



INSTALLATION MANUAL
ULTRA LIGHT HYBRID BUMPER
PRODUCT NUMBER: TB68-03
APPLICATION: 2025 TOYOTA 4RUNNER



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

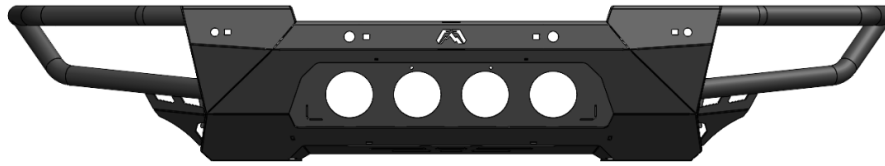
FOUNDER, FAB FOURS

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



23493 – BUMPER SHELL



23473 – GRILLE SUPPORT BRACKET

REQUIRED TOOLS

- BODY PRY TOOL
- PHILLIPS HEAD SCREWDRIVER
- 12MM SOCKET WRENCH
- 13MM SOCKET WRENCH
- 17MM SOCKET WRENCH
- 10MM SOCKET WRENCH
- 5/8" COMBINATION AND SOCKET WRENCH
- 11/16 COMBINATION AND SOCKET WRENCH
- PERMANENT MARKER
- SMALL RECIPROCATING SAW
- RUBBER Mallet OR DEAD BLOW HAMMER
- MASKING TAPE (OPTIONAL)

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 | 50521-HW

IDENTIFICATION NUMBER	COMPONENT DESCRIPTION	QTY
50521-HW	7/16"-14 X 1.25", HEX HEAD CAP SCREW, YELLOW-ZINC, GRADE 8	6
50521-HW	7/16", USS, FLAT WASHER, YELLOW-ZINC, GRADE 8	12
50521-HW	7/16"-SAE, LOCK WASHER, YELLOW-ZINC, GRADE 8	6
50521-HW	7/16"-14, HEX NUT, YELLOW-ZINC, GRADE 8	6
50521-HW	1.75" ROUND PLASTIC PLUG	2

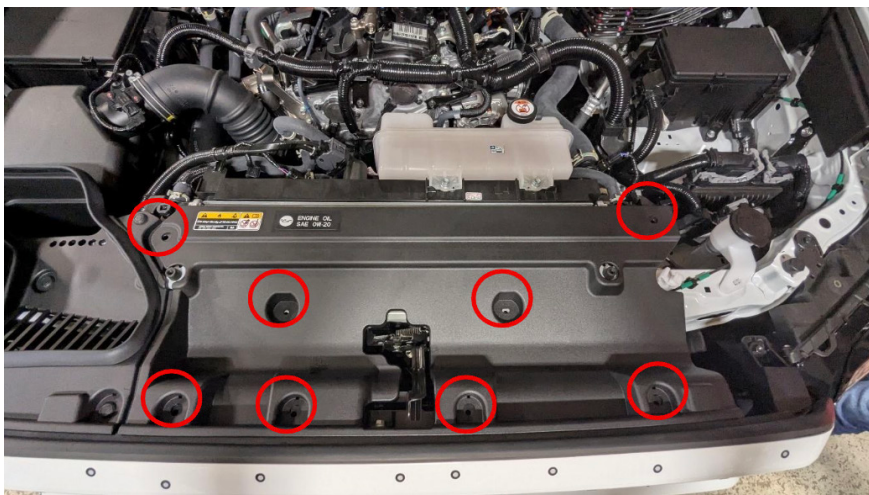
DISASSEMBLY & INSTALLATION

1. Disconnect the vehicles battery located in the trunk of the vehicle. (Figure 1)



Figure 1

2. Using the panel pry tool remove the eight (8) push pins in the under-hood cowl. To release the pins, depress the center. (Figure 2-5)



Figures 2-5

3. Using the panel pry tool remove the four (4) push pins in the intake scoop. (Figure 6)

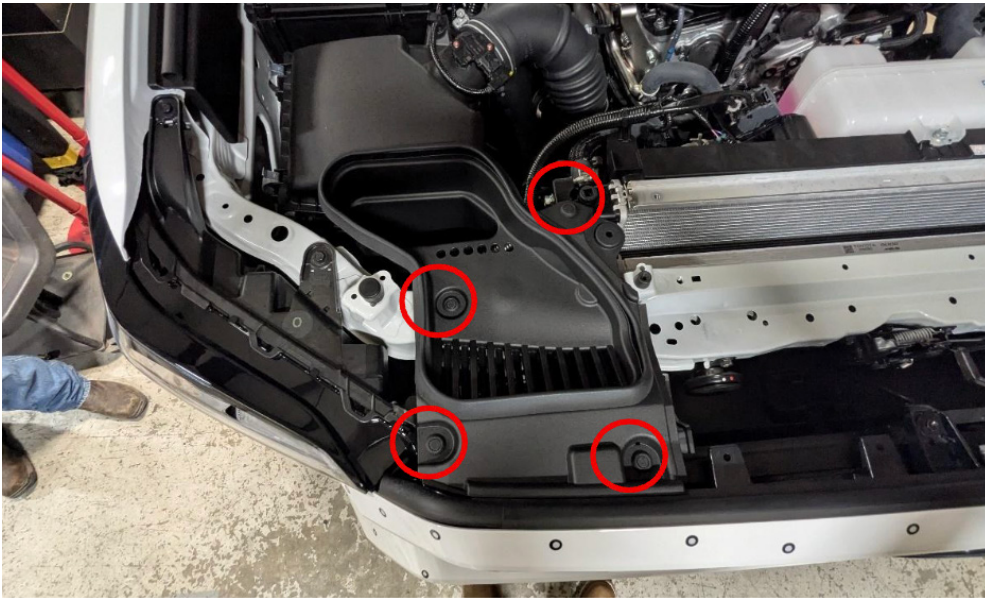


Figure 6

4. Using the panel pry tool and phillips head screwdriver, remove the six (6) push pins and four (4) screws in the front part of the DS inner fender liner. Repeat on the passenger's side. (Figures 7-9)

