



**INSTALLATION MANUAL**  
**BLACK STEEL / BLACK STEEL ELITE FRONT**  
**PRODUCT NUMBER: S/Q626X**  
**APPLICATION: 2024 GMC 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

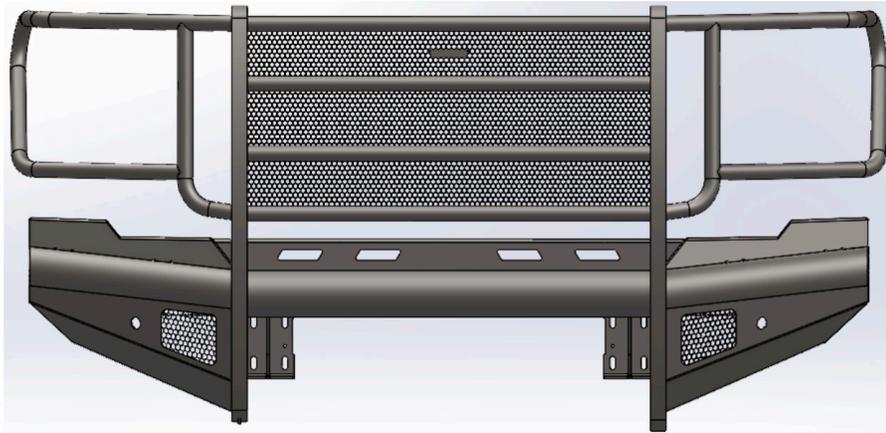
# GETTING STARTED

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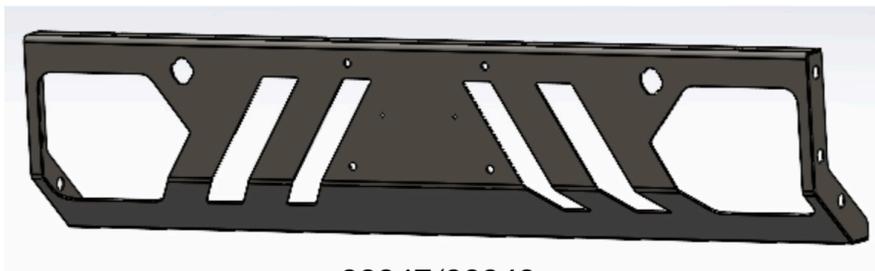
Before you begin the installation process of your new Fab Fours product, we suggest laying out all materials and parts on a pad or protective surface.

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.

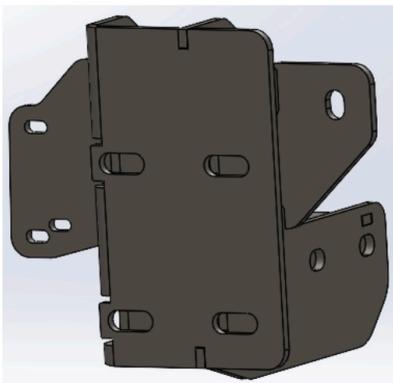
# PROVIDED MATERIALS



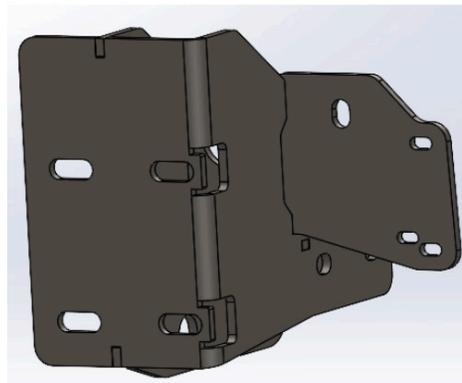
23180/23181



23247/23248



23187



23188



61366 QTY: 2

## REQUIRED TOOLS

- 7MM SOCKET WRENCH
- 13MM SOCKET WRENCH
- 15MM SOCKET WRENCH
- 18MM SOCKET WRENCH
- T10 STAR HEAD SOCKET WRENCH
- 7/16" SOCKET WRENCH
- PLYERS
- BODY PRY TOOL

