



INSTALLATION MANUAL
TOYOTA TUNDRA VENGEANCE REAR BUMPER
PRODUCT NUMBER: E545 1-IM
APPLICATION: 2022 TOYOTA TUNDRA



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

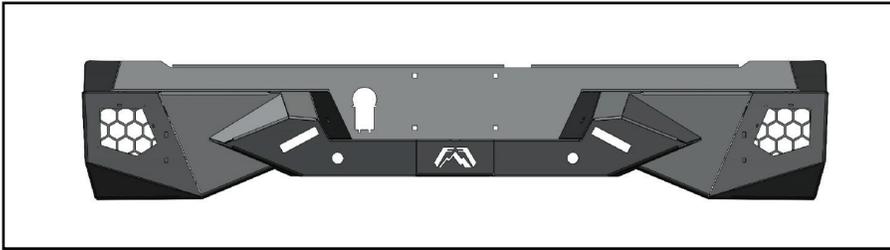
FOUNDER, FAB FOURS

GETTING STARTED

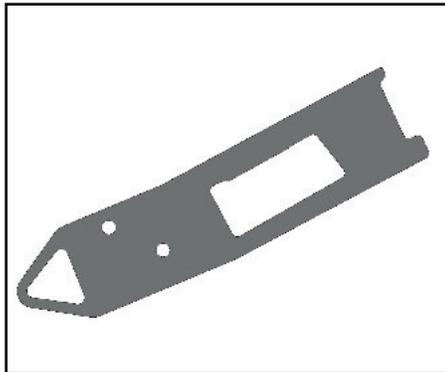
Before you begin the installation process of your new Fab Fours product, we suggest laying out all materials and parts on a pad or protective surface.

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.

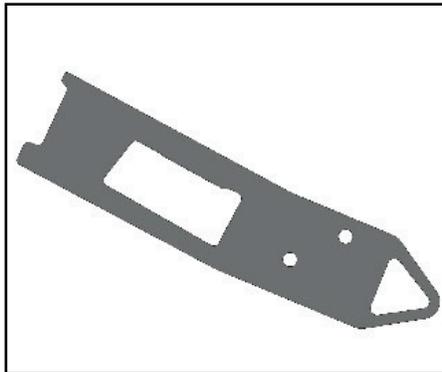
PROVIDED MATERIALS



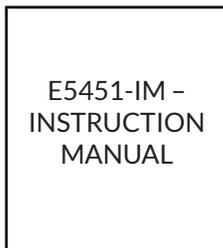
22627 - FAB FOURS VENGEANCE REAR BUMPER



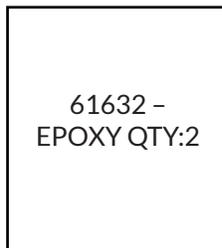
22628 - PS TAG
LIGHT BRACKET



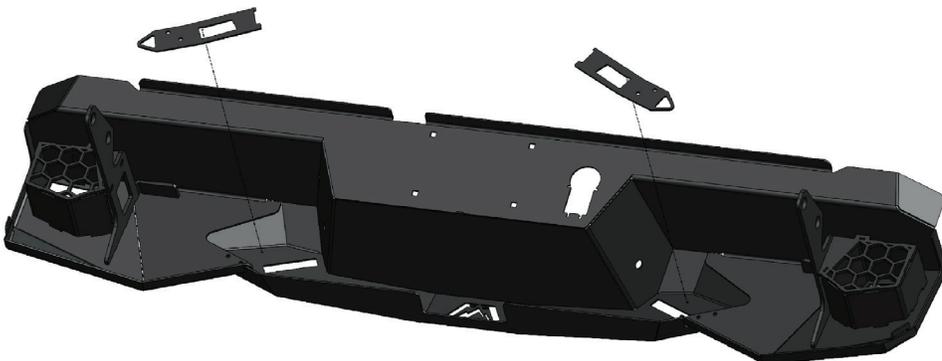
22629 - DS TAG
LIGHT BRACKET



E5451-IM -
INSTRUCTION
MANUAL



61632 -
EPOXY QTY:2



TOOLS REQUIRED

- Body panel pry tool
- Phillips head screwdriver
- Needle nose pliers
- Razor blade
- Electric drill
- Metal saw (Sawzall / cutoff wheel)
- 11/64" Drill bit
- 3/32" allen wrench
- 10mm socket wrench
- 12mm socket wrench
- 22mm socket wrench
- 1/4" socket wrench
- 1/2" socket wrench
- 10mm combination wrench
- 12mm combination wrench
- 22mm combination wrench
- 1/2" combination wrench

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.

