



Installation Instructions

Front Bumper

Product Number: B1650, B1651, B1652

Application: '12-Current Toyota Tacoma

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.

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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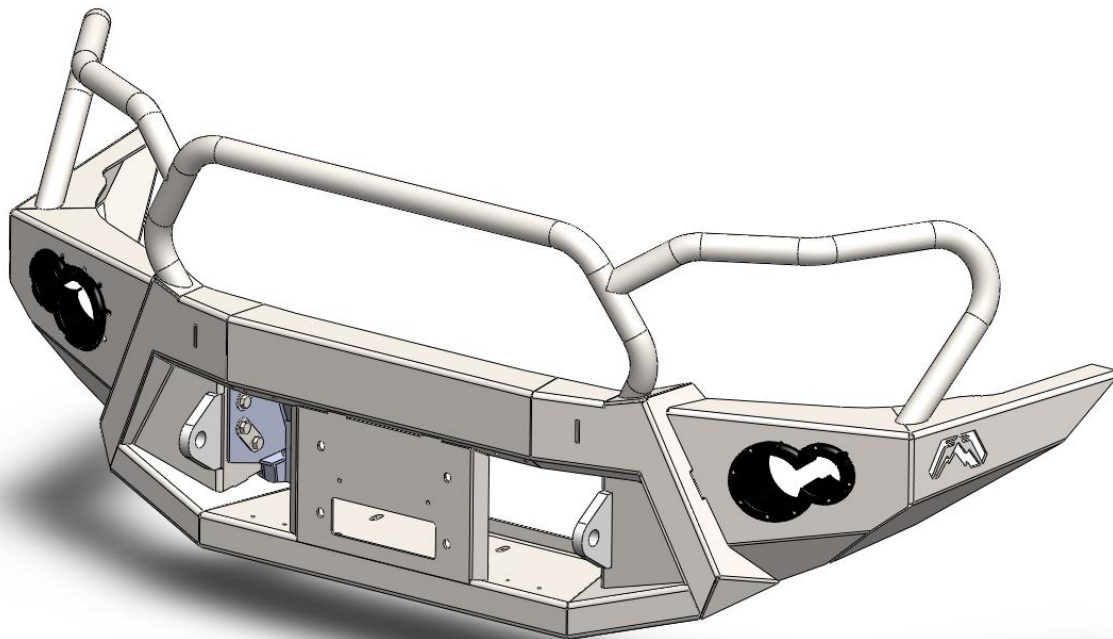
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I. Overview

Congratulations on your new purchase of the industries' best and most stylish front bumper for the 2012 and newer Toyota Tacoma! This bumper has been **engineered** for strength.

Your bumper is 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 Toyota Tacoma front bumper from Fab Fours Inc.





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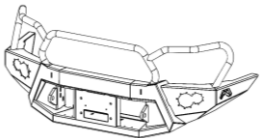






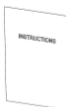
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II. Tools Required

- 19mm (3/4"), 17mm, 14mm, 10mm Socket
- Phillips, Flat Blade Screw Driver
- Ratchet wrench, extensions

III. Kit Contents

| QTY | DESCRIPTION | FAB FOURS PART NUMBER |
|---|---|-----------------------|
|  x 1 | B1651 Bumper Shell | B1651 |
|  x 1 | Driver fog light mounting bracket | 20194 |
|  x 1 | Passenger fog light mounting bracket | 20195 |
|  x 2 | Fab Fours foglight | 61349 |
|  x 2 | Fab Fours running light, turn indicator | 61350 |
|  x 1 | HDLA Hardware Kit | HDLA-HW |
|  x 1 | B1651 Hardware Kit | 61368 |
|  x 1 | B1651 Instruction Manual | B1651-IM |



