



INSTALLATION MANUAL
PREMIUM REAR BUMPER
PRODUCT NUMBER: W6352
APPLICATION: 2024 TOYOTA TACOMA



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

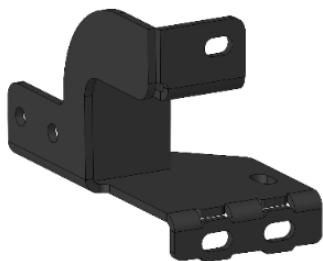
Before you begin the installation process of your new Fab Fours product, we suggest laying out all materials and parts on a pad or protective surface.

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.

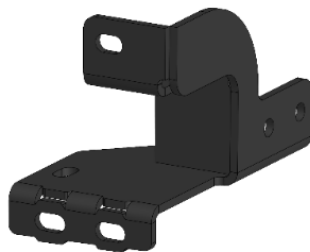
PROVIDED MATERIALS



23317 - BUMPER SHELL



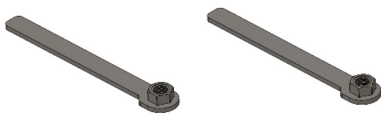
23318



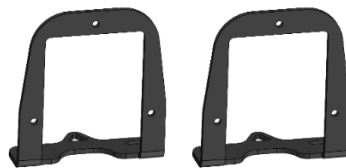
23319



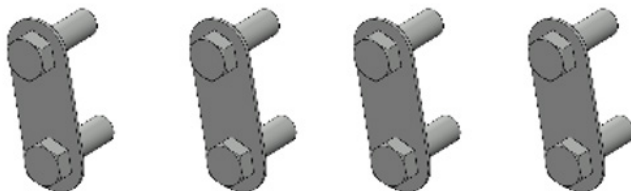
23320 QTY: 2



23324 QTY: 2



23471 QTY: 2



20296 QTY: 4

61632 EPOXY QTY:2

61784 PLASTIC SHEET QTY: 2

REQUIRED TOOLS

- BODY PRY TOOL
- 13MM SOCKET WRENCH
- 10MM SOCKET WRENCH
- 7/16" SOCKET WRENCH
- 7/16" COMBINATION WRENCH
- 3/32 ALLEN WRENCH
- 11/32 SOCKET WRENCH
- FLAT SCREW DRIVER
- ¼" & 3/16" DRILL BIT & DRILL
- ANGLE GRINDER WITH METAL CUT-OFF WHEEL
- BOX CUTTER OR RAZOR BLADE

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 | 50494-HW

IDENTIFICATION NUMBER	COMPONENT DESCRIPTION	QTY
50494-HW	PLASTIC LICENSE PLATE NUT	2
50494-HW	#10-24 X ¾" BLACK BUTTON HEAD CAP SCREW	8
50494-HW	10-24 CLIP ON BARREL NUT	8
50494-HW	¼"-20 X 1" HEX HEAD BOLT ZINC	10
50494-HW	¼"-20 NYLOCK HEX NUT ZINC	10
50494-HW	¼" FLAT WASHER ZINC	20
50494-HW	1/2"-13 X 4", HHCS , ZINC, GR8	4
50494-HW	1/2"-13 X 1", HHCS , ZINC, GR8	8
50494-HW	1/2-13 FINISHED HEX NUT STL ZINC	14
50494-HW	1/2 SAE FLAT WASHER GRADE 8 Z&Y	26
50494-HW	8-32 X 3/4 BUTTON SOCKET CAP ALLOY ZINC	4
50494-HW	#8-32 X NYLOCK, HEX NUT , ZINC, GR2	4
50494-HW	#8-SAE FLAT WASHER	4
50494-HW	1/2" BOLT RETAINER	4

DISASSEMBLY & INSTALLATION

1. From under the truck unplug bumper wire harness and trailer plug. Bumper harness is located on rear driver side of truck. Press black tab to release gray lever on connector, then rotate lever to fully disconnect harness. (Figure 1)

