



INSTALLATION MANUAL
VENGEANCE FRONT BUMPER
PRODUCT NUMBER: V625X
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.

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



23232 - FF VENGEANCE FRONT BUMPER



22352 - LIGHT BAR L-BRACKETS QTY:2

61632 EPOXY 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 | 50228-HW & TXX50-HW

IDENTIFICATION NUMBER	COMPONENT DESCRIPTION	QTY
50228-HW	1/4"-20 X 1", HEX HEAD CAP SCREW, ZINC, GRADE 8	2
50228-HW	1/4"-20, HEX NUT, ZINC, GRADE 8	2
50228-HW	1/4"-SAE, FLAT WASHER, ZINC, GRADE 8	4
50228-HW	1/4"-SAE, LOCK WASHER, ZINC, GRADE 8	2
TXX50-HW	1 3/8"- X , BLACK RUBBER GROMMET	4
TXX50-HW	BLACK PLASTIC PLUG	4
TXX50-HW	1/2" LICENSE PLATE NUT	2

INSTALLATION

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

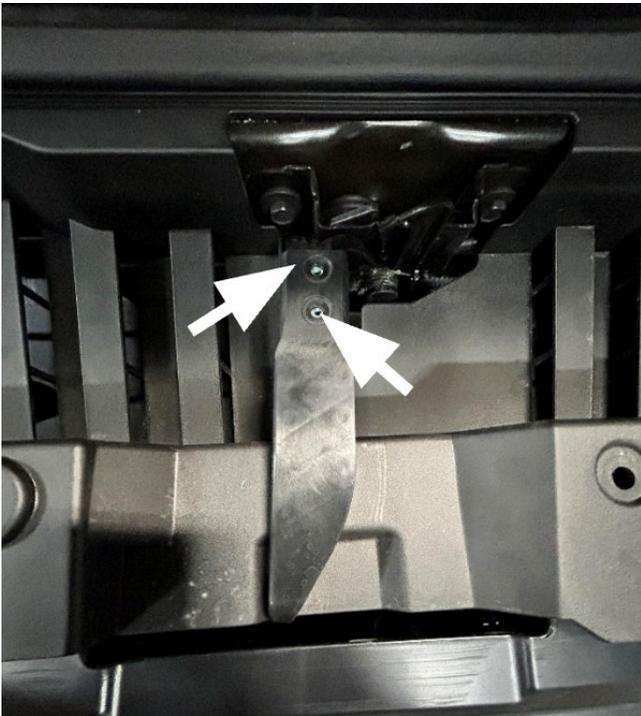


Figure 1

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.

