



**INSTALLATION MANUAL**  
**VENGEANCE REAR BUMPER**  
**PRODUCT NUMBER: E5852**  
**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.

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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

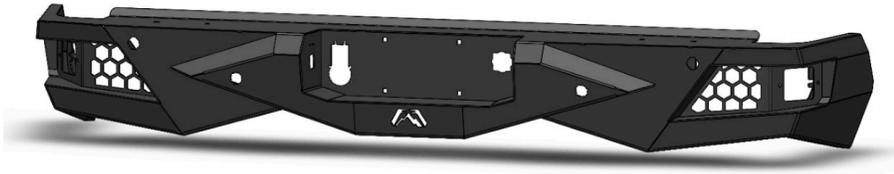
# GETTING STARTED

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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



23126-W (BUMPER)



22074 COVER PLATE QTY: 2

61632 EPOXY QTY:2

61648 LED LIGHT STRIP KIT

61784 PLASTIC SHEET QTY: 2

## REQUIRED TOOLS

- BODY PRY TOOL
- 7MM SOCKET WRENCH
- 13MM SOCKET WRENCH
- 15MM SOCKET WRENCH
- 18MM SOCKET WRENCH
- 3/32 ALLEN WRENCH
- 11/32 SOCKET WRENCH
- FLAT SCREW DRIVER
- 11/16 SOCKET WRENCH
- 5/8 SOCKET WRENCH

## 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 | 50210-HW

IDENTIFICATION NUMBER	COMPONENT DESCRIPTION	QTY
50210-HW	PLASTIC LICENSE PLATE NUT	4
50210-HW	#8 SAE FLAT WASHER, STAINLESS STEEL	12
50210-HW	#8-32 3/4" BUTTON HEAD CAP SCREW, STAINLESS STEEL	6
50210-HW	#8-32 NYLOCK HEX NUT, STAINLESS STEEL	6
50210-HW	7/16" YELLOW ZINC LOCK WASHER, GRADE 8	4
50210-HW	7/16" YELLOW ZINC FLAT WASHER, GRADE 8	8
50210-HW	7/16"-14, YELLOW ZINC HEX NUT, GRADE 8	4
50210-HW	7/16"-14, YELLOW ZINC HEX HEAD BOLT, GRADE 8	4
50210-HW	1 3/8" RUBBER GROMMET	4
50210-HW	3/4" PLASTIC PLUG	4

# DISASSEMBLY

1. From under the truck unplug all wire harnesses including sensor, keyless entry, trailer plug and camera. Figure 1-2

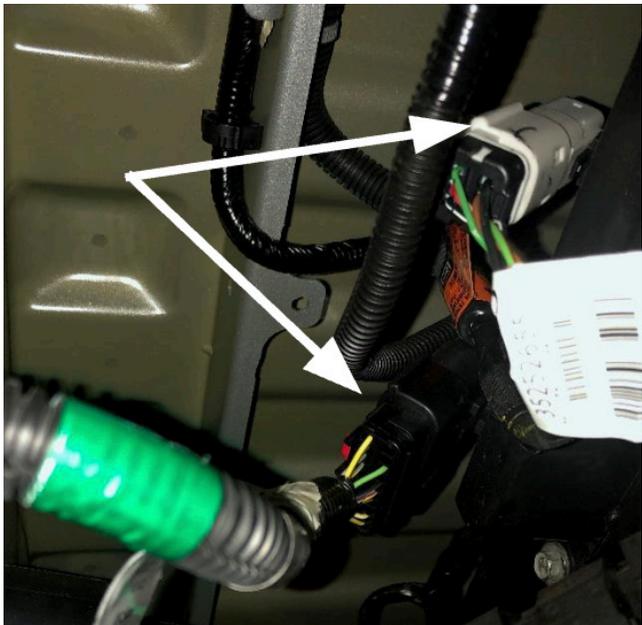


Figure 1



Figure 2

2. Use a 15mm socket wrench to remove the outside support bracket bolt on the driver and passenger sides. Figure 3.



Figure 3

3. Use a 13mm socket wrench to remove the two bolts from behind the license plate. Figure 4.



Figure 4

4. Use an 18mm socket wrench to remove the two (2) nuts from the mounting plate on both the driver and passenger side. With assistance, remove the bumper from the OEM truck. Figure 5.

