



INSTALLATION MANUAL
PREMIUM REAR BUMPER
PRODUCT NUMBER: Y685X
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.



TABLE OF CONTENTS

2	SAFETY / DISCLAIMER
3	TABLE OF CONTENTS
4	A MESSAGE FROM THE OWNER
5	GETTING STARTED
6	PROVIDED MATERIAL
8	INSTALLATION
25	CONTACT

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



23476 – BUMPER SHELL



23421



23422



23477



23478



EXPLODED VIEW

REQUIRED TOOLS

- 10MM SOCKET WRENCH
- 12MM SOCKET WRENCH
- 13MM SOCKET WRENCH
- 17MM SOCKET WRENCH
- 3/4" SOCKET WRENCH
- 3/4" COMBINATION WRENCH
- SOCKET EXTENSION AND SWIVEL
- BODY PANEL PRY TOOL
- SMALL RECIPROCATING SAW
- SILVER MARKER

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



Figure 1

2. Using a panel pry tool, remove the black plastic step pad on the rear bumper. (Figure 2)

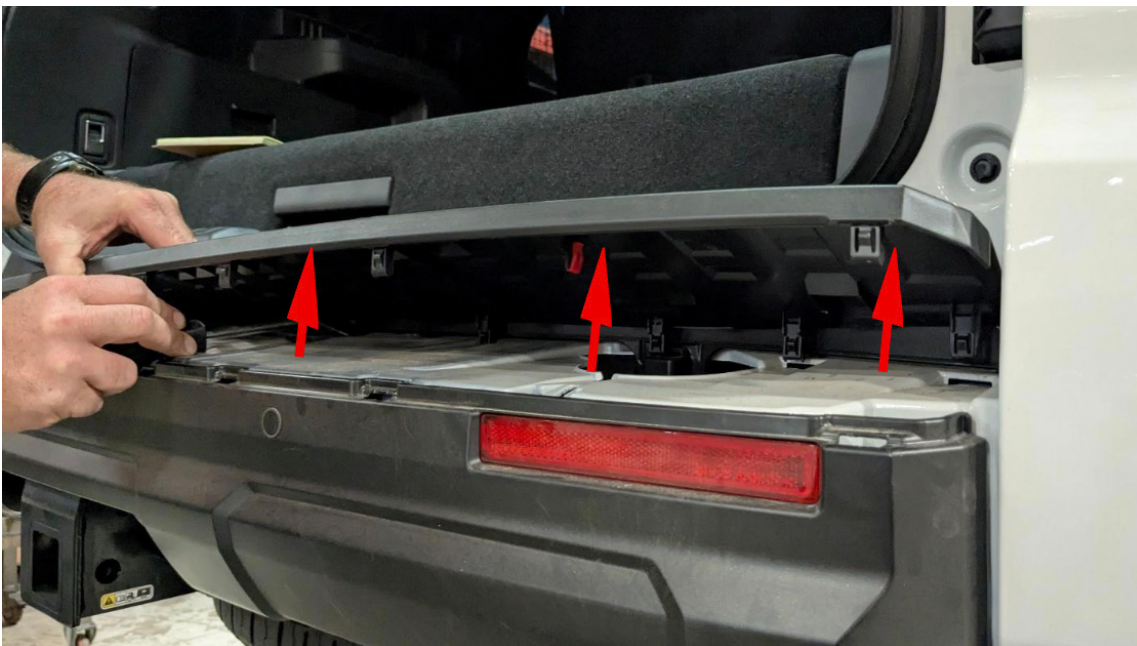


Figure 2

3. Remove the filler panel at the top of the bumper by pulling it outward. (Figure 3)



Figure 3

4. Using a panel pry tool, remove the four (4) push pins from the underside of the bumper facia. Using a 10mm socket wrench, remove the three (3) screws. Remove the filler panel at the top of the bumper by pulling it outward. (Figure 4)

