



INSTALLATION MANUAL
GRUMPER
PRODUCT NUMBER: GR5900
APPLICATION: 2023 FORD F250 & F350



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

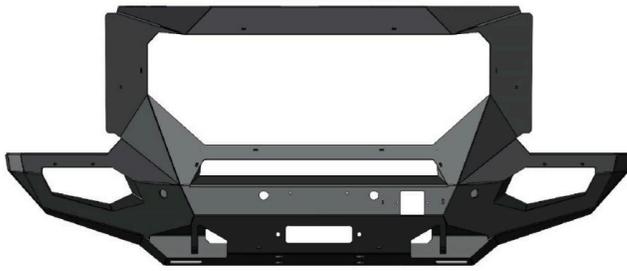
FOUNDER, FAB FOURS

GETTING STARTED

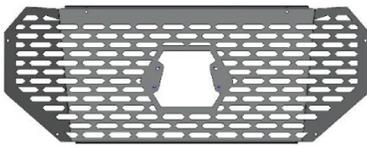
Before you begin the installation process of your new Fab Fours product, we suggest laying out all materials and parts on a pad or protective surface.

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



23104



23105



23106



23107



23108



61633



23109



61784



21871
(QTY:2)



20296
(QTY:4)

61632 - EPOXY (QTY:2)

REQUIRED TOOLS

- PANEL PRY TOOL
- TAPE MEASURE
- MASKING TAPE
- SILVER MARKER
- TOOL FOR CUTTING THICK PLASTIC
- DRILL
- 1/4" DRILL BIT
- E6 TORX SOCKET
- T25 TORX BIT
- 1/8" ALLEN WRENCH
- 8MM SOCKET WRENCH
- 11MM SOCKET WRENCH
- 15MM SOCKET WRENCH
- 18MM SOCKET WRENCH
- 7/16" SOCKET WRENCH
- 7/16" COMBINATION WRENCH
- 1/2" SOCKET WRENCH
- 1/2" COMBINATION WRENCH
- 3/4" COMBINATION WRENCH
- 3/4" DEEP 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 | 50439-HW

IDENTIFICATION NUMBER	COMPONENT DESCRIPTION	QTY
50439-HW	1/4"-20 X 1", HEX HEAD CAP SCREW, ZINC, GRADE 8	2
50439-HW	1/4"-20, HEX NUT, ZINC, GRADE 8	2
50439-HW	1/4"-SAE, FLAT WASHER, ZINC, GRADE 8	4
50439-HW	1/4"-SAE, LOCK WASHER, ZINC, GRADE 8	2
50439-HW	1/2"-13 X 1.5", HEX HEAD CAP SCREW, YELLOW-ZINC, GRADE 8	12
50439-HW	1/2"-SAE, LOCK WASHER, YELLOW-ZINC, GRADE 8	20
50439-HW	1/2"-SAE, FLAT WASHER, YELLOW-ZINC, GRADE 8	24
50439-HW	1/2"-13, HEX NUT, YELLOW-ZINC, GRADE 8	20
50439-HW	5/16"-18 X 3/4", HEX HEAD CAP SCREW, YELLOW-ZINC, GRADE 8	11
50439-HW	5/16"-18, HEX NUT ZINC, GRADE 8	6
50439-HW	5/16"-SAE, LOCK WASHER ZINC, GRADE 8	11
50439-HW	5/16"-SAE, FLAT WASHER, ZINC, GRADE 8	17
50439-HW	10-24 X 3/4", SOCKET HEAD CAP SCREW, BLACK SS	2
50439-HW	10-24, CLIP ON BARREL NUT	2
50439-HW	1 3/8", GROMMET, PLASTIC, MM9307K81	4
50439-HW	PLASTIC PLUG	4
50439-HW	1/2" BOLT RETAINER	4