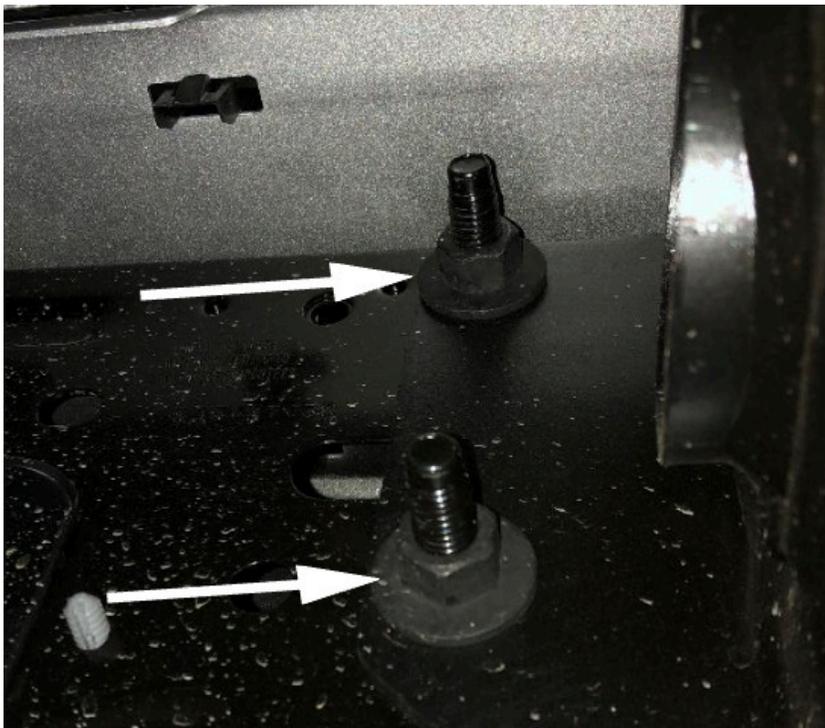


Figure 5

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5. With the bumper, press in the two clips on the trailer plug and push out to remove it from the bumper. Figure 6.

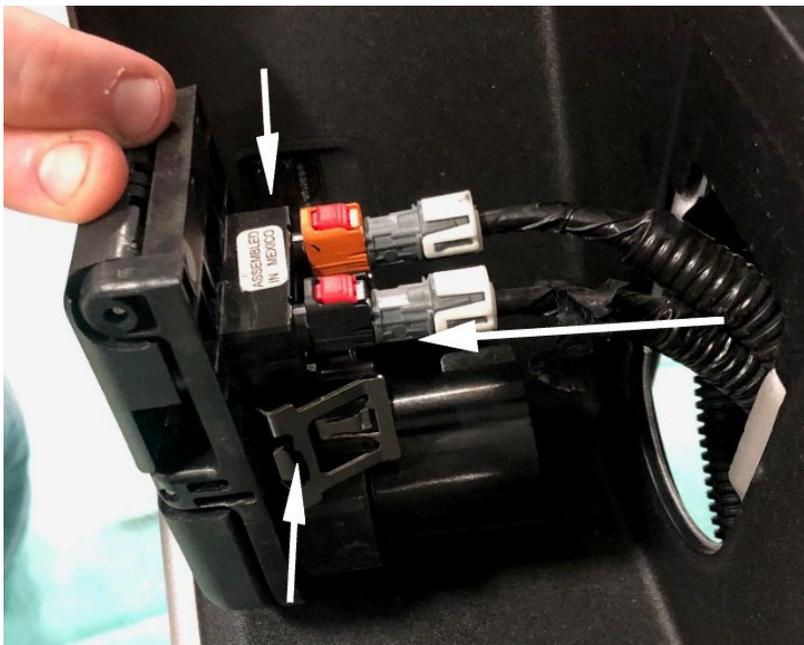


Figure 6

6. Remove the spare tire lock by pressing the clips in and pushing out. Figure 7.



Figure 7

7. If equipped, remove the blind spot sensors from the OEM bumper using a 7mm socket wrench to remove the two bolts. Figure 8.



