



INSTALLATION MANUAL
VENGEANCE FRONT BUMPER
PRODUCT NUMBER: D525X
APPLICATION: 2021 FORD BRONCO



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

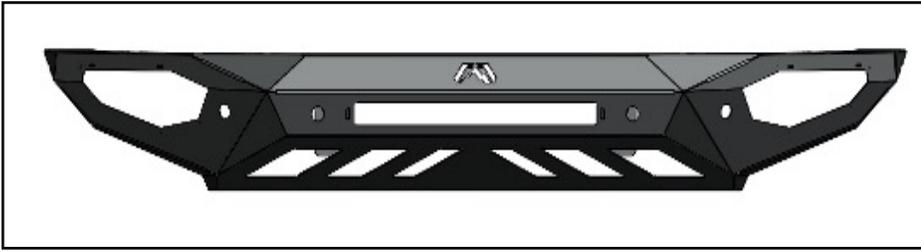
GETTING STARTED

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.

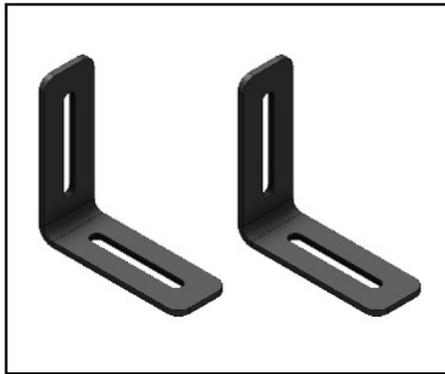
Failure to fully account for all components before beginning installation may leave vehicle immobile until part is acquired. Refer to the next pages as an inventory check.



PROVIDED MATERIALS



22501 - BUMPER SHELL



22352 - MOUNTING
BRACKETS

61632 -
EPOXY QTY:2

TOOLS REQUIRED

- PANEL PRY TOOL
- 15MM SOCKET WRENCH
- 15MM OPEN END 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 | 50298- HW, 50228-HW

FAB FOURS IDENTIFICATION	COMPONENT DESCRIPTION	QTY
50298-HW	Flanged Hex Head Screw, M12 x 1.75mm, 30mm, Yellow-Zinc	4
50298-HW	1 3/8", Grommet, Plastic, mm9307K81	4
50298-HW	Plastic Plug	4
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", Flat Washer, Zinc, Grade 8	4
50228-HW	1/4", Lock Washer, Zinc, Grade 8	2

DISASSEMBLY

NOTE: Save all OEM parts until installation is complete!

1. Using the panel pry tool remove the eight (8) push pins attaching the two (2) tow hook cover plates to the bumper. (Figure 1)

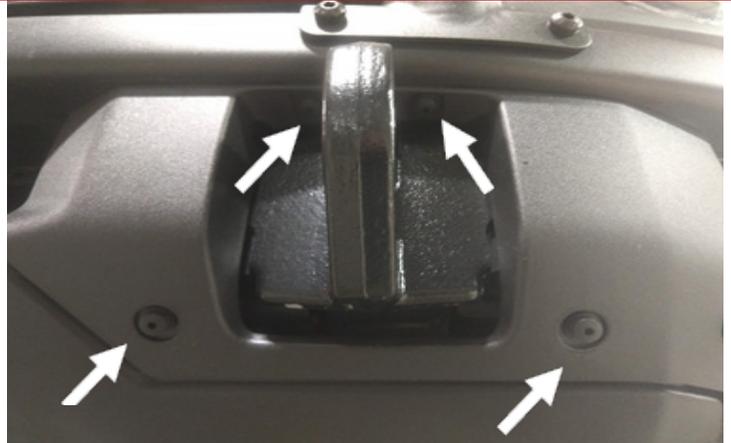


Figure 1

2. Using the 15mm socket wrench remove the six (6) bolts that attach the factory bumper to the frame. (Figure 2)

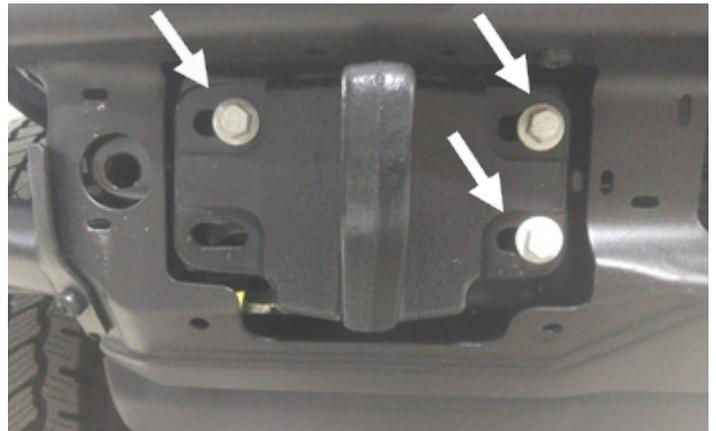


Figure 2

3. The factory bumper can now be removed from the vehicle.

4. Remove the OEM electrical harness from bumper by removing the push pins. (Figure 3-4)

NOTE: Document the location of each sensor housing for reference when reinstalling into your bumper.