## ASSISTANCE

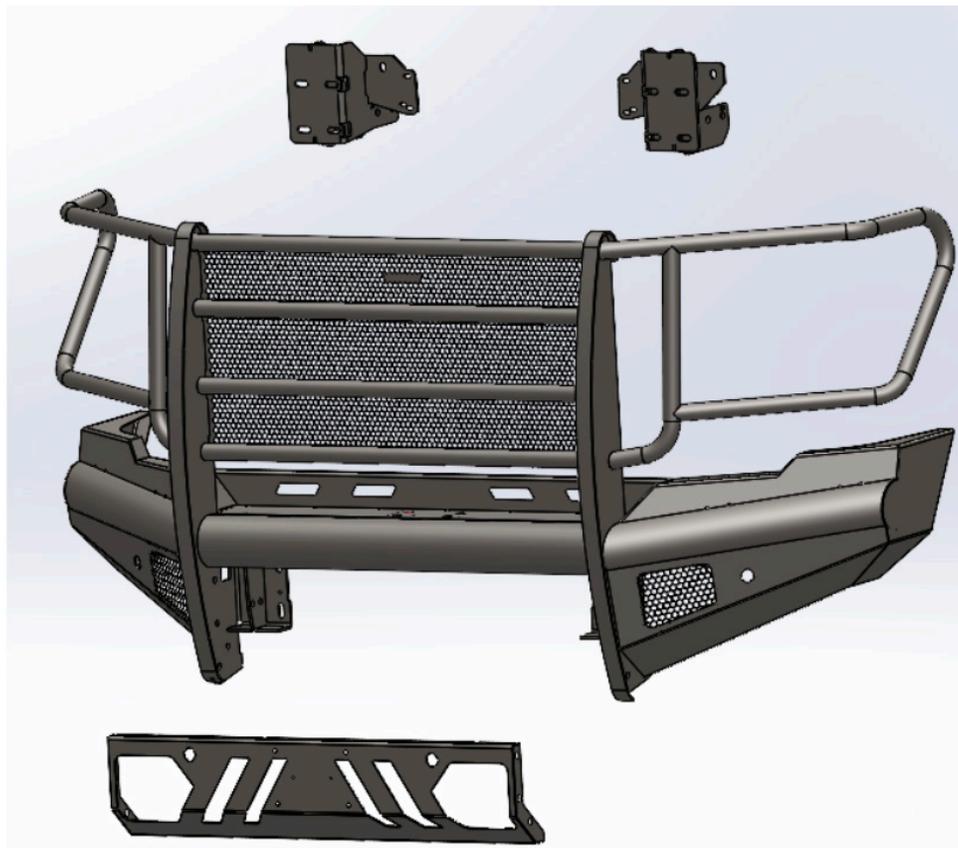
We recommend two people perform the installation as items are heavy and may need to be held in place while installing.

## 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 | 50459-HW + 20260-HW

IDENTIFICATION NUMBER	COMPONENT DESCRIPTION	QTY
50459-HW	1/2-13 X 4 1/2 HEX CAP SCREW GRADE 8 Z&Y	4
50459-HW	1/2"-13 X 2.25", HHCS , ZINC, GR8	8
50459-HW	1/2 SAE FLAT WASHER GRADE 8 Z&Y	24
50459-HW	1/2"-SAE X , LOCK WASHER , ZINC, GR8	12
50459-HW	1/2"-13, X , HEX NUT , ZINC, GR8	12
50459-HW	1 3/8", GROMMET, RUBBER, MM9307K81	4
50459-HW	PLASTIC PLUG, MM9283K13	4
20260-HW	1/2"-13 X 1", YELLOW ZINC HEX CAP BOLT, GRADE 8	6
20260-HW	1/2"-13 X 2.25", YELLOW ZINC HEX CAP BOLT, GRADE 8	4
20260-HW	1/2", YELLOW ZINC FLAT WASHER, GRADE 8	20
20260-HW	1/2", YELLOW ZINC LOCK WASHER, GRADE 8	16
20260-HW	1/2"-13, YELLOW ZINC HEX NUT, GRADE 8	10



# INSTALLATION

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1. Using a T10 bit remove the two (2) screws attaching the hood latch handle. Figure 1.