Figure 8

8. Use a 7mm socket wrench to remove the sensor from its plastic casing. Figure 9.

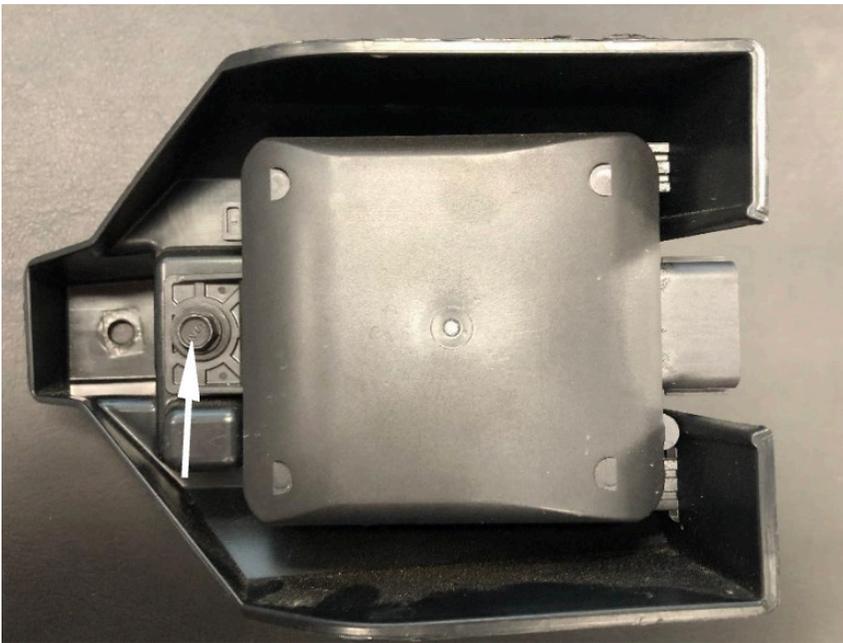


Figure 9

9. Use a 7mm socket wrench to remove the two license plate lights from the OEM bumper. To unplug the lights, turn the connector counterclockwise. Figure 10.



Figure 10

10. To remove the four (4) sensors: Carefully spread the housing clips and push the sensor out of the housing (Figure 11). With the sensor removed, press the four (4) tabs in and push the housing out of the bumper. Figure 12. \*\*\*NOTE: Label each sensor housing to insure it is placed in the correct place when installed into the Fab Fours bumper.\*\*\*

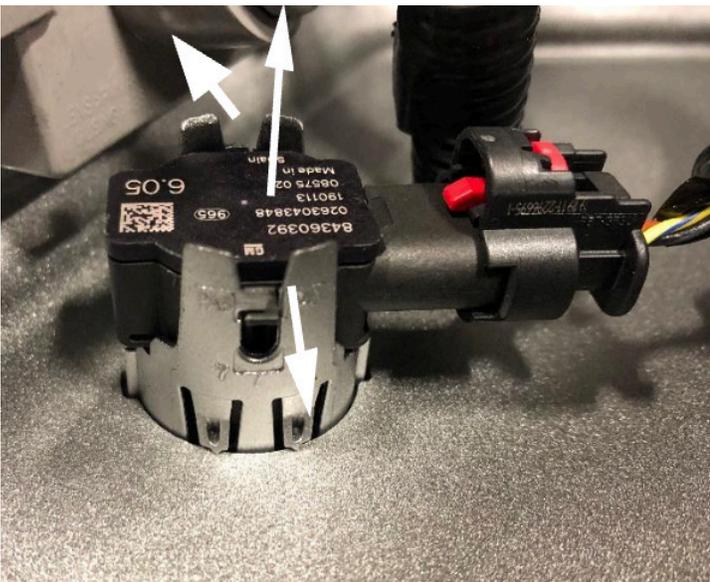


Figure 11

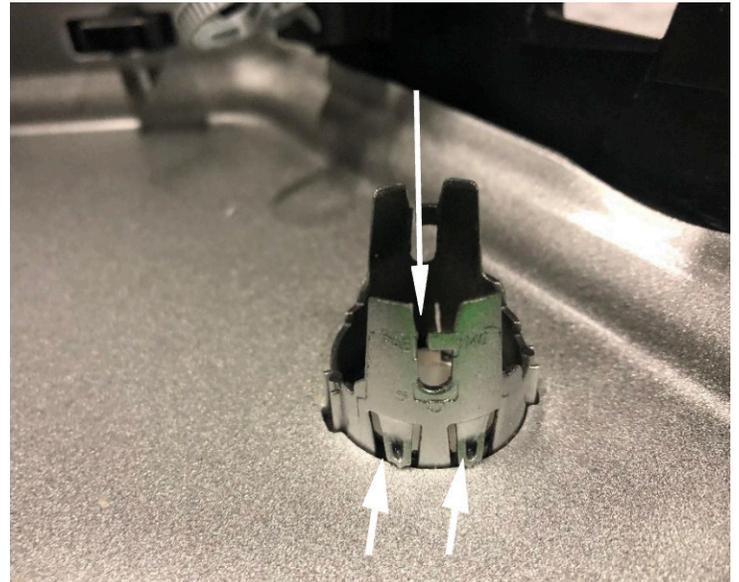


Figure 12

11. Remove the keyless entry sensor from behind the license plate by pressing in the three (3) clips and pushing it out. Figure 13.