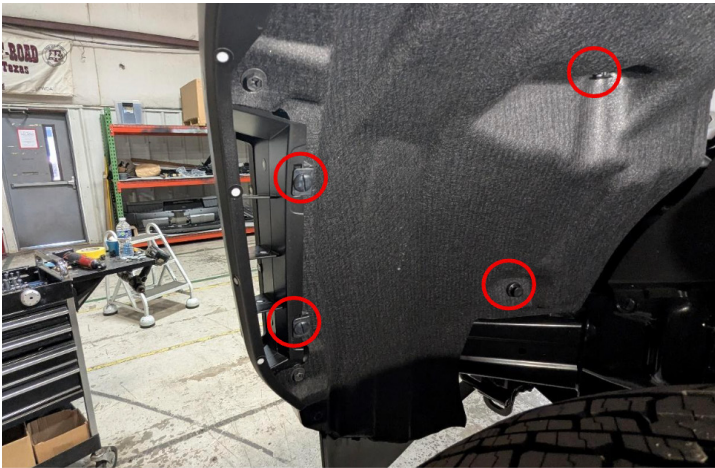


Figure 7



Figure 8



Figure 9

5. Using a 10mm socket wrench, remove the five (5) remaining screws from the air dam. (Figure 10)

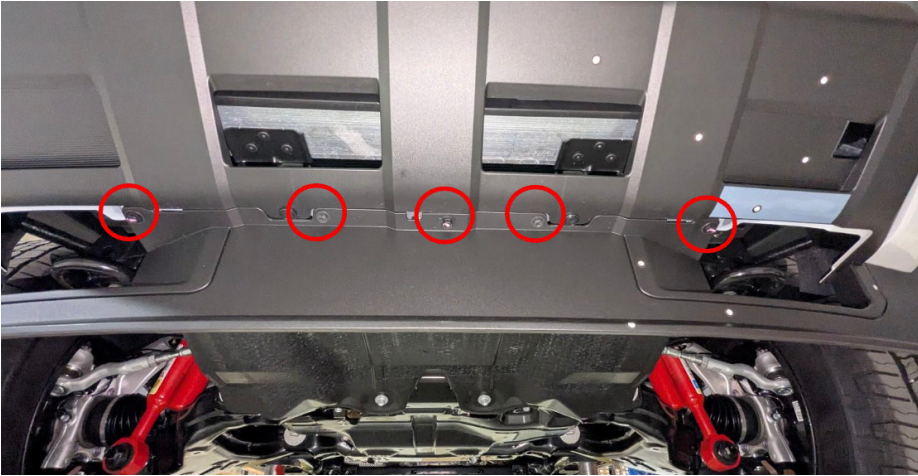


Figure 10

6. Using the panel pry tool, release the three (3) tabs on the lower portion of the flare inside the fender and pull the flare away from the vehicle to release the rest of the clips along the top of the flare. Repeat on the passenger's side. (Figure 11-13)



Figure 11

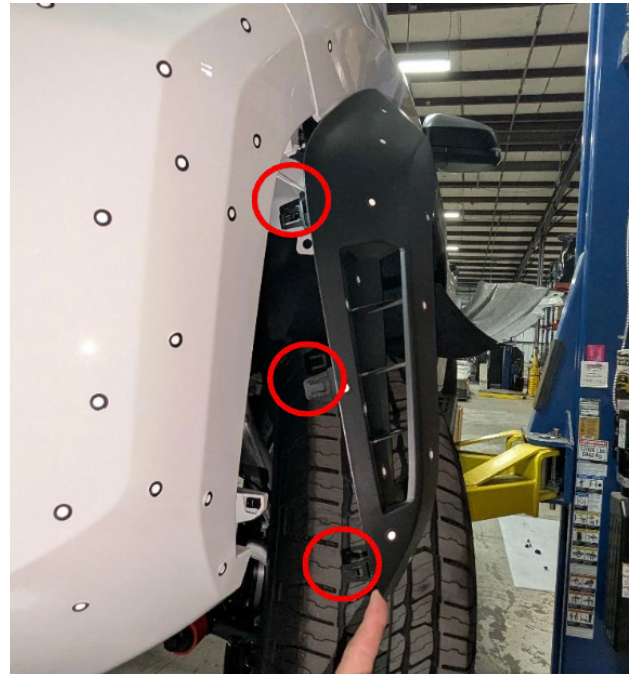


Figure 12

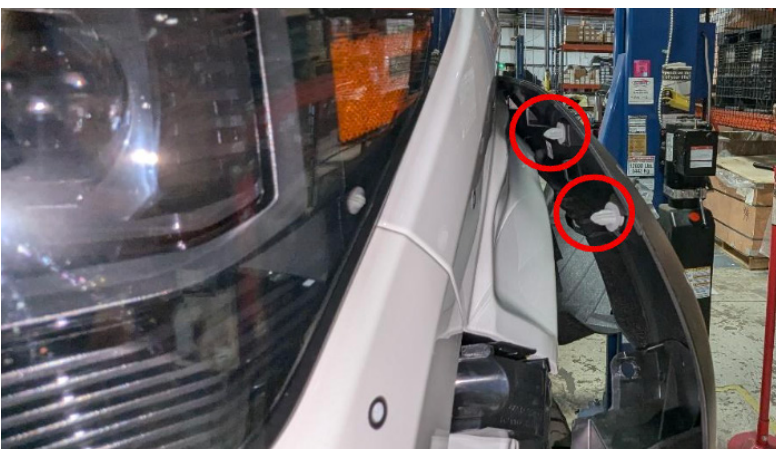


Figure 13

7. Using a 10mm socket wrench, remove the screw that was exposed by removing the flare. (Figure 14)



Figure 14

8. Using a 10mm socket wrench, remove the four (4) screws from the bottom of the fascia. Set these aside for reassembly later. (Figure 15)

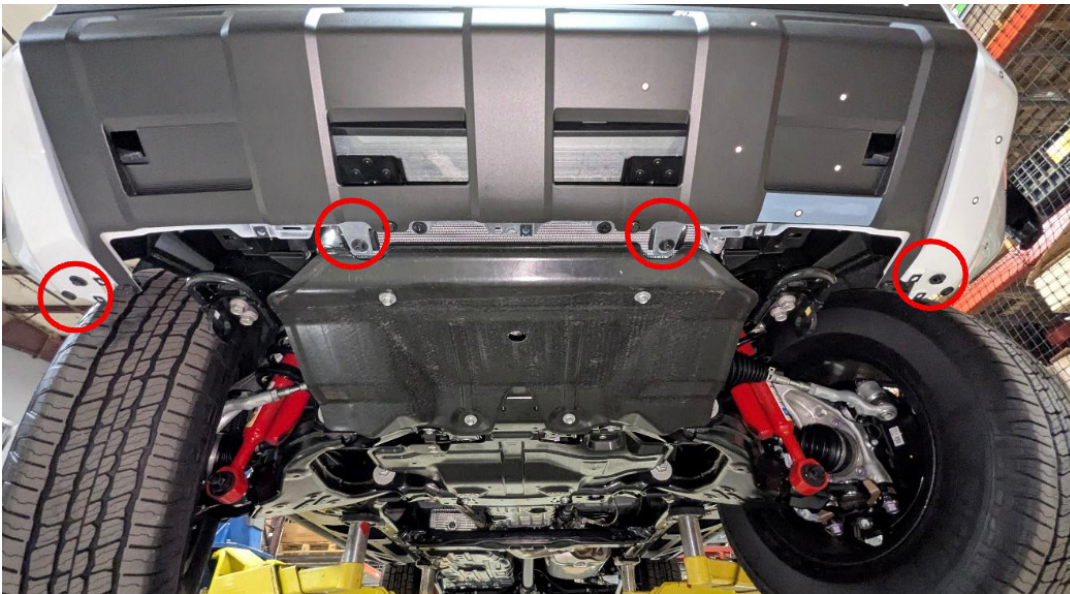


Figure 15

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9. Using a 10mm socket wrench, remove the three (3) screws from the top of the grille. (Figure 16)