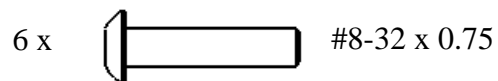
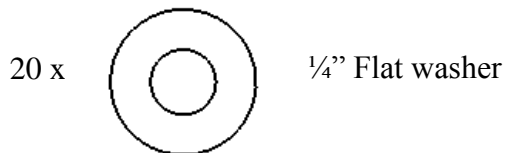
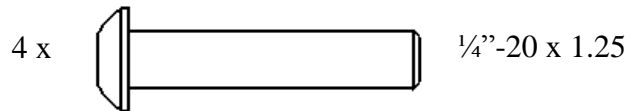
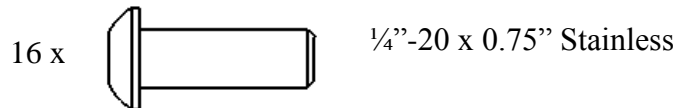
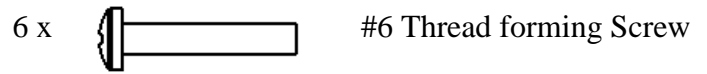
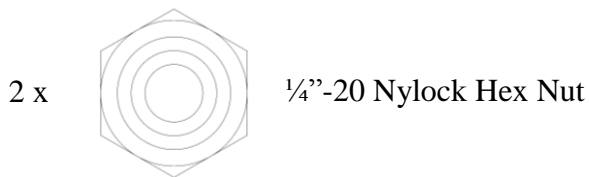
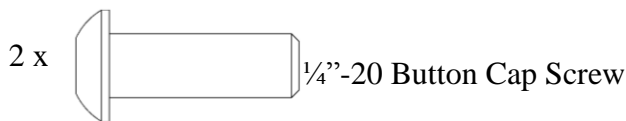
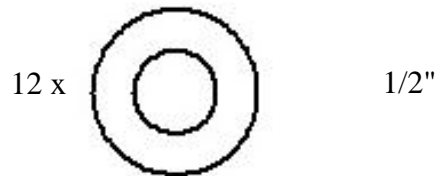
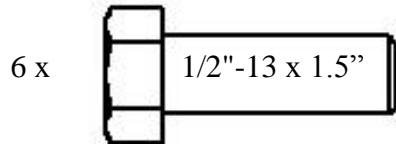
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IV. Included Hardware





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V. Removal of OEM Grill

A. Open Hood

B. Using a 10mm socket and ratchet, remove the two silver screws in the top of the grill.

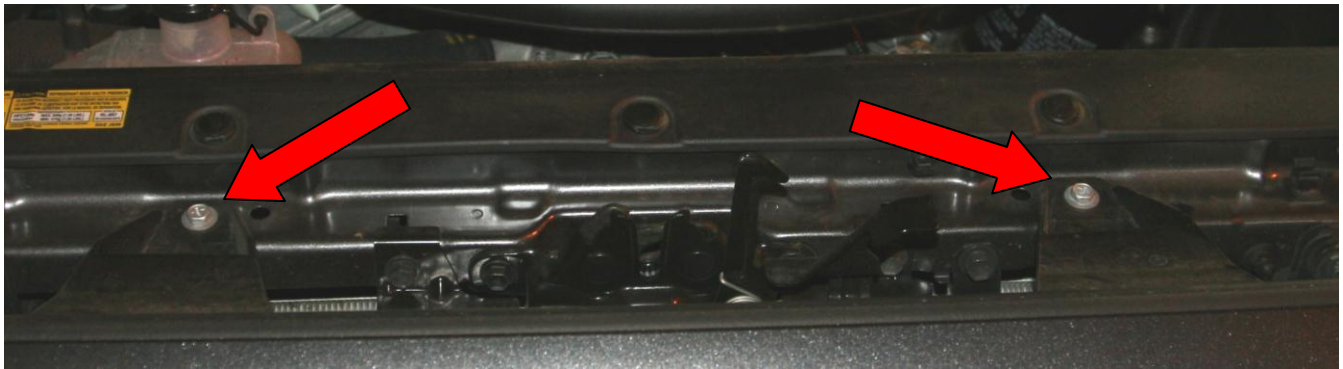


Figure 1 – Upper grill screw removal

C. Remove the two plastic clips from the top of the grill. Using a small flat blade screwdriver can be helpful to release the central “button” portion of the clip, allowing the clip to be pulled free.

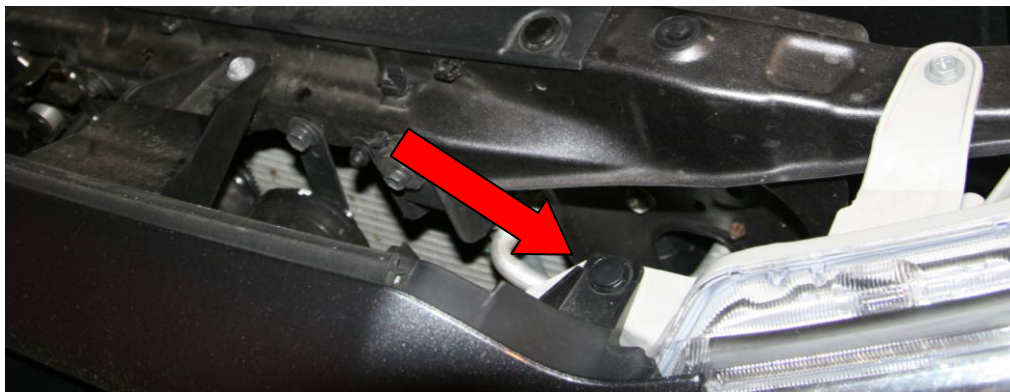


Figure 2 – Upper grill clip removal



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D. Remove the 3 plastic clips holding the inside bottom of the grill to the vehicle. There is one clip on each side near the headlight, and one located centrally.