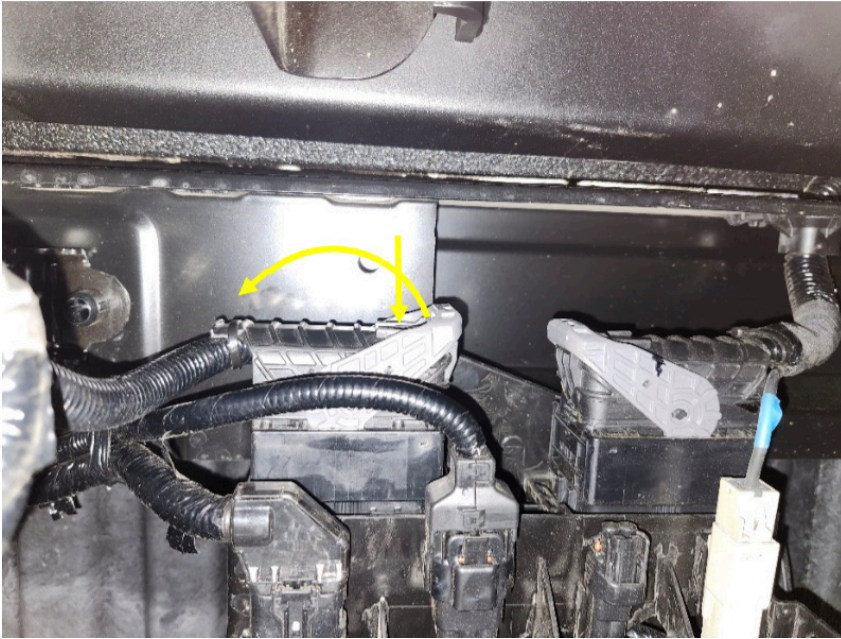


Figure 1

2. Use body pry tool to remove plastic covers on top of bumper and on bumper hitch step. (Figure 2 & 3)



Figure 2



Figure 3

3. Use a 13mm socket wrench to remove 3 bolts per side on top of bumper and 2 nuts on step of bumper. (Figure 4 & 5) Once bolts are removed, bumper can be removed from truck.



Figure 4

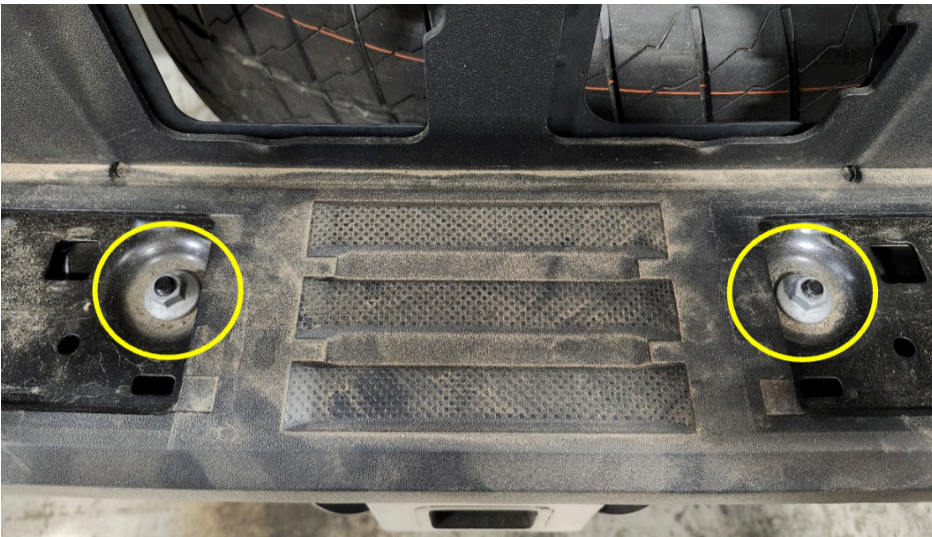


Figure 5

4. Unplug license plate tag light and remove from OEM bumper.
5. Press in the two clips on the trailer plug and push out to remove it from the bumper.

6. Using body pry tool remove all plastic pins from inside of left and right side of bumper to remove inner plastic layer of bumper. (Figure 6 & 7)