HARDWARE KIT | E5451-IM

| FAB FOURS IDENTIFICATION | COMPONENT DESCRIPTION | QTY |
|--------------------------|--|-----|
| 50318-HW | 1/4"-20 x 3/4", Hex head cap screw, Yellow-zinc, Grade 8 | 4 |
| 50318-HW | 1/4", Flat washer, Yellow-zinc, Grade 8 | 8 |
| 50318-HW | 1/4"-20, Nylock nut, Yellow-zinc, Grade 8 | 4 |
| 50318-HW | #8-32 x 3/4", Button head cap screw, 18/8SS | 4 |
| 50318-HW | #8-32, Nylock hex nut, Zinc, Grade 2 | 4 |
| 50318-HW | #8-SAE, Flat Washer, 18/8SS | 4 |
| 50318-HW | 1-3/8", Grommet, Plastic, mm9307K81 | 2 |
| 50318-HW | Plastic Plug | 2 |
| 50318-HW | License Plate nut | 4 |
| | | |

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1. Using the body panel pry tool and a 10mm socket wrench, remove the two (2) screws and two (2) push pins in the lower valance to remove it from the bumper. Figure 1.



Figure 1

2. Using a body panel pry tool and needle nose pliers to remove the two (2) step pads from the bumper shell by lifting on the step pads while squeezing the clips from inside the bumper. Figures 2&3.



Figure 2



Figure 3

3. Using a body panel pry tool, lift on the cover plates in the center step pad to remove them. Figure 4.



Figure 4

4. Using a 12mm socket wrench, remove the four (4) screws per side. Figure 5.



Figure 5

-
5. Using a body panel pry tool, remove the push pin where the license plate mounts. Figure 6.



Figure 6

6. Using a 12mm socket wrench, remove the two (2) screws in the center step of the bumper. Figure 7.



Figure 7

7. At this point you can pull the bumper away from the vehicle and access the electrical connectors across the inside. Disconnect the trailer plug, the two (2) parking sensors, and the tag/reverse lights by depressing the tabs on the connectors. Figure 8,9,10.



