



INSTALLATION MANUAL
VENGEANCE FRONT BUMPER
PRODUCT NUMBER: D585X
APPLICATION: 2023 GMC 1500



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.

TABLE OF CONTENTS

2	SAFETY / DISCLAIMER
3	TABLE OF CONTENTS
4	A MESSAGE FROM THE OWNER
5	GETTING STARTED
6	PROVIDED MATERIAL
8	INSTALLATION
22	CONTACT

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

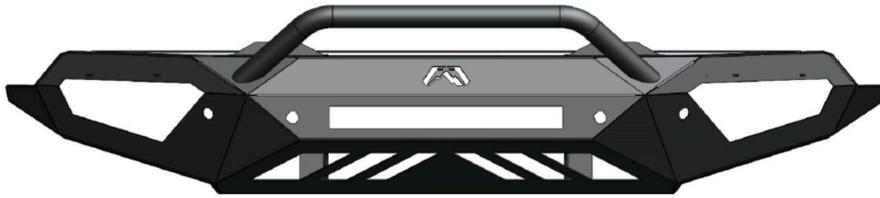
FOUNDER, FAB FOURS

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



23013 - BUMPER SHELL



22352 - L-BRACKETS
QTY: 2

61632 - EPOXY PACKETS QTY:2

TOOLS REQUIRED

- T15 TORX
- PANEL PRY TOOL
- 7MM SOCKET WRENCH
- 10MM SOCKET WRENCH
- 13MM SOCKET WRENCH
- 15MM SOCKET WRENCH
- 18MM SOCKET WRENCH
- 7/16" SOCKET AND COMBINATION WRENCH
- SMALL RECIPROCATING SAW

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 | 50373-HW & TXX50-HW

IDENTIFICATION NUMBER	COMPONENT DESCRIPTION	QTY
50373-HW	1/4"-20 X 1", YELLOW-ZINC, GRADE 8, HEX HEAD CAP SCREW	2
50373-HW	1/4"-20, YELLOW-ZINC, GRADE 8, HEX NUT	2
50373-HW	1/4"-SAE, YELLOW-ZINC, GRADE 8, FLAT WASHER	4
50373-HW	1/4"-SAE, YELLOW-ZINC, GRADE 8, LOCK WASHER	2

IDENTIFICATION NUMBER	COMPONENT DESCRIPTION	QTY
TXX50	1/2" LICENSE PLATE NUT	2
TXX50	1 3/8" RUBBER GROMMET	4
TXX50	BLACK PLASTIC PLUG	4