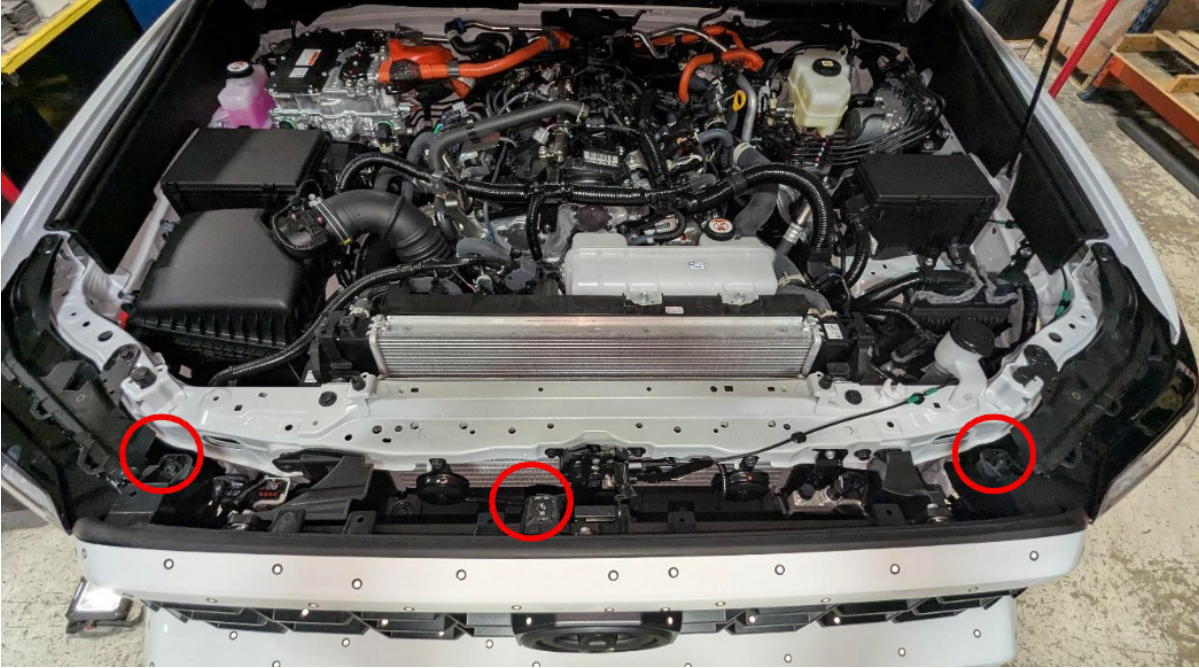


Figure 16

10. Disconnect the wiring harnesses on the passenger's side of the vehicle. (Figure 17)

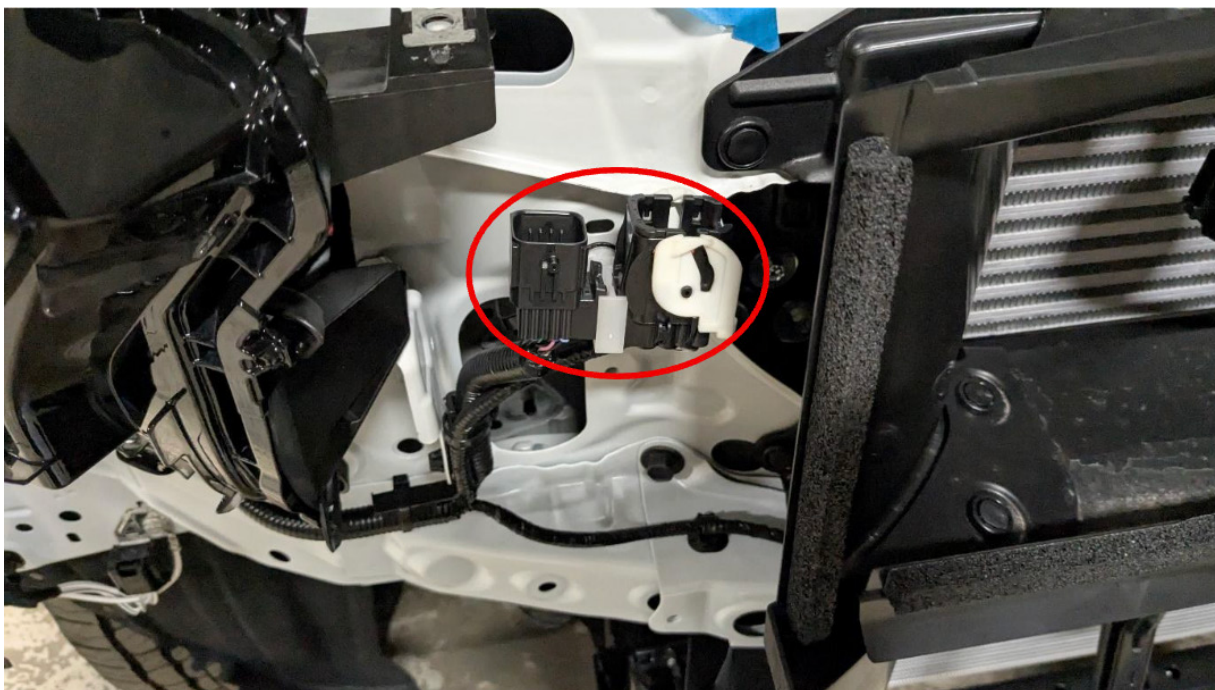


Figure 17

11. Pull the corners of the fascia outward away from the vehicle in order to release the clips along the fender. The fascia can now be removed from the vehicle by pulling outward along the rest of the fascia. (Figure 18)

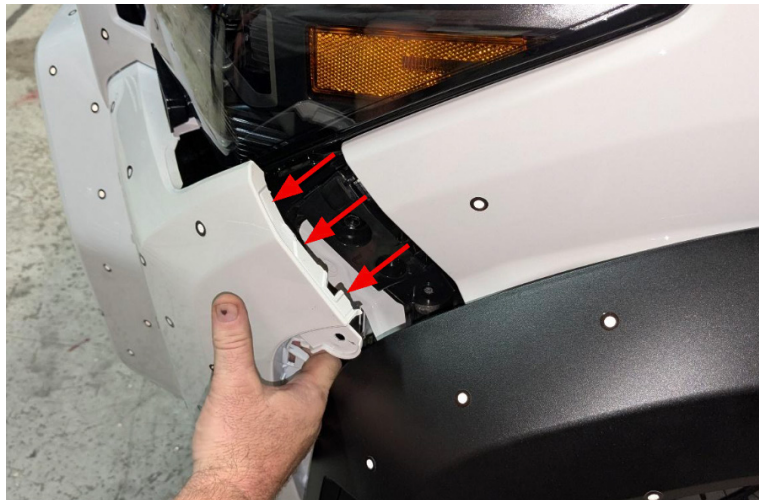


Figure 18

12. Using a 17mm socket wrench, remove the eight (8) screws from the crash bar. Set these aside for reassembly later. (Figure 19-20)



Figure 19

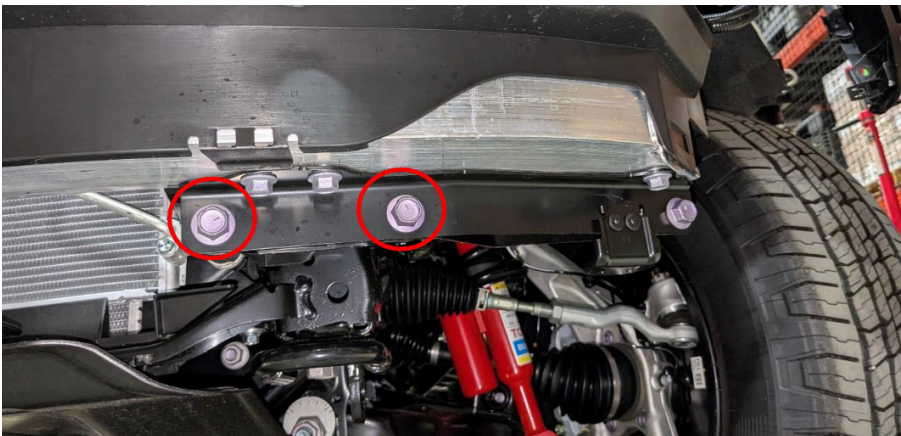


Figure 20

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13. Using a 17mm socket wrench, remove the two (2) screws from each tow hook. (Figure 21)