Figure 8

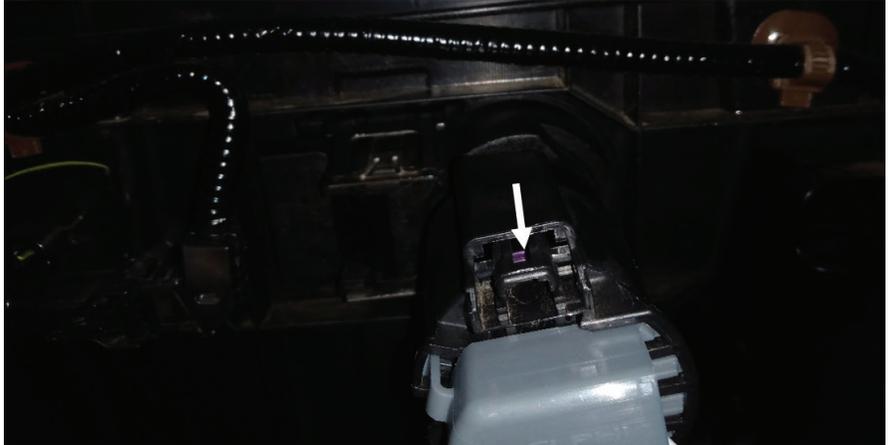


Figure 9

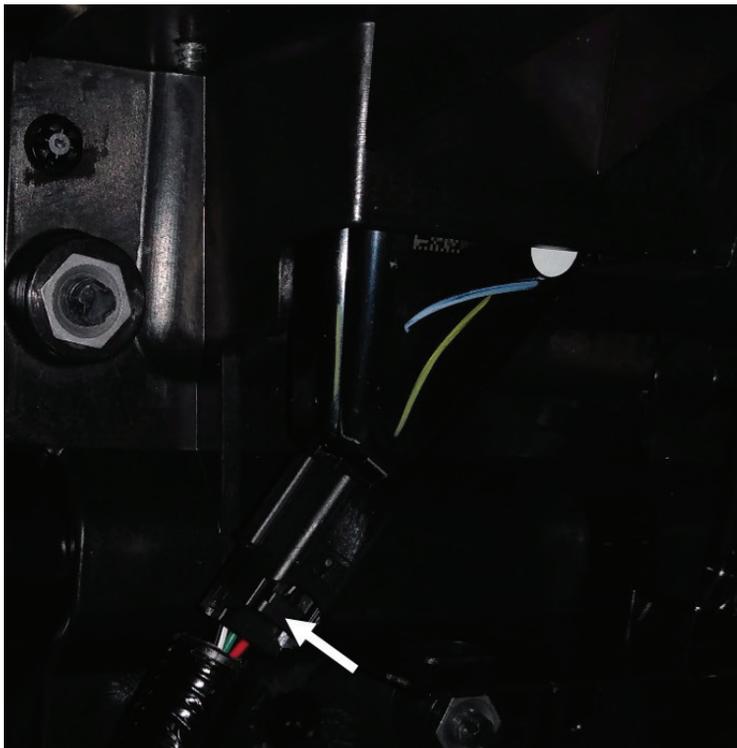


Figure 10

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8. Using the panel pry tool, remove all the wiring harness retainers along the inside of the bumper.
Figure 11.



Figure 11

9. Using a 10mm socket wrench, remove the sensor that is bolted to the inside of the bumper near the trailer plug.
Figure 12.



Figure 12

10. Remove the bumper from the vehicle and set it on a soft work surface to finish disassembly.

11. Remove the trailer plug from the bumper by depressing the two (2) metal tabs. Figure 13.



Figure 13

12. Using a razor blade, remove the parking sensor housings from the OEM bumper by cutting through the double-sided tape. Figure 14.

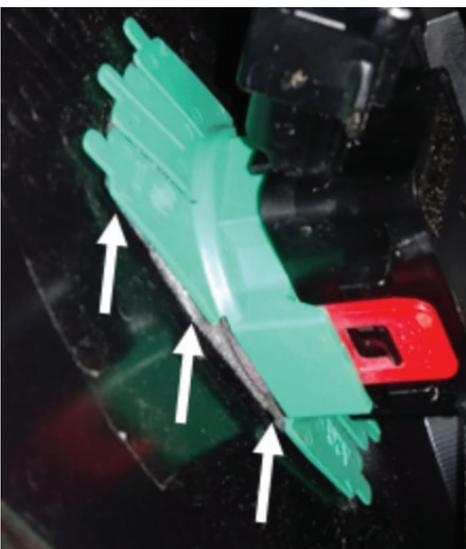


Figure 14

-
13. Using a 10mm socket wrench, remove the two (2) screws to remove the two (2) tag/reverse lights. Note which light is driver and which is passenger before removal. Figure 15.



Figure 15

14. Using a 22mm socket and combination wrench, remove the two (2) bolts closest the rear of the vehicle in either side of the trailer hitch where it meets the frame. Figure 16.



Figure 16

15. Prepare the new bumper for installation by using the provided epoxy to reinstall the OEM parking sensor housings in the placement and orientation in which they were removed. Figure 17.