INSTALLATION

1. Using a T15 Torx bit remove the two (2) screws in the hood latch handle to remove it. Figure 1

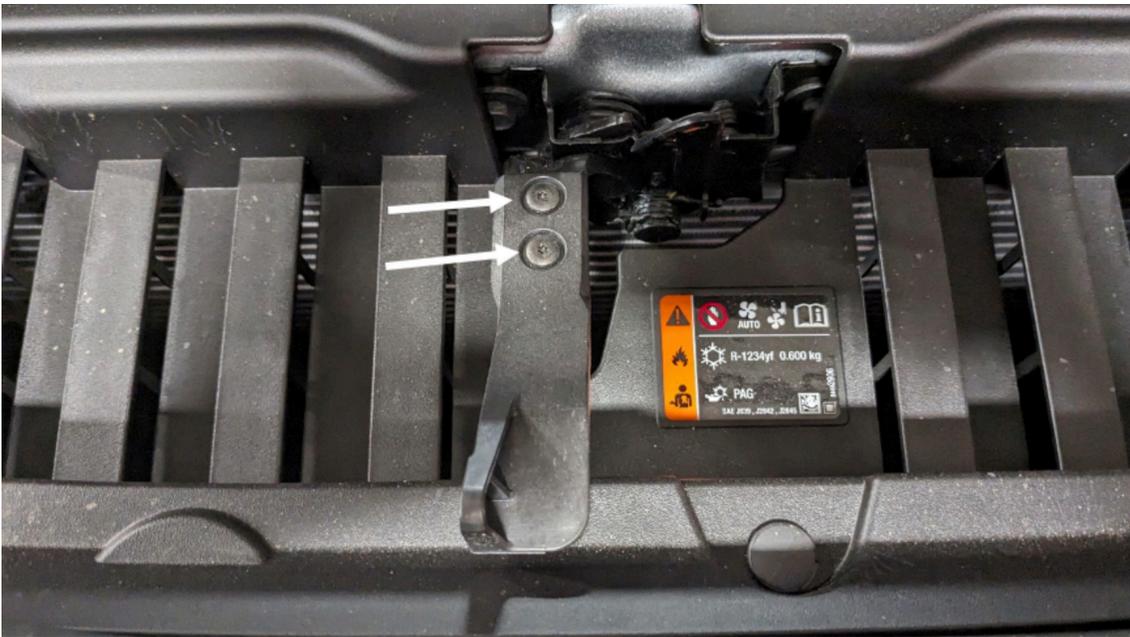


Figure 1

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



Figure 2

3. Using a 10mm, remove the four (4) screws across the top of the grille. Figure 3



Figure 3

4. Using a T15 Torx, remove the six (6) lowest forward most screws in each front inner fender. Figure 4-5



Figure 4

-
5. Starting from the front edge of the fender flares, pull outward to detach them from the vehicle past the separation line in the fender. Figure 5



Figure 5

6. Using a 7mm socket wrench, remove the screw in the corner of the valance. Figure 6



Figure 6

7. Starting on one side of the vehicle, pull outward on the valence to release the clips which attach it. The seam where the valence meets the fender has six (6) clips, using a panel pry tool you can help release these clips while pulling outward on the valence. Once the seam clips are released there are several other clips along the valence that can be released simply by pulling outward. Figure 7-8

