



**INSTALLATION MANUAL**  
**PREMIUM REAR BUMPER**  
**PRODUCT NUMBER: W5051**  
**APPLICATION: 2021 FORD F150**



## **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.

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### **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.

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### **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
- 7 DISASSEMBLY
- 9 INSTALLATION
- 14 CONTACT

# A MESSAGE FROM THE OWNER

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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*

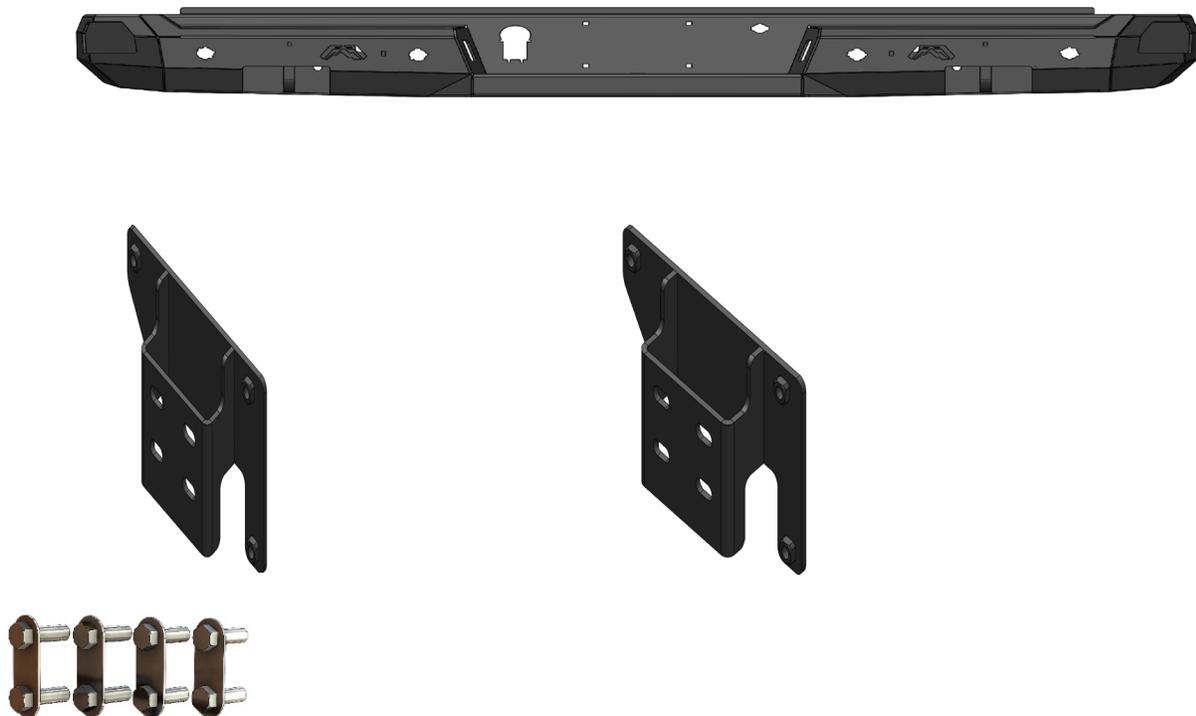
FOUNDER, FAB FOURS

# GETTING STARTED

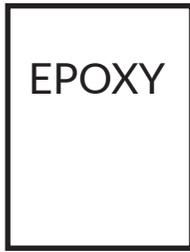
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Before you begin the installation process of your new Fab Fours product, we suggest laying out all materials and parts on a pad or protective surface.

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.

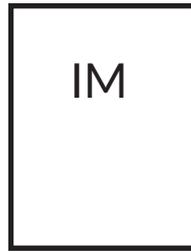


# PROVIDED MATERIALS



EPOXY

61632  
QTY: 2



IM

W5051-IM



HW  
KIT

50273-HW



22415



22416



22417



20296 x4

## HARDWARE KIT | 50273

FAB FOURS IDENTIFICATION	COMPONENT DESCRIPTION	QTY
50273-HW	1/4" Plastic License Plate Nut	4
50273-HW	7/16"x1 1/4" Yellow Zinc Bolt, Grade 8	6
50273-HW	7/17" Yellow Zinc Flat Washer, Grade 8	6
50273-HW	7/16" Yellow Zinc Lock Washer, Grade 8	6
50273-HW	1 3/8" Rubber Grommet	4
50273-HW	1/2"-13 Yellow Zinc Hex Nut, Grade 8	8
	Plastic Plug	4
50273-HW	1/2" Yellow Zinc Flat Washer	8
	1/2" Yellow Zinc Lock Washer	8

