



INSTALLATION MANUAL
REAR BUMPER
PRODUCT NUMBER: Y6751
APPLICATION: 2024 TOYOTA LAND CRUISER



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



23420 - REAR BUMPER



23421



23422



61784 - BLACK
PLASTIC SHEET (2)

61632 EPOXY QTY:2



EXPLODED VIEW

REQUIRED TOOLS

- 10MM SOCKET WRENCH
- 12MM SOCKET WRENCH
- 13MM SOCKET WRENCH
- 17MM SOCKET WRENCH
- 3/4" SOCKET WRENCH
- 3/4" COMBINATION WRENCH
- 1/8" ALLEN WRENCH
- SOCKET EXTENSION AND SWIVEL
- PHILLIPS-HEAD SCREWDRIVER
- BODY PANEL PRY TOOL
- SMALL RECIPROCATING SAW
- PLIERS
- SILVER MARKER
- MASKING TAPE
- DRILL
- 1/4" DRILL BIT
- UTILITY KNIFE

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 | 50514-HW

| IDENTIFICATION NUMBER | COMPONENT DESCRIPTION | QTY |
|--------------------------|--|-----|
| 50514-HW | 1/2"-13 X 6-1/2", HEX HEAD CAP SCREW, YELLOW-ZINC, GRADE 8 | 2 |
| 50514-HW | 1/2"-13, NYLON INSERT LOCK NUT, YELLOW-ZINC, GRADE 8 | 2 |
| 50514-HW | 1/2", FLAT WASHER, YELLOW-ZINC, GRADE 8 | 4 |
| 50514-HW | 10-24 X 3/4", SOCKET HEAD CAP SCREW, BLACK SS | 8 |
| 50514-HW | 10-24, CLIP ON BARREL NUT | 8 |
| 50514-HW | M8-1.25 X 25MM, HEX FLANGE BOLT, YELLOW-ZINC, CLASS 10.9 | 14 |

DISASSEMBLY & INSTALLATION

1. In the driver side and passenger side rear wheel wells, use a 10mm socket and pry tool to remove the 4x screws and 1x push pin per side. Figure 1.



Figure 1

2. Finish removing the mud flaps by use a 10mm socket to remove 1x 10mm screw at the base of the flap on both driver and passenger sides. Figure 2.



Figure 2

3. Once the mud flaps have been removed, use a pry tool to remove the 1x push pin located at the bottom of the rear flares. Figure 3.



Figure 3

4. Carefully begin to pull the rear flares away from the truck starting at the bottom. Work your way to the top of the OE bumper and remove the 1x push pin with a pry tool once visible. Figure 4.



Figure 4

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5. Carefully remove the rear hitch cover if equipped by pulling it away from the OE bumper. Once removed, use a pry tool to remove the 2x push pins located by the hitch. Figure 5.

