



Installation Instructions

Vengeance Rear Bumper

Product Number: E1351

Application: '99-Current Ford Super Duty

SAFETY

Your safety and the safety of others is very important.

- In order to help you make informed decisions about safety, we have provided installation instructions and other information.
- These instructions alert you to potential hazards that could hurt you or others.
- Please do a job safety analysis (JSA) before each task to identify potential hazards for your situation and remove/protect against them.
- You must use your own good judgment, and take your time.

Read and understand all safety precautions and instructions before installing this product.

**THIS PRODUCT IS FOR OFFROAD USE ONLY. ALL LIABILITY FOR
INSTALLATION AND USE RESTS WITH THE OWNER.**

**CARELESS INSTALLATION AND OPERATION CAN RESULT IN SERIOUS INJURY
OR EQUIPMENT DAMAGE.**

**SENSORS' FIELD OF VIEW WILL BE ALTERED WITH USE OF THE
REPLACEMENT BUMPER.**

Injury hazard

Failure to observe these instructions could lead to severe injury or death.

- 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 insure 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 on a vehicle. Thoroughly inspect the area to be drilled (on both sides of material) prior to drilling, and relocate any objects that may be damaged.
- 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.
- Always perform regular inspections and maintenance on mounts and related hardware.

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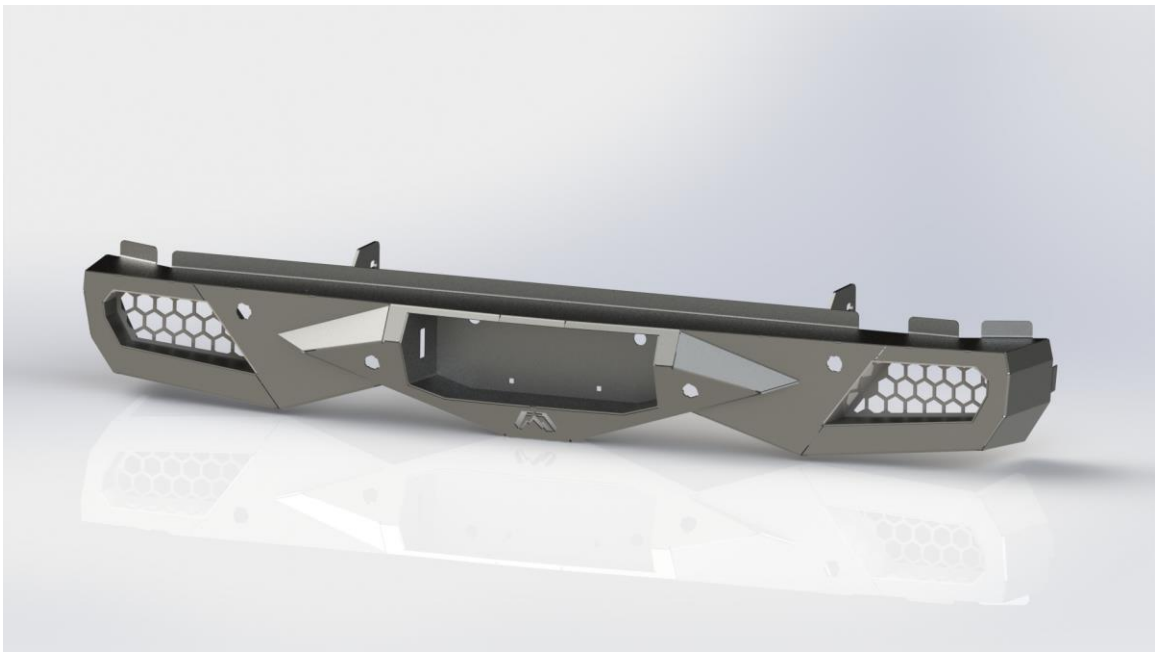
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I. Overview

Congratulations on your new purchase of the industries' best and most stylish rear bumper available for the 99-Current Ford Super Duty. This bumper has been designed to be lightweight and easily customized with the industry's highest quality accessories.

Your rear bumper designed in 3-D from digitized data, CNC laser cut, fabricated, and powder coated... all in the U.S.A.

Enjoy the fit and finish of a quality Ford Super Duty rear bumper from Fab Fours Inc.



