



**INSTALLATION MANUAL**  
**BLACK STEEL AND BLACK STEEL ELITE FRONT BUMPER**  
**PRODUCT NUMBERS: S596X OR Q596X**  
**APPLICATION: 2023 FORD SUPER DUTY**



## **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
8	INSTALLATION
25	CONTACT

# A MESSAGE FROM THE FOUNDER



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.

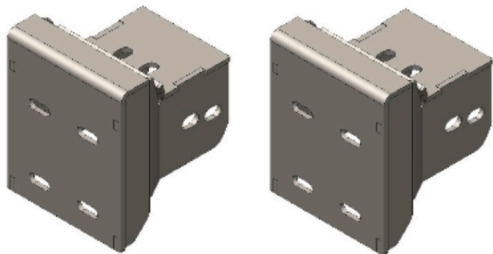
# PROVIDED MATERIALS



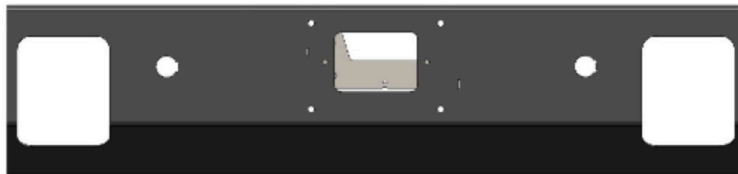
23063 - FRONT BUMPER TREAD  
23064 - FRONT BUMPER ELITE



61366 - TOW HOOKS QTY: 2



23065 - FRAME BRACKETS QTY:2



23074 - LOWER GUARD TREAD  
23075 - LOWER GUARD ELITE



61784 - BLACK PLASTIC SHEET

## TOOLS REQUIRED

- 18MM SOCKET WRENCH
- 3/4" SOCKET WRENCH & OPEN-END WRENCH
- 8MM SOCKET WRENCH (IF ACC EQUIPPED)
- 22MM SOCKET 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.

## HARDWARE KIT | 50424-HW

IDENTIFICATION NUMBER	COMPONENT DESCRIPTION	QTY
50424-HW	1/2" X 2" YELLOW ZINC HEX HEAD BOLT, GRADE 8	8
50424-HW	1/2" YELLOW ZINC FLAT WASHER, GRADE 8	16
50424-HW	1/2" YELLOW ZINC LOCK WASHER, GRADE 8	8
50424-HW	1/2" YELLOW ZINC HEX NUT, GRADE 8	8
50424-HW	M14-2X50 HEX HEAD BOLT ZINC	4
50424-HW	M14-2 HEX NUT ZINC	4
50424-HW	M14 FLAT WASHER ZINC	8
50424-HW	M14 LOCK WASHER ZINC	4
50424-HW	M6 BLACK BUTTON HEAD BOLT	2
50424-HW	M6 FLANGE HEX NUT	2
50424-HW	1 3/8" RUBBER GROMMET	4
50424-HW	3/4" BLACK PLASTIC PLUG	4

## HARDWARE KIT | 20260-HW

IDENTIFICATION NUMBER	COMPONENT DESCRIPTION	QTY
20260-HW	1/2" X 1" YELLOW ZINC HEX HEAD BOLT, GRADE 8	6
20260-HW	1/2" X 2.25" YELLOW ZINC HEX HEAD BOLT, GRADE 8	4
20260-HW	1/2" YELLOW ZINC LOCK WASHER, GRADE 8	16
20260-HW	1/2" YELLOW ZINC HEX NUT, GRADE 8	10
20260-HW	1/2" YELLOW ZINC FLAT WASHER, GRADE 8	20

# INSTALLATION

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1. Remove the plastic tow hook covers by pulling on them to release the clips. Figure 1