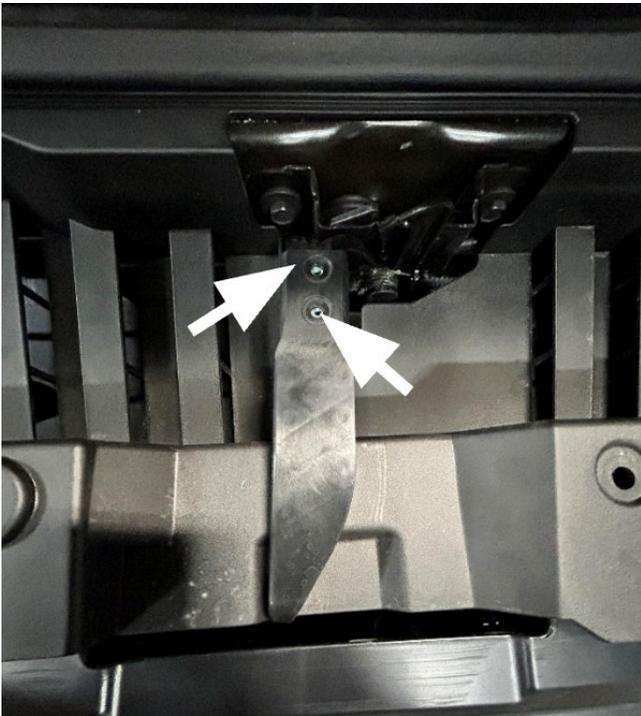


Figure 1

2. Using a body panel pry tool, remove the push pins from the under hood cowl to remove the cowl from the vehicle. Figure 2.