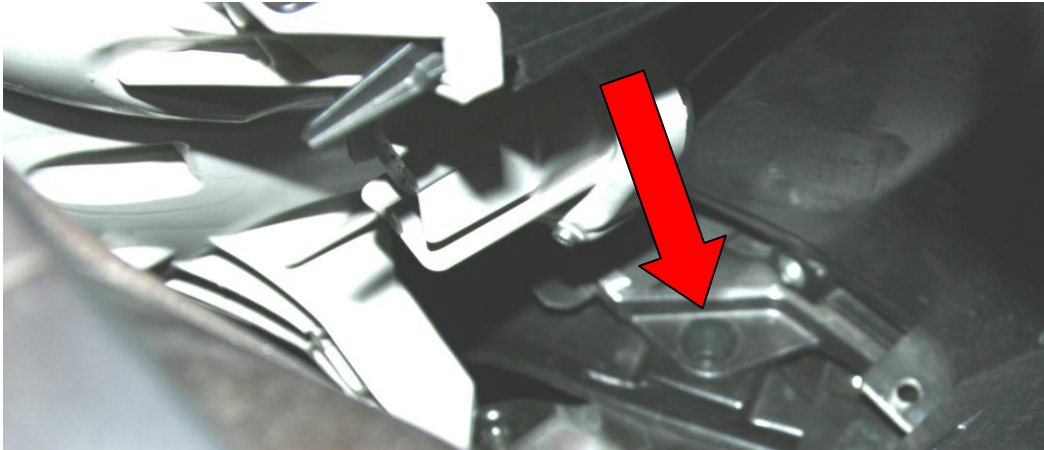


Figure 3 – Lower grill clip removal

E. Loosen the tabs holding the grill to the bumper cover by pulling up on them. Remove grill and set aside.

VI. Removal of OEM bumper

A. Remove the 10mm screw and plastic quarter turn clip from each front fenderwell.



Figure 4 – Fenderwell fastener removal



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B. Using a 10mm socket, remove the 6 screws in the bottom of the OEM bumper cover.

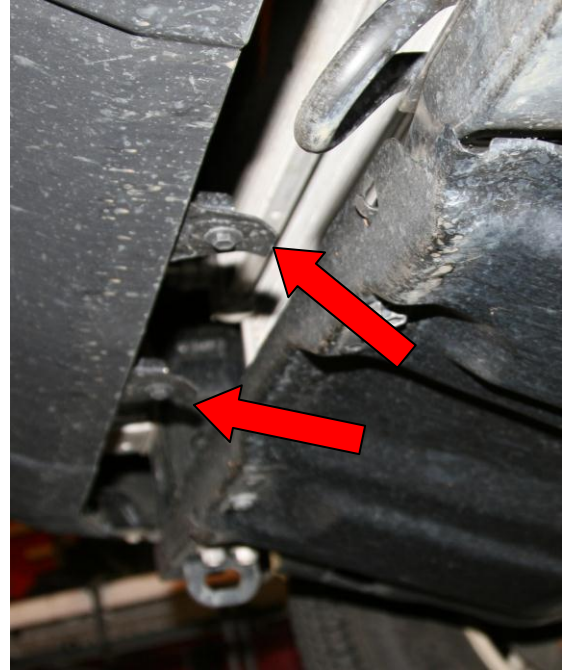


Figure 5 & 6 – OEM bumper cover screw removal

C. From inside the bumper cover, unplug the foglight harnesses

D. Remove the body-colored trim pieces from under the headlights by carefully popping the inner portion loose from the black bracket, then gently pulling or prying the outer tab out from the fender.



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E. Remove the three black metal brackets from the front of the vehicle by removing the 10mm nuts. The center bracket comes out first, then the outer brackets. Retain the 10mm nuts as they will be reused.