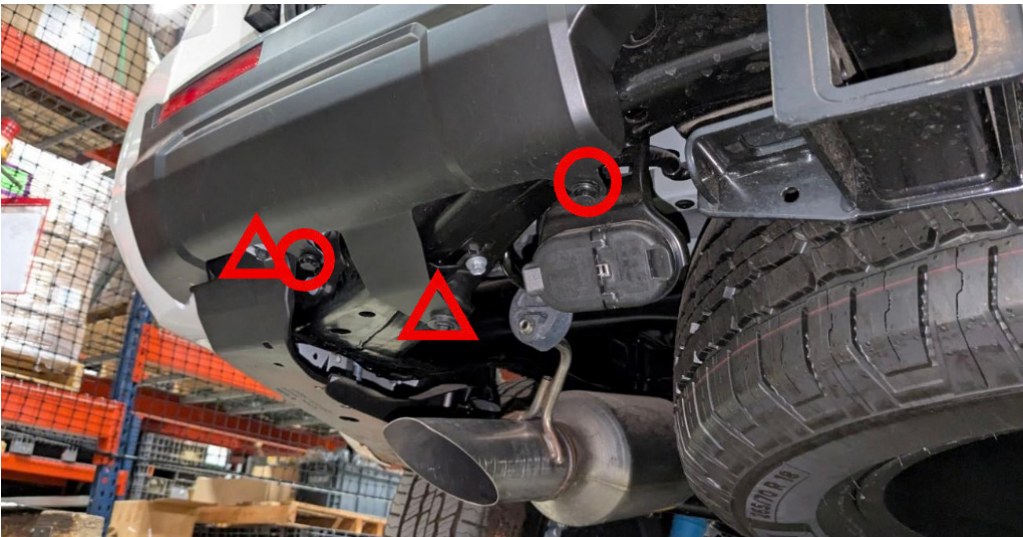


Figure 4

5. Remove the filler panels inside each of the taillights by pulling them outward. (Figure 5)



Figure 5

6. Using a panel pry tool, remove the three (3) push pins from each fender flare. Using a 10mm socket wrench, remove the remaining screw. Pull outward on the flare to release the clips and remove the flare from the vehicle. (Figure 6-8)



Figure 6



Figure 7



Figure 8

7. Using a panel pry tool and 10mm socket wrench, remove the two (2) push pins and one (1) screw in the face of each inner fender liner. (Figure 9)