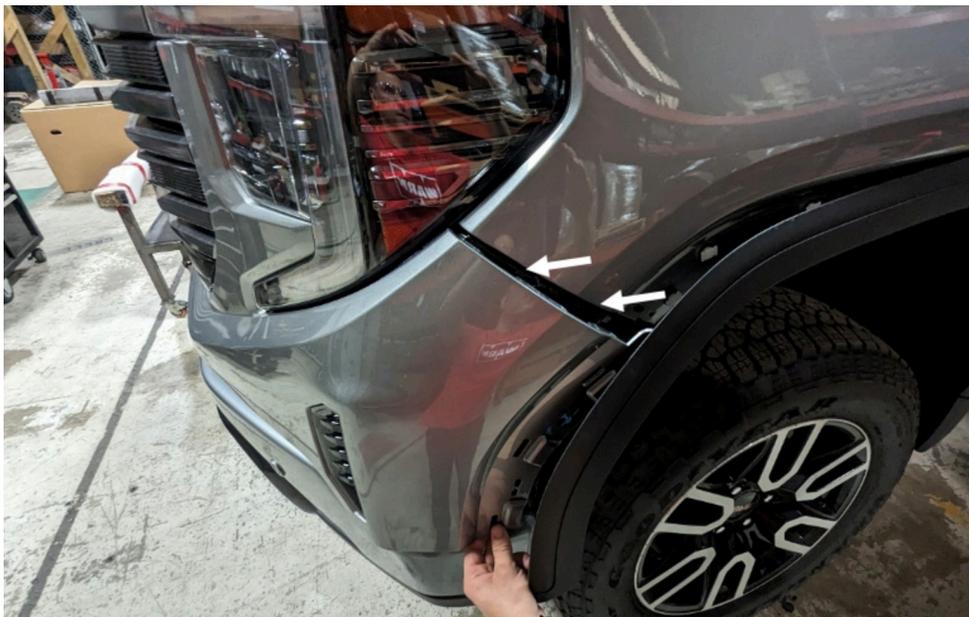


Figure 7

8. Using a 10mm socket wrench, remove the three (3) screws along the bottom of the grille. Figure 8



Figure 8

9. Disconnect the camera wiring and camera washer hose. Figure 9-10



Figure 9

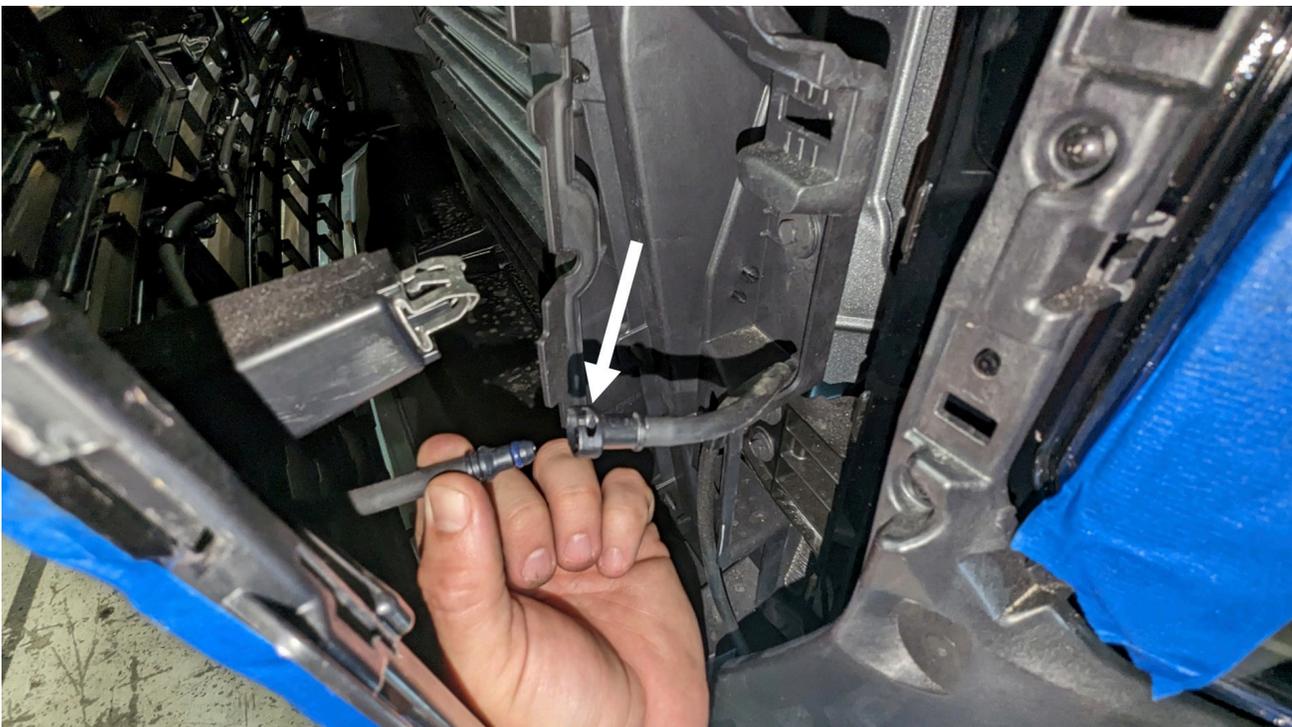


Figure 10

10. The grille can now be removed by pulling outward to release the clips holding it to the vehicle.

11. Using a 10mm socket wrench, remove the nine (9) screws around the perimeter of the upper louvers. Figure 11

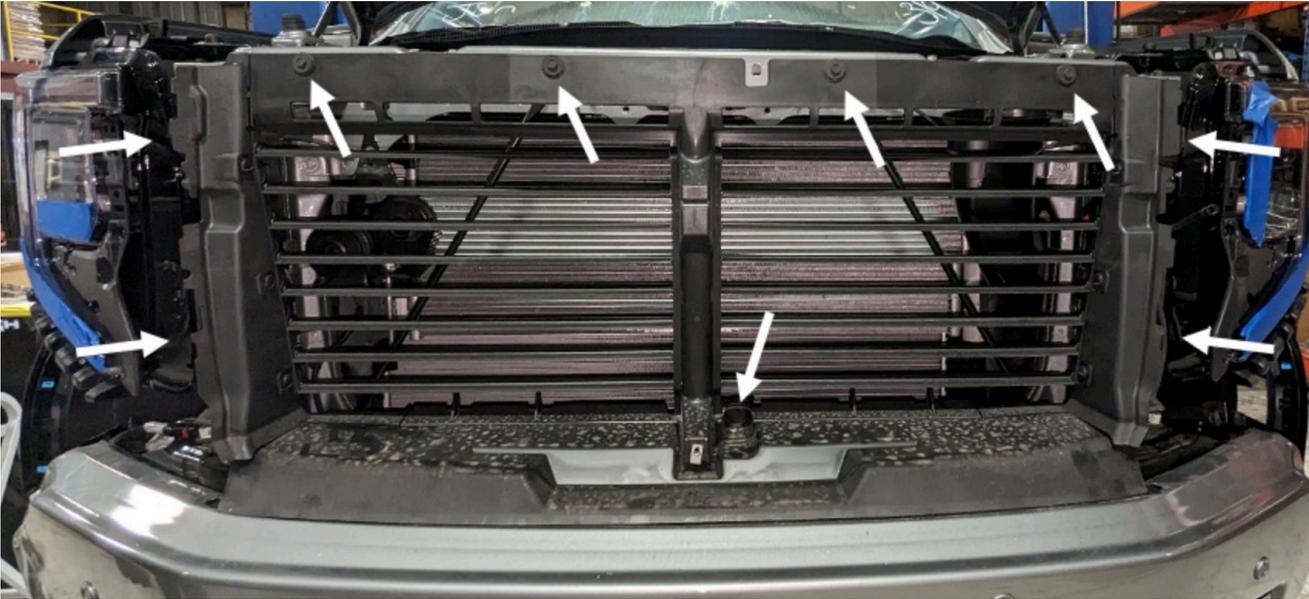


Figure 11

12. Disconnect the upper louver electrical harness and remove the upper louvers from the vehicle. Figure 12



Figure 12

13. Using an 18mm socket wrench, remove the two (2) bolts on each side of the top of the OEM bumper mounting brackets. Figure 13