Figure 21

14. Using a 12mm socket wrench, remove the four (4) screws from the skid plate. (Figure 22)



Figure 22

15. Using a panel pry tool, remove the two (2) push pins from the plastic frame covers inside of each frame rail to remove them from the vehicle. (Figure 23)

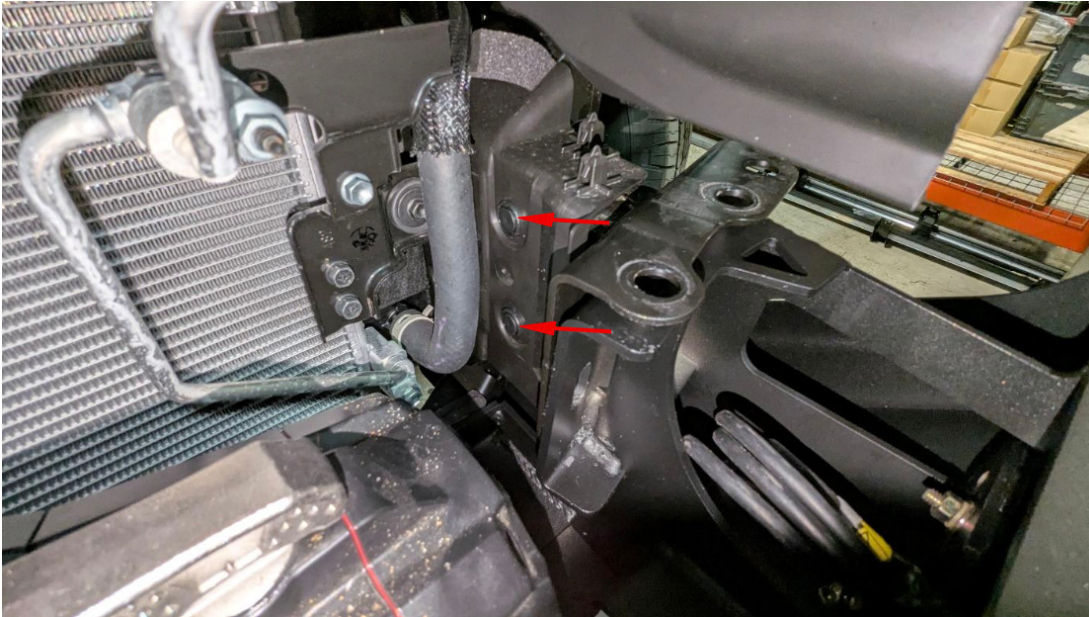


Figure 23

16. Using a panel pry tool, remove the four (4) push pins from the bottom of the fascia. (Figure 24)

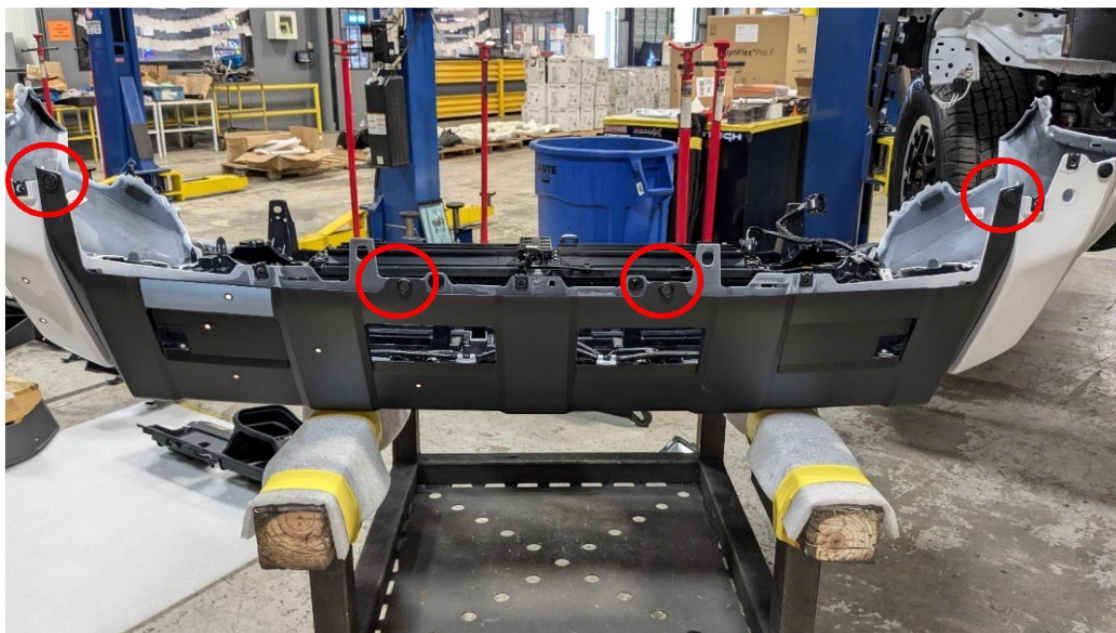


Figure 24

17. Pinch the locking tabs on the center two (2) parking sensor covers to remove them. Set them aside for reassembly later. (Figure 25)

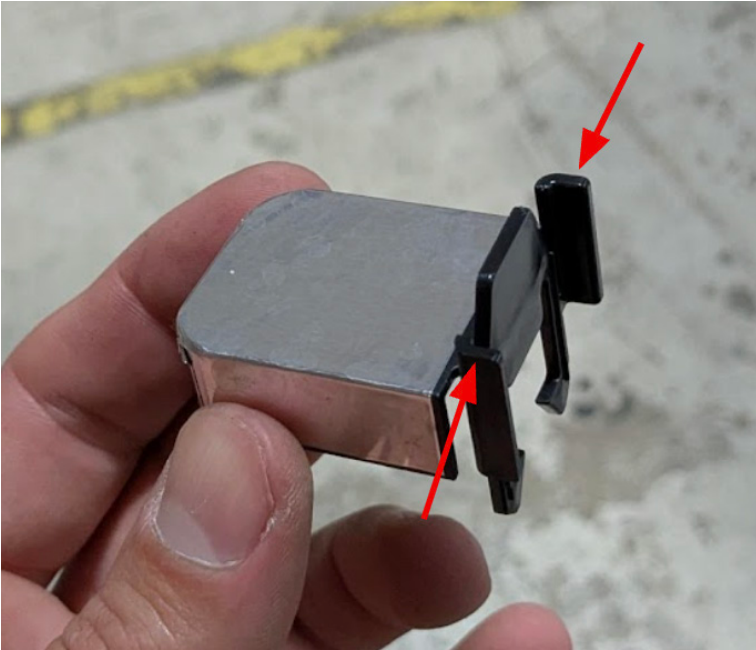


Figure 25

18. Carefully spread the green locking tabs on the parking sensor housings to remove the sensors from their housings. (Figure 26)

