



**INSTALLATION MANUAL**  
**VENGEANCE REAR BUMPER**  
**PRODUCT NUMBER: E5351**  
**APPLICATION: 2021 FORD RAPTOR**



## **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.

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# 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

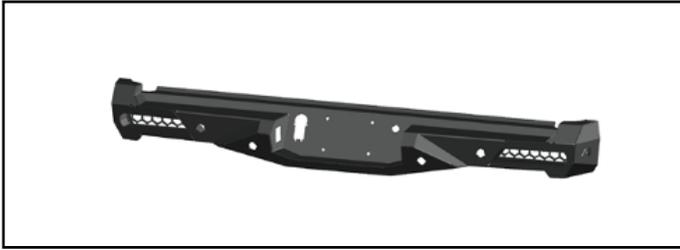
# GETTING STARTED

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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



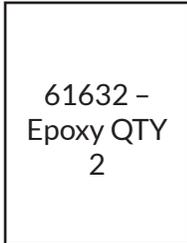
22524 - Vengeance Rear Bumper



22413 - Nut Plate QTY 4



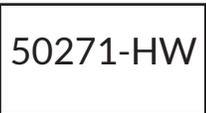
20217 - Spare  
Tire Lock  
Spacer



61632 -  
Epoxy QTY  
2



E5351-IM



50271-HW

## HARDWARE KIT | E5351

FAB FOURS IDENTIFICATION	COMPONENT DESCRIPTION	QTY
50271-HW	1/2" Plastic License Plate Nut	4
50271-HW	7/16"x1 1/2" Yellow Zinc Bolt, Grade 8	4
50271-HW	7/17" Yellow Zinc Flat Washer, Grade 8	4
50271-HW	7/16" Yellow Zinc Lock Washer, Grade 8	4
50271-HW	1 3/8" Rubber Grommet	4
50271-HW	Plastic Plug	4

## TOOLS REQUIRED

- Socket Wrench with Extensions
- 5/8", 3/4", 8mm, 9mm, and 13mm Sockets
- 5/8", 3/4", 8mm, 9mm, and 13mm Box End Wrench
- Body Panel Pry Tool
- Sawzall or Cutoff wheel

## 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.

## ASSISTANCE

This manual shows the six sensor configuration for illustration purposes but your specific installation may vary.

# 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 (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 (Figure 2). A body panel pry tool is recommended for removal.

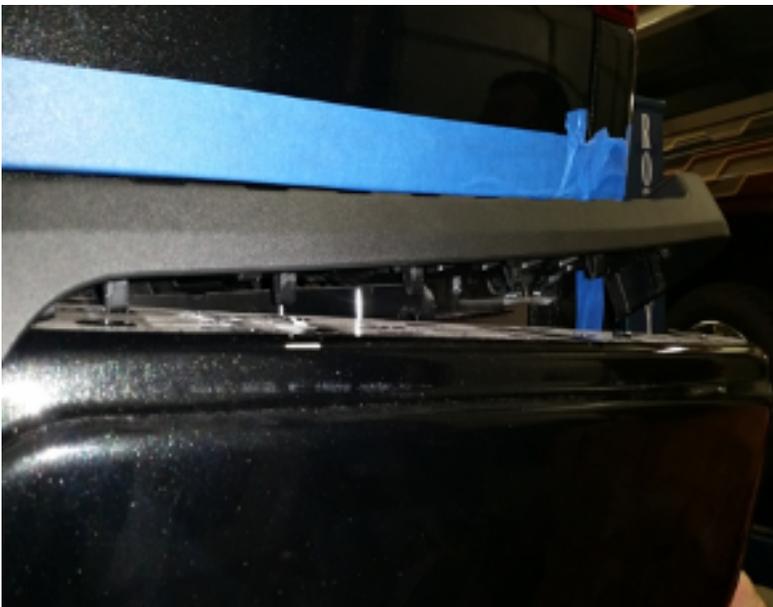


Figure 2

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5. Remove the 10 bolts that are accessible from behind the trailer hitch using a 13mm socket. (Figure 3a-c)