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Parts List

- **Rear replacement bumper**
- **50040-HW fastener kit**
- **Instruction Manual**
- **10019 Wiring kit**
- **License plate lights Qty. 2**
- **Wiring Kit – 10019**
- **LED Rear Light Strip Kit - 61648**

Tools Required

- **Socket Wrench with Extension (Ratcheting wrenches may also be convenient)**
- **7/16", & 21mm Sockets and Box End Wrenches**
- **Hex Bit Socket for #8-32 Button Head**
- **Flat and Phillips Head Screwdrivers**
- **Floor Jack and wood block.**

NOTE: PLEASE READ THE ENTIRE MANUAL BEFORE ATEMPTING INSTALLATION! Ignoring these steps will increase your probability of scratching the vehicle during product installation.

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II. Removal of Stock Bumper

1. Disconnect wiring harness (ref. figure 1).



Figure 1

2. With help and the use of a floor jack to support bumper, use a 13/16 or 21mm socket to remove the nuts and bolt straps securing the OEM bumper to the frame (ref. figure 2a-b).

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Figure 2a



Figure 2b

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3. Remove license plate, and OEM license plate lights. Using a flathead screwdriver, pull out plastic anchors holding wiring harness to bumper. If equipped with sensors, push sensor housing tabs, indicated by circles, away from sensors and carefully wiggle sensors back and forth while pulling sensors out of housing (ref figure 3).



Figure3

III. Rear Bumper Installation

1. **FOR SENSOR BUMPER INSTALLATION ONLY:** Install Sensor Housing in bumper by lining up plastic protrusions of the housing with the sensor profile (ref figure 4a-f).look at images below to confirm proper orientation and placement. Figure 4a and 4b represent the oem locations and location in the Fab Fours bumper. **DO NOT EPOXY AT THIS TIME.**

Due to the angled design of the clips, Fab Fours recommends that you angle the sensors upwards so that the sensors don't read the ground. You will need to test the sensors in this configuration after installing the bumper.

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OEM Locations



Figure 4a

Fab Fours Locations



Figure 4b



Figure 4c (Outer drivers side)



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Figure 4d (inner drivers side)



Figure 4e (inners passenger side)

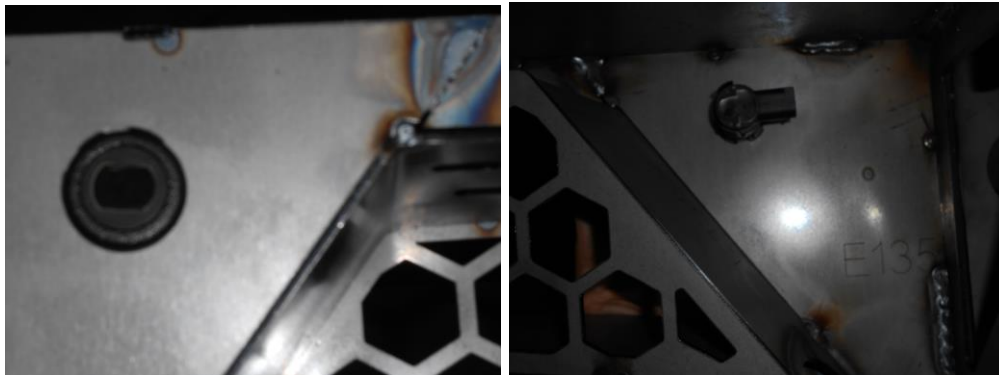


Figure 4d (outer passenger side)

2. Install provided license plate lights with the provided #8 hardware.
3. Replace the OEM bumper with the Fab Fours Vengeance Plate Bumper. Use the OEM bolt strips and nuts to fasten the bumper mounts to the frame rail in the OEM mounting locations. Do not fully tighten.
4. Level and align the bumper in relation to the truck bed. Fully tighten all fasteners.
5. Slowly lower the tailgate to ensure there will be no interference. If required, loosen the frame/bumper bolts and adjust alignment of the bumper.
6. Reinstall license plate with provided plastic inserts

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7. Prep the area shown below and attach the red LED strip in the location shown. Wire as desired depending on functionality. You have the following options: wire to your brake lights, running lights or tag lights.



8. Secure all loose wiring and harnesses to the frame or bumper with zip ties.
9. Install supplied hole plug into appropriate hole depending on year
99-07: Plug Driver Side Hole
08-Current: Plug Passenger Side Hole
10. FOR SENSOR BUMPER INSTALLATION ONLY: Install the sensor harness back into the housing clips and plug the OEM sensor harness into the truck. Test the sensors to ensure that the truck does not read the ground or any give off any errors.

Once the testing is complete, epoxy the sensors into place. **DO NOT EPOXY THE SENSORS, ONLY THE HOUSINGS.**

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III. Maintenance/Care

- Periodically check and tighten all fasteners.
- Stripped, fractured, or bent bolts or nuts need to be replaced.
- After washing of the vehicle make sure to fully dry all surfaces



More than expected... Better than expected