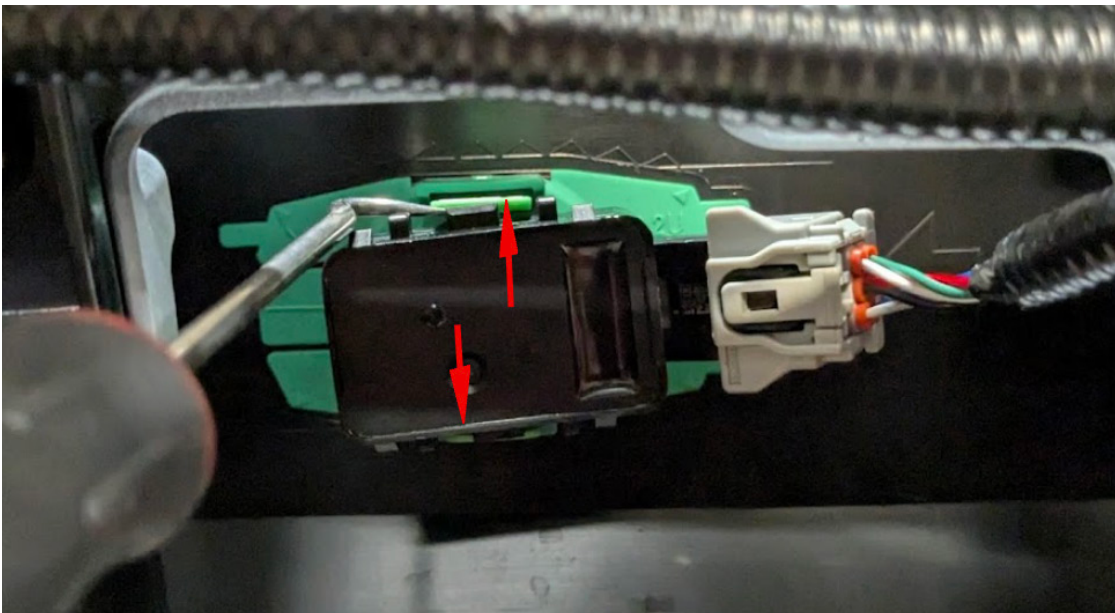


Figure 26

19. Using a panel pry tool, release the wiring harness retainers and move the harness up and out of the way as far as possible. (Figure 27)

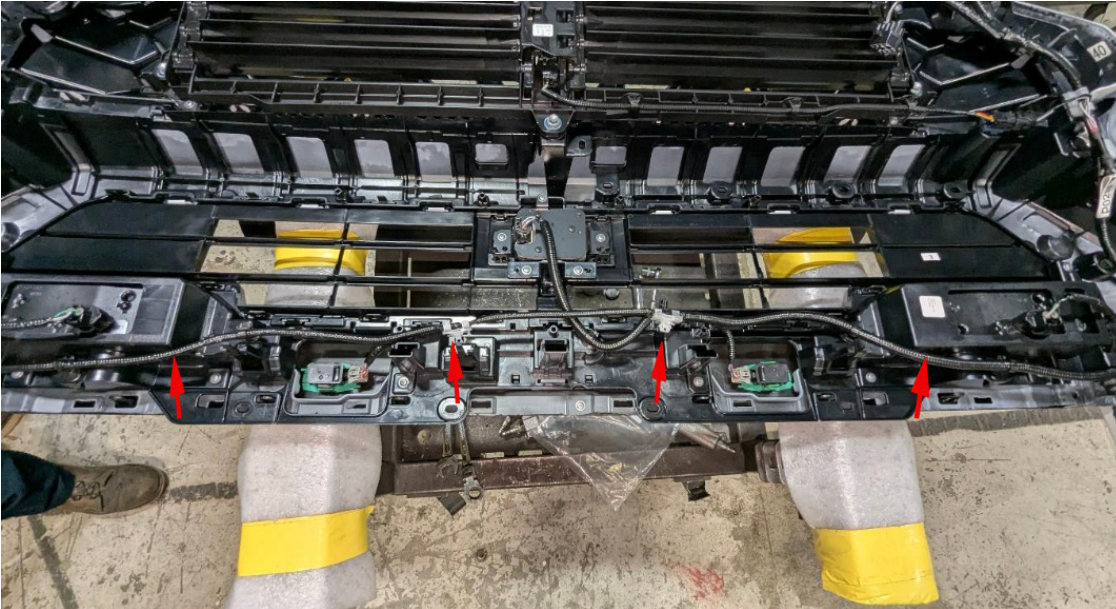


Figure 27

20. Using a Phillips-head screwdriver, remove the eight (8) screws across the inside of the fascia. (Figure 28)

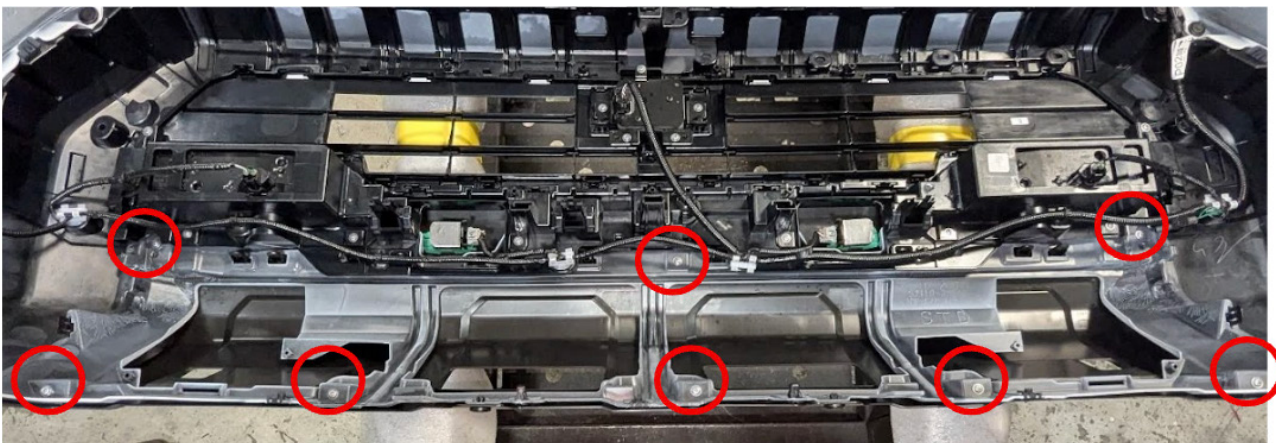


Figure 28

21. Using a panel pry tool, release the remaining clips attaching the lower black fascia cover and sensor facia from the painted portion of the facia. (Figure 29-31)

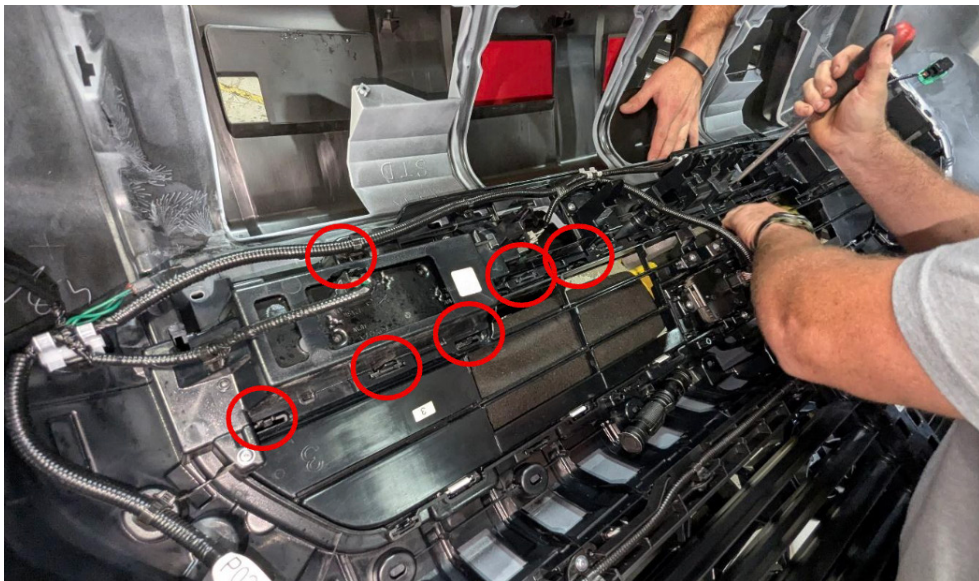


Figure 29



Figure 30



Figure 31

21. Using a Phillips head screwdriver, reinstall three (3) of the previously removed screws to resecure the facia. (Figure 32)