INSTALLATION

1. Remove the plastic tow hook covers by pulling on them to release the clips. Figure 1



Figure 1

2. Disconnect the bumper electrical harness connected to the inside of the driver side frame rail. Figure 2



Figure 2

5. Using an E6 torx socket remove the three (3) studs that attach the ACC bracket to the vehicle. Figure 5

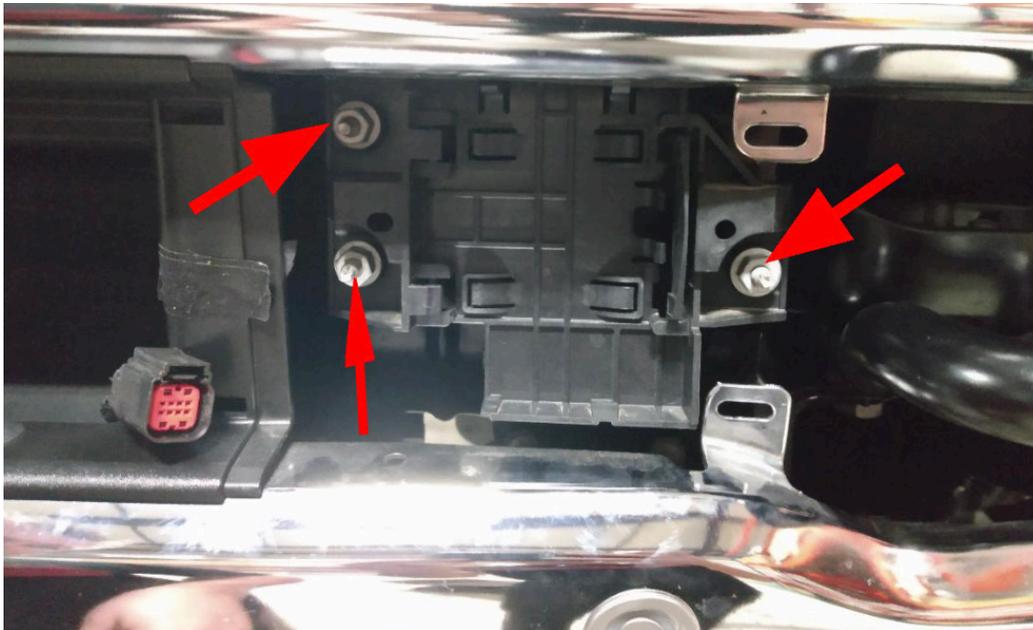


Figure 5

6. Using an 18mm socket wrench, remove the eight (8) bolts that attach the bumper to the tow hook brackets. Figure 6

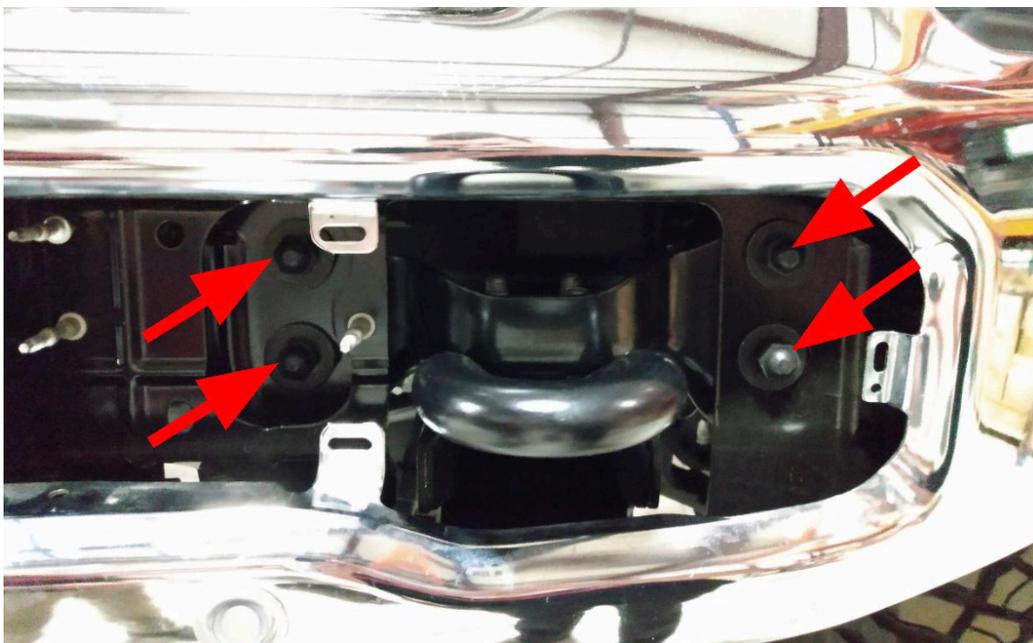


Figure 6

7. Using a 15mm socket wrench, remove the two (2) bolts per side that attach the bumper reinforcement brackets to the frame. Figure 7

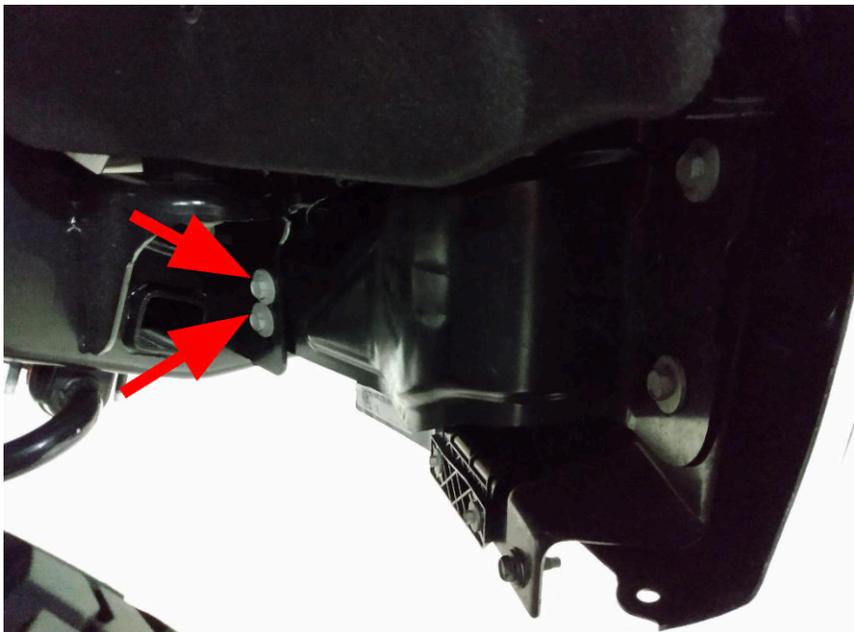


Figure 7

8. Using a body panel pry tool, remove the two (2) push pins attaching the shroud to the grille. The bumper can now be removed from the vehicle. Figure 8



Figure 8

-
9. Using an 18mm socket wrench, remove the eight (8) bolts attaching the tow hooks to the frame and remove the tow hooks. Figure 9

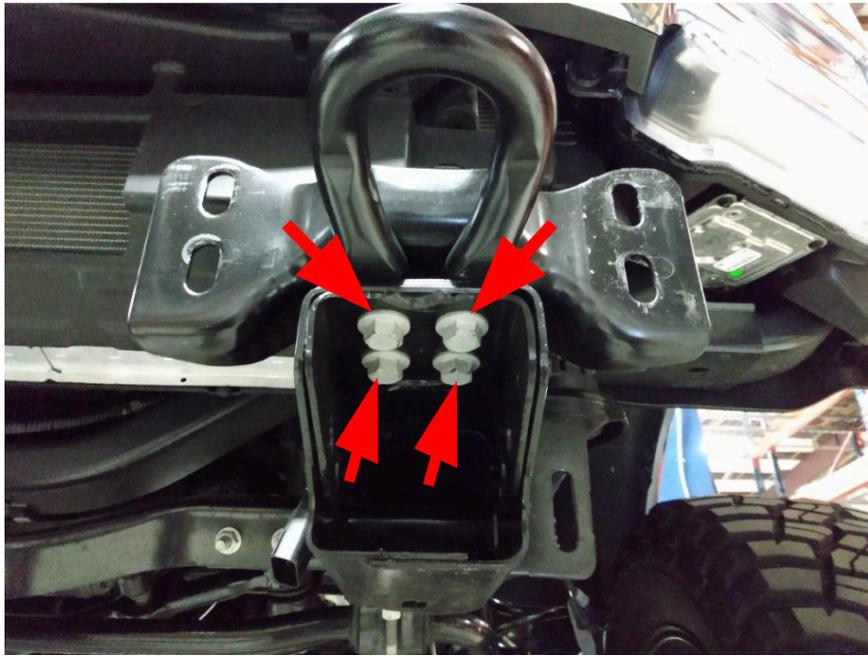


Figure 9

10. Using an 18mm socket wrench, remove the eight (8) nuts attaching the underrun guards to the bottom of each frame rail. Figure 10