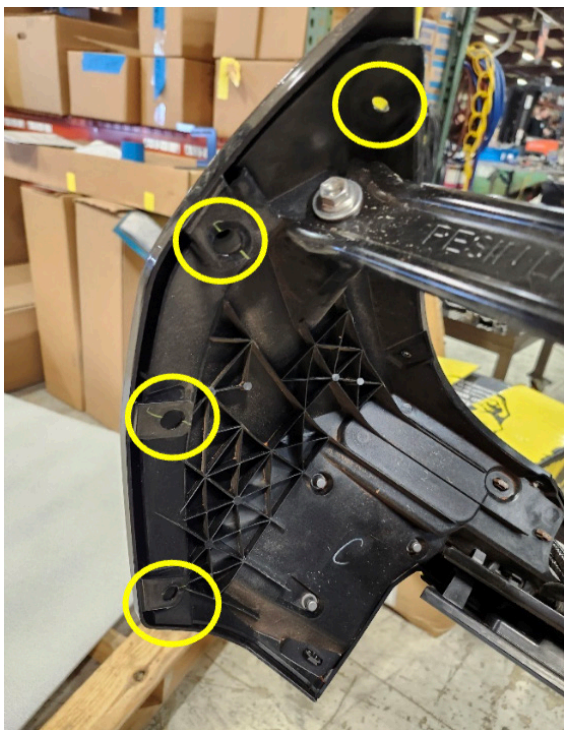


Figure 6



Figure 7

7. If equipped, remove the blind spot sensors from the OEM bumper using a 10mm socket wrench to remove the three bolts. (Figure 8) Be sure to note the side of the truck that sensor is removed from before unplugging and removing.

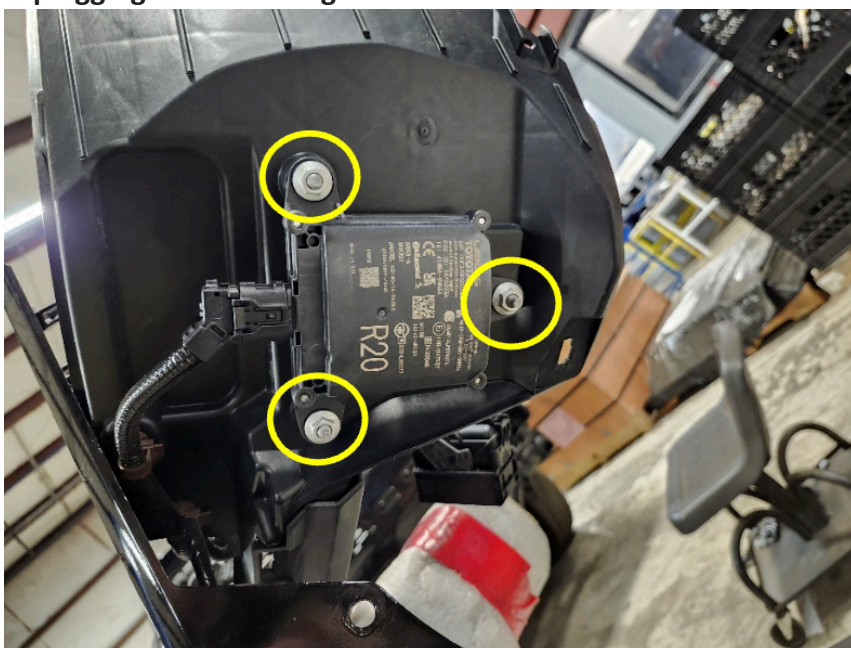


Figure 8

8. Mark the location and orientation of all four (4) sensors in bumper. Unclip each sensor from its housing and remove from bumper but carefully prying clips open and pulling out sensor. (Figure 9)

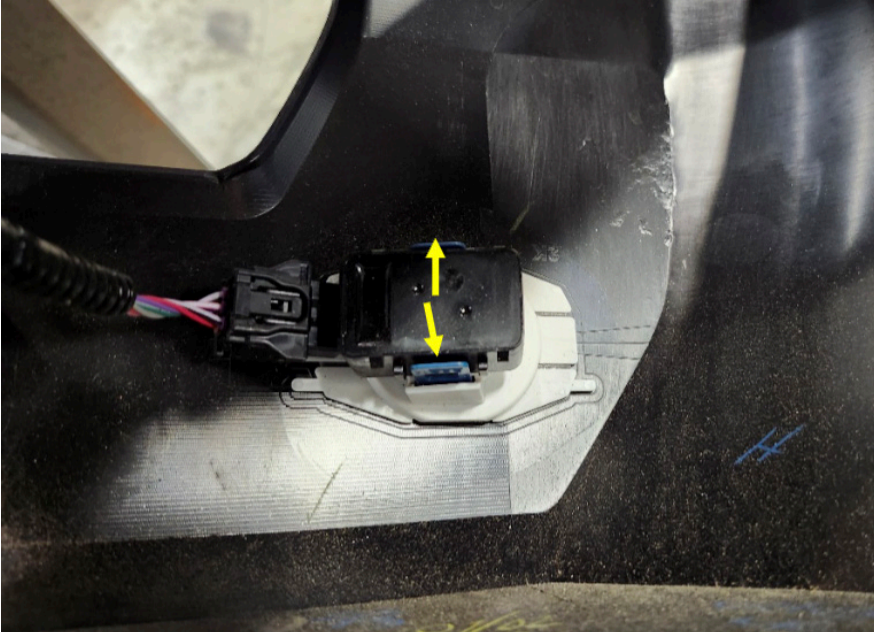


Figure 9

9. Remove sensor housings from bumper by carefully prying sensor and separating adhesive from inside of bumper surface. A box cutter or razor blade may be helpful to separate adhesive.
10. Using epoxy packets (61632) install sensor housings into new bumper (23317) in same locations and orientation as OEM bumper. Allow epoxy to dry and then install sensors.