Figure 13

14. Using a 15mm socket wrench, remove the three (3) bolts per side holding the bumper supports to the frame and bumper. Figure 14



Figure 14

15. Using a 10mm socket wrench, remove the four (4) screws per side holding the bumper supports to the frame and bumper. The bumper can now be removed from the vehicle. Figure 15

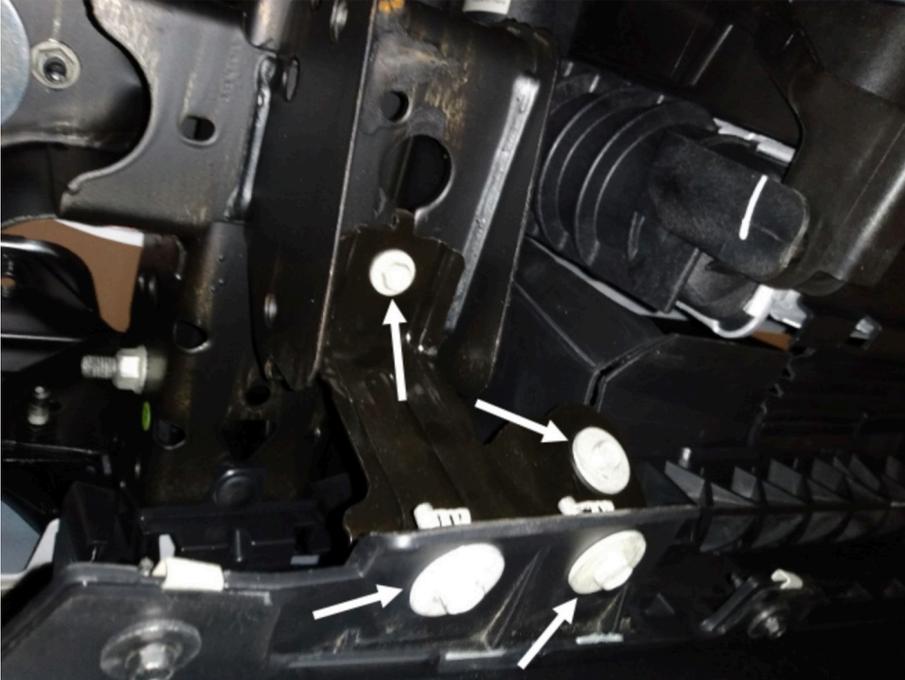


Figure 15

16. Separate the bumper from the vehicle enough to access the electrical connector to finish removing the bumper from the vehicle. Figure 16



Figure 16

17. Using a 10mm and 18mm socket and combination wrench, remove the two (2) screws per side holding the underrun bracket to the frame. Figure 17