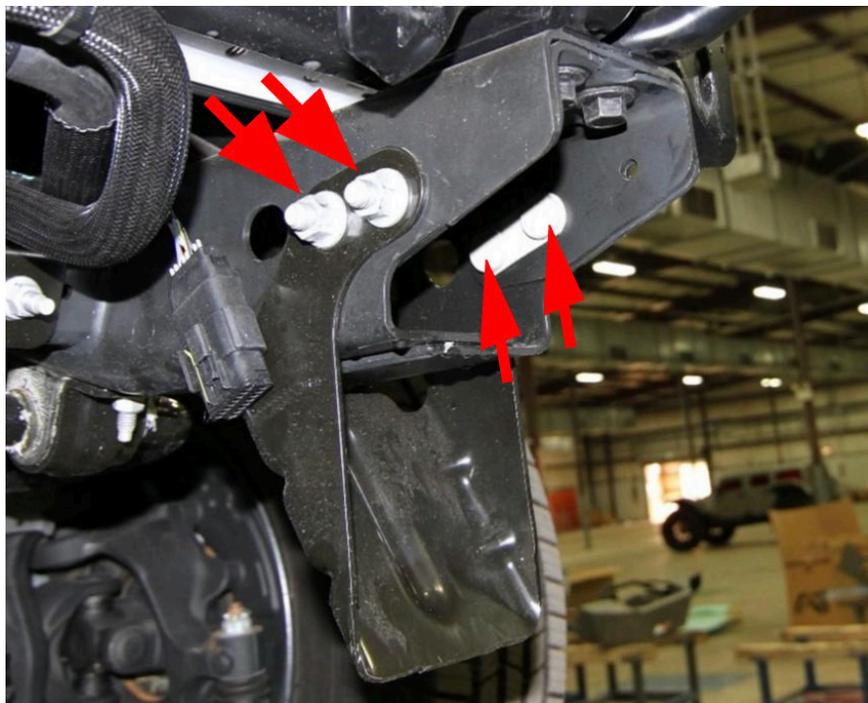


Figure 10

11. Using an 8mm socket wrench, remove the four (4) screws in each fog light bracket to remove them from the bumper. Figure 11

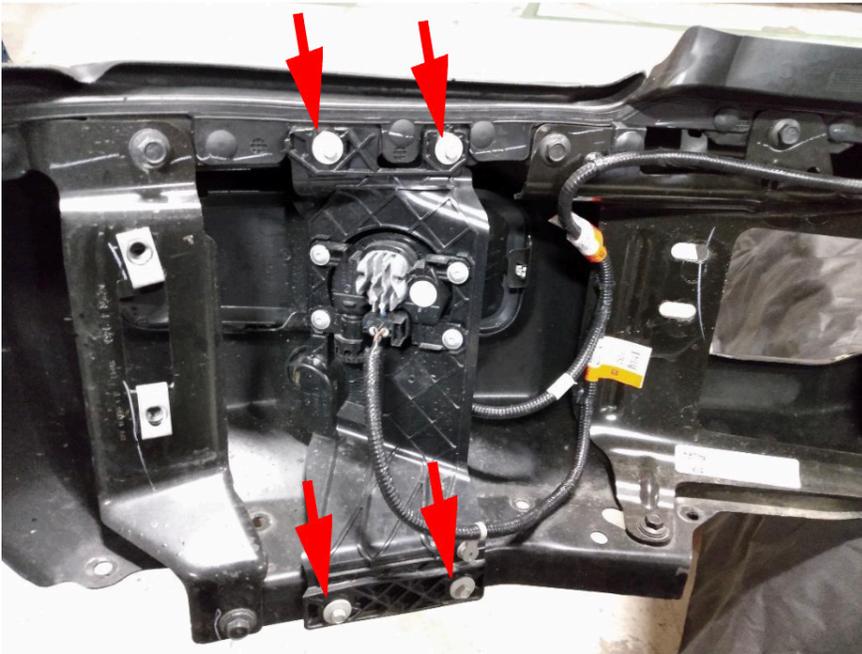


Figure 11

12. Using a panel pry tool, remove the push pin clip. Figure 12



Figure 12

13. Use a panel pry tool to remove the (12) push pins attaching the under-hood cowl to the vehicle to remove it. Figure 13



Figure 13

14. Using a panel pry tool remove the two (2) plastic covers over the lower grille bolts. Figure 14



Figure 14

15. Using a 10mm socket wrench, remove the two (2) lower grille screws. Figure 15



Figure 15

16. Using a 10mm socket wrench, remove the four (4) upper grille screws. Then, using a pry tool remove the two (2) push pins and remove the grille. Figure 16