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11. Remove the plastic wire shroud from the blind spot monitoring sensor plugs by unclipping the 3x clips around the outside using a flat head screwdriver. (Figure 10-11)

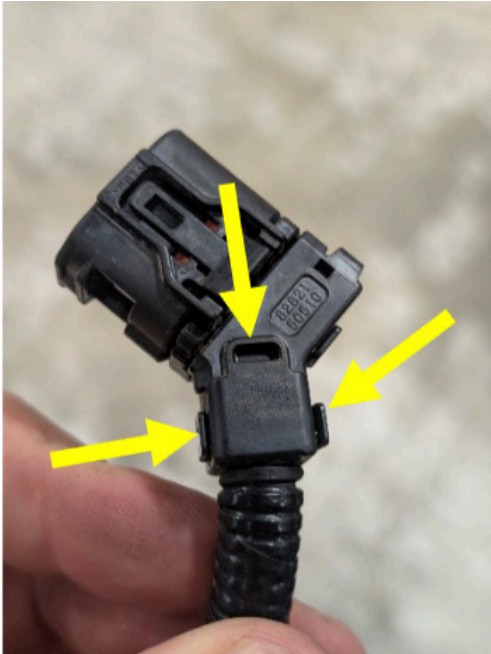


Figure 10

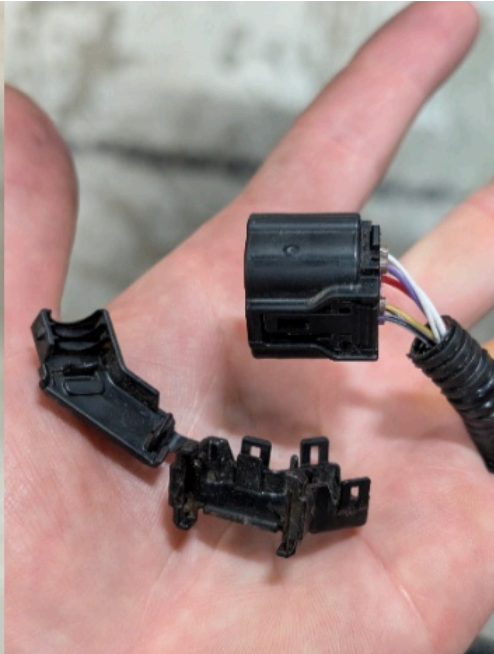


Figure 11

12. Using three (3) $\frac{1}{4}$ " bolts, $\frac{1}{4}$ " nuts and six (6) flat washers [50494-HW], install blind spot monitoring sensors (BSM) onto the mounting brackets [23471]. Insert plug from Step 11 into the BSM sensors before installing brackets into bumper shell. (Figure 12)

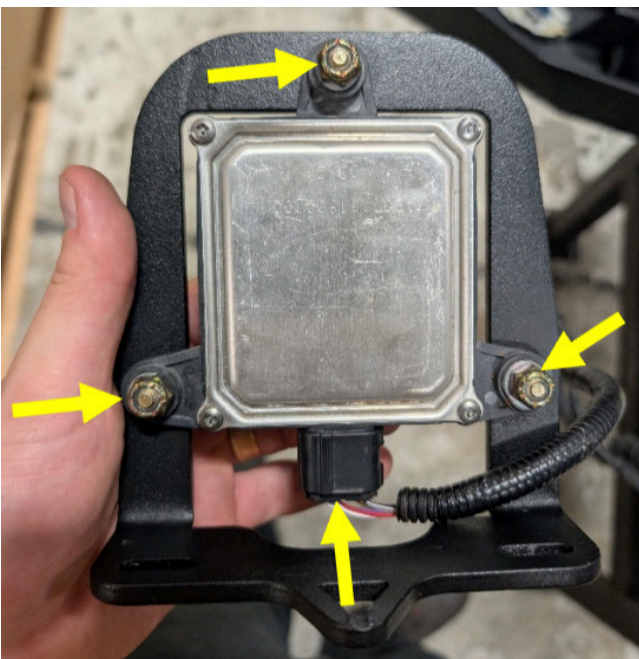


Figure 12

13. Hold black plastic sheet to the inside of the bumper making sure to cover the BSM hole completely. Mark and drill holes using a $\frac{1}{4}$ " drill bit using the bumper holes as reference. Install the sheet into the bumper using the provided 10-24 black button head screws and clip nuts [50494-HW]. Figure 13.