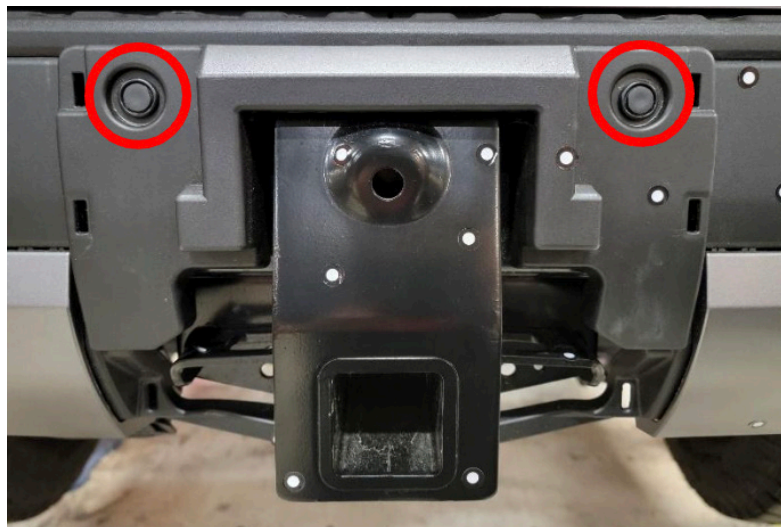


Figure 5

6. Use a 10mm socket to remove the 2x screws located underneath the OE bumper. Figure 6.

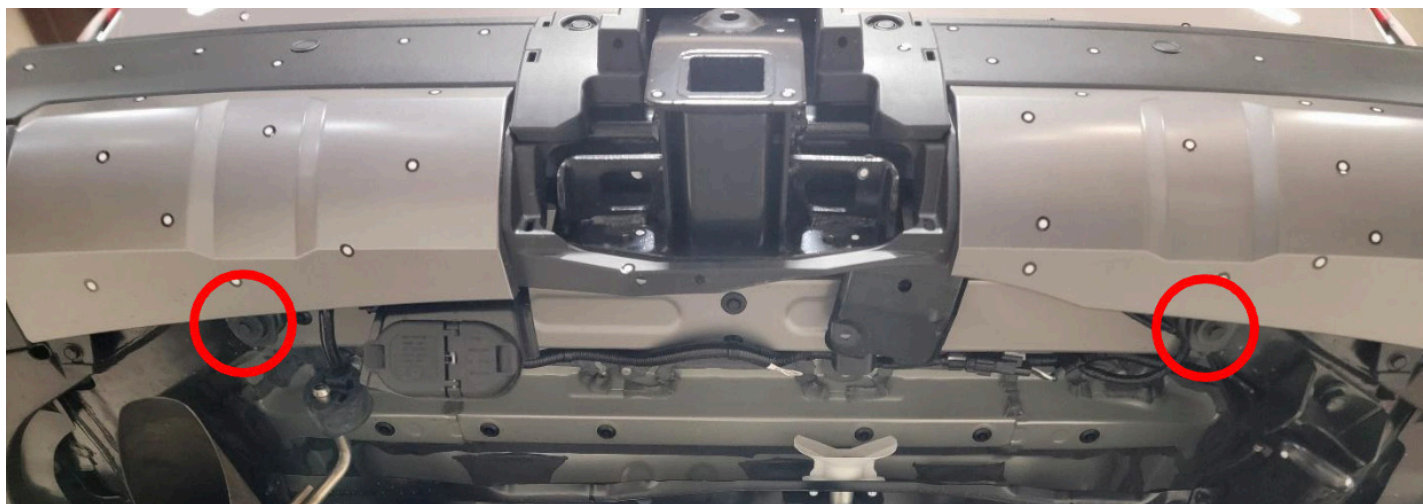


Figure 6

7. Using your hands and a pry tool, carefully remove the OE bumper top deck. Figure 7.



Figure 7

8. Using your hands and a pry tool, carefully remove the plastic rear trim piece behind the OE bumper top access mounting bolts. Figure 8.