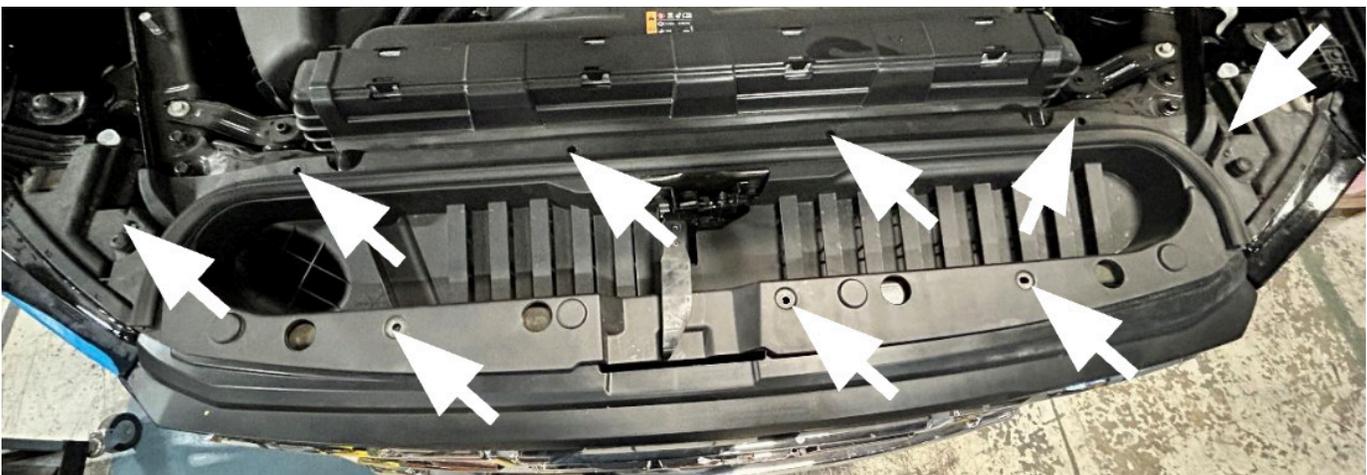


Figure 2

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



Figure 3

4. Using a panel pry tool, remove the front 1/4 of the front fender flare by releasing the push pins. Figure 4-5.



Figure 4



Figure 5

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

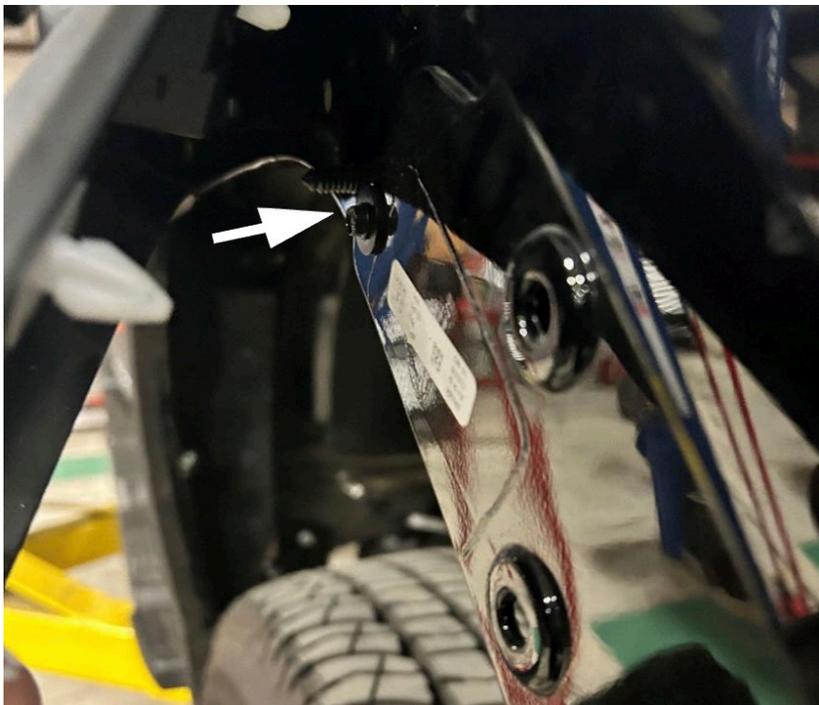


Figure 6

6. Remove the valances on either side of the grille by pulling outward to release the plastic clips. Figure 7.



Figure 7

7. If equipped, disconnect the grille camera washer hose. Figure 8.



Figure 8

8. If equipped, disconnect the grille camera wiring harness. Figure 9.



Figure 9

- 
9. Remove the grille by pulling outward starting on one side and working across to release the clips. Figure 10.



Figure 10

10. Using a 15mm socket wrench with a long extension, remove the two (2) screws behind the bumper at the bottom of the bumper mounting brackets. Figure 11.

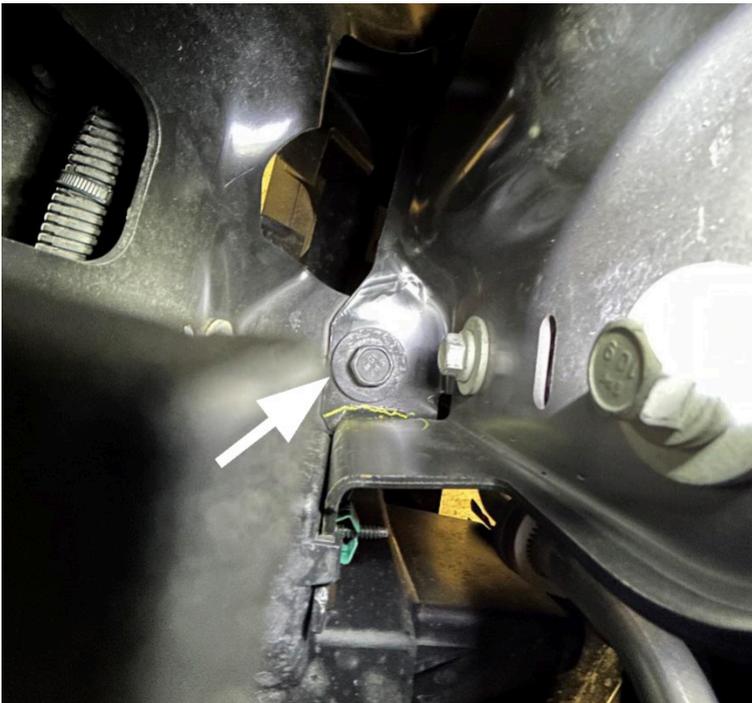


Figure 11

11. Using a 15mm socket wrench, remove the two (2) screws at the top of the bumper mounting brackets. Figure 12.



Figure 12

12. Using a 15mm socket wrench, remove the two (2) screws from the bumper gussets. Figure 13.

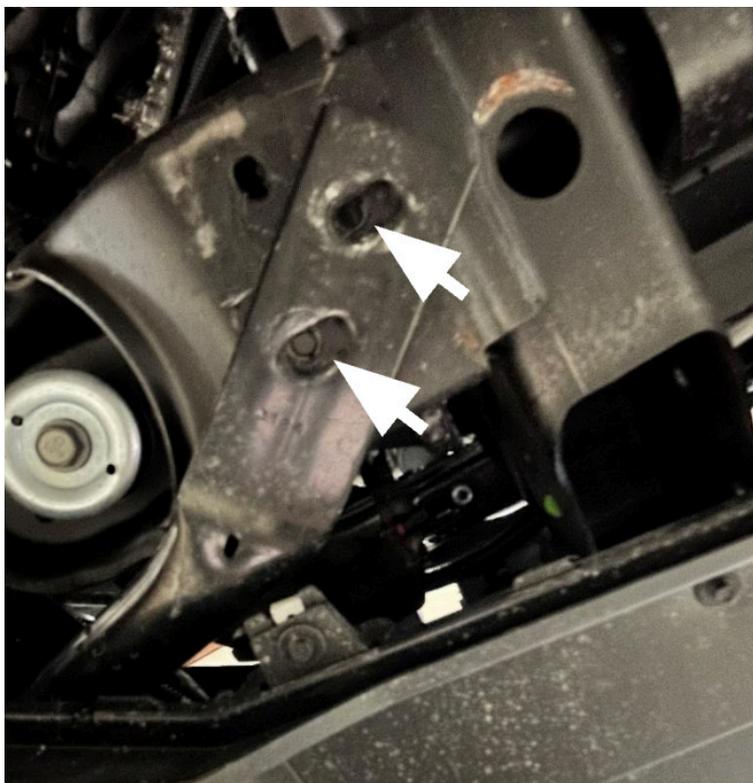


Figure 13

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13. If applicable, disconnect the block heater wiring harness on the driver's side of the vehicle. Figure 14.