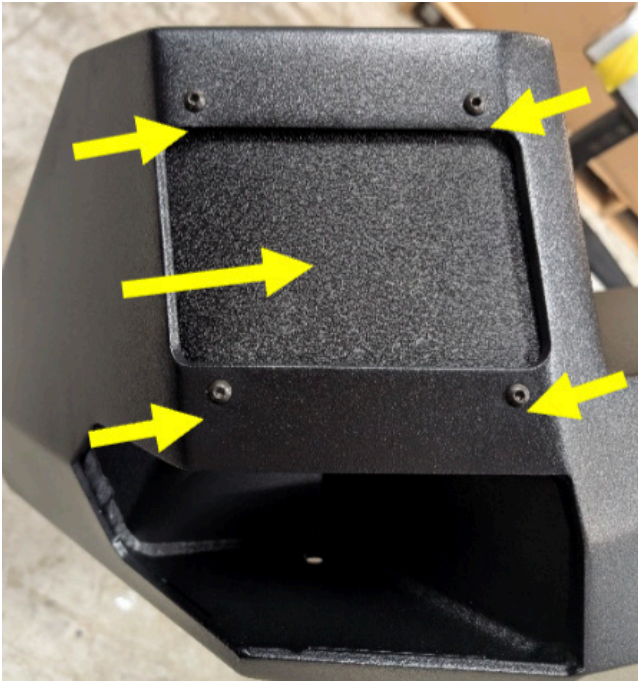


Figure 13

14. Install the BSM sensors and brackets from Step 12 into the DS and PS mounting locations in the Fab Fours bumper using the provided 4x $\frac{1}{4}$ " HHCS with washers and nuts. Make sure to keep edge of bracket parallel with the edge of the step box. (Figure 14-15)

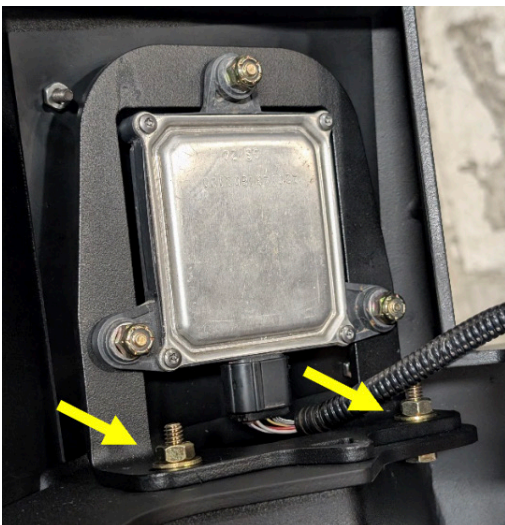


Figure 14

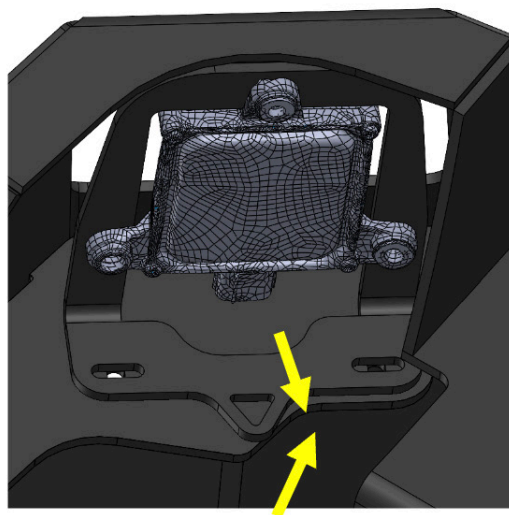


Figure 15

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15. Using a cutting tool, trim the plastic shroud underneath the taillight as shown in Figure 16.