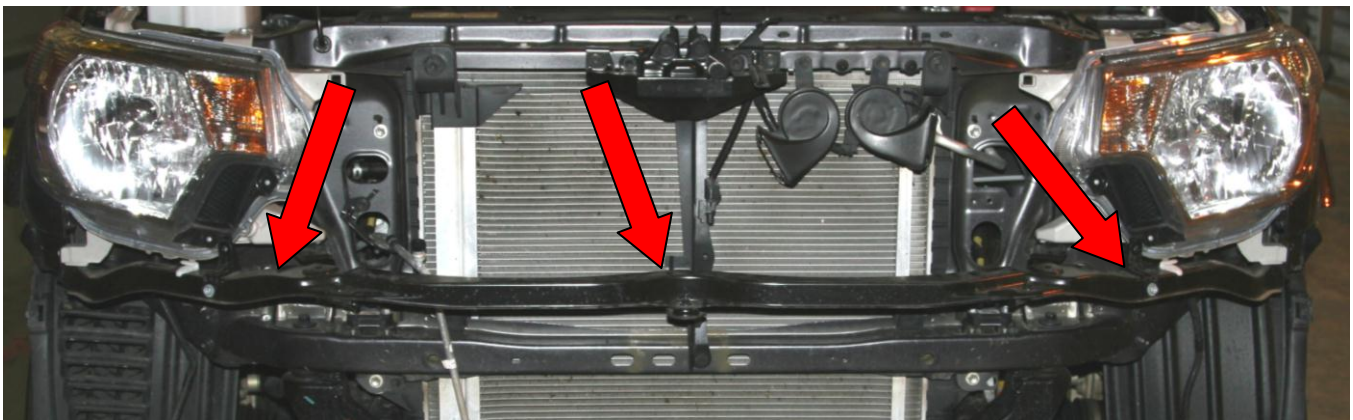


Figure 7 – Removal of upper bumper support bracketry

F. Using a 10mm socket, remove the outer bumper support brackets from the vehicle.

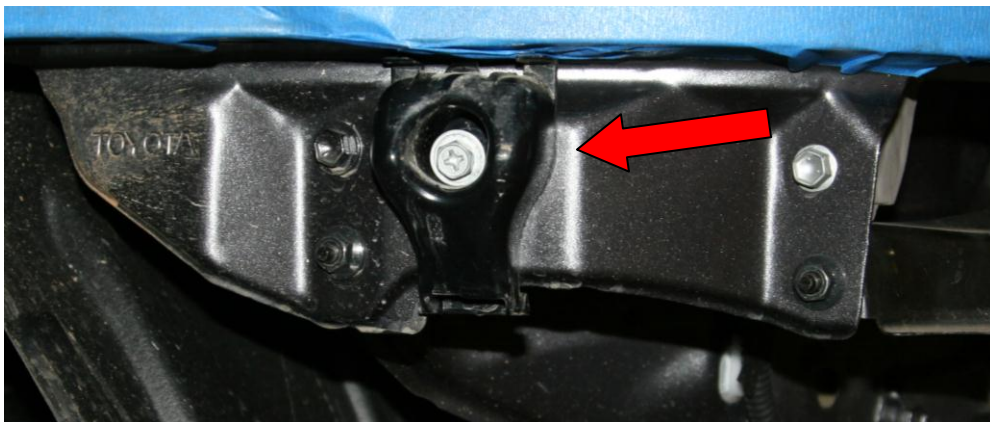


Figure 8 – Removal of outer bumper support brackets



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G. Remove the lower aluminum bumper structure from the vehicle by removing the six 14mm nuts. It may be helpful to loosen the 14mm fasteners inside of the horizontal beam before pulling the bumper structure free.