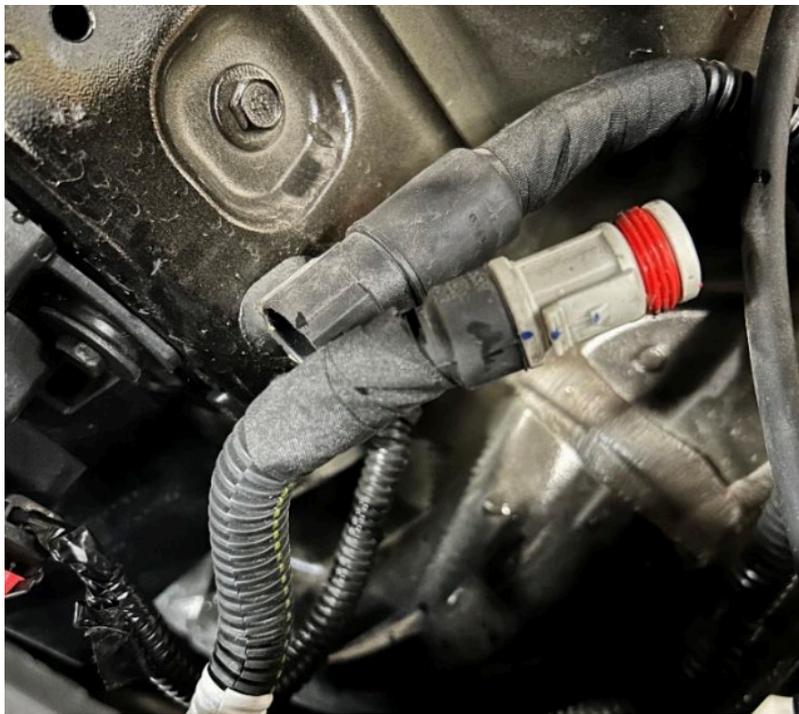


Figure 14

14. Disconnect the bumper electrical wiring harness on the passenger side of the vehicle. Figure 15.

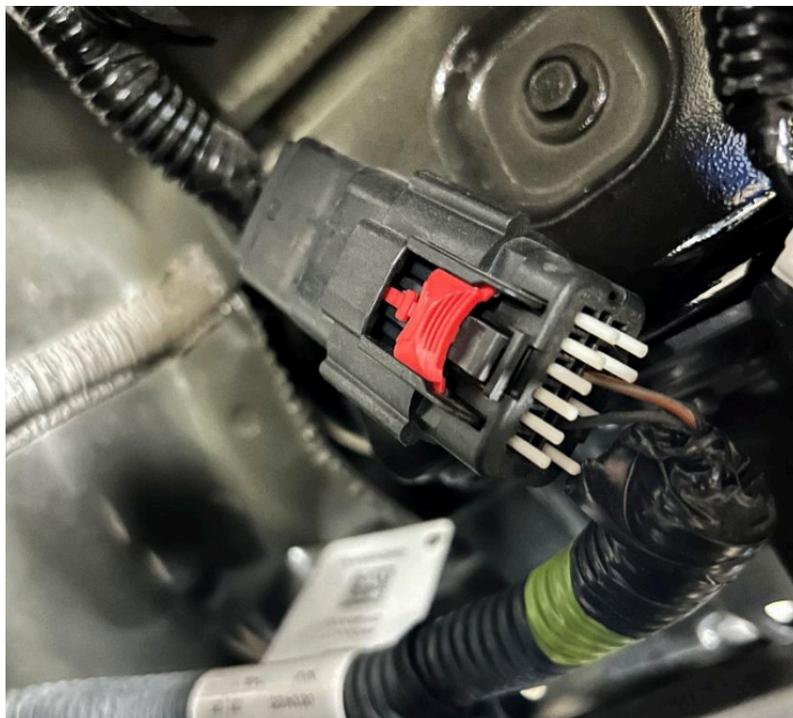


Figure 15

15. Using a 15mm socket wrench, remove the four (4) screws per bumper bracket. Figure 16.

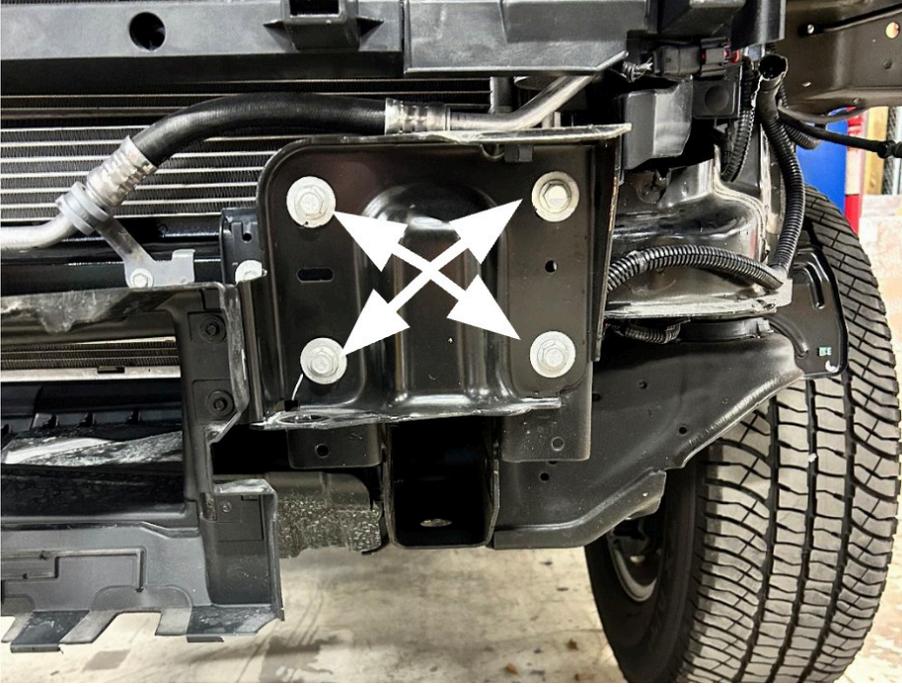


Figure 16

16. Using a 10mm socket wrench, remove the four (4) screws from the intercooler shroud. Figure 17.



Figure 17

17. If equipped with parking sensors, use 15mm socket to remove bolts inside OEM bumper inner structure to access sensors. Figure 18.



Figure 18

18. Remove parking sensors from OEM bumper. Be sure to mark orientation of sensor in housing, and sensor housing in bumper. Figure 19-20

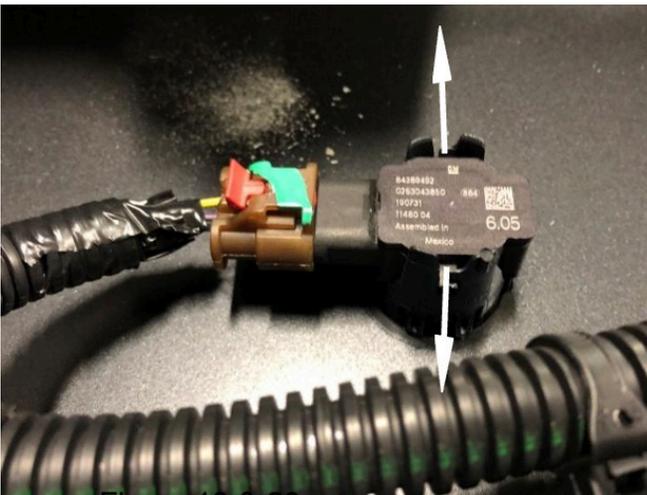