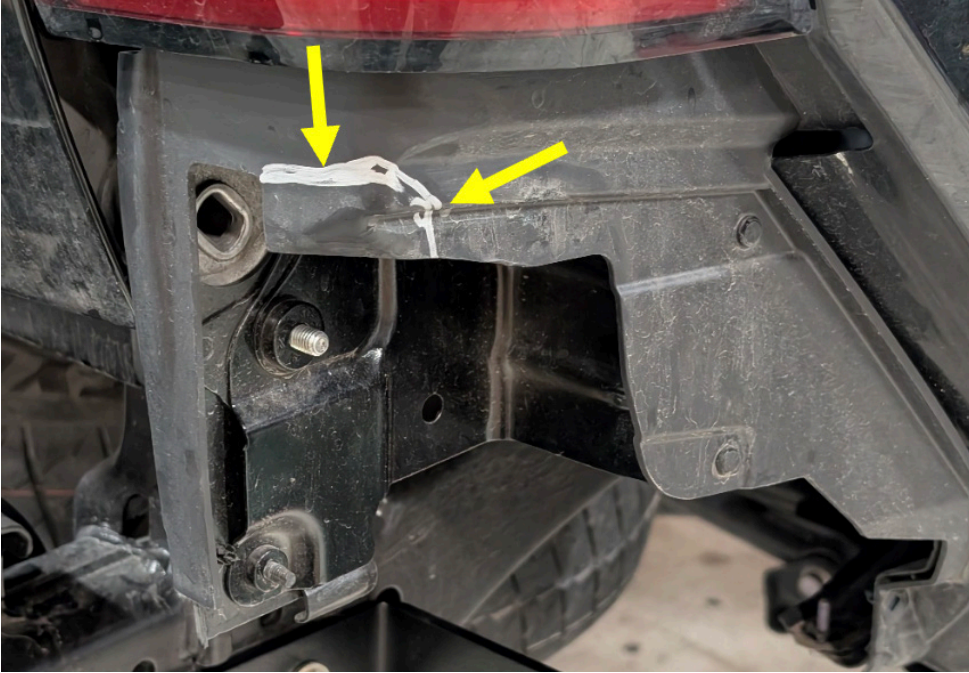


Figure 16

16. Install license plate tag light into new bumper using the provided epoxy packets [61632]. (Figure 17)



Figure 17

17. Install the trailer plug into the bumper by first removing the silver clips from the plug using a straight screwdriver.

18. Hold the plug into the bumper and use a marking tool to mark the four (4) holes in the bumper. Use a 3/16" drill bit to drill holes in the plug. Use four (4) #8 bolts, washers and nylock nuts [50494-HW] to fasten trailer plug into bumper. (Figure 18)

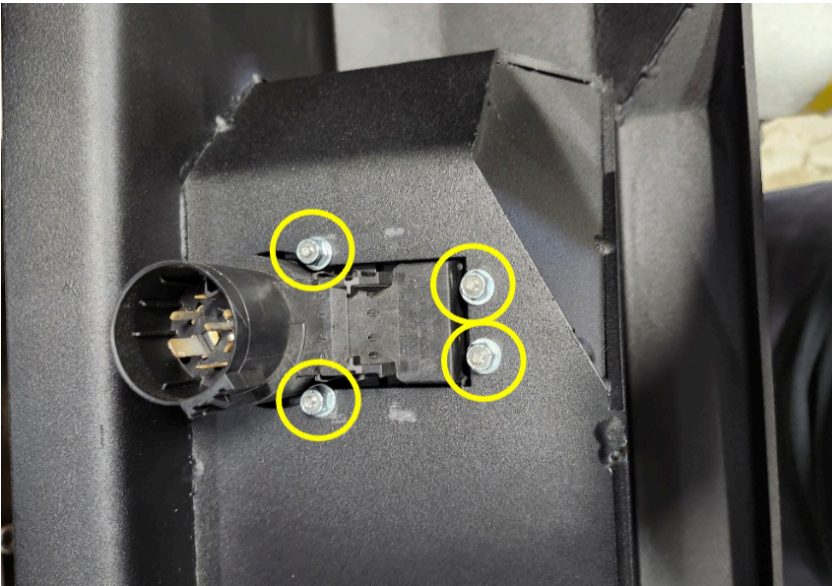


Figure 18

19. Connect all sensors and the tag light to bumper wiring harness.

20. Using cutoff wheel, remove small flange with stud from both sides of the OEM hitch. (Figure 19)



Figure 19

21. Remove two (2) rear most plastic plugs on inside and outside of frame using hammer and straight screwdriver. Repeat for both sides of truck. (Figure 20)