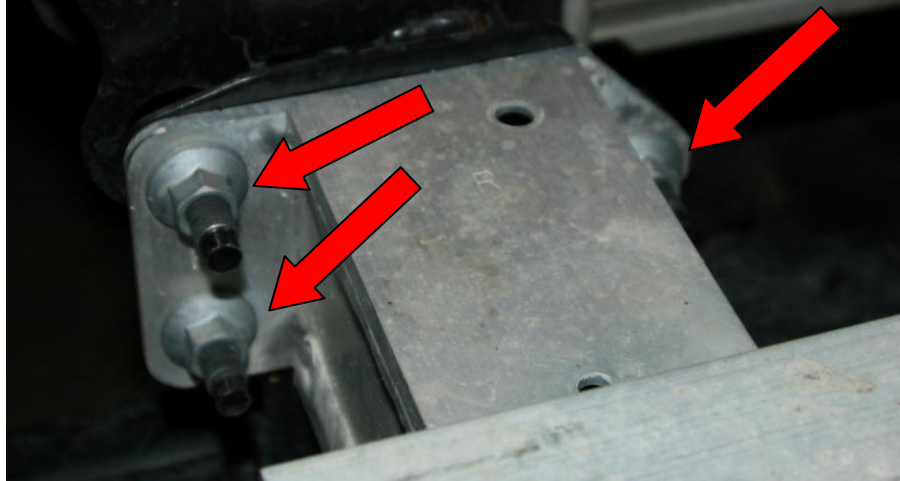


Figure 9 – Removal of bumper beam

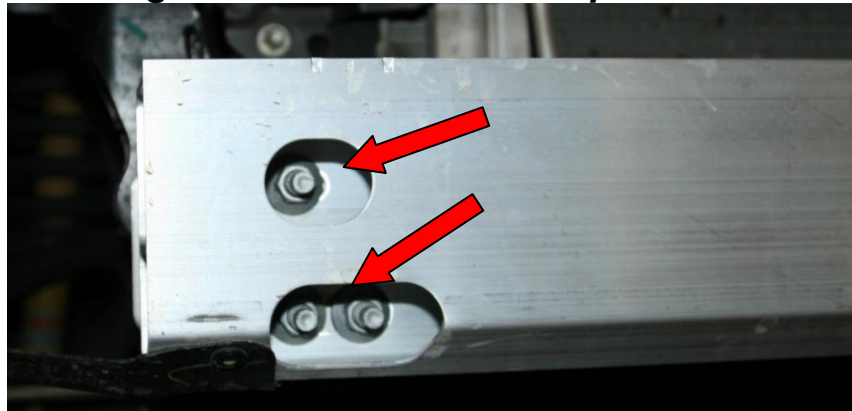


Figure 10 – Internal bumper beam fasteners can be loosened to facilitate beam removal

H. Remove the lower bumper beam extensions and tow eye by removing the 17mm bolts.



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Figure 11 & 12 – Bumper beam extension and tow eye removal

VII. Pre-Installation Assembly

A. Remove the Bumper from the shipping carton. Lay all items out on a blanket to prevent damage to the powder coating.

B. OPTIONAL: If installing winch and roller fairlead (neither provided) into bumper, do it at this time. Follow the winch Manufacturer's instructions to mount the fairlead to the front of the bumper and the winch itself to the 4 hole pattern on the internal winch tray of the bumper.

C. Install turn indicators into the plastic light insert using three self-tapping screws as shown:



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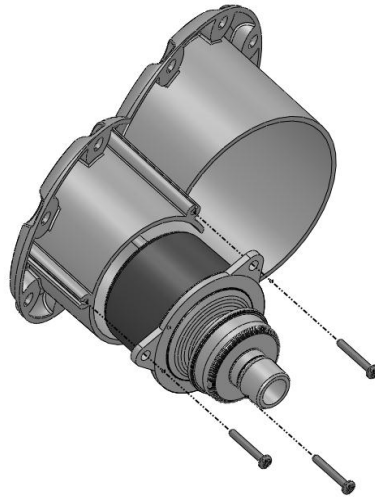


Figure 13 – Turn signal installation

D. Install the light inserts with turn indicators into the cutout in the bumper. Use the $\frac{3}{4}$ " length $\frac{1}{4}$ " stainless steel button head screws, $\frac{1}{4}$ " washers and hex nuts to fasten the insert through the holes shown below. Do not use the two holes closest to the center of the bumper at this time. Use washers only on the nut side (inside the bumper). Use needle nose pliers to tighten nuts with limited access.