Figure 9

8. Using a 10mm socket wrench, remove the four (4) screws in the plastic panels below the quarter panels. (Figure 10)

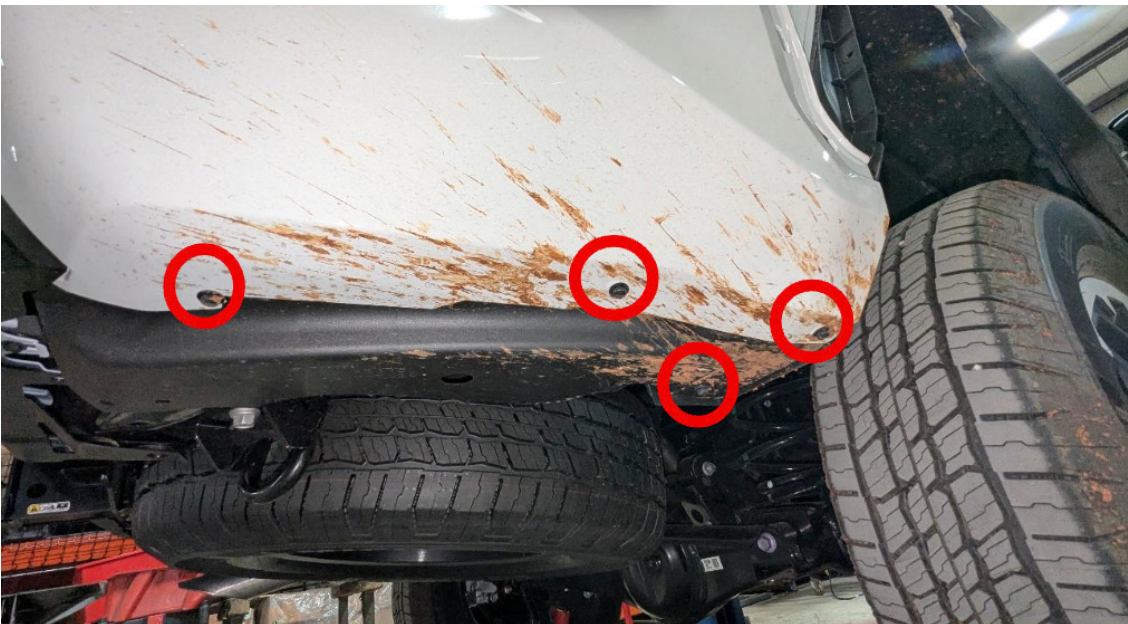


Figure 10

9. Using a 10mm socket wrench, remove the eight (8) screws across the back of the rear fascia. (Figure 11)



Figure 11

10. Disconnect the two (2) bumper wiring harness. (Figure 12-13)



Figure 12



Figure 13

11. Use a panel pry tool to remove the push pin at the wheel well of the rear fascia. Pull outward on the rear fascia at the wheel wells to release the clips along the quarter panel and remove the fascia from the vehicle. (Figure 14)



Figure 14

12. Then remove the foam crash pad. (Figure 15)

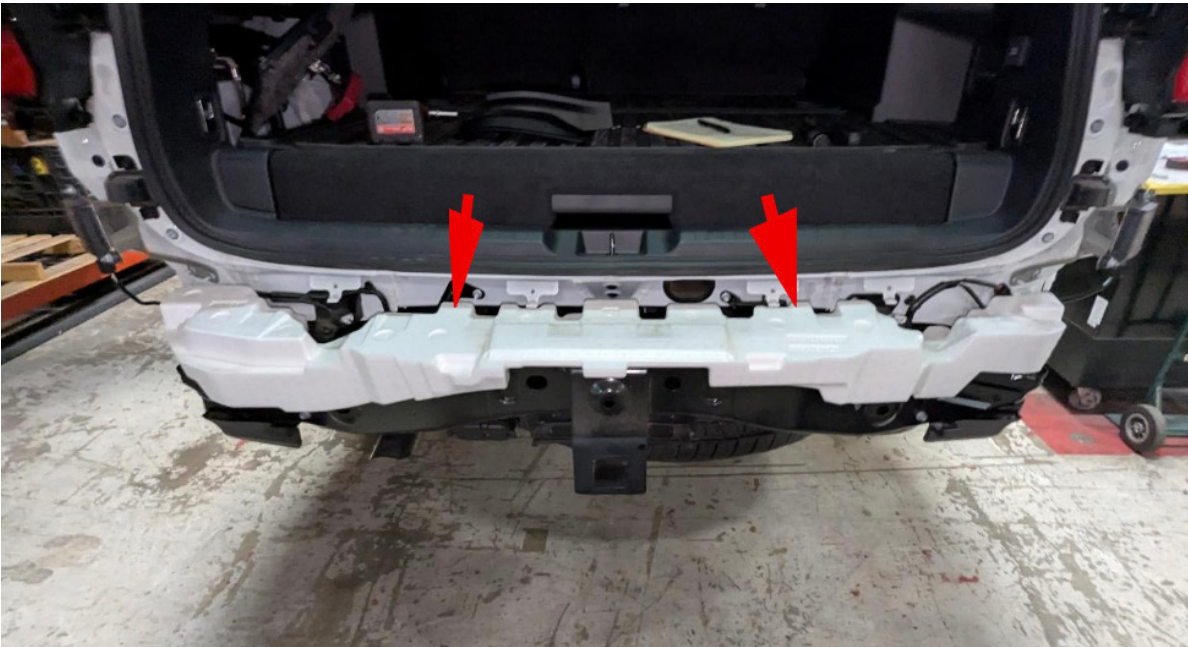


Figure 15

-
13. Disconnect the two (2) parking sensor harness plugs on each side of the rear of rear of the vehicle. (Figure 16-17)