## TOOLS REQUIRED

- Socket Wrench with Extensions
- 5/8" Socket
- 3/4" Socket
- 8mm Socket
- 9mm Socket
- 13mm Socket
- 5/8" Box End Wrench
- 3/4" Box End Wrench
- 8mm Box End Wrench
- 9mm Box End Wrench
- 13mm Box End Wrench
- Chaser Taps

## 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.

# DISASSEMBLY

1. Remove license plate and OEM license plate lights from the bumper. Disconnect trailer plug and sensor harness plugs from the sensors, and license plate lights so that the harness is no longer attached to the OEM bumper. (Figure 1)



Figure 1

2. Remove one (1) Christmas tree plug and one (1) clip connecting the harness to the frame.

3. Remove seven plastic Christmas tree plugs holding the harness to the inside of the bumper. Fish the harness out of the bumper and out of the way.

4. The OE bumper will come off in 3 pieces. From the outside and starting from the passenger side edge peel away the plastic that is clipped into the top of the bumper. Flat head screwdriver is recommended for removal. (Figure 3).

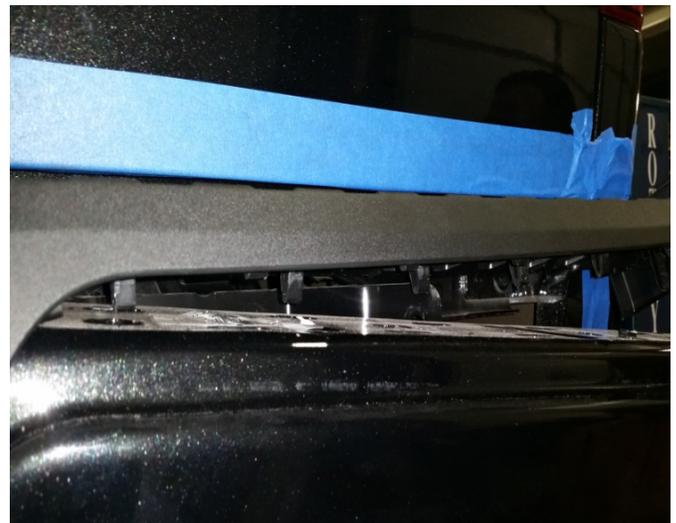


Figure 3

5. Remove the final 10 bolts that are now accessible using a 13mm socket. (Figure 3a-c)

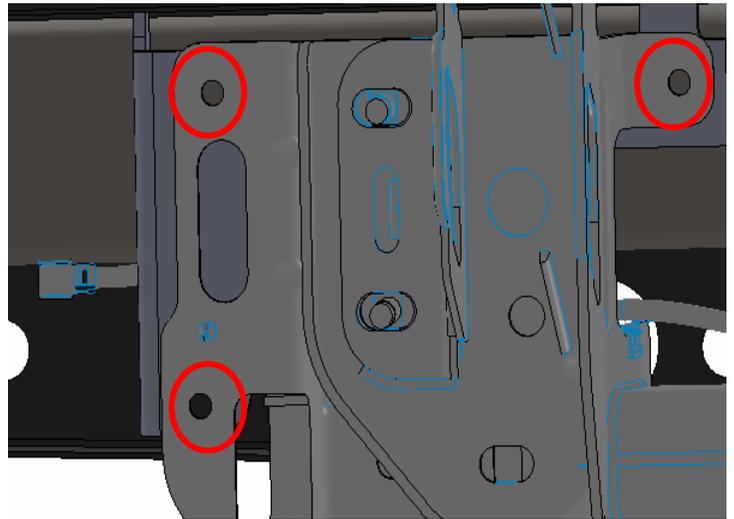


Figure 3a (3x per side, outer bolt locations)



Figure 3b (2x per side, inner bolt locations)