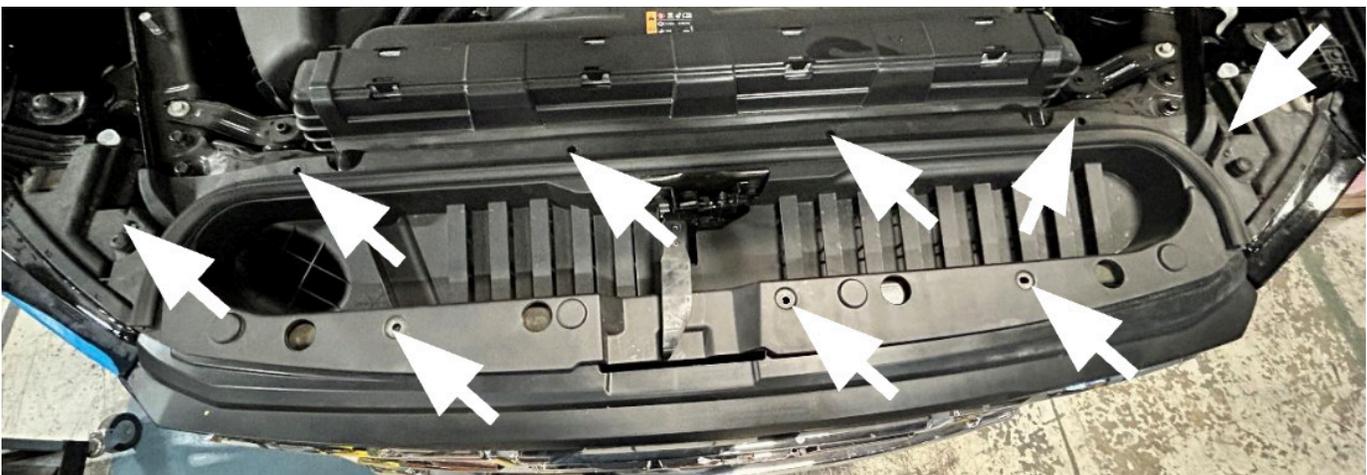


Figure 2

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.

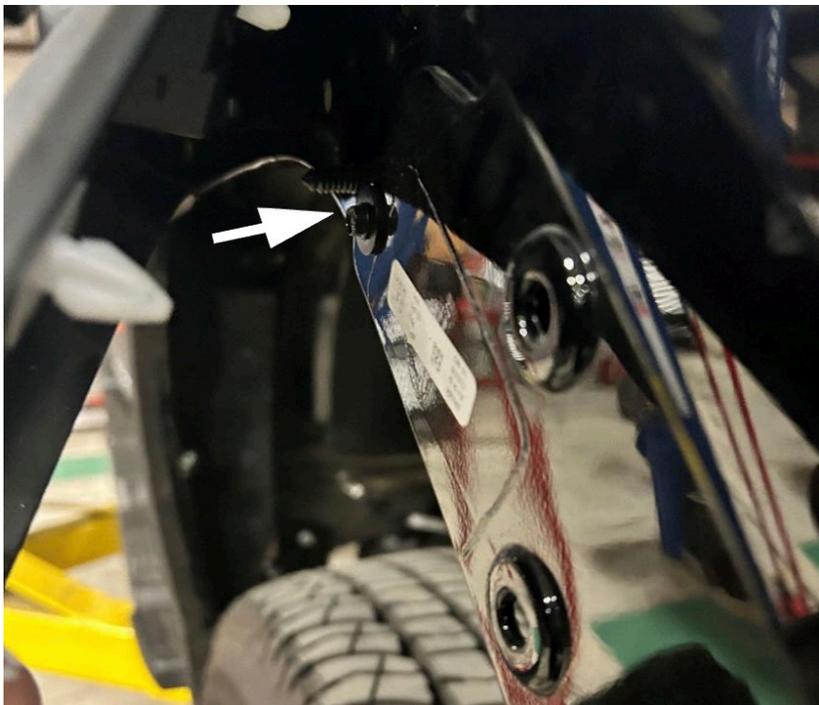


Figure 6

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.