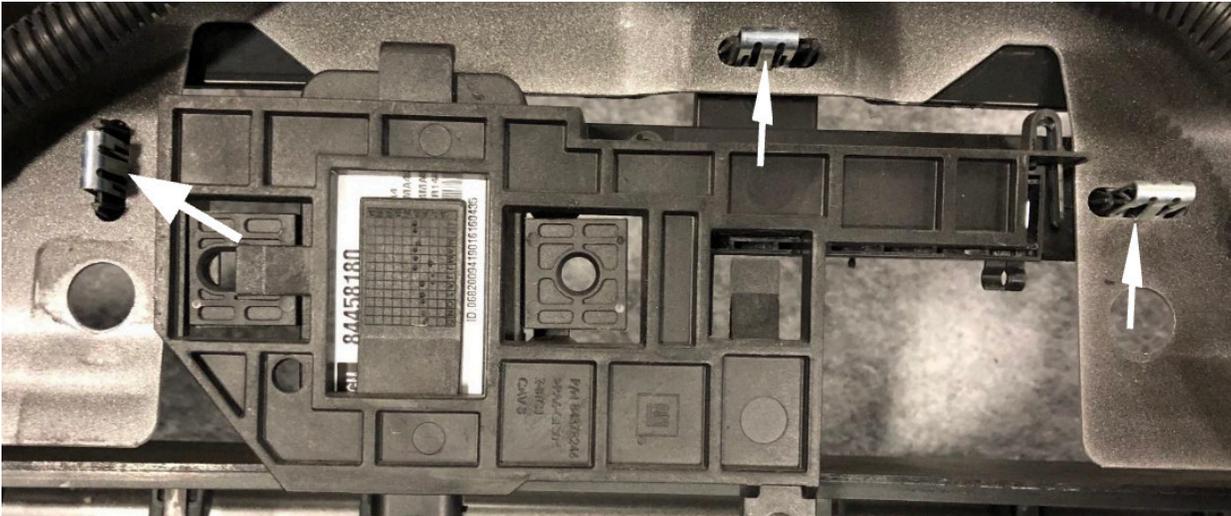


Figure 13

12. Remove the sensor harness from the bumper by unclipping it and set it aside for later use.

## INSTALLATION

13. Install the keyless entry sensor to the license plate bracket using zip ties. The sensors can now be plugged in. Figure 14. NOTE: If not equipped with Blind side sensors use the cover plates (22074) to cover the sensor holes.



Figure 14



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16. Install 61784 plastic sheets cut in step 14 using #8 cap head bolts, washers and nylon insert nuts.
17. Use a 3/32 allen wrench and 11/32 socket wrench to install the license plate lights with a #8-32 bolt, flat washers and nylock nut (50210-HW). Figure 17.



Figure 17

18. Install the spare tire access key by pushing it through the bumper (23126) and engaging the clips to hold it in place. Figure 18.



Figure 18

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19. Install the trailer plug by pushing it through the bumper (23126) and use a flat screwdriver to engage the clips on either side. Figure 19.