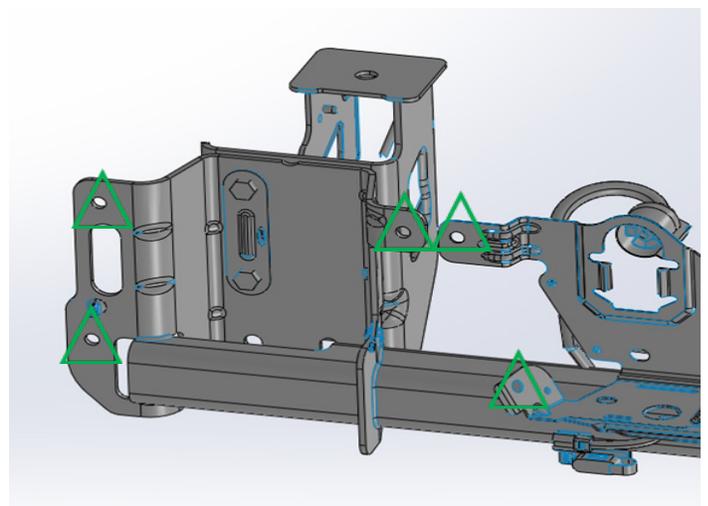


Figure 3c (5x bolt locations per side)

# INSTALLATION

6. With the OEM bumper removed from the truck, carefully remove all the sensors by pressing the clips away from the sensors and pulling the sensor out of the housing. Remove the sensor housings and note their location in the OEM bumper so you can install them into the same location on the Fab Fours bumper. Use one of the provided epoxy packets to hold the housings in place. (Figure 4a-b)

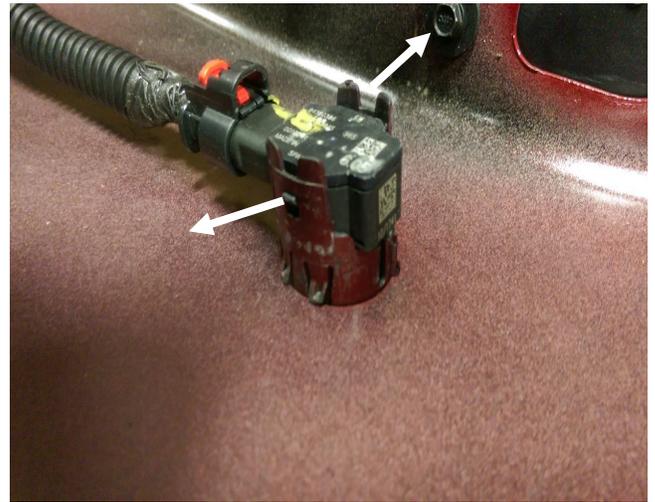


Figure 4a

7. Install the sensor housings into the new bumper placing them in their respective holes. Install the sensors into their housings at this time. Use caution to not press or touch the membranes of the sensor.



Figure 4b

8. Trim off the outside clip of the license plate light housing along with the flanges that surround the inside surface. (Figure 5)



Figure 5

9. Install the license plate light into the bumper and use the remaining epoxy packet to hold it in place. (Figure 6)

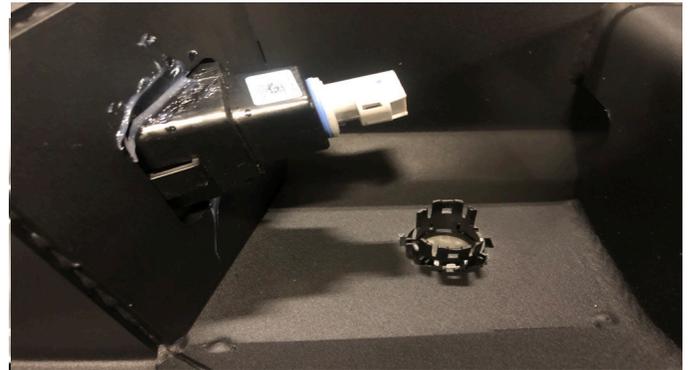


Figure 6

10. To install the trailer plug, first remove the metal brackets located on either side of the plug. With the brackets removed, install the plug into the new bumper and then reattach the metal bracket to secure it. The brackets will have to be bent to be able to reinstall them, use a flat head screwdriver to bend them back in place once installed. (Figure 7-8)