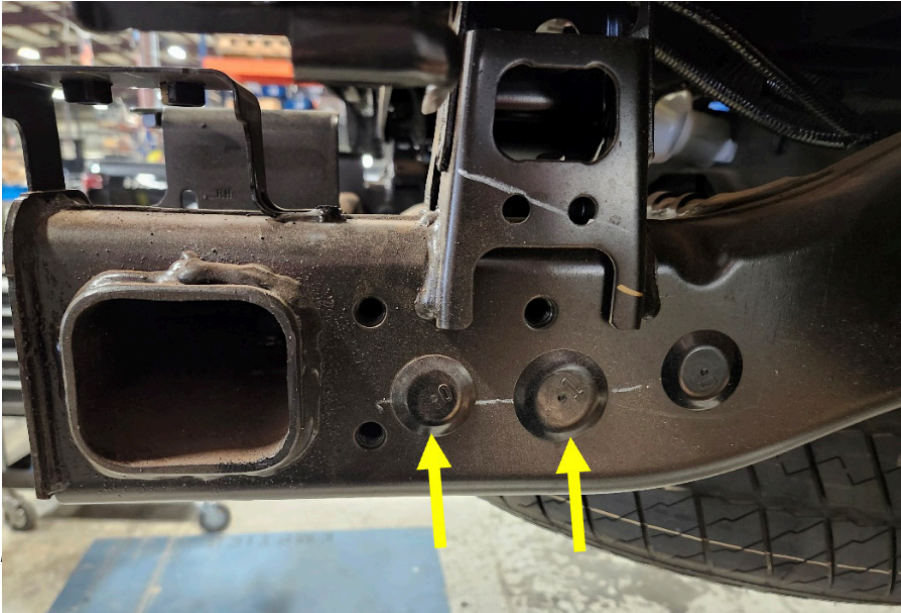


Figure 20

22. Place intermediate brackets [23318 for PS & 23319 for DS] over rear trailer hitch cross bar as shown in (Figure 21)

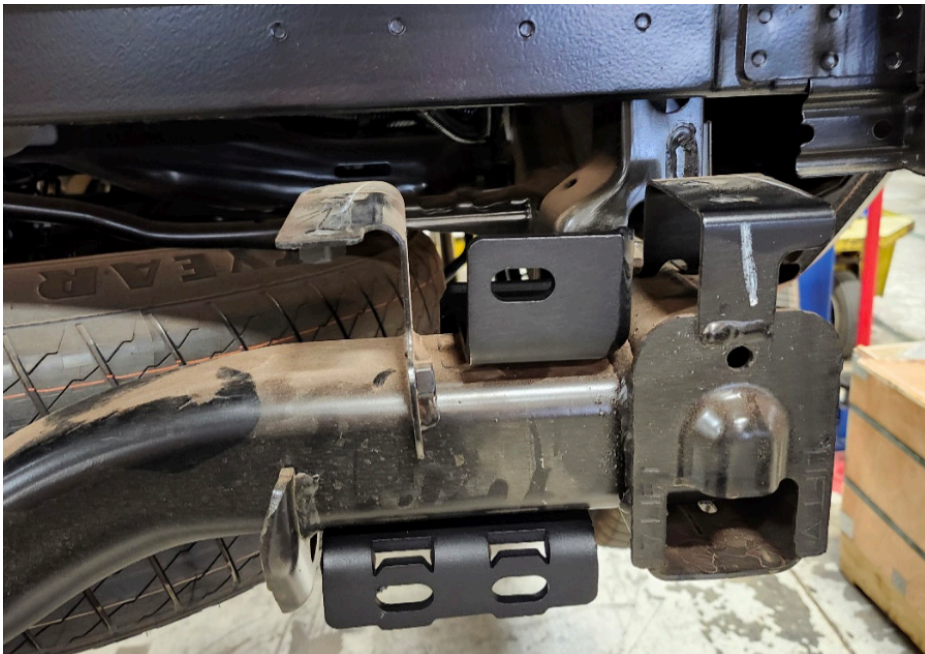


Figure 21

23. Attached the brackets from Step 20 to the hitch frame using 2x of the provided 1/2" x 1.5" HHCS with flat washers. Insert the 2x provided nut plates [23324] inside the hitch frame openings until you can loosely install the 1/2" HHCS through the bracket and frame. (Figure 22-23)



Figure 22



Figure 23

24. Place the provided 2x 1/2" bolt strips [20296] into the base of the DS and PS bumper brackets along with 2x 1/2" HHCS with flat washer on the top of the brackets. Use the provided 1/2" retaining washers to hold the bolt strips and bolts in place. (Figure 24)