Figure 8

9. Use a 10mm socket to remove the 6x 10mm screws located behind the plastic cover removed during step 8. Figure 9.

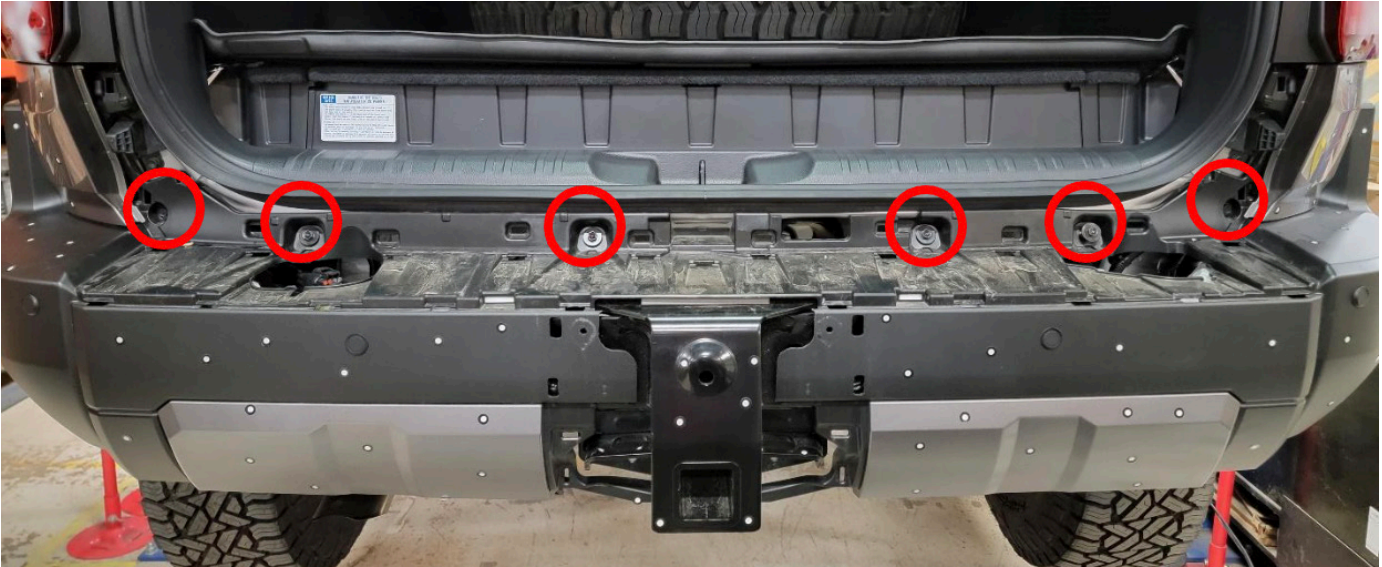


Figure 9

10. Use a 10mm socket to remove the 3x 10mm screws located on both the driver and passenger side lower OE bumper wings. Figure 10.



Figure 10

11. Carefully remove the plastic covers located underneath the taillights by pulling them away from the vehicle. Figure 11.



Figure 11

12. Carefully remove the plastic covers located beside the taillights by pulling them away from the vehicle. Figure 12.



Figure 12

13. Use a 10mm socket to remove the 2x 10mm screws underneath the driver side and passenger side taillights. Figure 13.

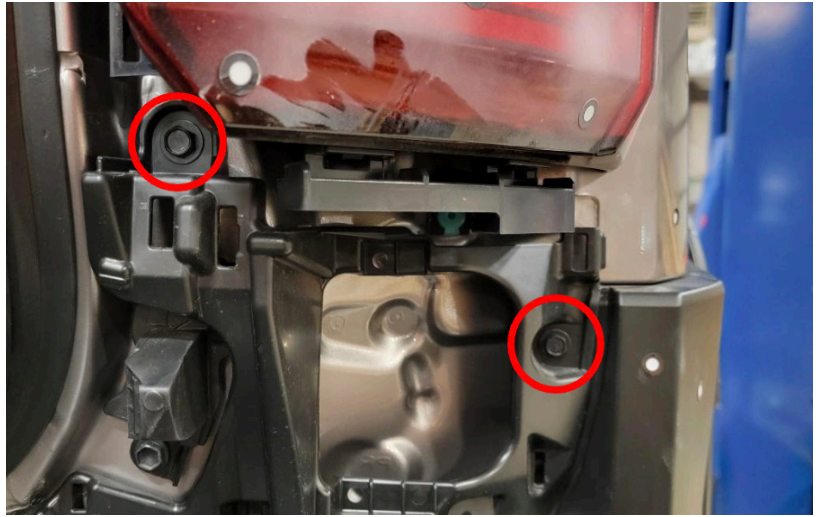


Figure 13

14. The OE bumper will be loose from the vehicle at this time, with assistance, pull the bumper away slightly and disconnect the driver side and passenger side wiring harnesses. Once disconnected remove the OE bumper from the vehicle and set aside. Figure 14-15.



Figure 14



Figure 15

15. Remove the foam from the top of the rear frame. Figure 16.



Figure 16

16. Use a 12mm socket to remove the 5x bolts holding the driver and passenger side crash bars onto the rear frame. Figure 17.