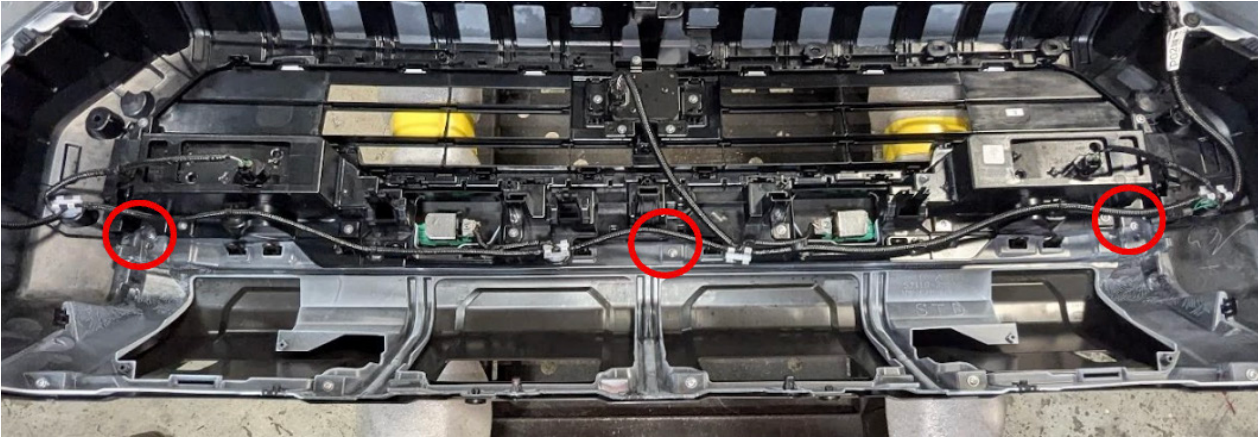


Figure 32

23. Use a Philips head screwdriver to remove the 4x screws around the DS and PS fog lights and 3x screws in the center. (Figure 33-34)

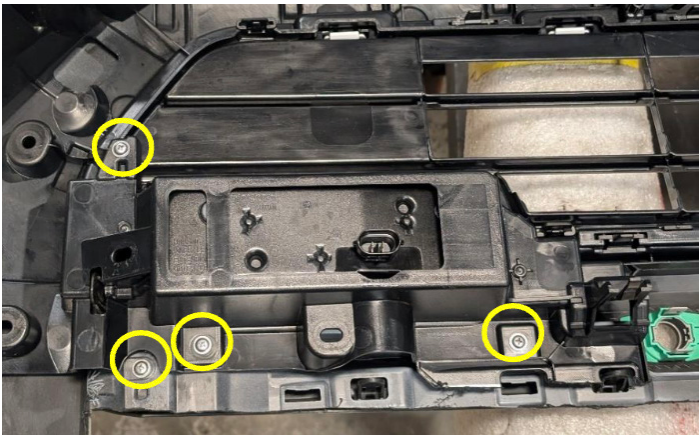


Figure 33



Figure 34

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- 24. Remove the center fog light cover from the front of the bumper facia by unclipping it from the back. Unbolt the fog lights using a Philips head screwdriver to remove the 2x screws. (Figure 35-36)**

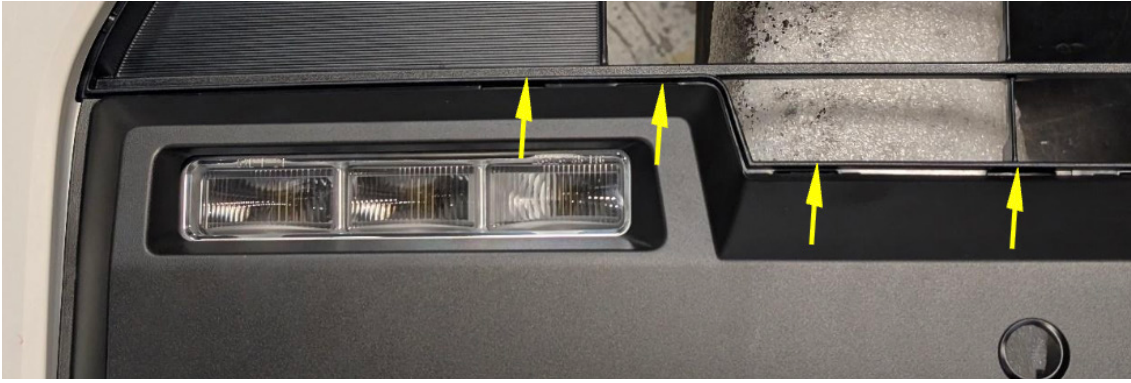


Figure 35



Figure 36

- 25. Reinstall the facia back on the front of the truck to place the templates and start the facia cutting process.**

26. Carefully place the provided cut templates onto the DS and PS facia and fenders. Starting with the center contour profile, adhere the template to the facia and work outwards by lining up the edge of the template with the chamfer body lines (1). Next, line the center of the template with the connecting edge and body line (2). Lastly, follow the fender lines cut out to place the template on the fender flares (3). (Figure 37)

Note: Take your time when locating the cut template on the facia to ensure the bumper fits properly.

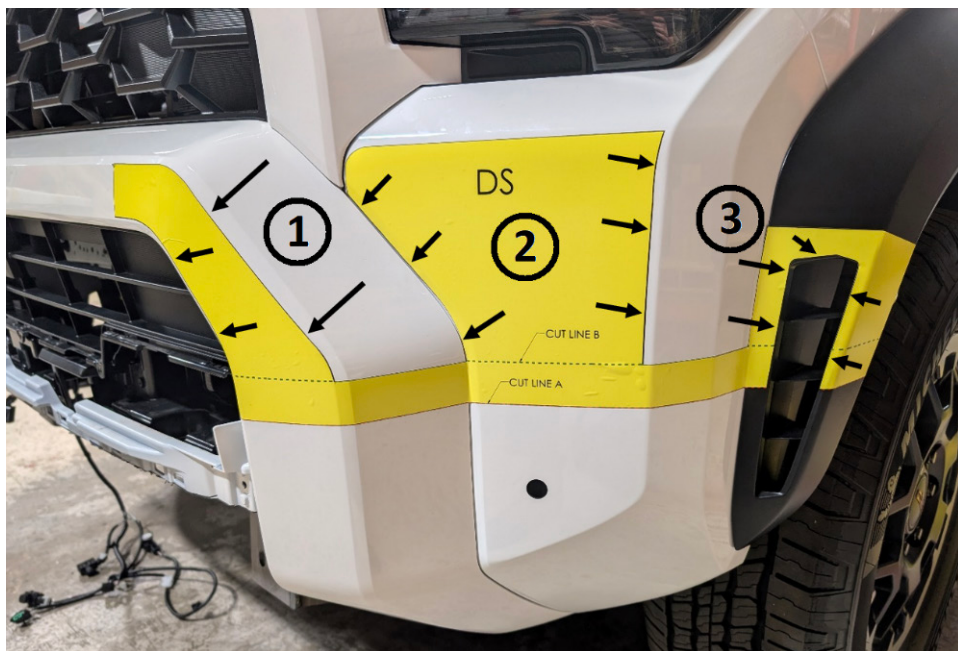


Figure 37

27. Cut the center section of the front bumper along the fog light profile. Cutline shown below in Figure 38. It is recommended that the edge of the cutting blade remain below the template line to ensure a clean fit. (Figure 38-39)