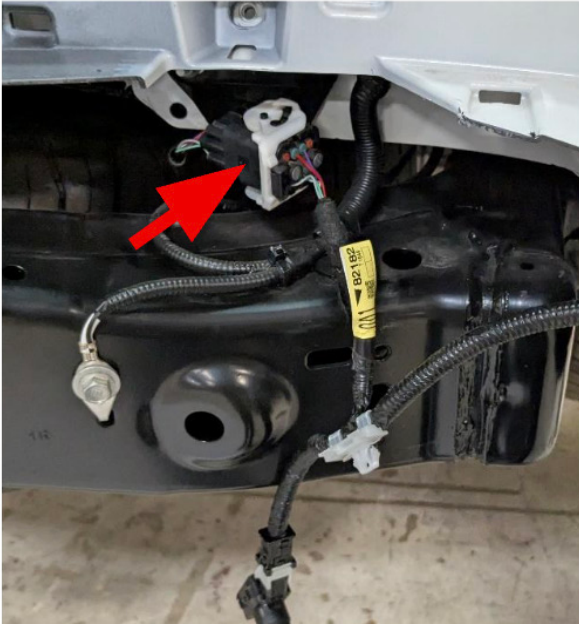


Figure 16



Figure 17

14. Using a 12mm socket wrench, remove the five (5) screws from each crash bracket. (Figure 18)

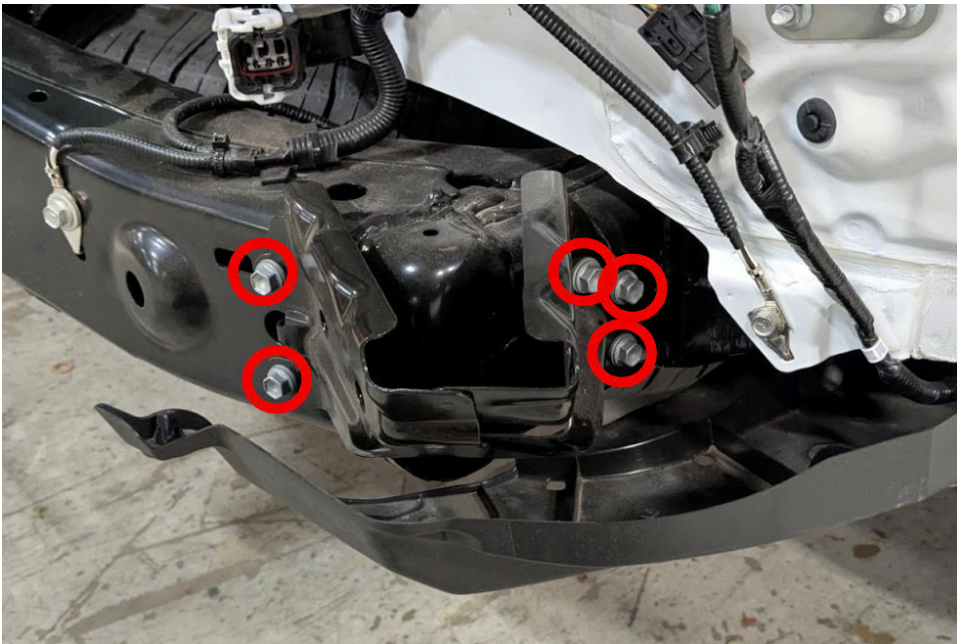


Figure 18

15. Using a silver sharpie, note the location and orientation of each parking sensor in the rear fascia. Pull outward on the two tabs to carefully release each sensor from its housing. (Figure 19)



Figure 19



Figure 20

16. Using a panel pry tool, release and remove the white plastic tabs from the inside of the rear fascia to separate the black plastic cover from the rear fascia. (Figure 21-23)