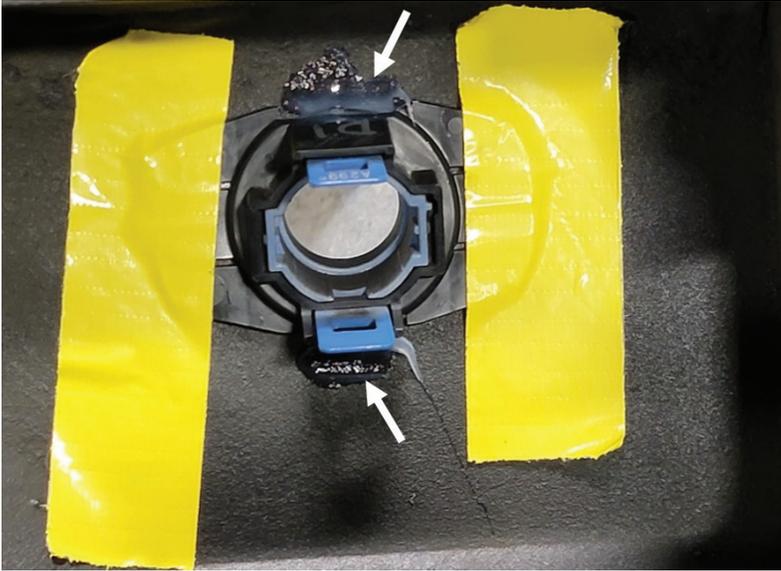


Figure 17

16. Using a 7/16" socket and combination wrench with the provided brackets (Part# 22628) and two (2) 1/4" grade 8 yellow-zinc bolts, flat washers, lock washers, and nuts reinstall the OEM passenger side tag/reverse light into the vengeance bumper. Figure 18.



Figure 18

17. Using a 7/16" socket and combination wrench with the provided brackets (Part# 22629) and two (2) 1/4" grade 8 yellow-zinc bolts, flat washers, lock washers, and nuts reinstall the OEM driver side tag/reverse light into the vengeance bumper.

18. Using an 11/64" drill bit, drill out the four (4) embossments inside the covers on the OEM trailer plug connector. Figure 19&20.