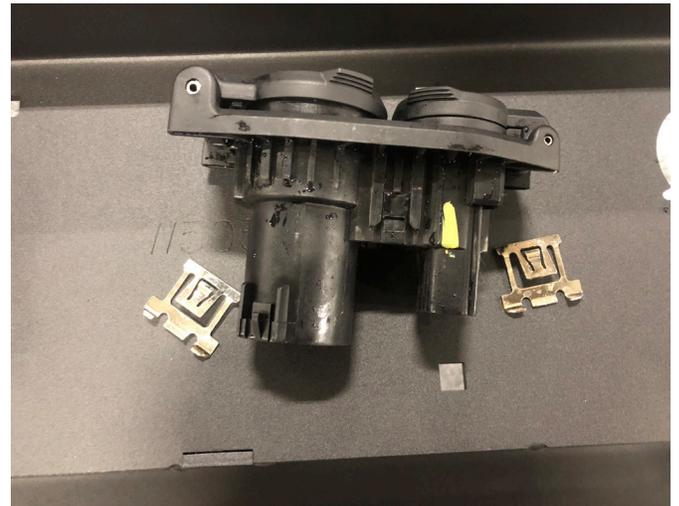


Figure 7

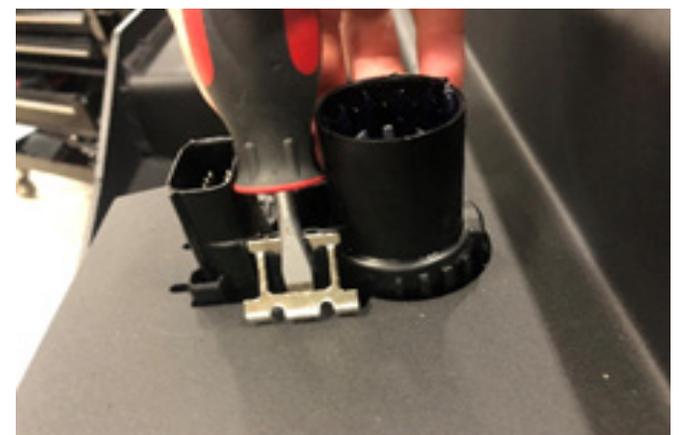


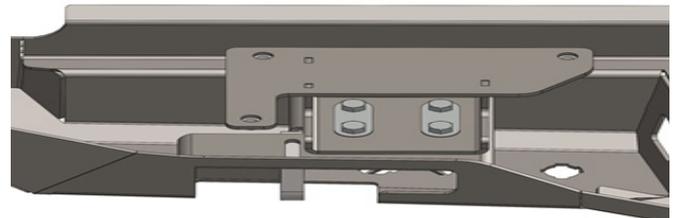
Figure 8

**11. Install the spare tire access lock into the new bumper and lock it in place using your truck key. (Figure 9)**



*Figure 9*

**12. Loosely install the mounting brackets onto the bumper using the provided 1/2" bolt strips (20296) along with 1/2" flat washers, lock washers and nuts (50273-HW). \*\*Note the orientation of the brackets (22416) goes on the passenger side and (22417) goes on the driver side\*\*. (Figure 10)**



*Figure 10*

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**14. Before installing the bumper: Trim the center plate and lower step mounting points off the frame using a cutoff wheel. (Figure 11-12)**



*Figure 11*



*Figure 12*

14. With assistance, hold the bumper up to the truck and use the provided 7/16" yellow zinc bolts, flat washers and lock washers to attach it to the frame (50273-HW). (Figure 13)



Figure 13

16. Plug all sensors, lights, and plugs into the wiring harness.  
***\*\*\* Carefully check tail gate clearance before tightening the mounting hardware\*\*\*.*** Fully tighten all mounting hardware to secure the bumper in place.

# CONTACT INFORMATION

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

**PHONE: (866) 385-1905  
FAX: 866-574-1423  
EMAIL: [SUPPORT@FABFOURS.COM](mailto:SUPPORT@FABFOURS.COM)  
[WWW.FABFOURS.COM](http://WWW.FABFOURS.COM)**



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

**- GREG HIGGS**