Figure 16

17. If applicable, disconnect the camera wiring and washer hose from the back of the grille. Figure 17-18

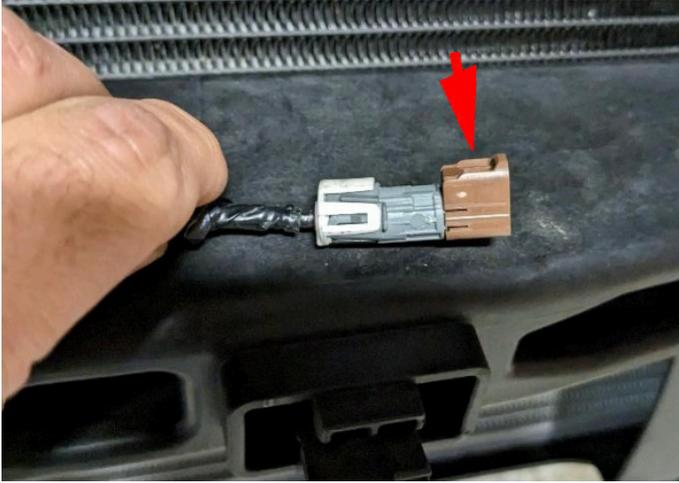


Figure 17

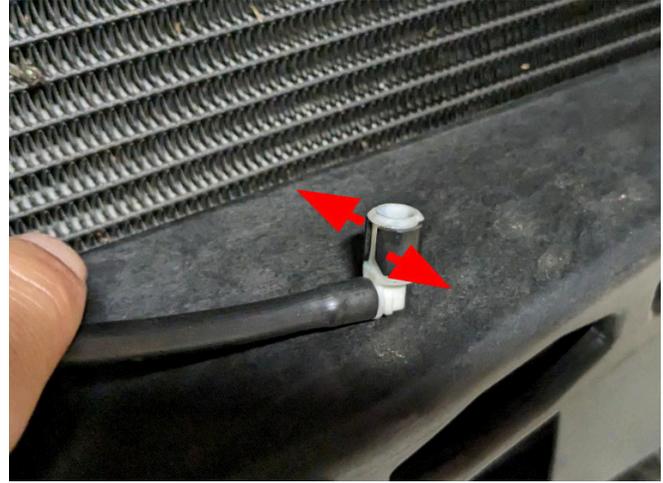


Figure 18

**** Complete the following steps for vehicles with halogen headlights. ****

18. Using masking tape, mark the grille to be cut as shown. Figure 19-20



Figure 19

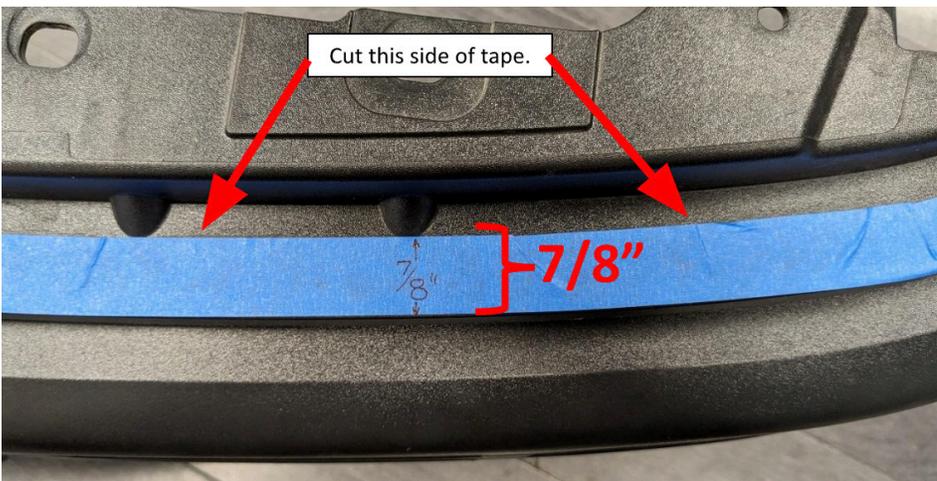


Figure 20

19. Using masking tape, mark the grille to be cut as shown. Figure 21



Figure 21

20. Using a cutting tool cut the grille where marked. You should be left with three (3) separate pieces of the grille once cut, one (1) under the hood and one (2) for each headlight. Figure 22



Figure 22

**** Complete the following steps for vehicles with LED headlights. ****

21. Using masking tape, mark the grille to be cut as shown. Apply tape perpendicularly to the face of the grille. Figure 23



Figure 23

22. Using masking tape, mark the grille to be cut as shown. Figure 24

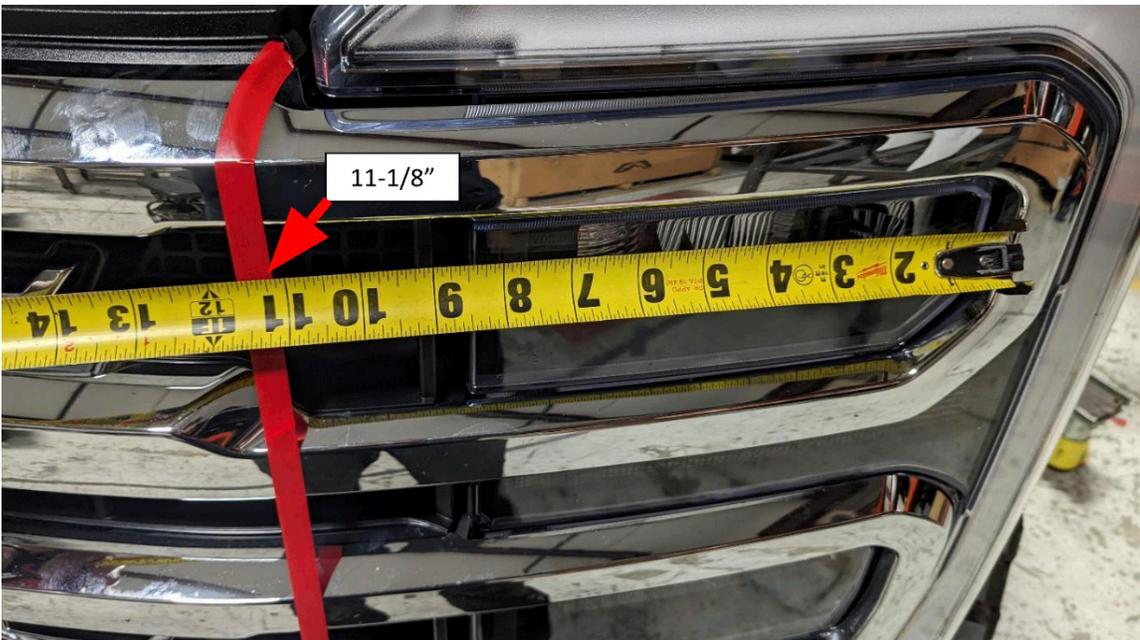


Figure 24

23. Using masking tape, mark the grille to be cut as shown. Figure 25



Figure 25

24. Using a cutting tool, cut the grille into three (3) separate pieces, one (1) for under the hood and one (1) for each headlight. Figure 26