Figure 19

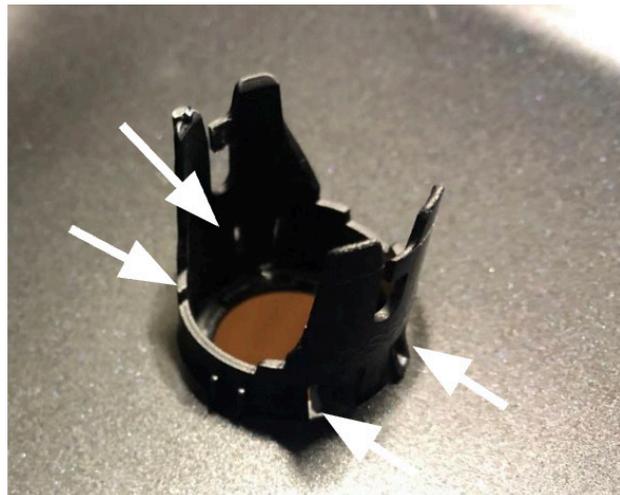


Figure 20

19. If applicable, reinstall the sensor housings into the bumper in the same location and orientation in which they were removed. Two sensors in the lower guard (23247/23248) and one in each wing of the bumper (23180/23181). Use the provided epoxy (61632) to secure them in place. Figure 21. (Note: If your truck does not have sensors, use the provided rubber grommets, and plugs to fill the sensor holes)



Figure 21

20. Install lower guard (*IF INSTALLING A WINCH, REFER TO WINCH TRAY INSTALLATION INSTRUCTIONS*) by rotating it into position from the bottom of the bumper as shown below. Install three ½" fasteners (as provided in hardware bag labeled 20260-HW) per side with bolt heads facing the inside of the bumper. Figure 22.