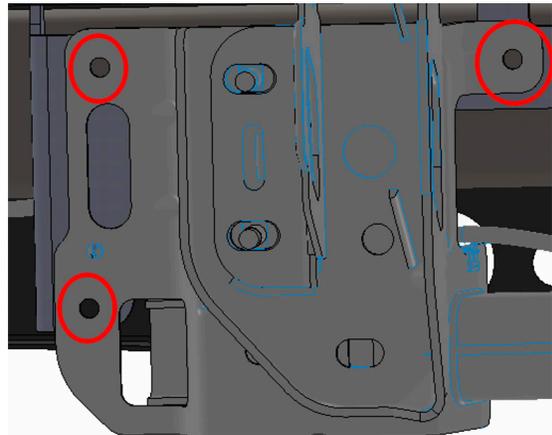


Figure 3a



Figure 3b

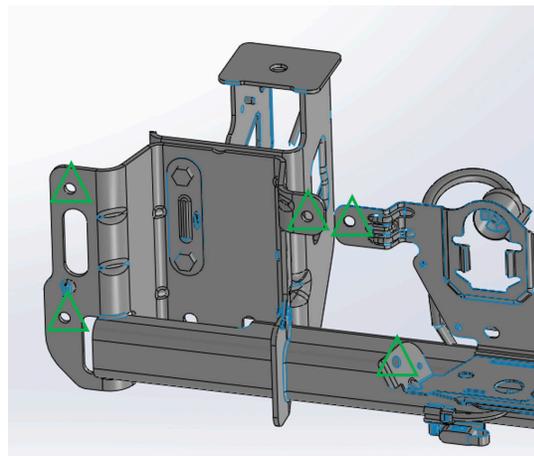


Figure 3c

6. Using a cut off saw, cut the plate attached to the trailer hitch along the bend line shown. Figure 4.



Figure 4

7. 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. (Figure 5a-b)



Figure 5a

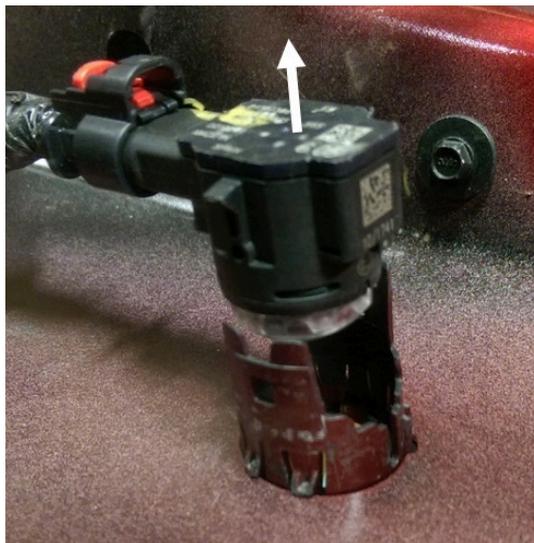


Figure 5b

# INSTALLATION

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8. Install the sensor housings into the new bumper placing them in their respective holes. Install the sensors into their housings at this time. If your vehicle is not equipped with parking sensors, installed the provided plastic plugs with rubber grommets instead. (Figure 6)



Figure 6

9. Trim off all of the clips of the license plate light housing along with all of the flanges that surround the inside surface. (Figure 7)



Figure 7

**10. Install the license plate light into the bumper in the same orientation in which it was removed from the OEM bumper. Use the provided epoxy to hold it in place. Figure 8.**



*Figure 8*

**11. Install the trailer plug into the bumper and engage the two metal clips to hold it in place. Figure 9.**



*Figure 9*

**12. Use the provided epoxy to attach the spare tire washer on the back side of the bumper. Use the rest of the epoxy to secure the sensor housings in place. Once the epoxy dries, install the spare tire lock from your OEM bumper into the new bumper. Figure 10.**



*Figure 10*

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13. With assistance, hold the bumper (22524) up to the truck and use the provided 7/16" yellow zinc bolts, flat and lock washers with the provided nut plates (22413) to install the bumper. Figure 10a-b.



Figure 10a

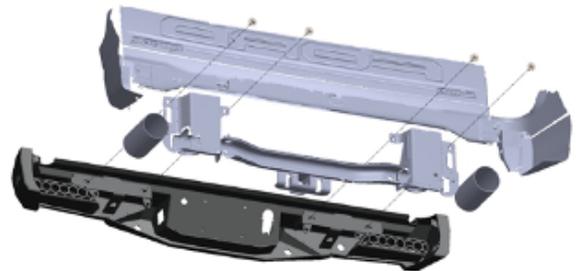


Figure 10b

14. Using a 3/4" socket wrench, align the bumper on the truck so that its even side to side and then tighten the previously installed hardware.

15. Reconnect wire harness to the sensors, lights, and trailer plug.

# CONTACT INFORMATION

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**FABFOURS.COM**



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

**- GREG HIGGS**