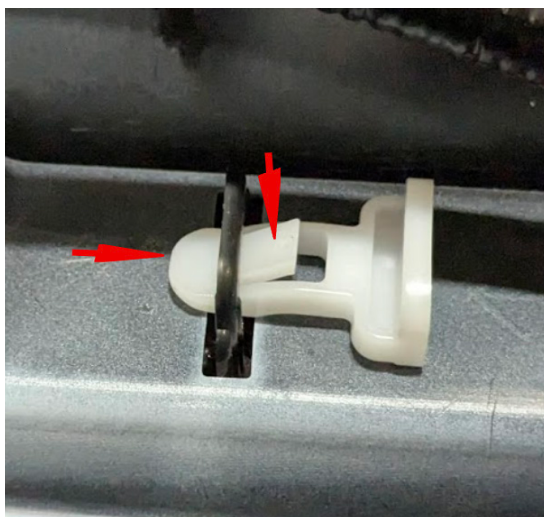


Figure 21

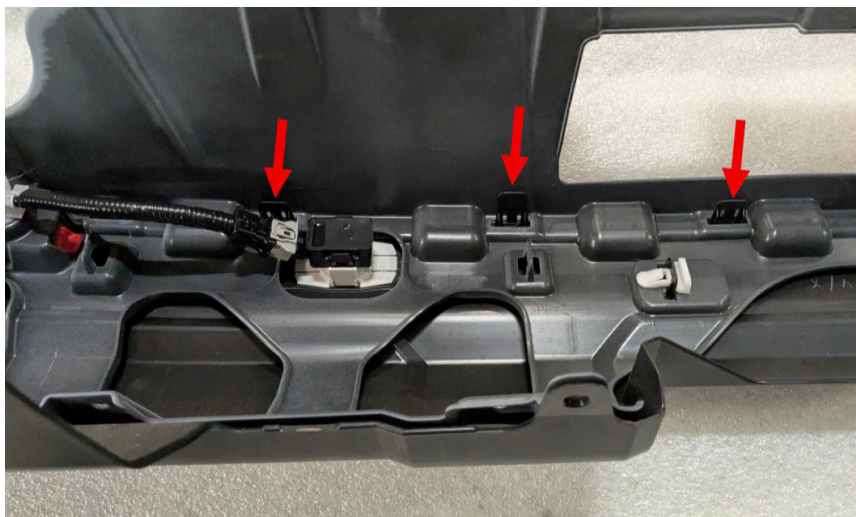


Figure 22



Figure 23

-
17. Using a panel pry tool, carefully pry the parking sensor housing from the inside of the fascia. (Figure 24)