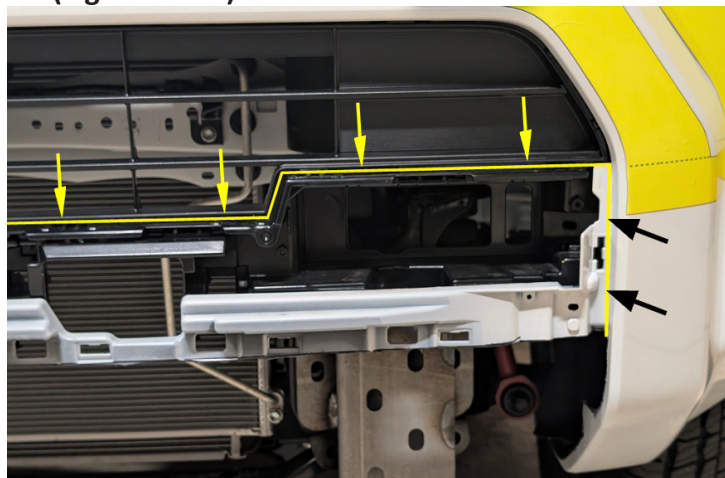


Figure 38

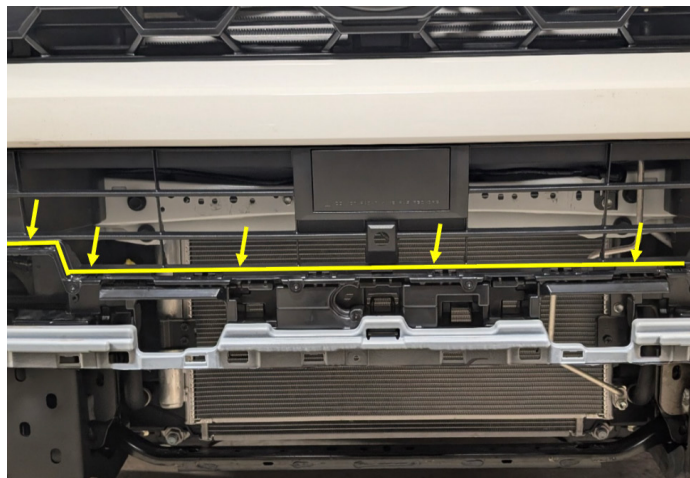


Figure 39

28. Start the cut at the fender and cut on the “CUT LINE B” cutline. It is recommended that the edge of the cutting blade remain below the template line to ensure a clean fit. (Figure 40)

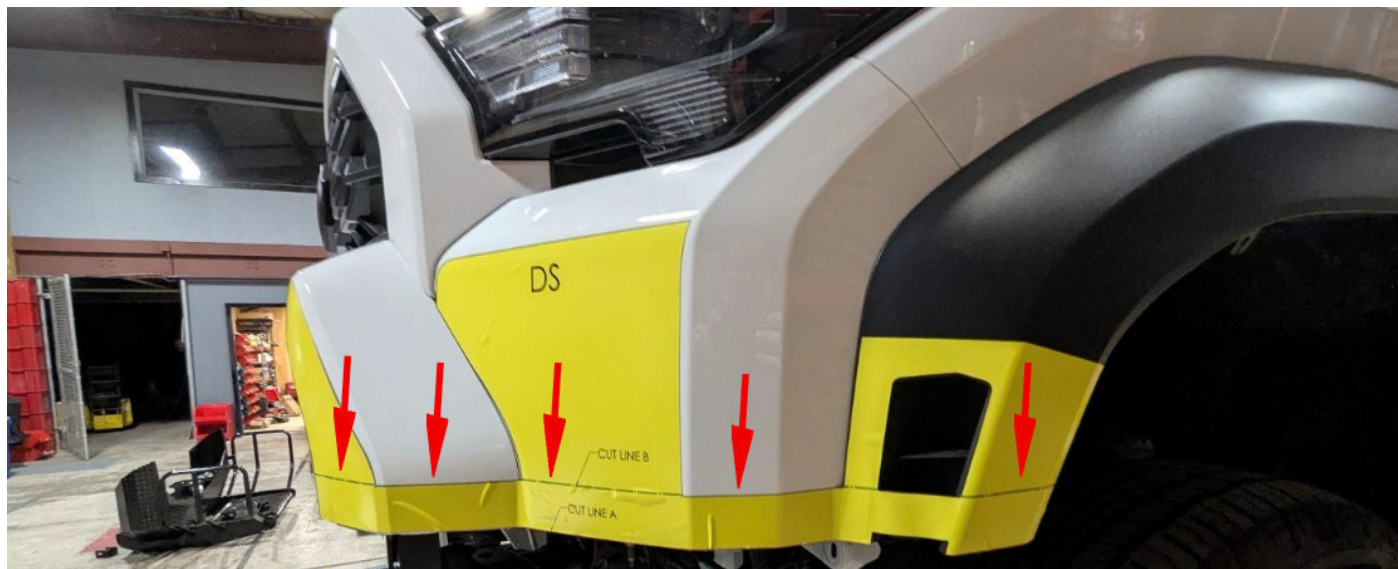


Figure 40

29. Following the template, cut the front facia along the “CUT LINE B”. It is recommended that the edge of the cutting blade remain below the template line to ensure a clean fit. (Figure 41)