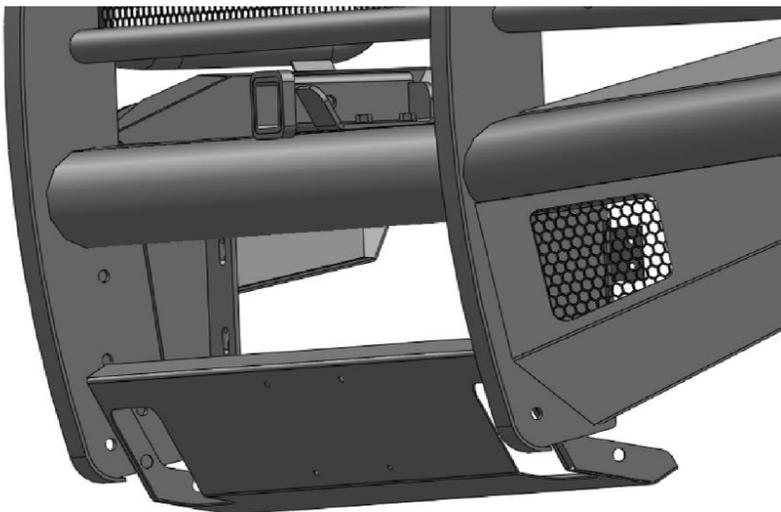


Figure 22

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21. After epoxy has fully dried, insert sensors into the housings in the wing and lower guard (23247/23248) in the correct OEM orientation. Route and secure OEM wire harness with zip ties. Figure 23.

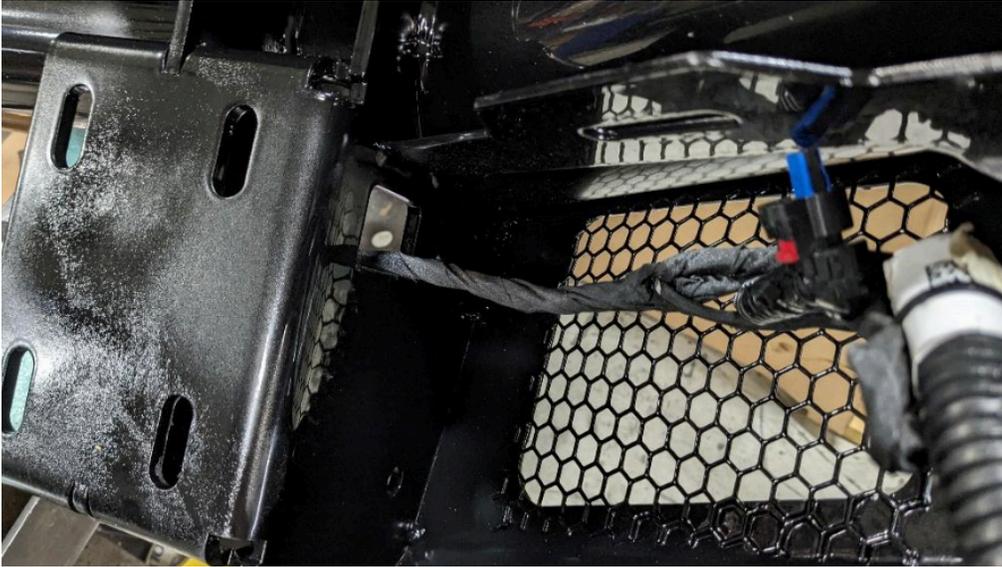


Figure 23

22. **OPTIONAL:** Install light pods at this time. Please refer to individual manufacturers wiring instructions and see image below as mounting reference. Figure 24



Figure 24

23. Install mounting brackets (23187 & 23188) using two (2) OEM bolts in front of frame horn (15mm socket), and two (2) OEM bolts through frame rail (18mm socket and wrench). Repeat for both sides. Figure 25-26.