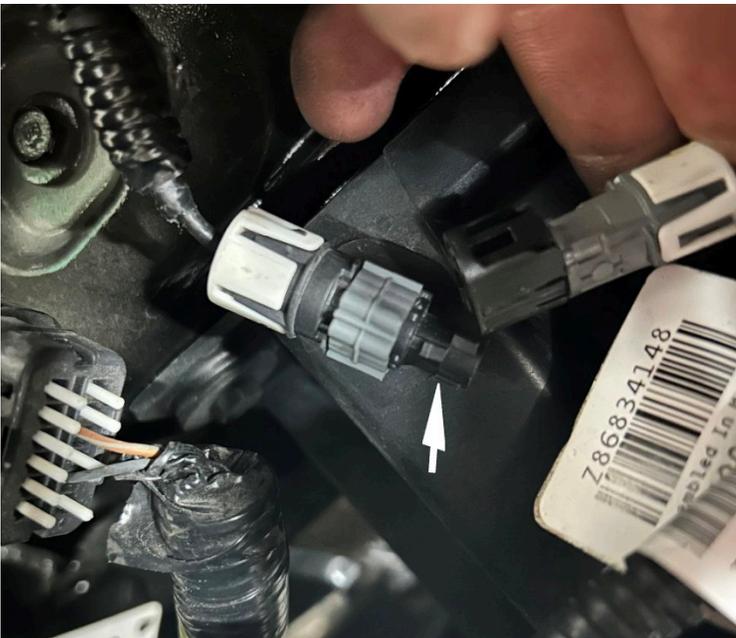


Figure 9

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



Figure 10

10. Use a 15mm socket wrench underneath the bumper to remove the four (4) bumper support bracket bolts. Figure 11



Figure 11

11. Use an 18mm socket wrench to remove four (4) mounting bolts. Figure 12



Figure 12

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



Figure 13

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

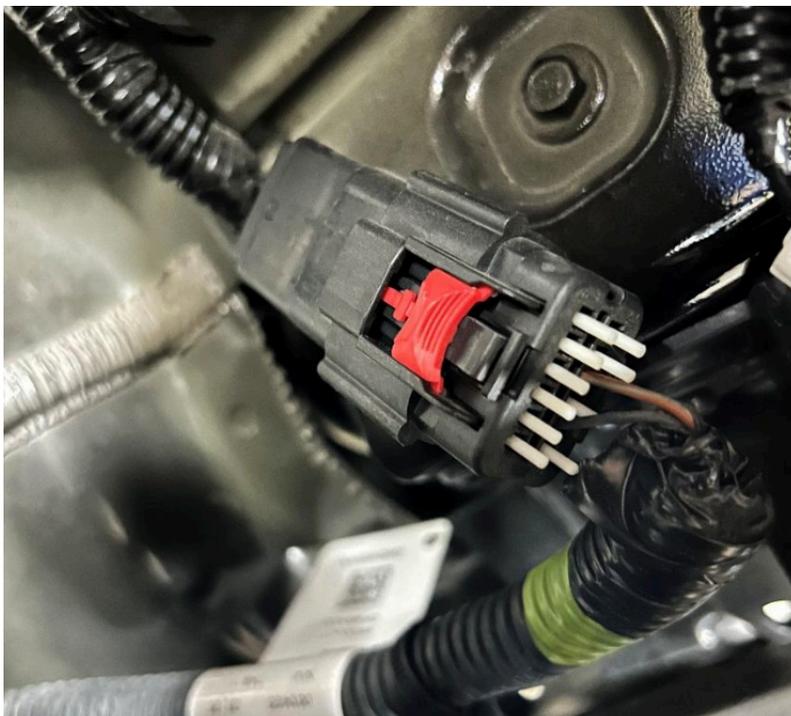


Figure 14

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



Figure 15

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



Figure 16

16. Use an 18mm socket wrench to remove the two (2) bolts holding the factory tow hooks onto the frame. Figure 17



Figure 17

17. Unclip all the plugs holding the sensor harness to the bumper using a body pry tool. Carefully remove the sensor from the housing by pushing the housing apart and removing the sensor by pushing up. Figure 18