Figure 3

5. Remove the sensor from the sensor housing by expanding both sides of the sensor housing and lifting. (Figure 5-6)

NOTE: Sensors are extremely delicate and must be handled with care! Do not push on face of sensors to remove!



Figure 4



Figure 5



Figure 6

6. Remove the sensor housing from the bumper by depressing the four (4) tabs while pulling outward from the outside of the bumper. (Figure 7-8)

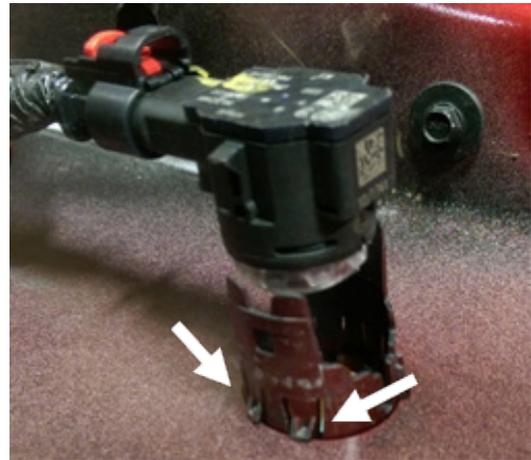


Figure 7



Figure 8

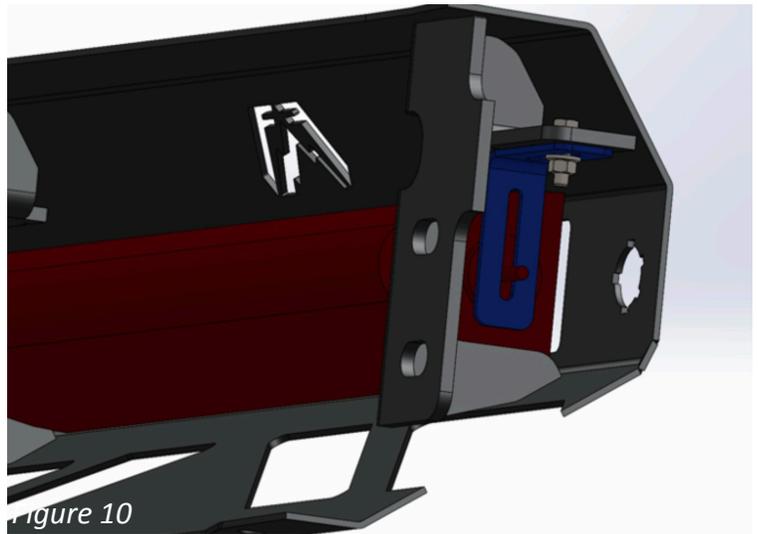
7. Remove the intercooler shroud from the vehicle by depressing the tabs around the perimeter of the shroud and then separating the shroud from the intercooler. (Figure 9)



Figure 9

PREINSTALLATION

1. Using a 7/16" socket and combination wrench, install the provided lightbar mounting brackets (part#: 22352) to the tabs in the bumper with the provided 1/4" hex head screws, flat and lock washers, and nuts.



2. Install your lightbar to the previously installed brackets per the light manufactures instructions.
3. Reinstall the factory sensors into the Fab Fours Bumper or install the provided four (4) rubber gromets and plastic plugs in the sensor holes if your vehicle is not equipped with sensors.

INSTALLATION

1. Install the Fab Fours bumper to the vehicle using the provided four (4) M12, Yellow-Zinc, screws and 15mm open end wrench. Align the bumper with the vehicle body vertically and horizontally leaving at least a 1/4 inch space between the body and bumper.

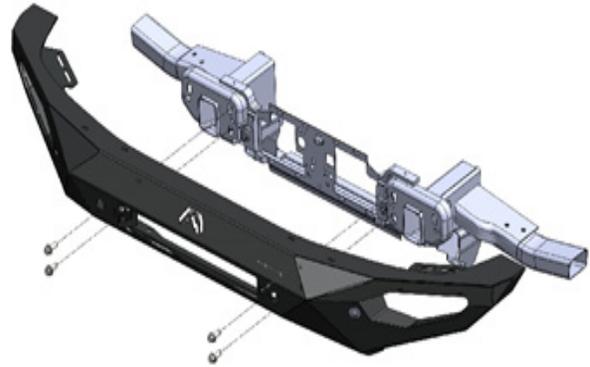


Figure 11



Figure 12

INSTALLATION COMPLETE

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