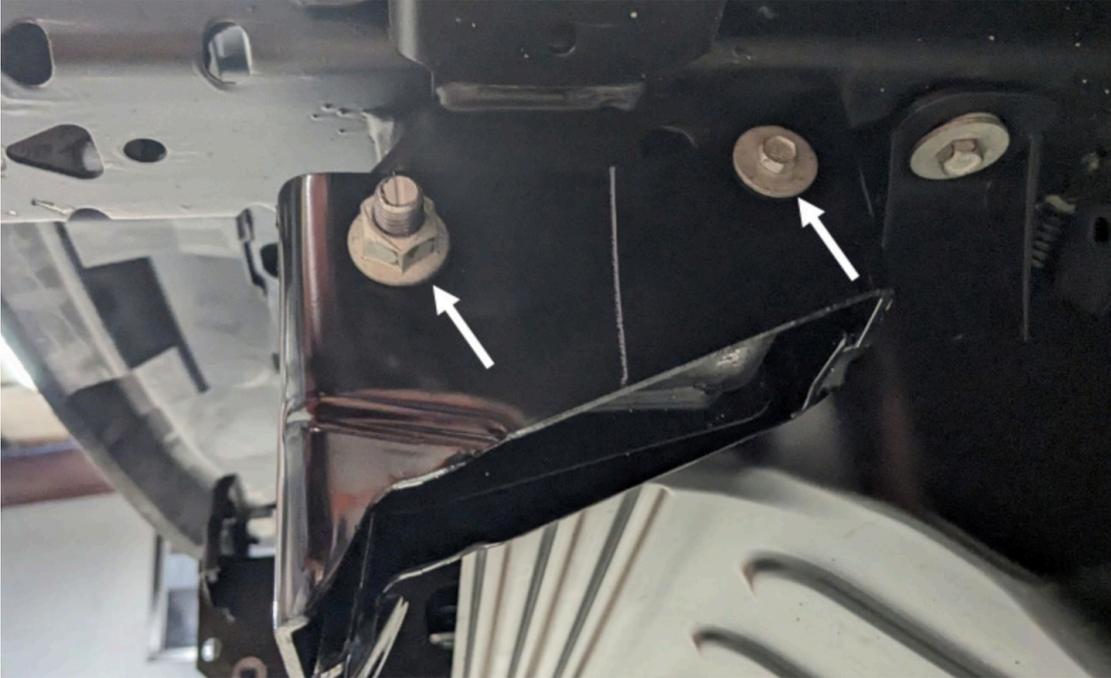


Figure 17

****Note: Steps 18, 26-30 only apply to vehicles with lower louvers. ****

18. Using a panel pry tool, remove the four (4) push pins from the lower louver shroud and the three (3) clips attaching the harness to the vehicle. Then, using a 15mm socket wrench remove the six (6) bolts in the frame horns to release the louvers from the frame. Figure 18

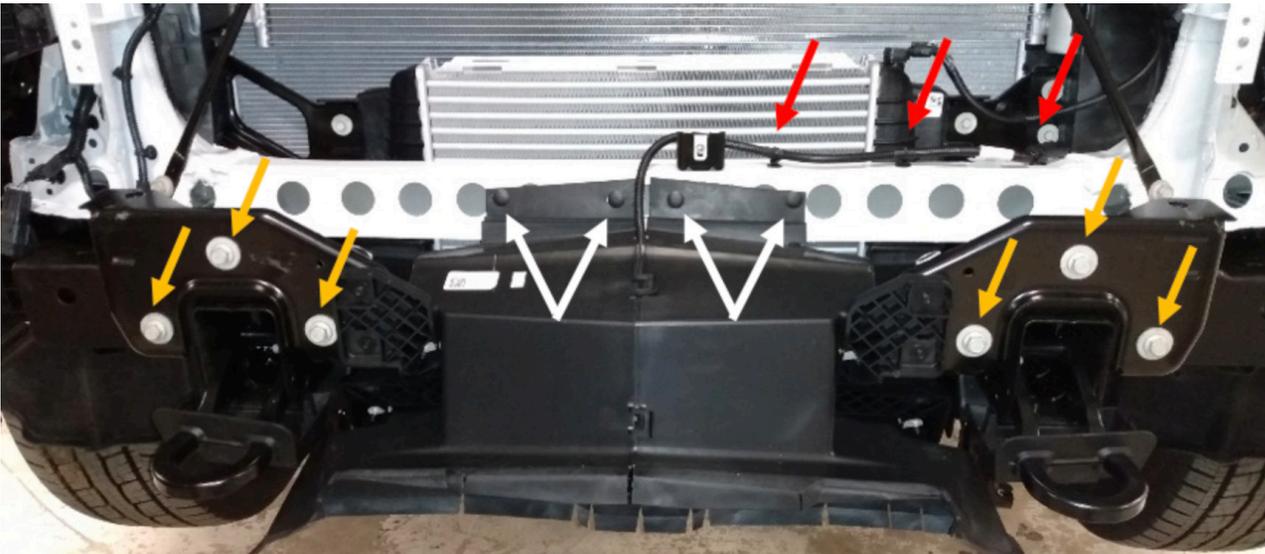


Figure 18

19. Using an 18mm socket wrench and combination wrench, remove the two (2) bolts attaching each tow hook to the frame to remove them. Then, use a panel pry tool to remove the push pin in the bottom of the tow hook shroud. Figure 19



Figure 19

20. Reinstall the previously removed upper louver set by reversing the steps used to remove it.

21. Reinstall the previously removed grille by reversing the steps used to remove it.

22. Reinstall the previously removed valence by reversing the steps used to remove it.

23. Reinstall the previously removed under hood cowl by reversing the steps used to remove it.

24. Reinstall the previously removed hood latch handle by reversing the steps used to remove it.

25. Reinstall the previously removed inner fender hardware by reversing the steps used to remove it.

28. Using a small reciprocating saw, trim the lower louver shroud as shown. Figure 22-24



Figure 22



Figure 23



Figure 24

29. Reinstall the previously removed lower louver set to the intermediate bumper bracket by reinstalling the four (4) screws with a 7mm socket wrench. Figure 25