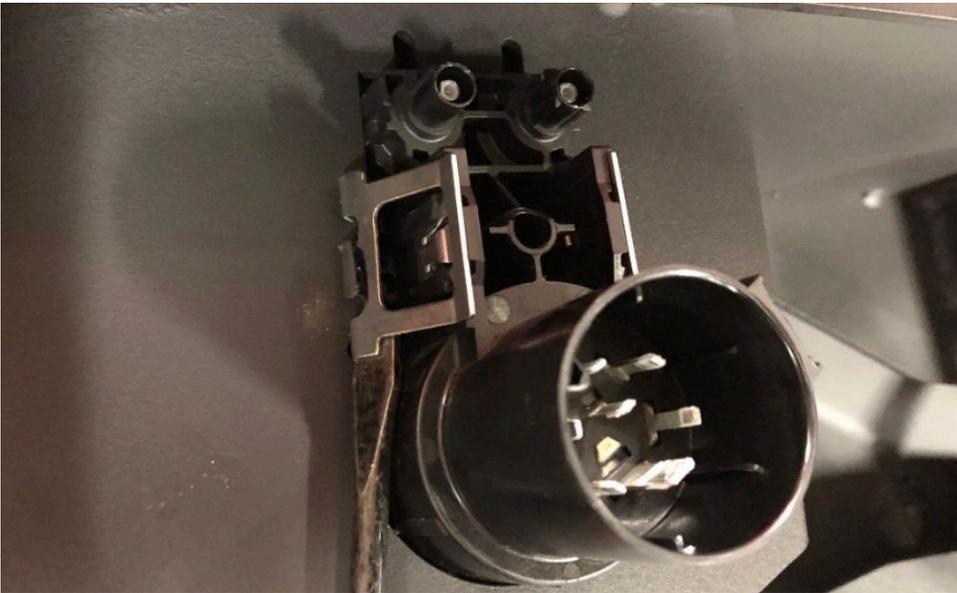


Figure 19

**NOTE:** Optional steps 18-20 for alternative mounting method for securing the trailer receptacle plug to the bumper. Hardware is not included for this mounting method.

20. Insert the trailer plug receptacle to the bumper (23126) and mark the bolt locations for drilling. (Figure 20)

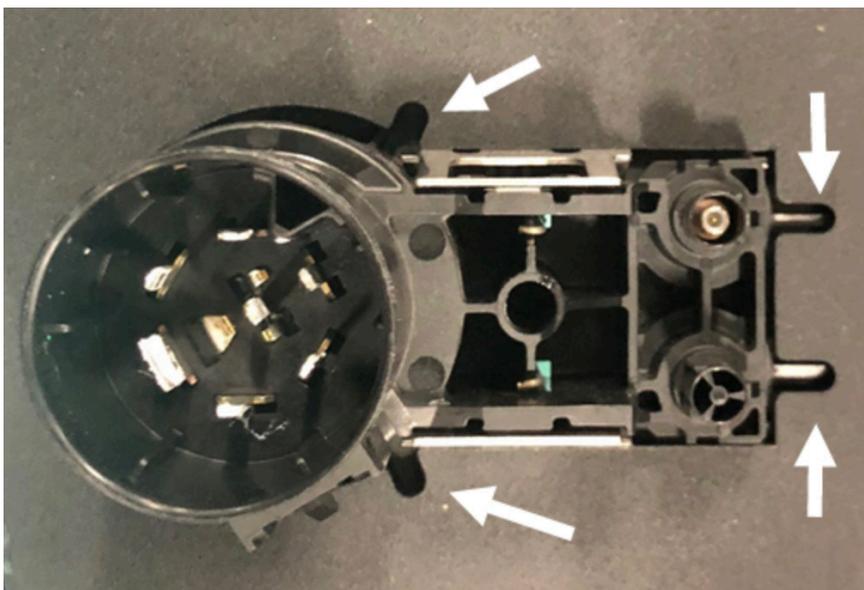


Figure 20

21. Remove the trailer plug receptacle. Using a drill with a 7/32" drill bit, drill out the trailer plug receptacle.

22. Using a 7mm socket wrench and the 3/32" Allen key install the trailer plug into the bumper (23126) using four (4) #8-32 x 1.0" long stainless-steel button head cap screws, flat washers, and hex nuts. (hardware not provided)

23. Install the sensor housings into the same locations as OEM and use epoxy (61632) to lock the housing in place. Once the epoxy is dry push the sensors into the housing. Feed the harness behind the mounting plates and plug the license plate lights and blind side sensors in. Figure 21.



Figure 21

24. If your truck is not equipped with sensors, use the four (4) rubber grommets and plugs to fill the sensor holes (50210-HW). Figure 22.



Figure 22

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25. With assistance, hold the bumper (23126) up to the mounts and use a 11/16 and 5/8 socket wrench to install the bumper with the 7/16" bolts, flat and lock washers with nuts (50210-HW). Figure 23.



Figure 23

26. Plug in all the sensor harnesses and install the four plastic license plate nuts by pushing them into the bumper (50210-HW). Figure 24.



Figure 24

# CONTACT INFORMATION

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**FABFOURS.COM**



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

**- GREG HIGGS**

