



INSTALLATION MANUAL
VENGEANCE BUMPER
PRODUCT NUMBER: E5251
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

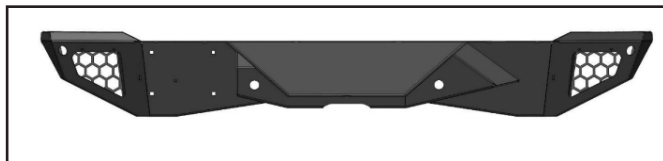
FOUNDER, FAB FOURS

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



22506 – VENGEANCE REAR BUMPER

61632 – EPOXY QTY 2

TXX50-HW – SENSOR
PLUG HARDWARE KIT

HARDWARE KIT | TXX50

FAB FOURS IDENTIFICATION	COMPONENT DESCRIPTION	QTY
TXX50-HW	WHITE PLASTIC LICENSE PLATE NUT	4
TXX50-HW	1 3/8" RUBBER GROMMETS	4
TXX50-HW	PLASTIC PLUGS	4

TOOLS REQUIRED

- 13mm WRENCH/SOCKET
- 18mm WRENCH/SOCKET
- 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.

1. Unplug the wiring harness located on the driver side of the vehicle between the frame and the bumper. Figure 1.

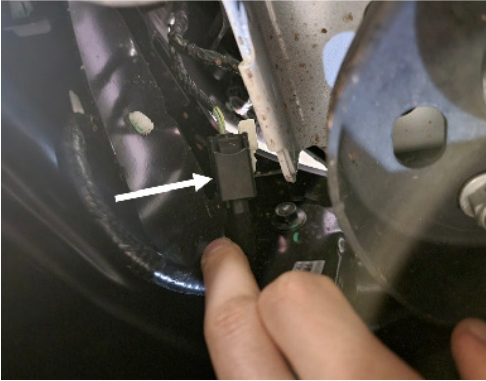


Figure 1

2. From underneath the bumper, use an 18mm socket or wrench to remove the 4x (2 on each side) bolts holding the bumper to the lower frame. If your Bronco is equipped with tow hooks remove them at this time and set them aside for later use. Use a 13mm socket or wrench to remove the 2x (1 on each side) bolts holding the bumper to the frame rails and remove the bumper from the vehicle. Figure 2.

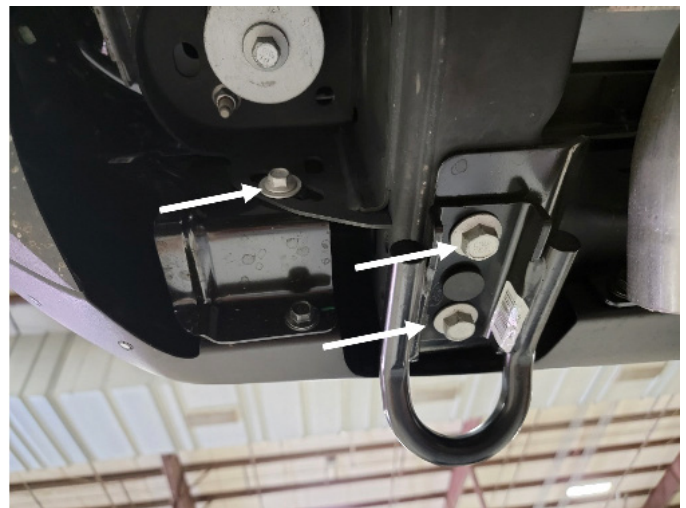


Figure 2

3. If vehicle is equipped with sensor; carefully remove the sensors from their housings by gently pulling the housing clips away from the sensor and pushing the sensor out. Remove the housings from the OEM bumper by compressing the clips on the inside and pushing the housing out of the bumper. NOTE: Both the sensors and the housings are delicate and should be handled with care. Mark the location of every sensor and its respective housing for installation into the new bumper. Figure 3-6

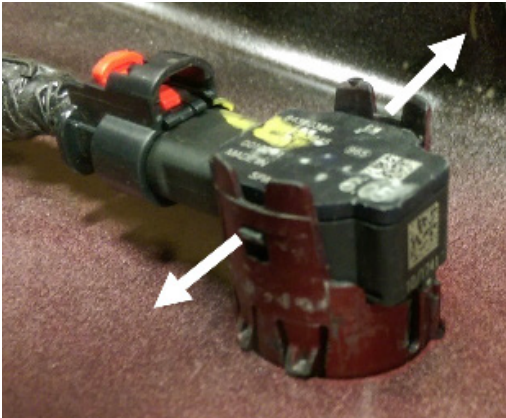


Figure 3

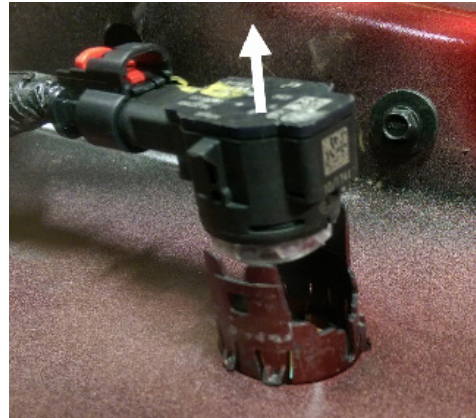


Figure 4

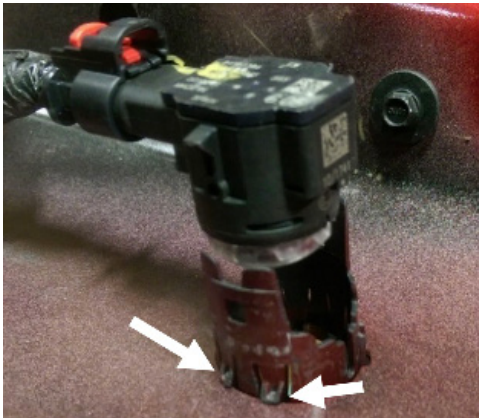


Figure 5



Figure 6

4. Install the sensor housings into their respective locations in the Elite bumper and use the provided epoxy packets to hold them in place.

5. Install the sensors into their respective housings by carefully pushing them into the housings until the clips engage.

6. Install the license plate light into the Vengeance bumper using the provided epoxy to secure it from the inside and plug it back into the wiring harness removed in Step 1. Figure 7-8.



Figure 7



Figure 8

7. With assistance, hold the bumper up to the frame and use the OEM hardware removed in step 2 (along with tow hooks if equipped) to attach it to the vehicle. Figure 9



Figure 9

8. Plug the wiring harness into its receiver and fully tighten all mounting hardware.

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