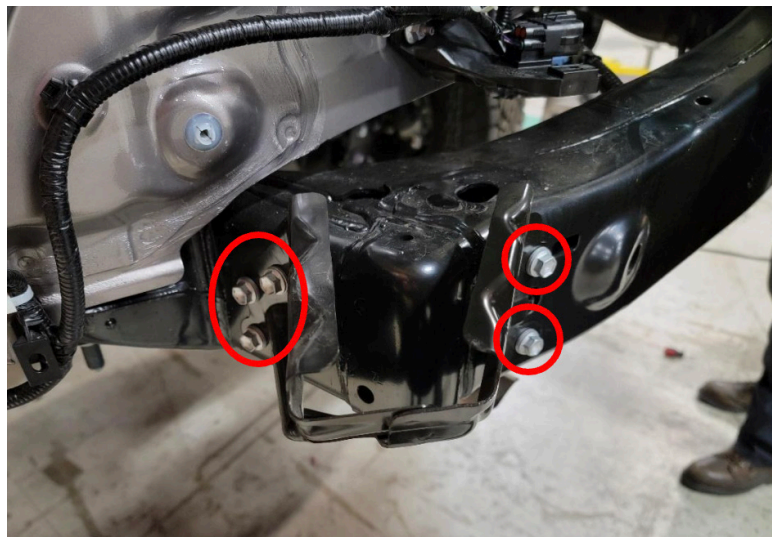


Figure 17

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17. Use a Phillips-head screwdriver to remove the driver and passenger side bumper wing brackets.
Figure 18.

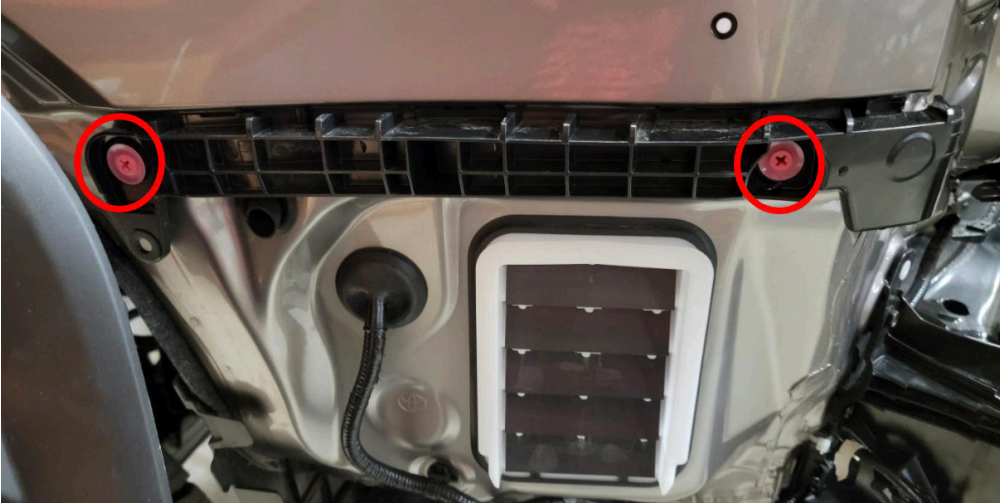


Figure 18

18. Using a 17mm socket wrench, remove the two (2) bolts in the factory tow hook to remove it from the vehicle. Figure 19.



Figure 19

19. Using pliers, carefully bend over the pinch weld seam at the bottom of the body toward the center of the vehicle at a 90-degree angle. Figure 20.



Figure 20

20. Using a panel pry tool, remove the push pins in the rear inner fender liners to remove them from the vehicle. Figure 21-22.

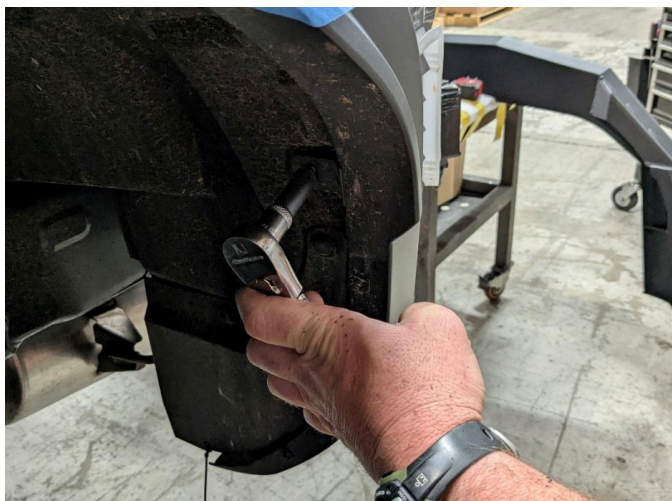


Figure 21



Figure 22

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21. Using masking tape, make a line parallel with the edge of the body across the fender flare. Figure 23.