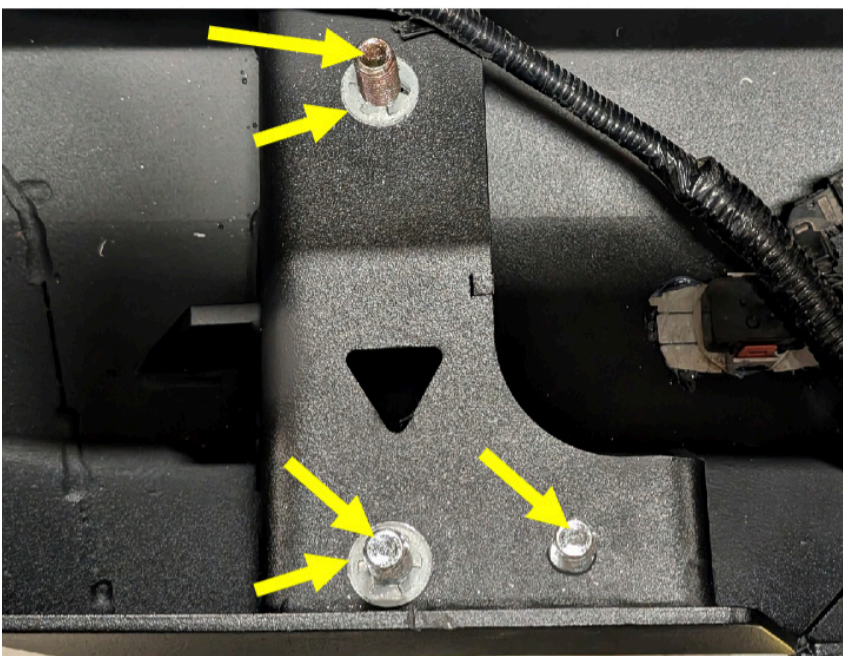


Figure 24

25. With assistance, hold the bumper up to the brackets and insert the bolts into the mounting brackets. Used the provided 1/2" nuts and washers to loosely secure the bumper in place. (Figure 25-26)



Figure 25



Figure 26

26. Insert 4" long 1/2" bolt with flat washer through the [23318-23319] brackets and frame. Install the L-brackets on the outside of the frame and attached them to the bumper shell with the remaining 4x 1/2"x 1.5" HHCS, flat washers and nuts. (Figure 27-28)



Figure 27



Figure 28

27. Adjust side to side alignment of bumper as needed. Tighten all $\frac{1}{2}$ " hardware with $\frac{3}{4}$ " wrench and socket, starting with bolts mounting intermediate brackets to the frame. Then adjust the wings as desired and fully tighten the $\frac{1}{2}$ " hardware on the L-brackets.

28. Plug in the sensor harness from step 1 and install the two (2) plastic license plate nuts [50494-HW] by pushing them into the bumper. (Figure 29)

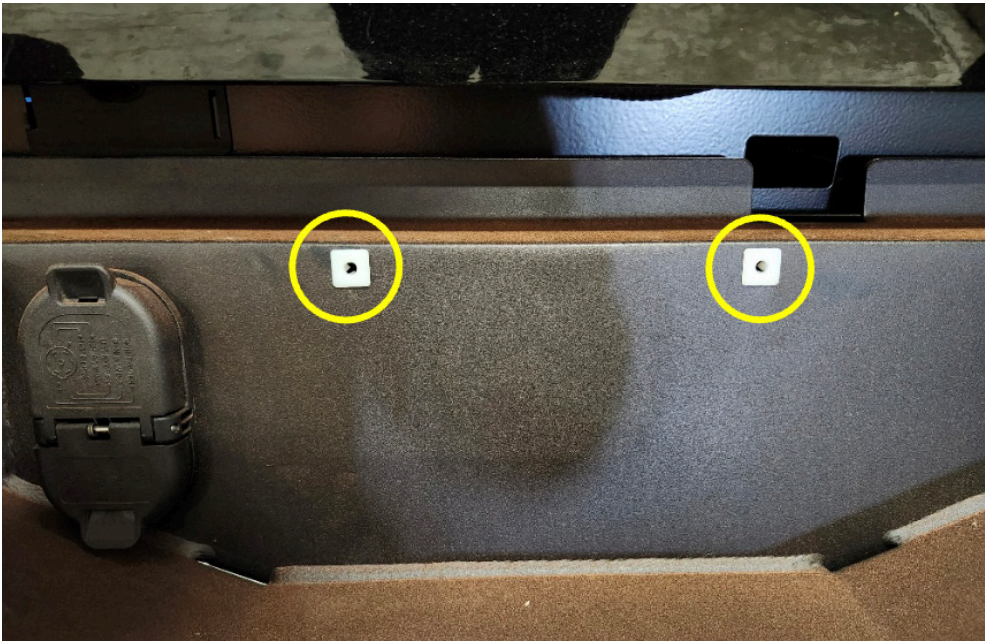


Figure 29

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