Figure 26

25. Reinstall the cut grille sections into their respective locations and using the hardware previously removed.

26. Loosely install the driver side frame bracket (Part#: 23107) using six (6) of the provided 1/2" bolts, flat washers, lock washers, and nuts. Repeat this process for the passenger side frame bracket (Part#: 23108).
Figure 27

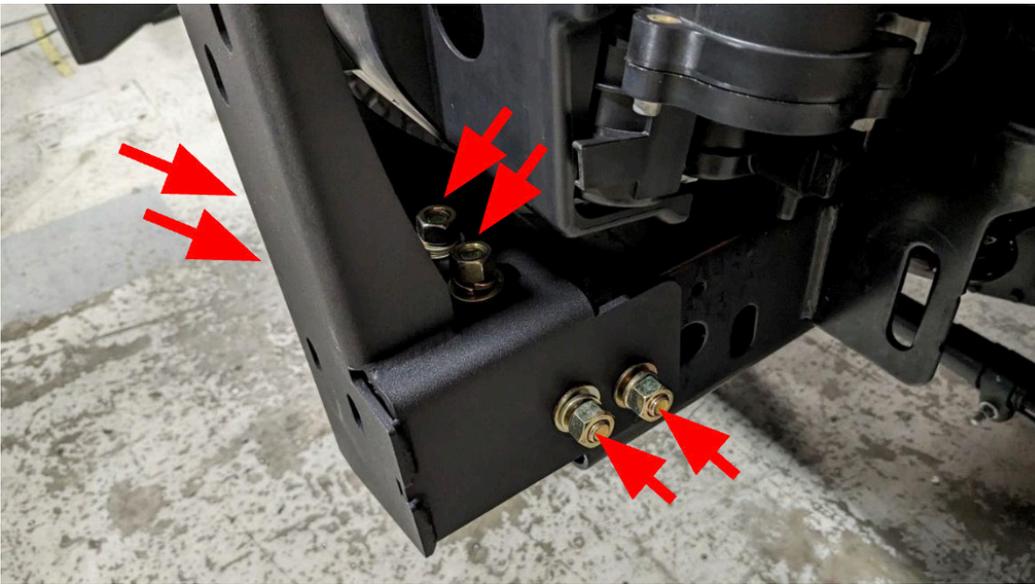


Figure 27

27. Using an E6 socket and 11mm combination wrench, remove the three (3) nuts from the ACC sensor bracket. Figure 28



Figure 28

28. Using a panel pry tool, remove the ACC bracket mounting studs from their plastic sockets. Figure 29

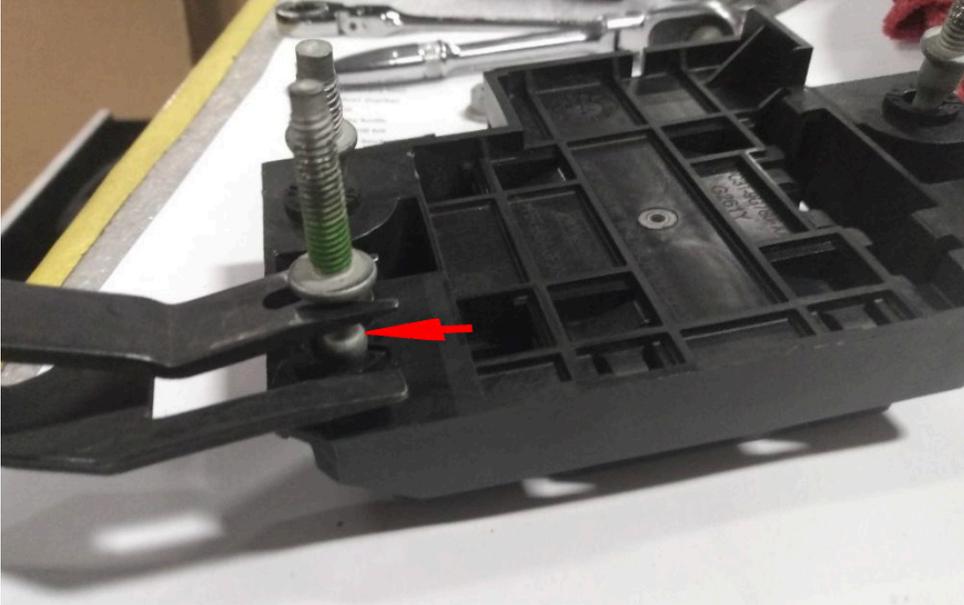


Figure 29

29. Using a panel pry tool and flat head screwdriver, remove the ACC bracket mounting stud sockets. Figure 30

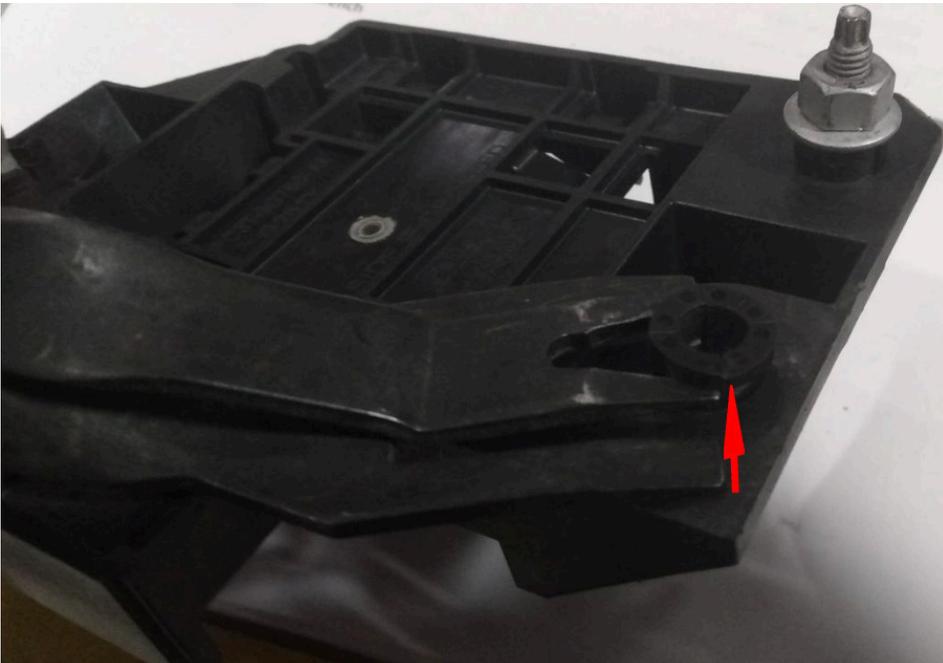


Figure 30

30. Reinstall the mounting studs, sockets, and locking nuts on the opposite side of the ACC mounting bracket by reversing the steps used to remove them. Figure 31