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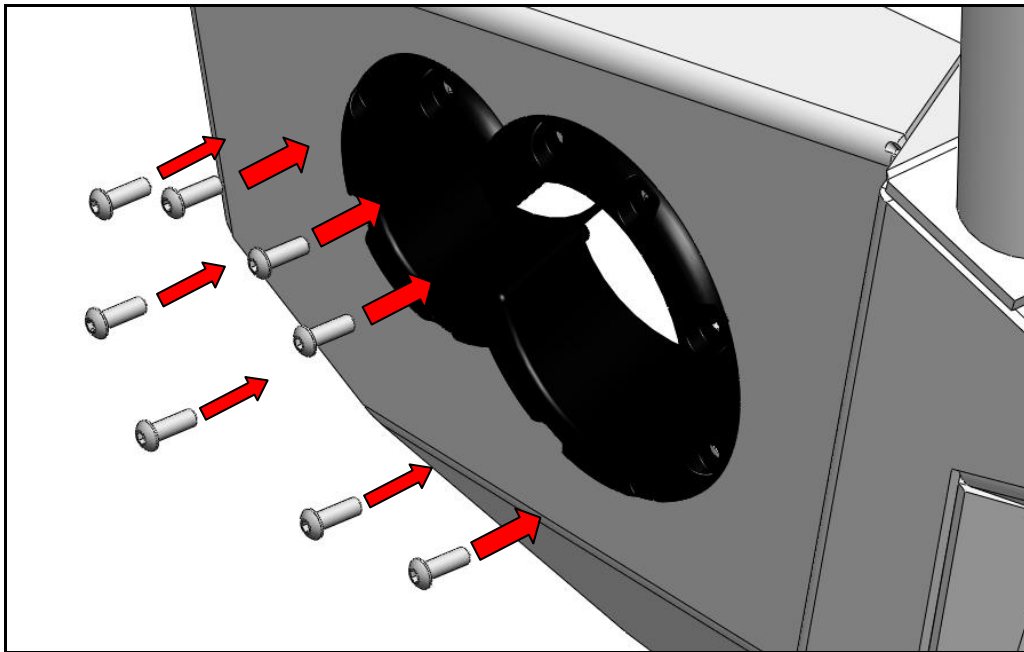


Figure 14 – Light Insert Installation

E. Install the Fab Fours fog lights onto the mounting brackets as shown below using the #8 button head screws, washers, and nylock hex nuts.

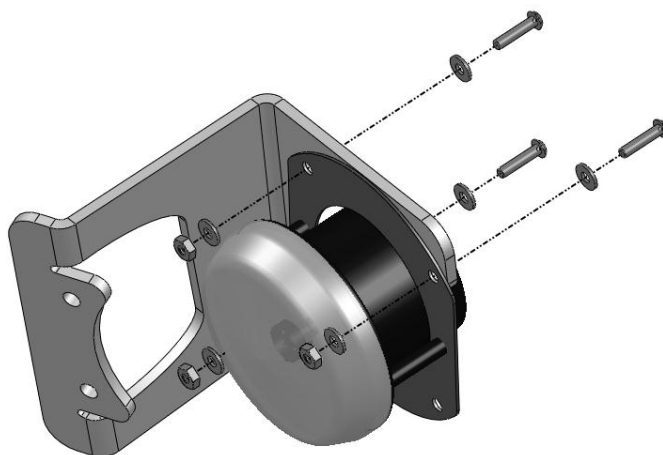


Figure 15 – Fog Light to Bracket Installation



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F. Install the fog light and bracket into the bumper using the remaining two holes available in the light insert. Use the 1-1/2" length 1/4" stainless steel button heads with 1/4" washers and nylock nuts.

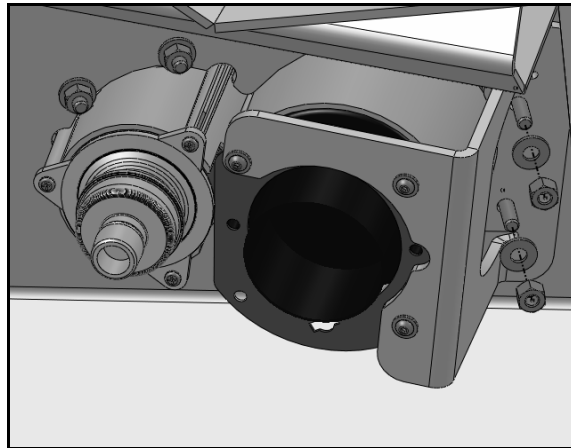


Figure 16 – Fog Light Installation

G. Repeat steps for other side.

H. Tap into the turn indicator wiring using the supplied tap connectors.

I. The turn indicator wiring harness may be installed at this time. To do so, remove the wiring harness and bulb socket from the lens housing. See below for wire color guide.



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WIRE COLORS:

| <u>WIRE</u> | <u>OEM COLOR</u> | <u>FAB FOURS COLOR</u> |
|-------------------|------------------------|------------------------|
| Running | - | White |
| TURN SIGNALS Turn | Red/Black (Driver) | Red |
| | Red/Yellow (Passenger) | |
| Ground | White/Black | Green |
| FOG LIGHT | Power | Red |
| | Ground | White/Black |

J. Tuck the Fab Fours provided wiring and bulb out of the way until the installation of the Fab Fours bumper is complete.

K. Tap into OEM fog light harnesses on each side of the vehicle using two supplied tap connectors.

L. Connect the supplied fog lamp wiring harnesses to tap connectors following wire color guide above.

M. Tuck OEM fog light harness and Fab Fours supplied wiring out of the way until completion of the bumper installation.



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VIII. Fab Fours bumper installation

A. Mount bumper brackets using OEM 14mm nuts. Fasten bottom of bracket to lower bumper beam using included 1/2" bolts, washers, and nuts. Do not completely tighten.