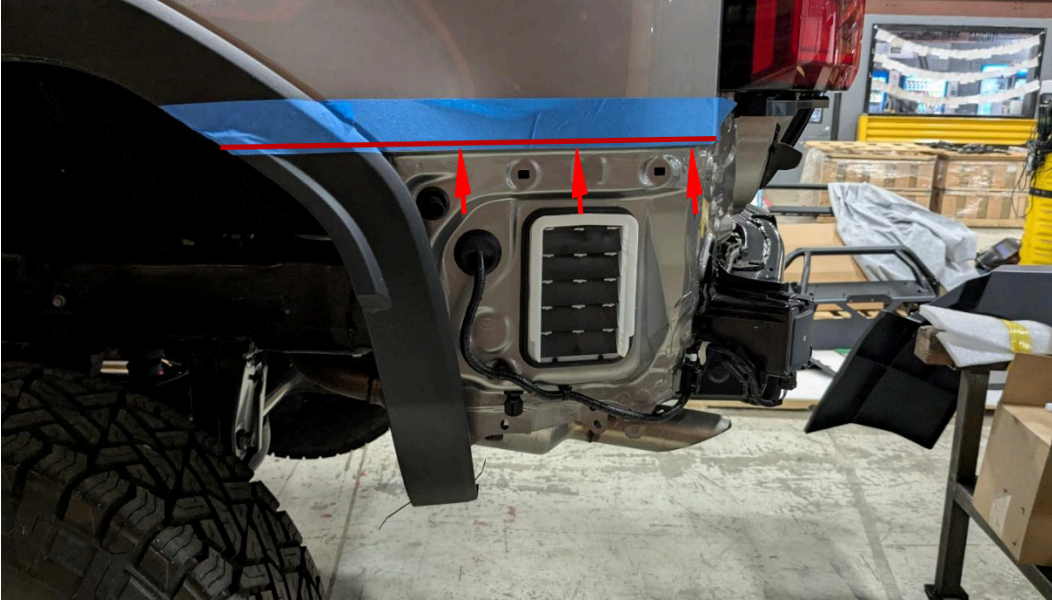


Figure 23

22. Using a small reciprocation saw, cut the fender flare along the previous marked line. Figure 24.



Figure 24

23. Using a silver marker, make a cut line on the factory rear bumper as shown. Figure 25-26

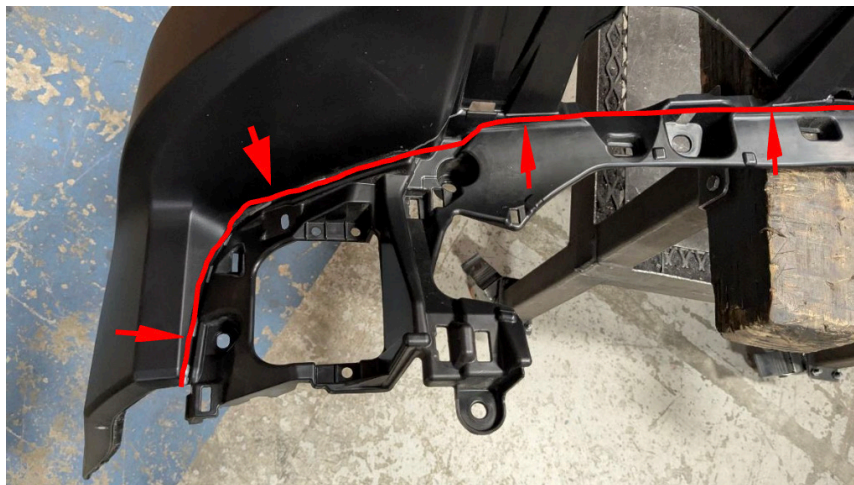


Figure 25



Figure 26

24. Using a 10mm socket wrench, reinstall the cut factory bumper back onto the vehicle as it was removed. Then, reinstall the plastic pieces below and beside the taillights by pushing them back into place to reengage the clips. Figure 27.



Figure 27

25. Using a small reciprocation saw, trim off the tab on the passenger's side of the bumper bolt cover. Figure 28.



Figure 28

26. Reinstall the bumper bolt cover onto the vehicle by pushing the clips in place. Figure 29.



Figure 29

27. Apply the supplied epoxy, to the face of the parking sensor housings then reinstall them into the new bumper in the same location and orientation from which they were removed from the factory bumper. Figure 30-31.