Figure 31

31. Using a marker and utility knife, cut the provided black plastic sheet down to a 3.5" x 4.5" size square. Figure 32



Figure 32

32. Using a marker and 1/4" drill bit, use the bumper to mark the black plastic sheet and drill the mounting hole locations. Figure 33



Figure 33

33. Using an 1/8" allen wrench, two (2) provided barrel nuts and #10 screws, install the black plastic sheet into the inside of the bumper. Figure 34

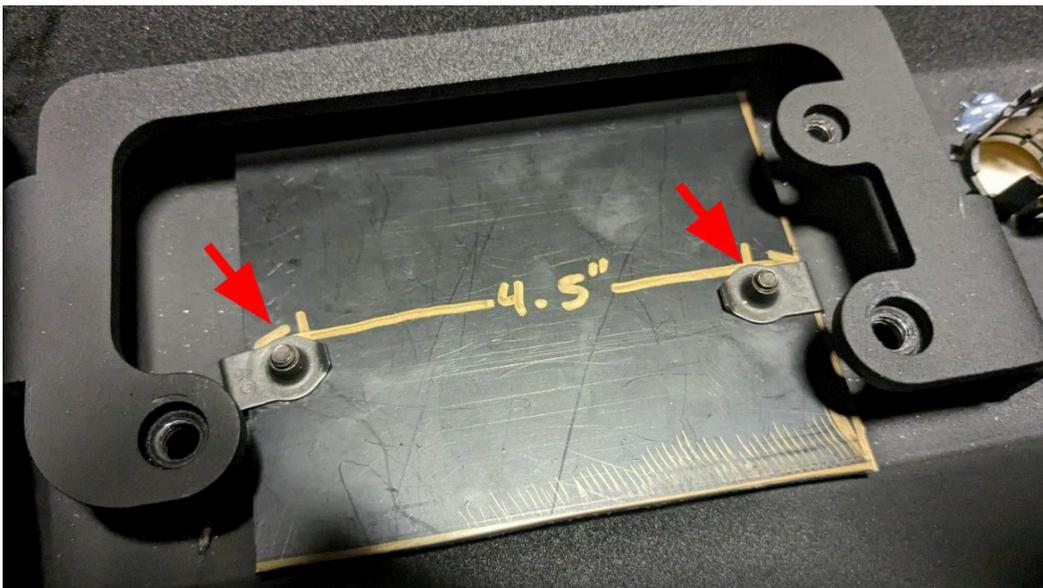


Figure 34

34. Using an E6 torx socket, install the ACC sensor to the bracket welding into the grumper shell. Using the top right screw adjust the sensor face to parallel with the front face of the grumper shell. Figure 35



Figure 35

35. Using a T25 torx bit, remove the camera hold down bracket from the factory grille in order to remove the camera from the grille. Figure 36



Figure 36

36. Apply the provided adhesive backed foam to the back side of the camera and trim the excess. Figure 37



Figure 37

37. Install the camera into the grille badge (Part#: 23106) using the provided hold down plate (Part#: 23109) and one (1) 5/16" bolt, lock and flat washers. After squaring camera up with hold down plate, tighten the bolt with a 1/2" socket wrench. Figure 38

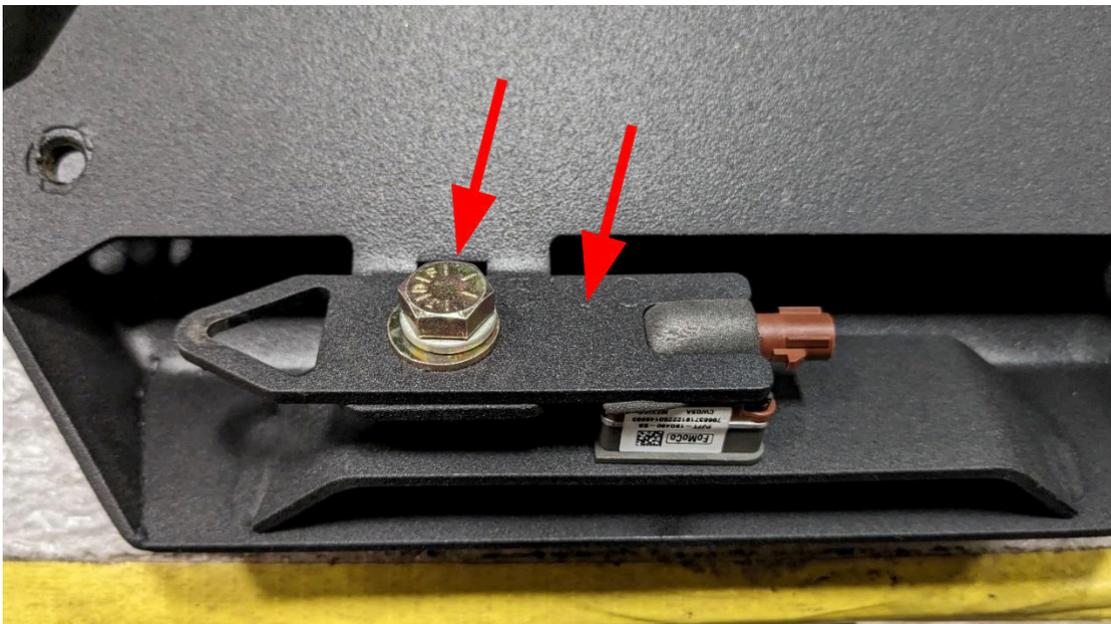


Figure 38

38. Install badge to the grille, using four (4) of the provided 5/16" bolts, lock and flat washers. Tighten hardware with a 1/2" socket wrench. Figure 39