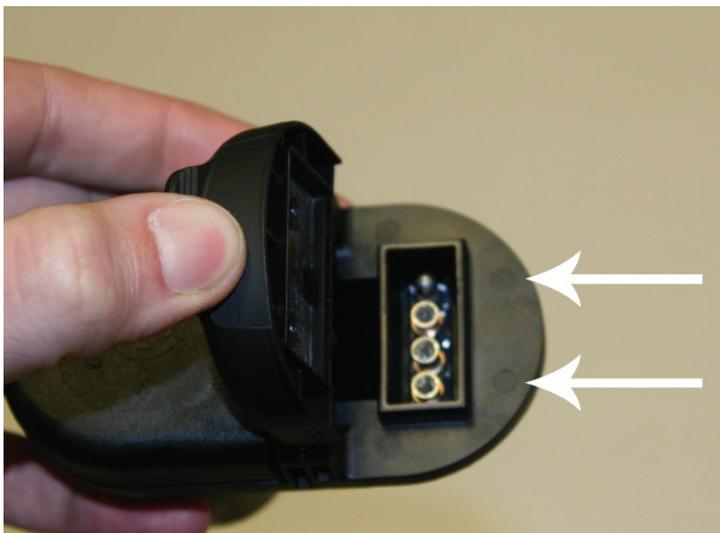


Figure 19

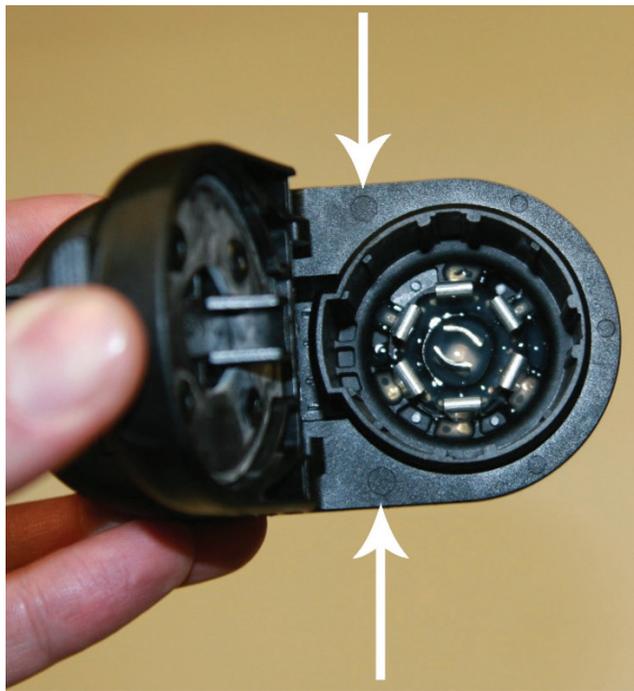


Figure 20

19. Using a 1/4" socket wrench and 3/32" allen wrench, install the trailer plug connector with the four (4) provided #8 screws, flat washers, and nuts. Figure 21.

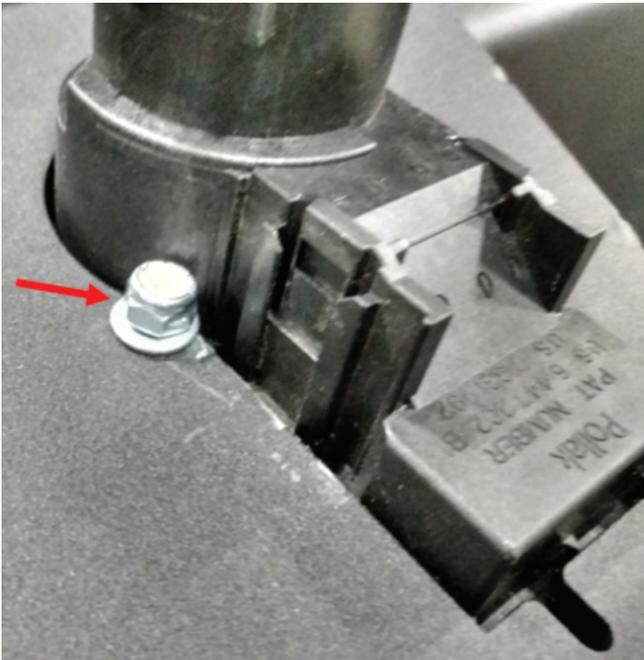


Figure 21

20. If installing lights in the wings, do so now per the light manufacturer's instructions.

21. Prior to installing the new bumper, the inner mounting tabs on each side of the trailer hitch need to be trimmed. Using a metal saw, trim the two (2) tabs. Figure 22

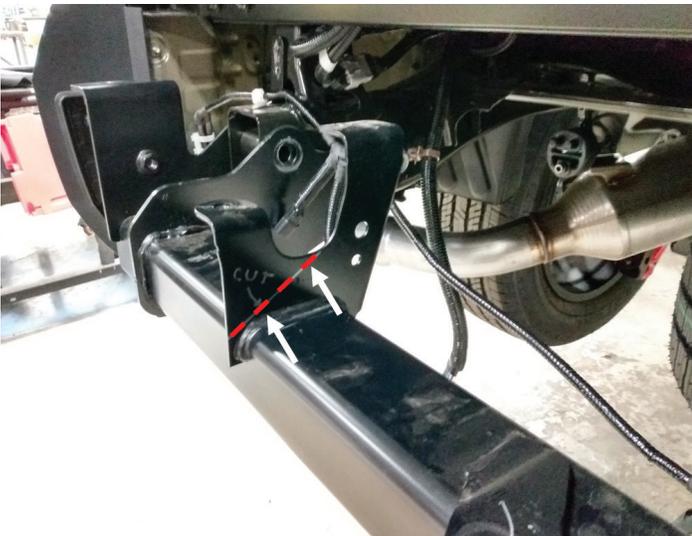


Figure 22

22. With assistance, hold the assembled bumper up to the vehicle. Reinstall the OEM hitch bolts removed earlier in the same orientation in which they were removed. Figure 23



Figure 23

23. Align the bumper so that it protrudes out from the rear of the OEM bumper end caps about 1/8" of an inch. Using 22mm socket and combination wrenches tighten the OEM hitch bolts to secure the bumper. Figure 24.



Figure 24

Installation complete.

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