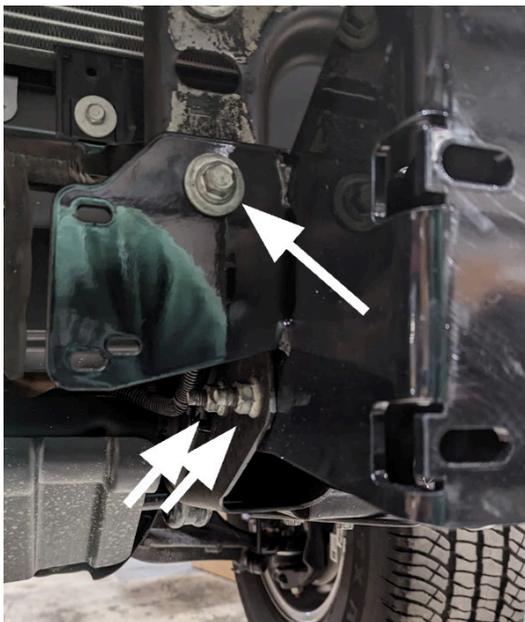


Figure 25

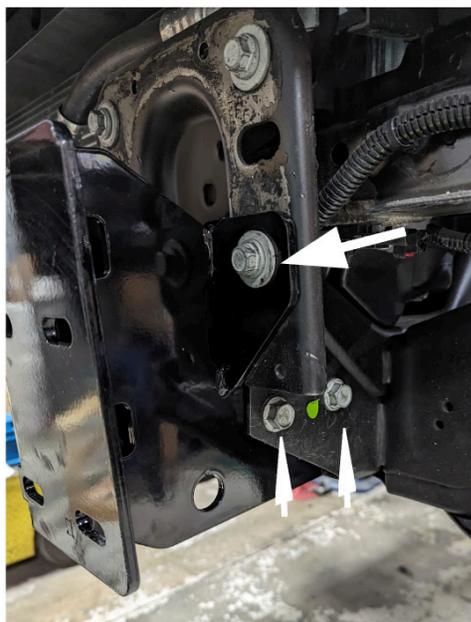


Figure 26

24. Install block heater plug into hole in DS mounting bracket (23187). Figure 27.



Figure 27

25. With assistance, lift the bumper (23180/23181) up to the brackets (23187 & 23188) and secure it loosely using the provided eight (8) bolt stacks of 1/2"-13 x 2", yellow zinc hex bolt, flat washers, lock washer, and hex nuts. (Figure 28) (50549-HW)



Figure 28



Figure 29

26. With assistance, lift and center the bumper to the vehicle and using a pair of 3/4" wrenches, fully tighten down the eight (8) 1/2"-13 bolts securing the bumper (22192) to the brackets (22193 & 22194).

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27. Use the provided 1/2" hex head bolts with washers and nuts to mount the two tow hooks (61366) to the bumper (20260-HW). Figure 30.

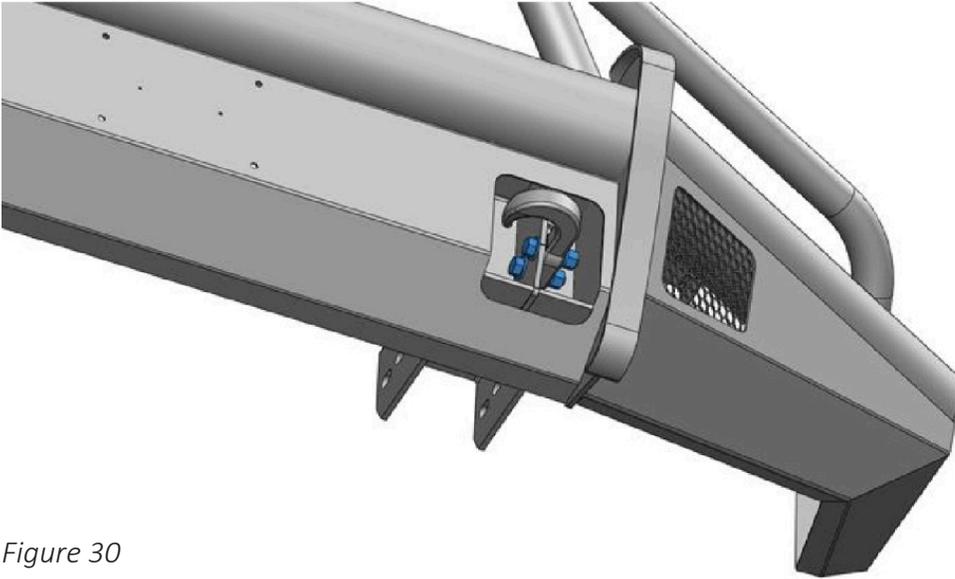


Figure 30

# 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**