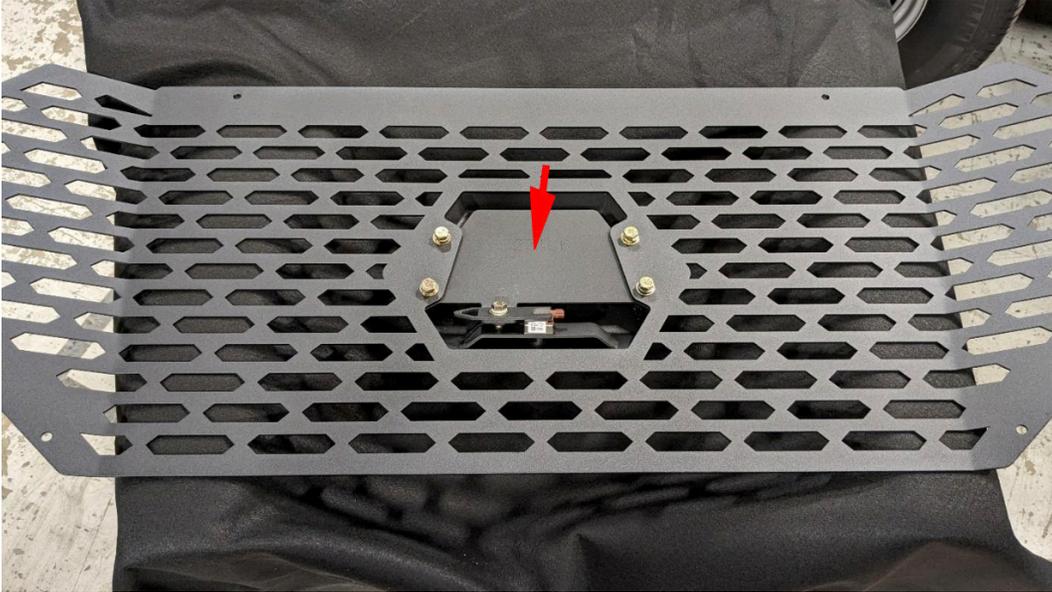


Figure 39

39. Install the grille to the Grumper shell using six (6) of the provided 5/16" bolts, lock and flat washers. Tighten the hardware with 1/2" socket and combination wrenches. Figure 40



Figure 40

40. Install the four (4) provided 1/2" bolt strips into the winch tray mounts using the four (4) provided bolt retainers. Figure 41

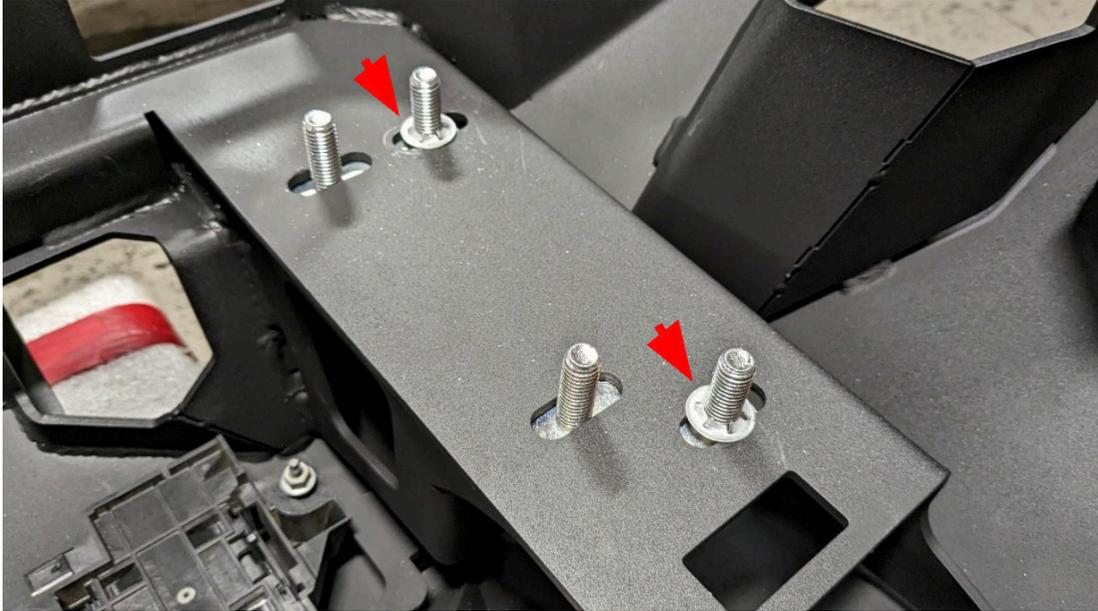


Figure 41

41. Reinstall the parking sensor housings into their respective holes in the Grumper shell in the same orientation and rotation from which they were removed from the factory bumper. Use the provided epoxy to secure the sensor housing to the Grumper shell. Figure 42



Figure 42

42. Reinstall the parking sensors and wiring harness into their respective housings. Reconnect the ACC sensor to the wiring harness.