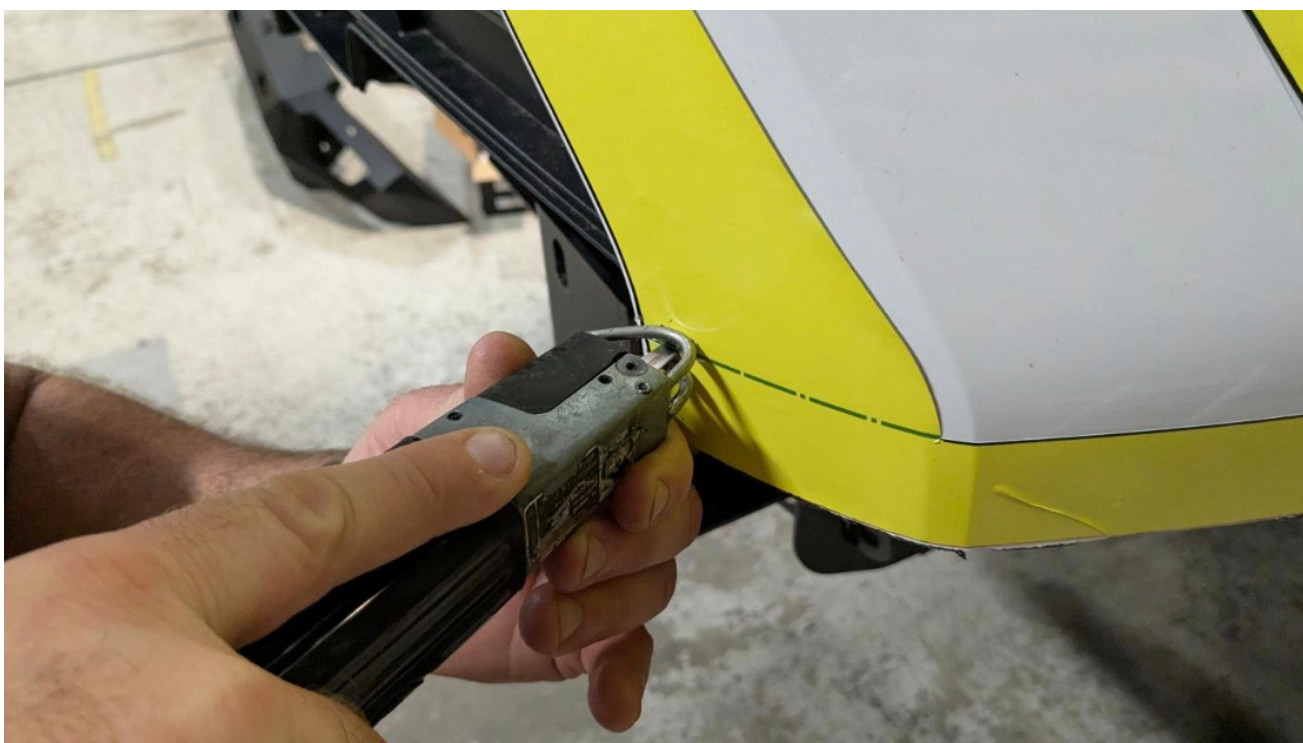


Figure 41

30. Clean up any plastic burs left behind after the cut to ensure a smooth bodyline post-install. It is recommended to use a piece of fine grit sandpaper (~180 grit or higher) to carefully clean up the cutline. (Figure 42)



Figure 42

31. Using a Phillips Head Screwdriver, remove the two (2) Philips Head Screws holding the front camera shroud in place. Use a 10mm socket, or wrench, to remove the final four (4) bolts securing the lower grill support bracket and remove it from the truck. After removal, replace the OEM Grill Support Bracket with the one provided by Fab Fours (Part#: 23473) and reinstall using previously removed OE hardware (2X Phillips Head Screws and 4X 10mm Bolts). (Figure 43-44)

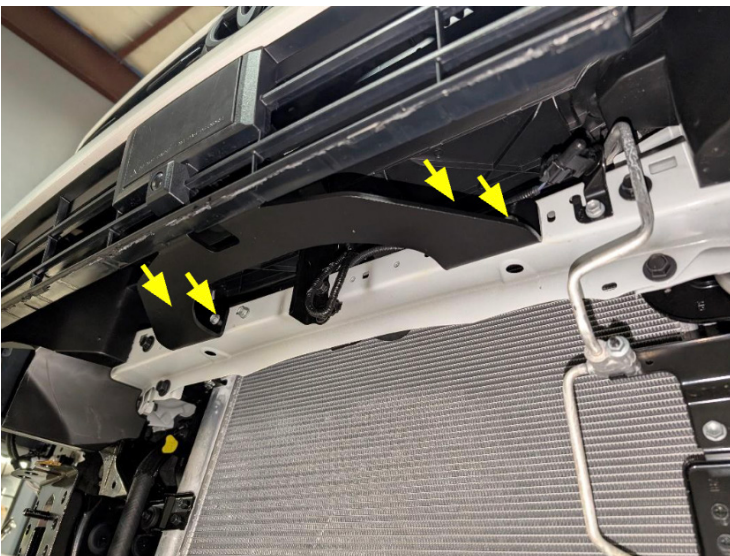


Figure 43

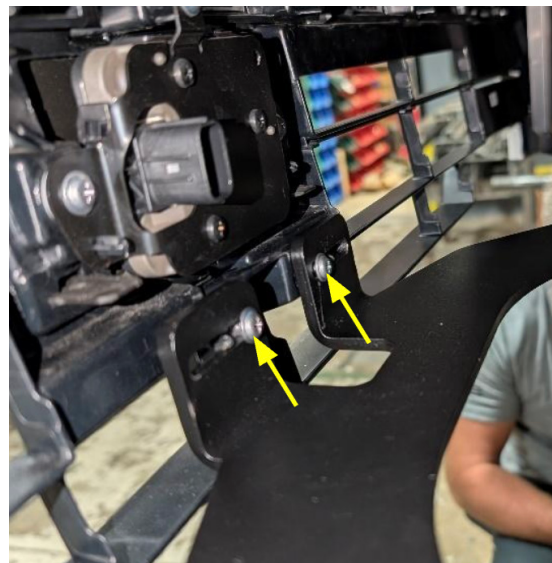


Figure 44

32. Using the provided epoxy, install the parking sensor housings in the new bumper in the same location and orientation from which they were removed. When placing the housing in the bumper, align the connector of the sensor with the etched rectangle in the bumper. (Figure 45-46). If installing 4" round lights, do so now before installing the bumper to the truck.

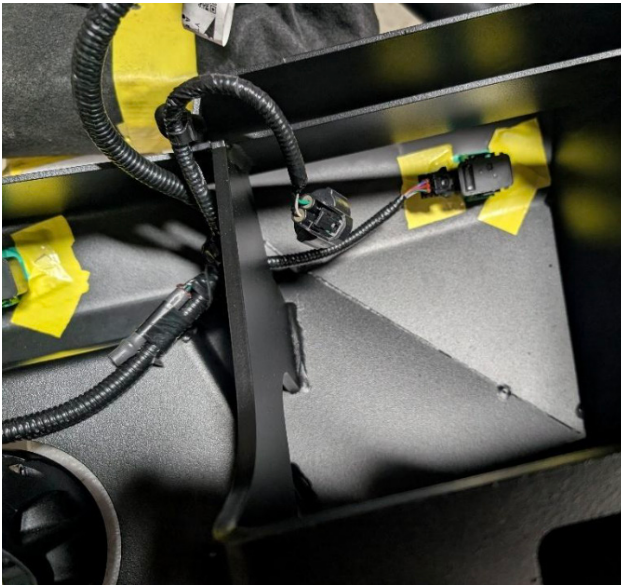


Figure 45



Figure 46

33. With assistance, hold the bumper up to the frame and use the provided (6) 7/16" bolts washers and nuts to fasten it to the truck. (Figure 47). Plug in the wiring harness and fully tighten all mounting hardware.

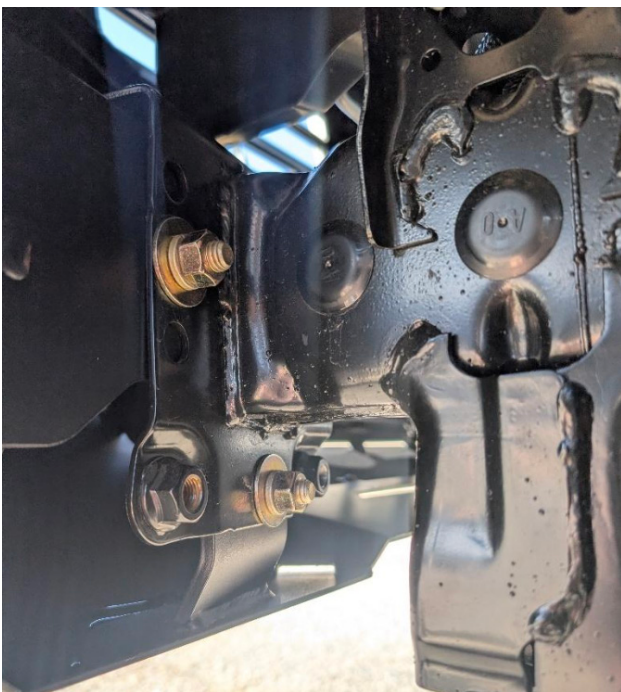


Figure 47

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