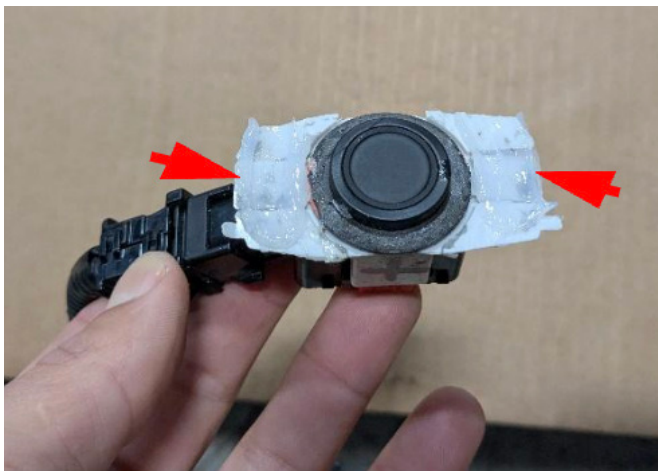


Figure 30



Figure 31

28. Using a utility knife, trim the provided black plastic sheets to 3.5" wide. Figure 32

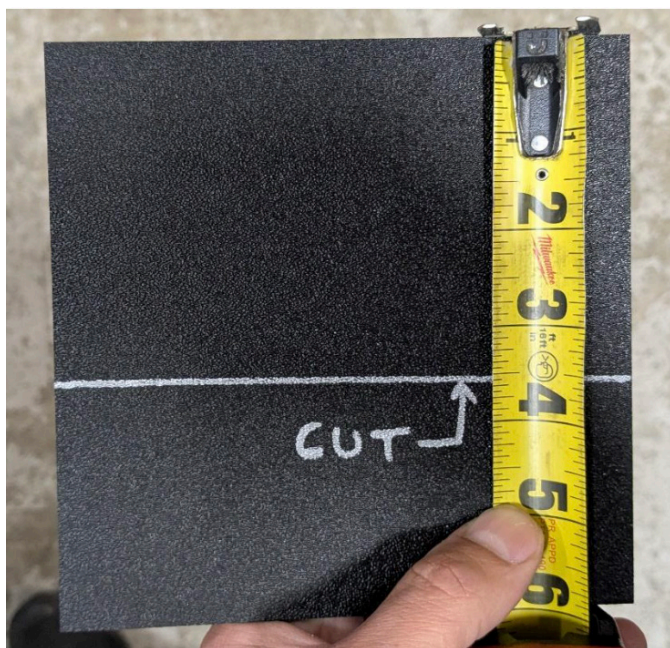


Figure 32

29. Using a silver marker, mark the four (4) holes in the bumper shell onto the textured side of the black plastic sheet. Using a 1/4" drill bit, make a hole at each of the previously marked spots on the black plastic sheet. Figure 33.



Figure 33

30. Install the eight (8) provided barrel nuts onto the black plastic sheets. Figure 34.



Figure 34

31. Using a 1/8" allen wrench, install four (4) of the provided #10 screws into each of the black plastic sheets to attach them to the bumper shell. Figure 35.