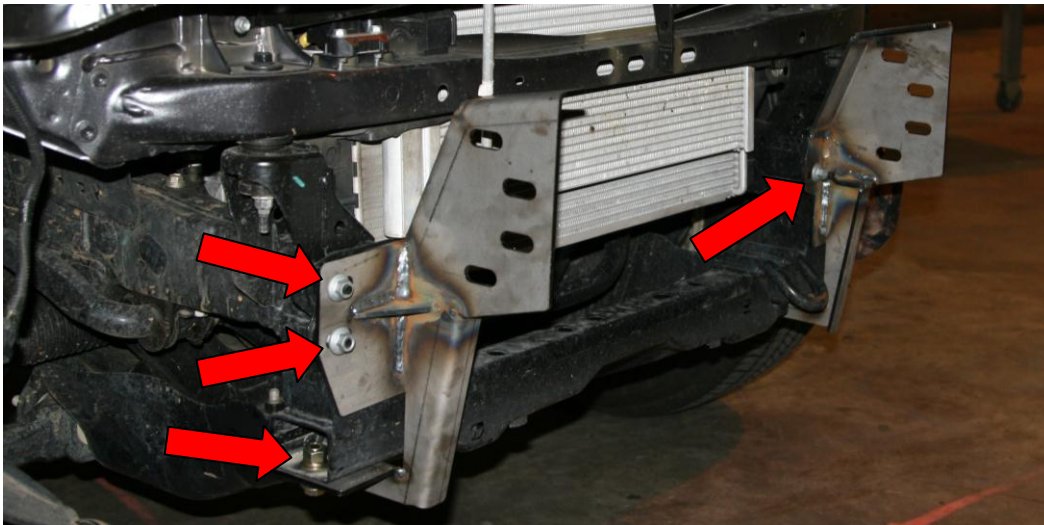


Figure 17 – Fab Fours bumper bracket installation



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B. Lift your Fab Fours bumper into place and insert the included bolt plates into the mounting holes. Do not attempt this without assistance! Use the included nuts and washers on the back side of the mounts once the bolt plates have been inserted, but do not fully tighten hardware at this point.

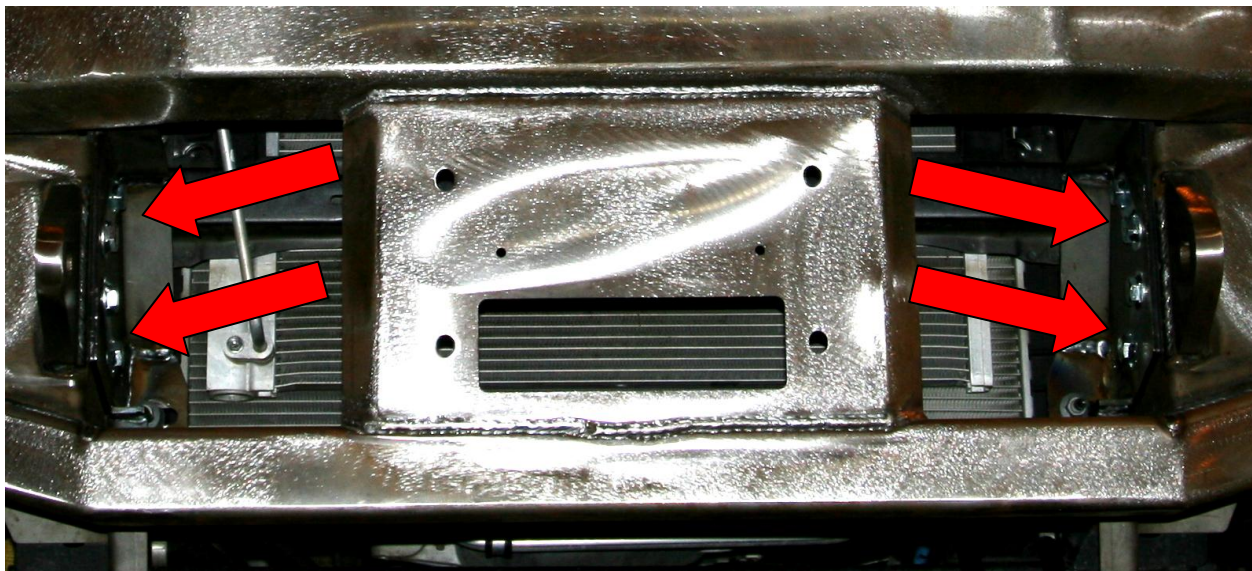


Figure 18 – Fab Fours bumper and hardware mounting

C. Adjust the bumper's center positioning at the frame mounts and tighten. Continue adjusting the bumper's position at the bumper mounts until you are satisfied with its location, then tighten all hardware.