Figure 25

30. Reinstall the previously removed lower louver set onto the vehicle by reinstalling the four (4) previously removed push pins from the top of the louver shroud and reconnect the electrical harness. Figure 26

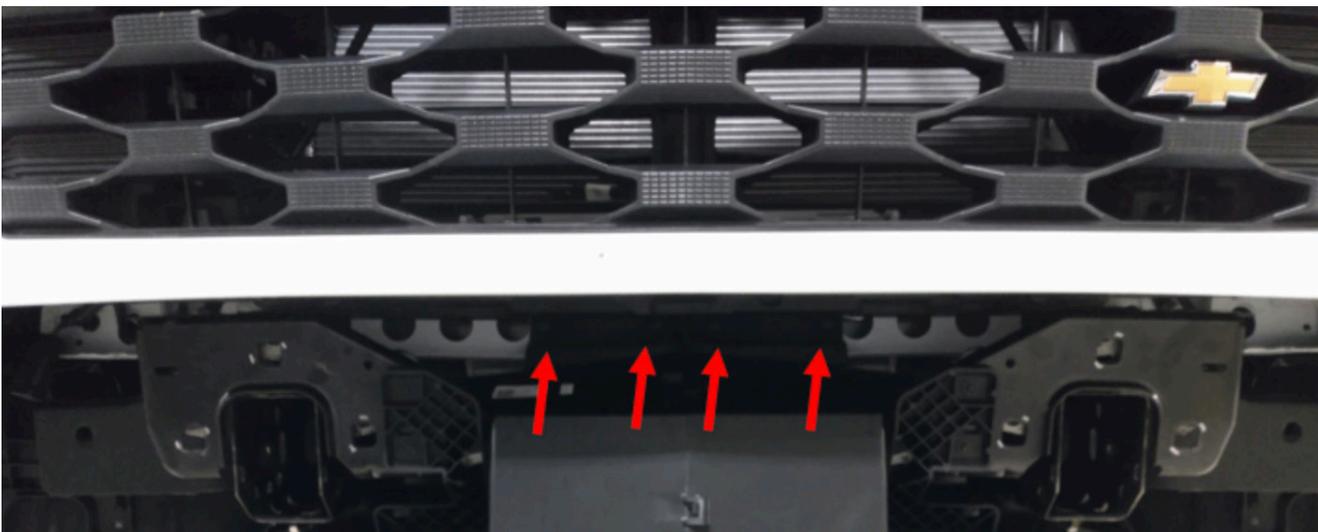


Figure 26

31. Disconnect the wiring harness from the fog lights. Figure 27



Figure 27

32. Using a 13mm socket wrench, remove the nine (9) bolts per side attaching the bumper structure to the bumper shell. Figure 28