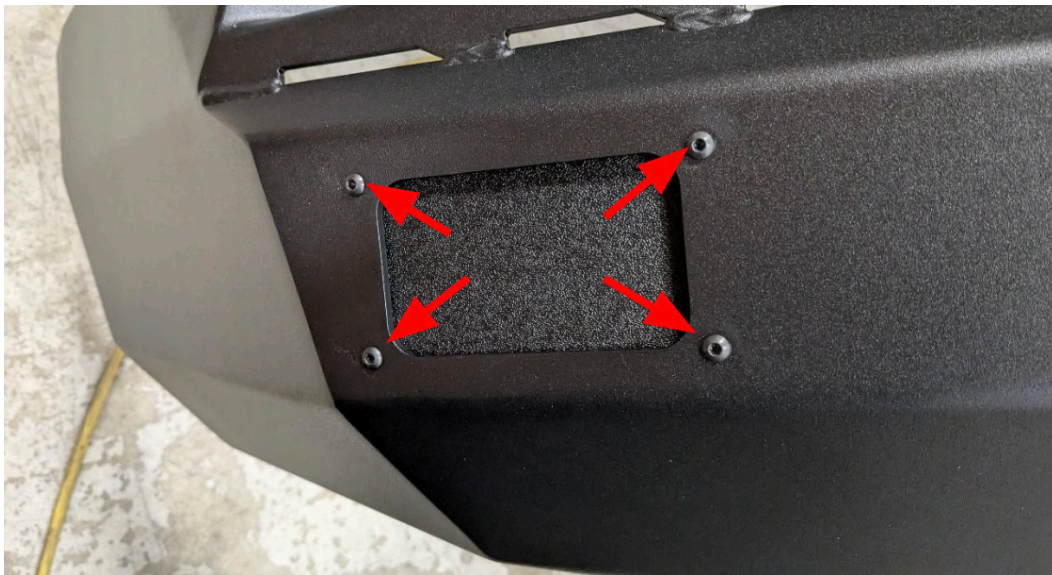


Figure 35

32. Install the driver's side bracket (Part#: 23422) to the frame using the one (1) 1/2" hex head cap screw, flat washers, nuts, and two (2) M8 hex flange screws. Repeat for the passenger side with (Part#: 23421). Figure 36-37.



Figure 36



Figure 37

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33. Tighten the previously installed M8 hardware with a 13mm socket wrench, swivel and extension. Tighten the 1/2" hardware with a 3/4" socket wrench and a 3/4" combination wrench. Figure 38.



Figure 38

34. With assistance, hold the bumper up to the vehicle and reconnect the wiring harness.
35. Install five (5) of the M8 flange head screws through the mounts in the bumper shell to the previously installed brackets. Figure 39.

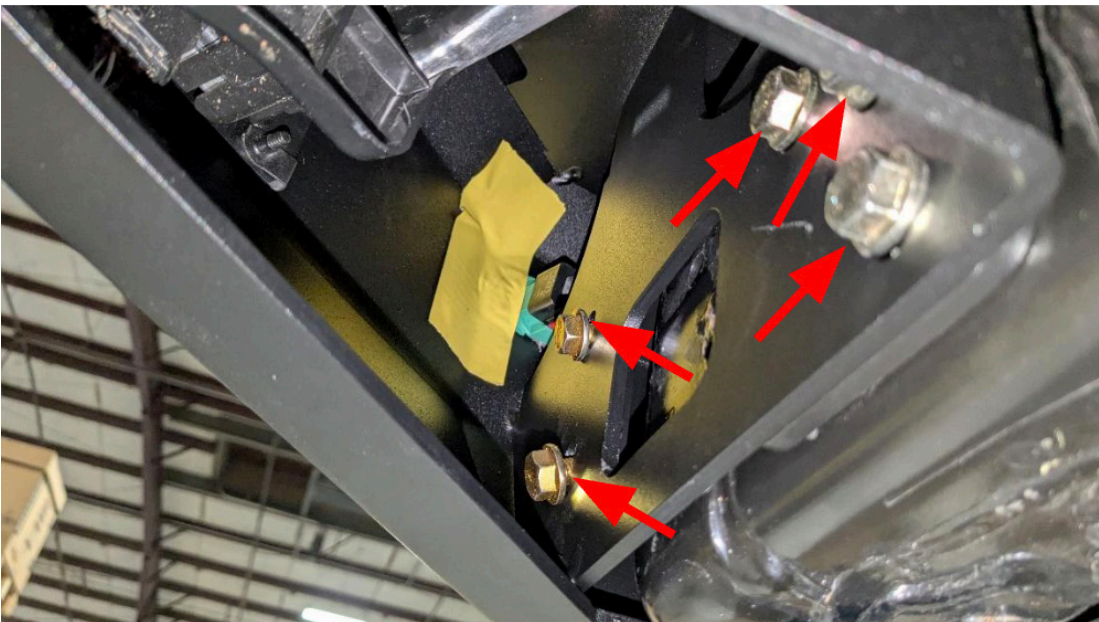


Figure 39

36. Align the bumper to the vehicle and use a 13mm socket wrench to tighten the previously installed M8 hardware. Figure 40.



Figure 40

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