Figure 24

18. Using a panel pry tool, carefully remove the sensor harness retaining clips. (Figure 25)

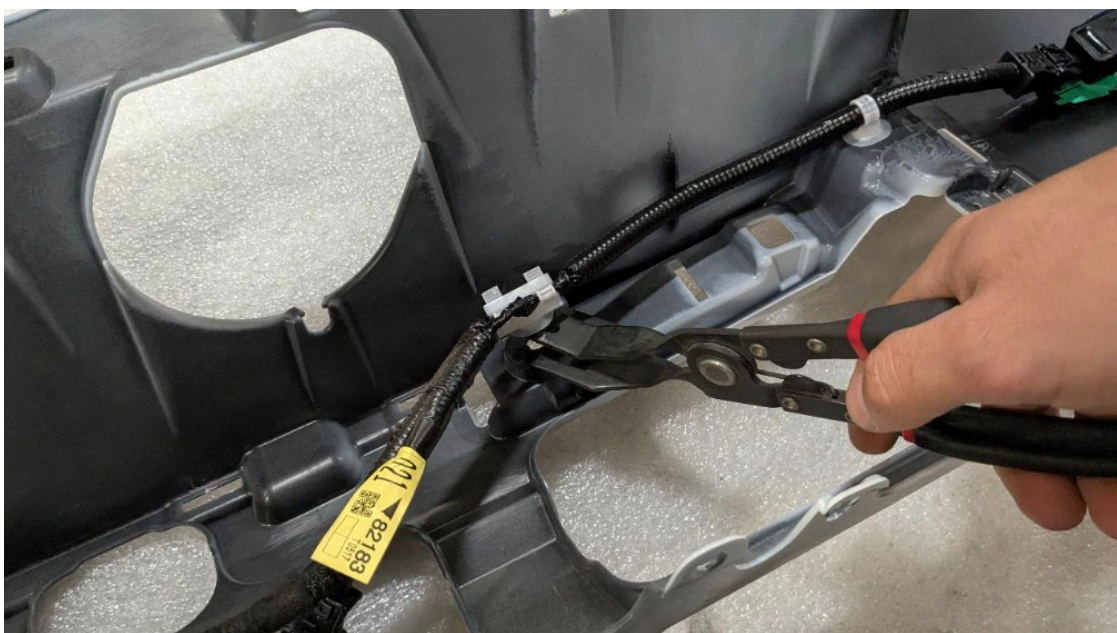


Figure 25

19. Using a silver sharpie, mark a line similar to the ones shown below. (Figure 26-27)



Figure 26

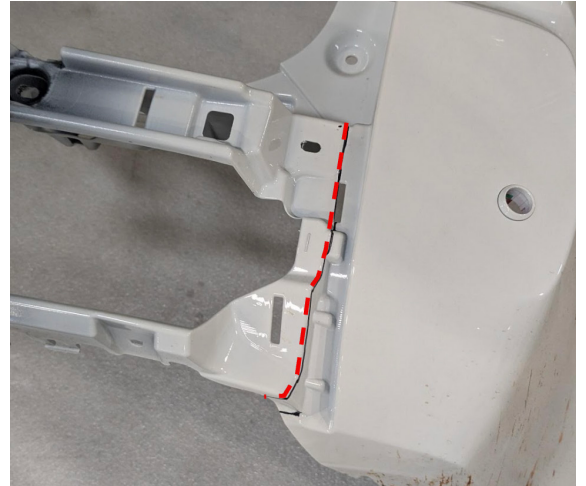


Figure 27

20. Using a silver sharpie, mark a line on each plastic filler panel from the bottom of the quarter panel (Figure 28)

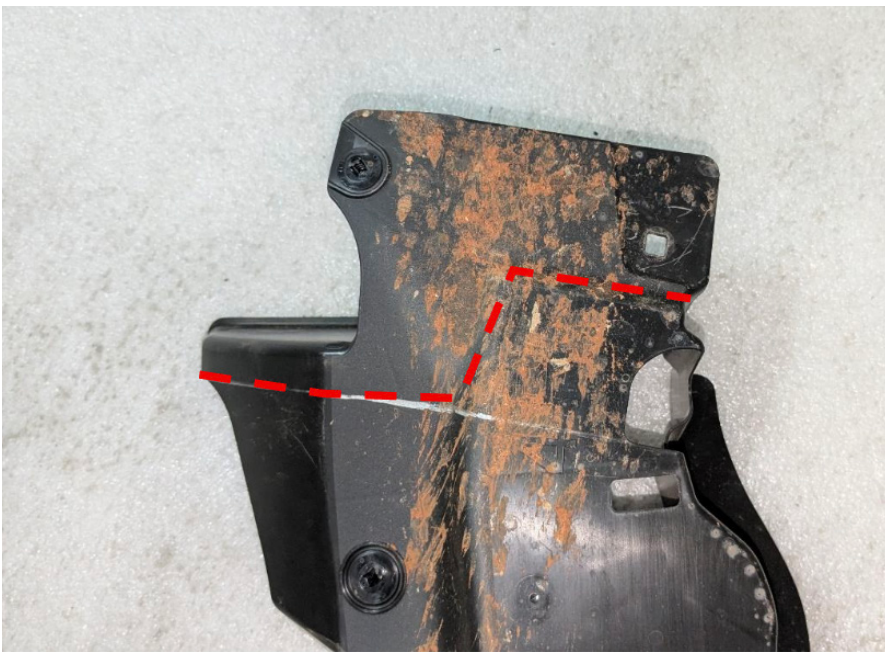


Figure 28

21. Using a small reciprocating saw, cut along the previously marked lines. (Figure 29)



Figure 29

22. Using the provided epoxy (Part#: 61632), reattach the parking sensor housings to the new bumper shell (Part#: 23476) Note the etched rectangle beside the sensor hole. (Figure 30-31)