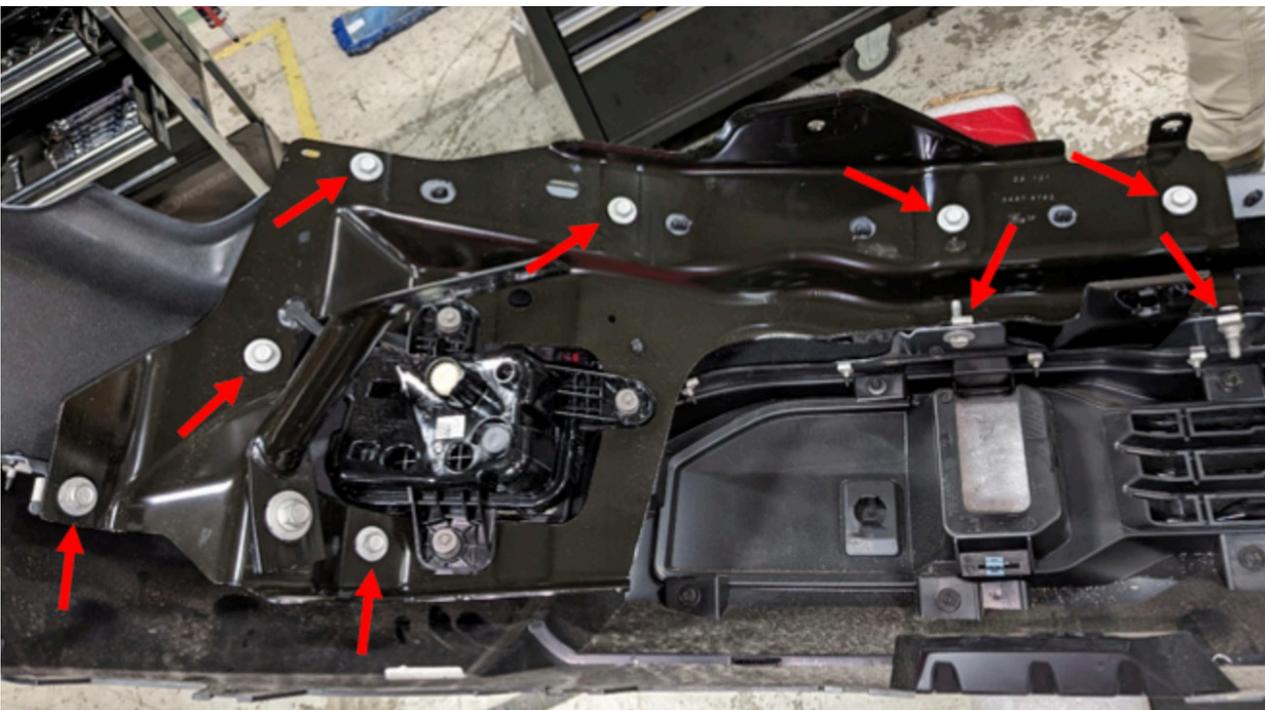


Figure 28

33. Note the orientation and position of the parking sensors and harness. Figure 29-31



Figure 29



Figure 30



Figure 31

34. Remove the sensors and sensor housings from the bumper shell. Spread the housings to release the sensors. Depress the housing tabs and push them out of the bumper shell. Figure 32-33

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



Figure 32

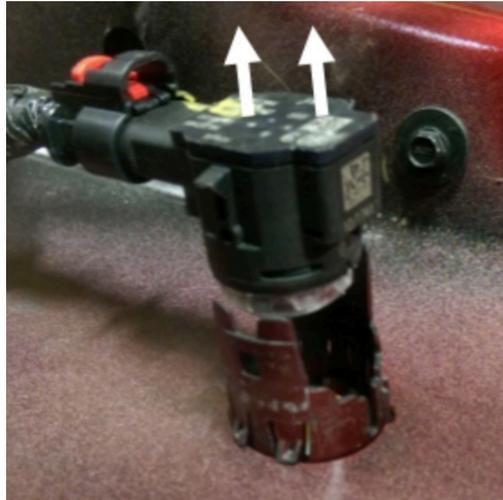


Figure 33

35. Remove the sensor housing from the bumper by depressing the four (4) tabs while pulling outward from the outside of the bumper Figure 34-35

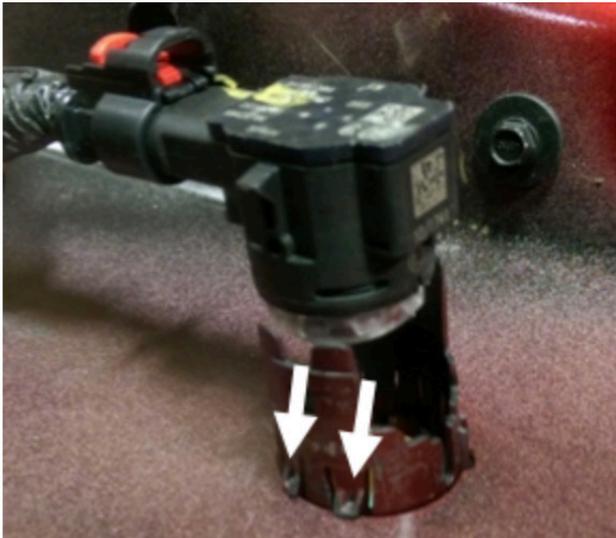


Figure 34



Figure 35

36. If installing a lightbar into the new bumper do so now using a 7/16" socket and combination wrench, two (2) provided lightbar mounting brackets (Part#:22352) with the provided 1/4" bolts, flat washers, lock washers, and nuts. Figure 36