D. Fasten the included center grill bracket to the OEM studs using two of the OEM 10mm nuts.



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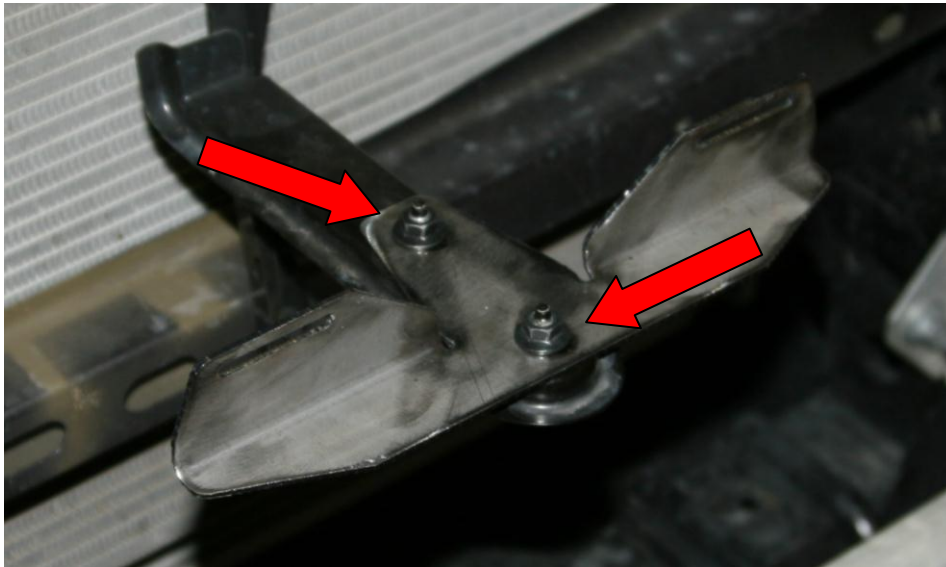


Figure 19 – Center grill bracket installation

E. Fasten the included outer grill brackets to the OEM studs using the OEM 10mm nuts. Additionally, you will need to drill a 1/4" hole in the OEM bracket to accommodate the 1/4" screws and nylok nuts.

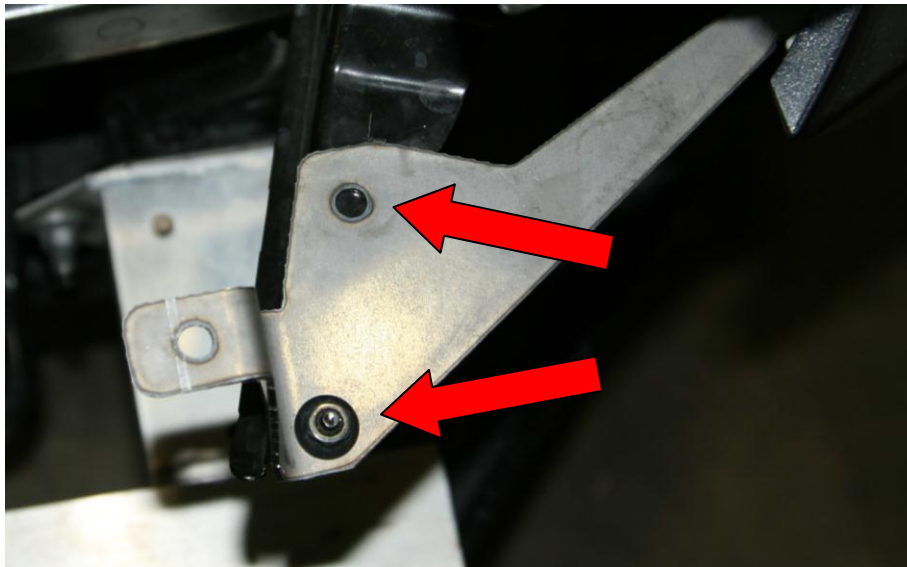


Figure 20 – Outer grill bracket installation



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F. Reinstall the factory grill and the trim pieces underneath the headlights.



Figure 21 – Completed bumper installation (shown with PreRunner tube option)

IX. 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



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More than expected... Better than expected