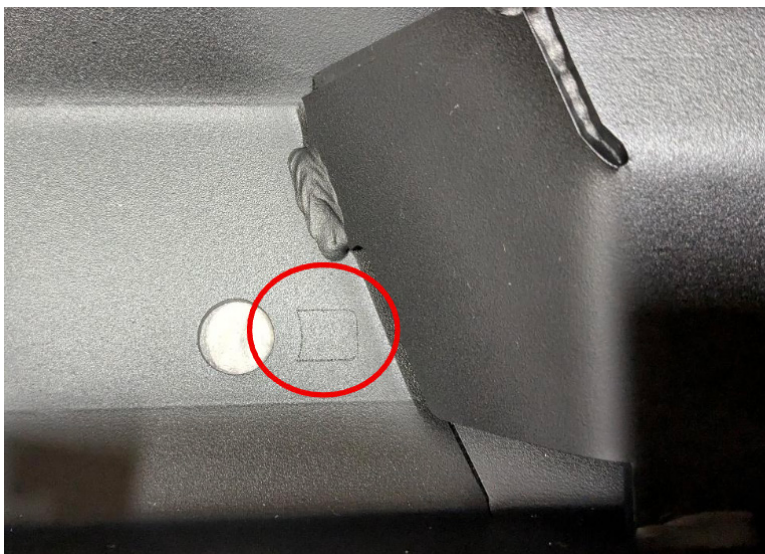


Figure 30

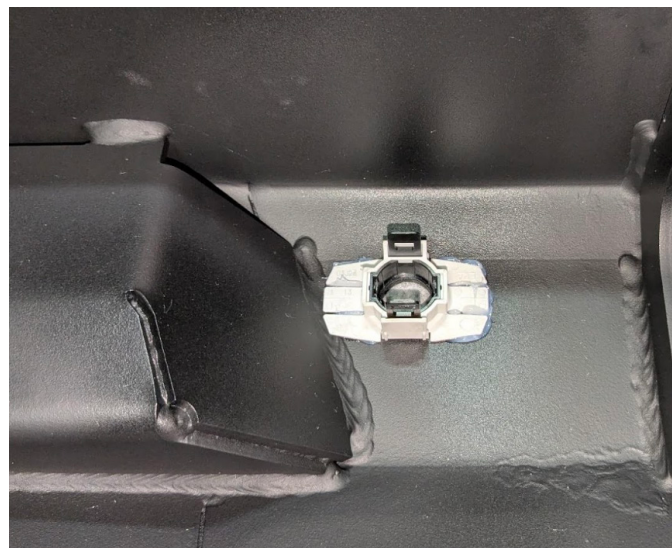


Figure 31

- 23. Reinstall the parking sensors into their respective housings aligning the connector of the sensor with the etched rectangle. (Figure 32-33)**



Figure 32



Figure 33

- 24. Using a 17mm socket wrench, remove the two (2) bolts in the factory tow-hook to remove it from the vehicle. (Figure 34-35)**



Figure 34



Figure 35

25. If installing lights, do so now per the lighting manufacturers' instructions. (Figure 36)



Figure 36

26. If the welds on the frame are more than 1/8" above the frame rail they will need to be ground down to be below 1/8" tall. (Figure 37)



Figure 37

27. Install the provided passenger's side mounting bracket onto to the frame using the five (5) provided M8 screws and one 1/2" bolt, flat washers, and nut. (Figure 38-40)