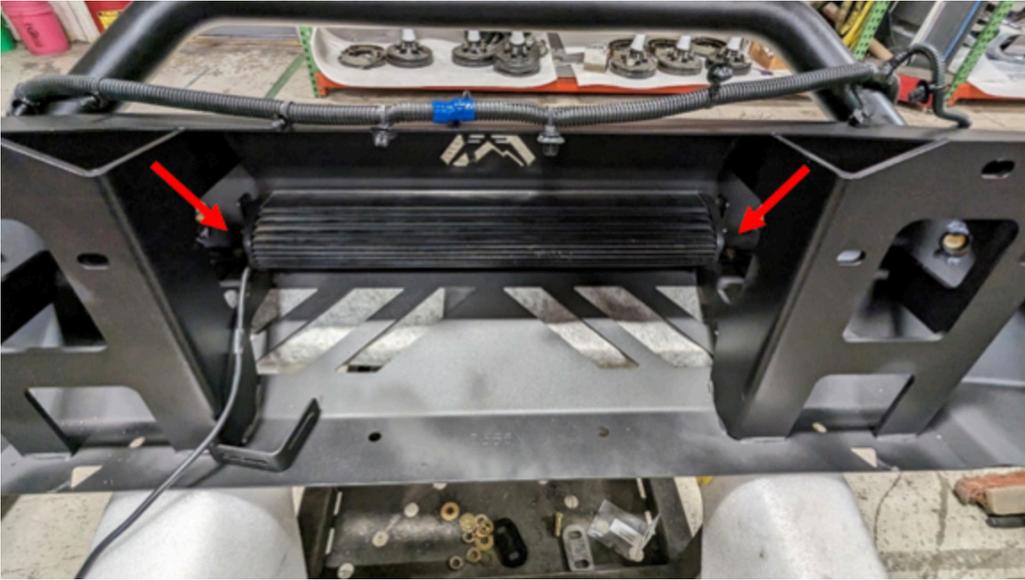


Figure 36

37. If installing cube lights into the wings, do so now per the light manufacturer's hardware and instructions.

38. Reinstall the parking sensors into the new bumper in the same position and orientation from which they were removed. Using the provided epoxy, fix the sensor housing in place to the bumper. Figure 37

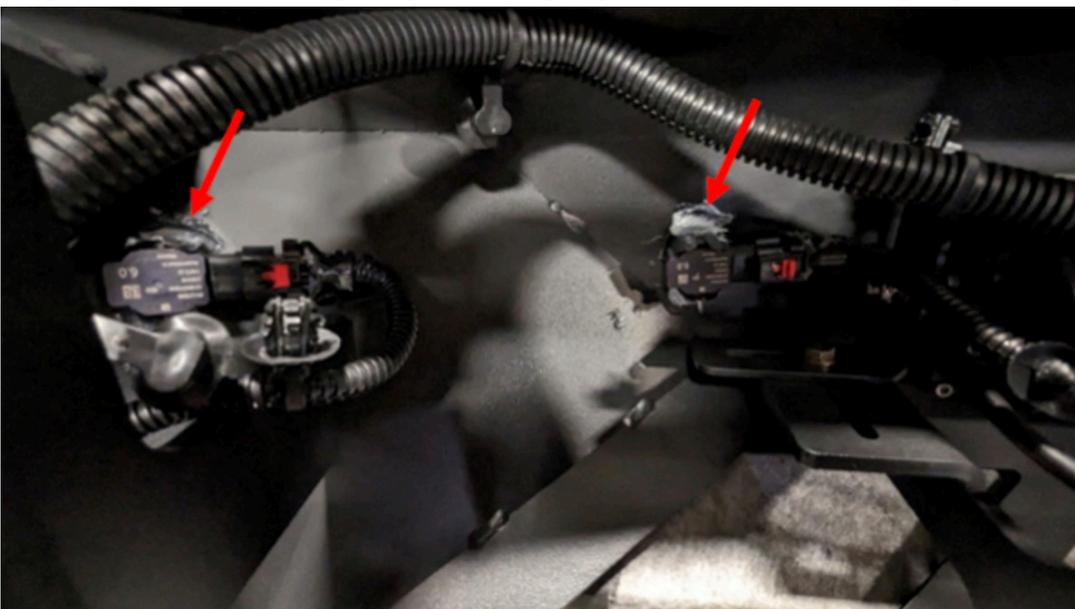


Figure 37

39. Using an 18mm socket wrench, install the bumper to the vehicle using the six (6) OEM bolts previously removed. Align the bumper side to side with the body of the vehicle then tighten the hardware.

Figure 38



Figure 38

INSTALLATION COMPLETE

CONTACT INFORMATION

**FAB FOURS INC.
2213 INDUSTRIAL PARK ROAD
LANCASTER, SC 29720**

PHONE: (866) 385-1905

FAX: 970-385-1914

EMAIL: SUPPORT@FABFOURS.COM

FABFOURS.COM



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

- GREG HIGGS