43. If installing lighting in the wings, do so now using the light manufactures hardware.

44. Install the two (2) provided L-brackets (Part#: 21871) with the two (2) 1/4" bolts, flat washer, lock washer and nuts. Install the 30" lightbar to these brackets using the light manufactures hardware. Tighten the 1/4" hardware with a 7/16" socket and combination wrench. Figure 43



Figure 43

45. The Grumper shell can now be held up to the vehicle and hung on the tabs at the top of the frame brackets to ease installation. Protect the surrounding areas of the vehicle with masking tape to prevent damage. Figure 44

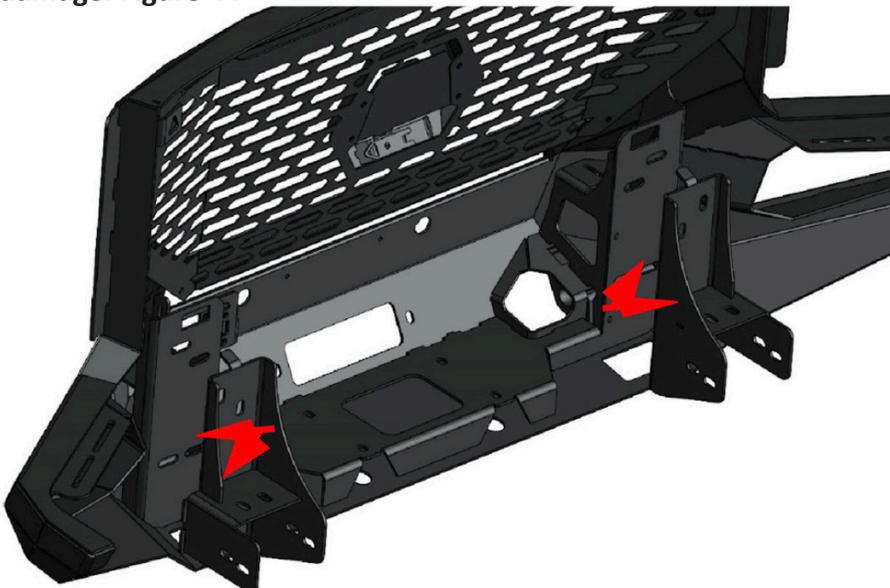


Figure 44

46. Reconnect the camera wiring harness. The camera washer hose can be secured up out of the way, it does not get reinstalled. Figure 45

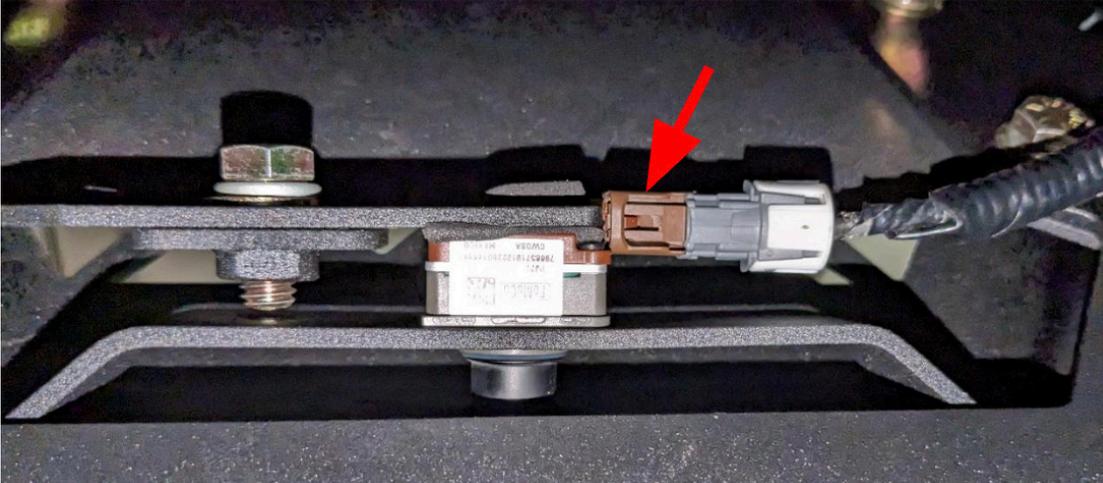


Figure 45

47. Install the eight (8) nuts, lock washer and flat washers onto the previously installed bolt strips. Figure 46-47

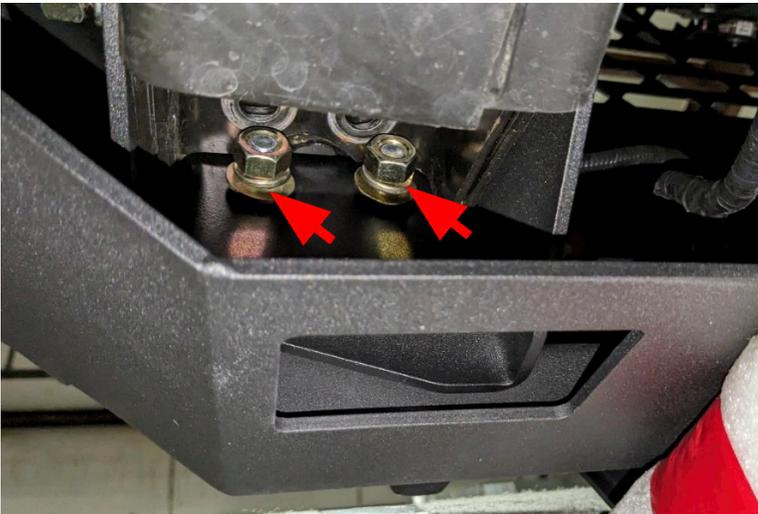


Figure 46

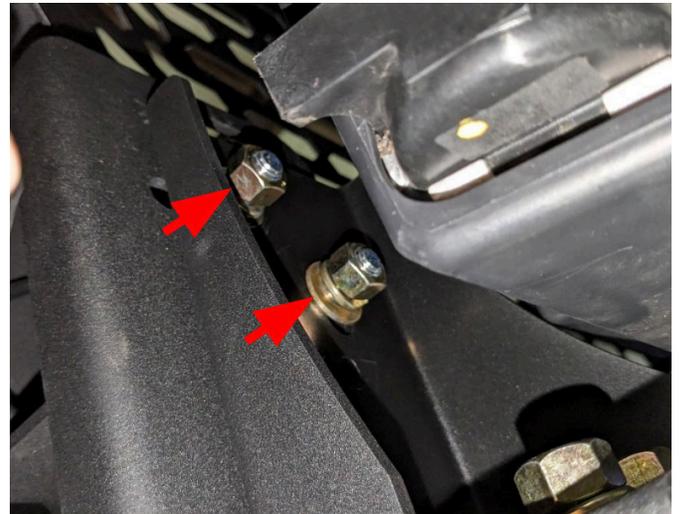


Figure 47

48. Align the Grumper shell to the vehicle. Using a 3/4" socket or combination wrench, tighten all the 1/2" hardware previously installed.

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