Figure 38

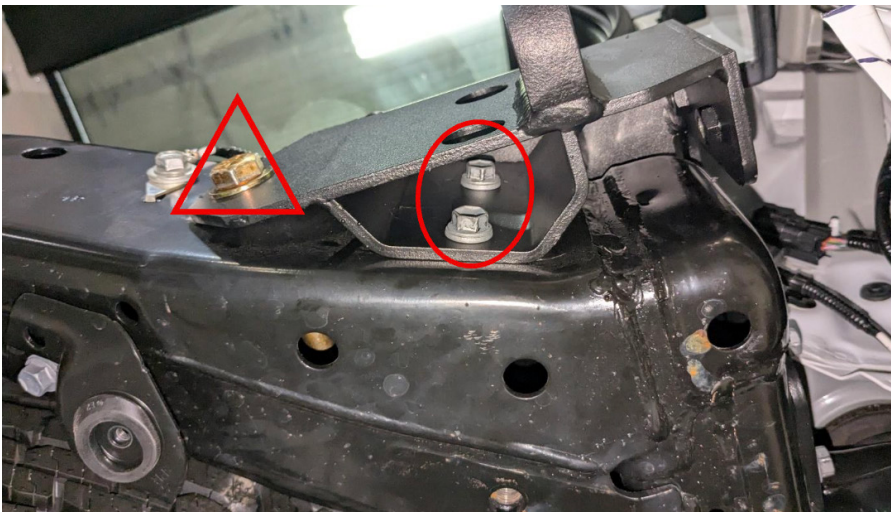


Figure 39



Figure 40

28. Remove two (2) of the plastic nut inserts from the black plastic filler panel and install them into the provided facia gussets (Part:23477&23478). (Figure 41)



Figure 41



Figure 42



Figure 43

29. Loosely install the factory screw into the previously installed plastic nut. (Figure 44)



Figure 44

30. Install the previously assembled facia gussets into the facia then use a 10mm socket wrench to tighten the screw. (Figure 45-46)



Figure 45



Figure 46

31. With assistance, hold the assembled bumper up to the rear of the vehicle placing the mounts between the previously installed brackets. Then, reconnect the wiring harnesses disconnected earlier. (Figure 47)



Figure 47

32. Install the ten provided M8 screws into the mounts. (Figure 48)

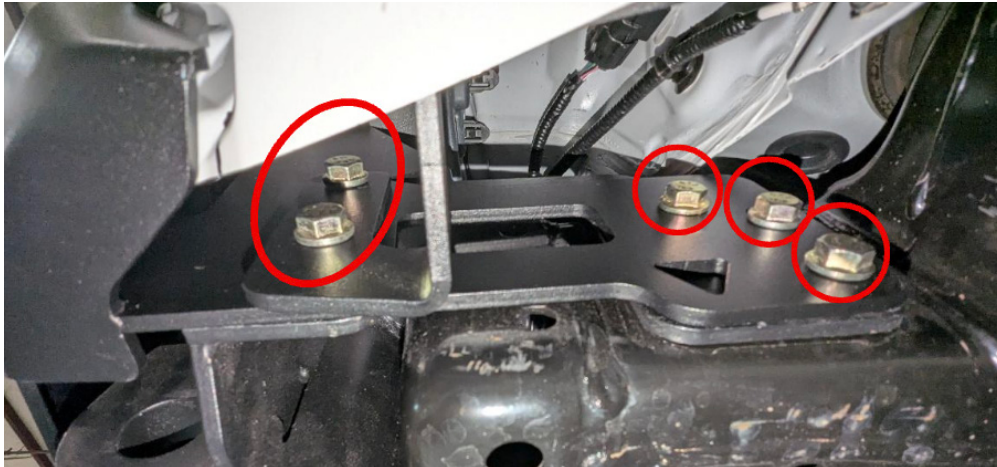


Figure 48

33. Align the bumper with the vehicle and then use a 13mm socket wrench to tighten the previously installed M8 hardware. (Figure 49-50)



Figure 49



Figure 50

34. Reinstall the outer parking sensors into their respective housing. (Figure 51)



Figure 51

CONTACT INFORMATION

**FAB FOURS INC.
2213 INDUSTRIAL PARK ROAD
LANCASTER, SC 29720**

**PHONE: (866) 385-1905
FAX: 970-385-1914
EMAIL: SUPPORT@FABFOURS.COM
FABFOURS.COM**



**“IF YOU’RE LOOKING FOR MORE OF THE SAME,
THEN YOU’VE COME TO THE WRONG PLACE.”**

- GREG HIGGS