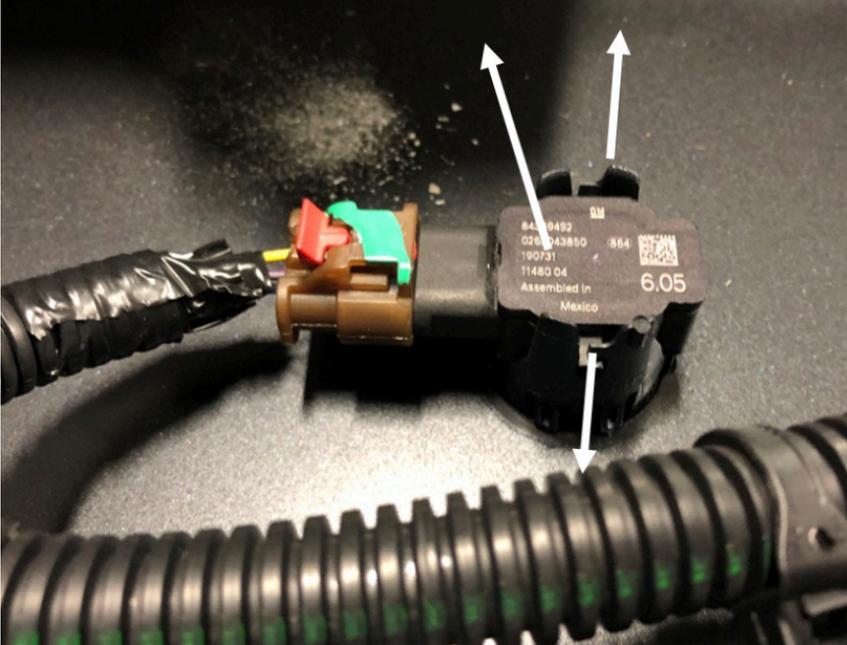


Figure 18

18. Remove the sensor housings from the bumper by pressing the four (4) clips in and pushing it out of the bumper. Make sure to mark what side of the bumper the housing came out of to install into the Fab Fours bumper. Figure 19

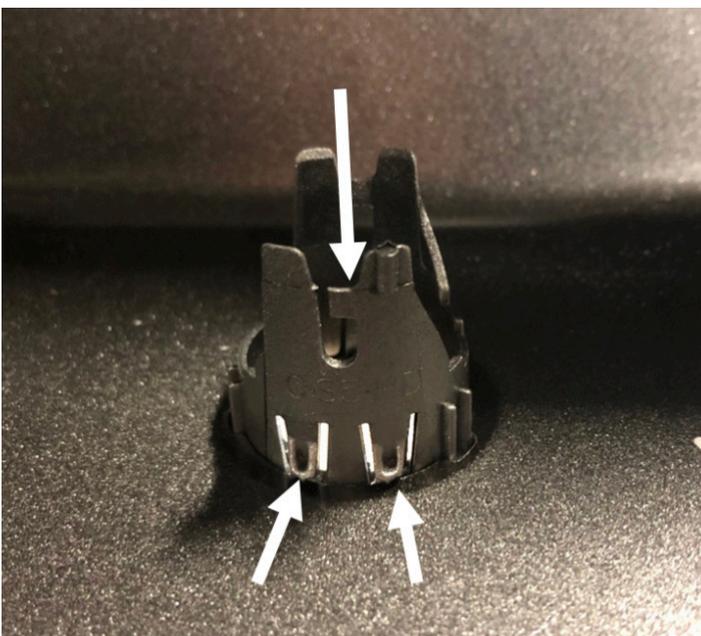


Figure 19

19. Remove the engine heater plug from the bumper by pressing in on the spring and turning clockwise. Figure 20



Figure 20

20. Using the provided epoxy, secure all four (4) Oem sensor housings in their appropriate sensor cutout in the bumper (22219). Allow twenty (20) minutes of time for the epoxy to cure. Figure 21



Figure 21

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21. Route the OEM wiring harness through the bumper with the main wiring harness connector being on the passenger side of the bumper. Carefully install all the sensors into their respective housings and clip them in place. Figure 22



Figure 22

22. Install the engine block heater removed during step 19 into the Fab Fours bumper brackets. Figure 23.



Figure 23

23. If installing a 20" light bar, use the 2x L-brackets (22352) along with the 1/4" hex head bolts, washers, and nuts to fasten it in place. Figure 24



Figure 24

24. With assistance, hold the bumper up the truck and use the 4x OE bolts removed during step 14 along with a 15mm socket wrench to fasten the bumper to the frame. Adjust the bumper to desired position and fully tighten bolts. Figure 25.



Figure 25

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

