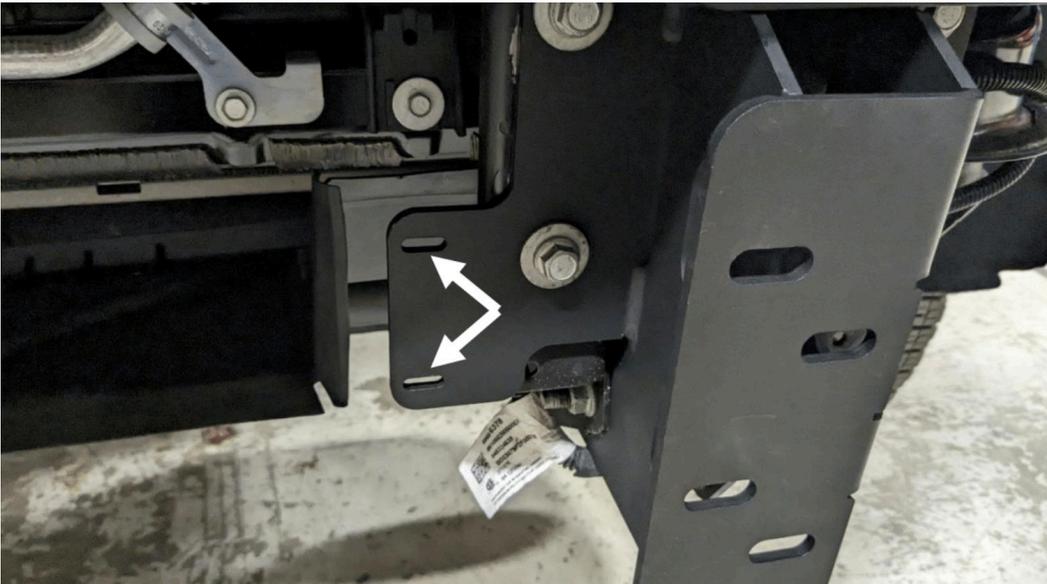


Figure 33

28. Install the bumper to the mounting brackets using the eight (8) provided flat washers, lock washers and hex nuts. Then, use a 3/4" combination wrench to tighten the hardware after aligning the bumper with the vehicle. (Figure 34)

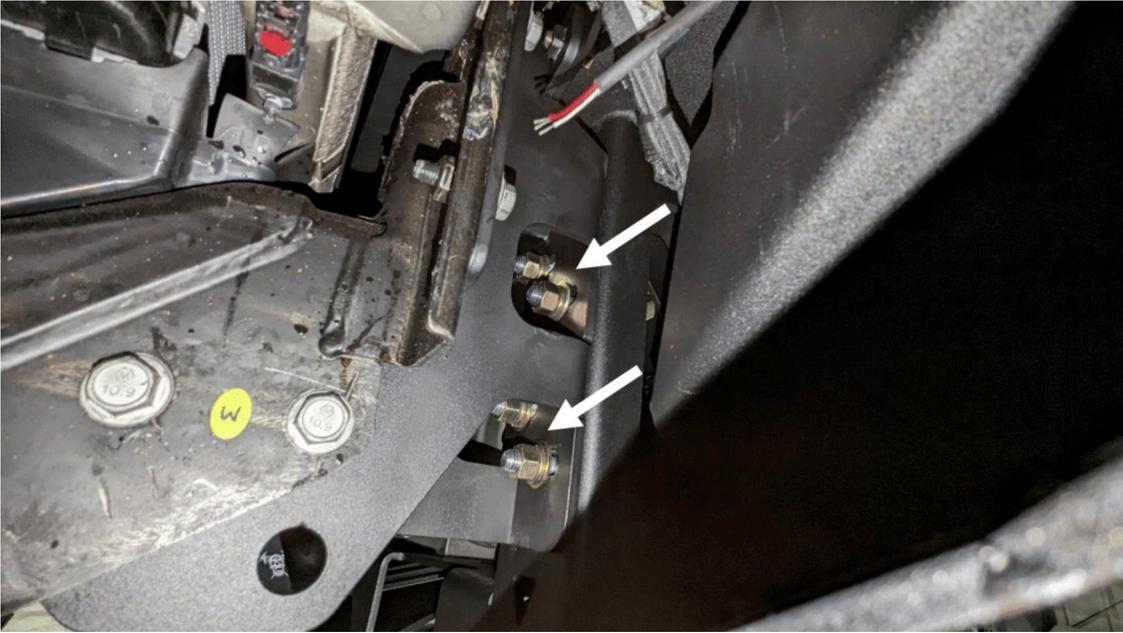


Figure 34

29. Reconnect the parking sensor harness to the vehicle. (Figure 35)



Figure 35

# 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**