Figure 1

2. Disconnect the bumper electrical harness connected to the inside of the driver side frame rail. Figure 2



Figure 2



3. Using 18mm socket, unbolt OEM bolts from bumper (four per side) and remove bumper from truck. (Figure 3)



Figure 3

4. Use an 18mm socket to remove the two nuts on either side of the frame and remove the frame horns from the frame. Set aside the nuts and bolt strips for later use. Figure 4



Figure 4

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5. Remove OEM tow hooks by removing four (4) bottom bolts using 18mm socket. (Figure 5)



Figure 5

6. OPTIONAL: If you wish, add after market light pods at this time. Please refer to individual manufacturers wiring instructions and see image below as mounting reference. Figure 6



Figure 6

7. Remove the rubber shroud from the top of the OE bumper and install it onto the Black Steel bumper using the OE clips. Figure 7.



Figure 7

8. If equipped: removed the parking sensors and sensor housings from the OE bumper and install them into the Black Steel bumper. Use epoxy to hold the sensor housings in place. If your truck does not have sensors, use the provided rubber grommets, and plugs to fill the sensor holes. The wire hardness may have to be unraveled between the ACC plug and the driver side inner sensor to allow more wire between them. Figure 8a-8b.



Figure 8a



Figure 8b

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9. If equipped: Remove the Adaptive Cruise Control (ACC) sensor from the OE bumper and install it into the black steel lower guard using the OEM hardware. \*\*\*NOTE: Make sure that the sensor is perpendicular to the ground once the bumper is on the truck.\*\*\* Figure 9.

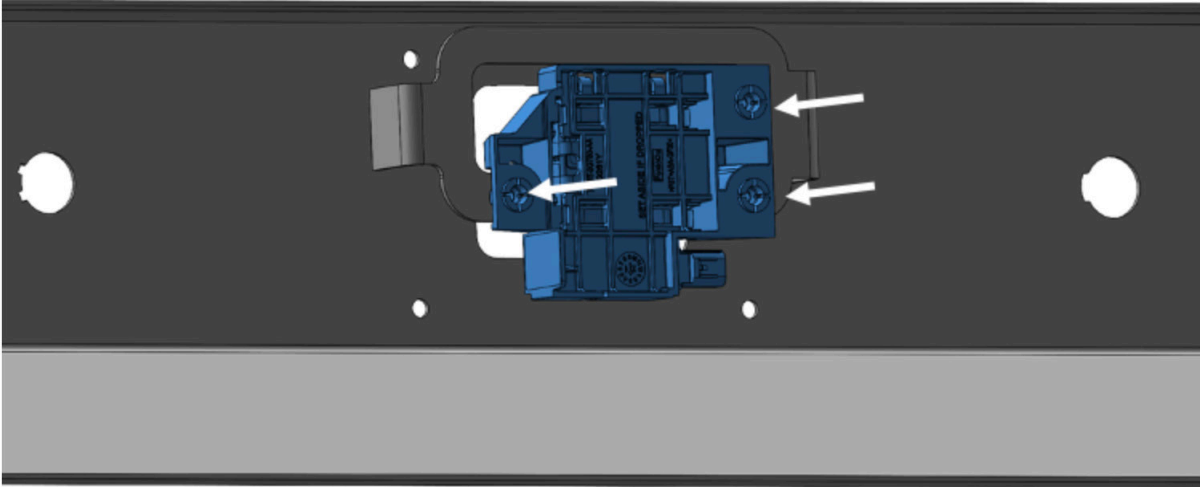


Figure 9

10. Cover the ACC sensor with the provided plastic sheet. Mark and drill the mounting holes using a 1/4" drill bit. Fasten the plastic over the ACC using the provided M6 black button head bolts and nuts (50424-HW). Figure 10.



Figure 10

11. Install lower guard (IF INSTALLING A WINCH, REFER TO WINCH TRAY INSTALLATION INSTRUCTIONS) by rotating it into position from the bottom of the bumper as shown below. Install three ½" fasteners (as provided in hardware bag labeled 20260-HW) per side with bolt heads facing the inside of the bumper. Figure 11.

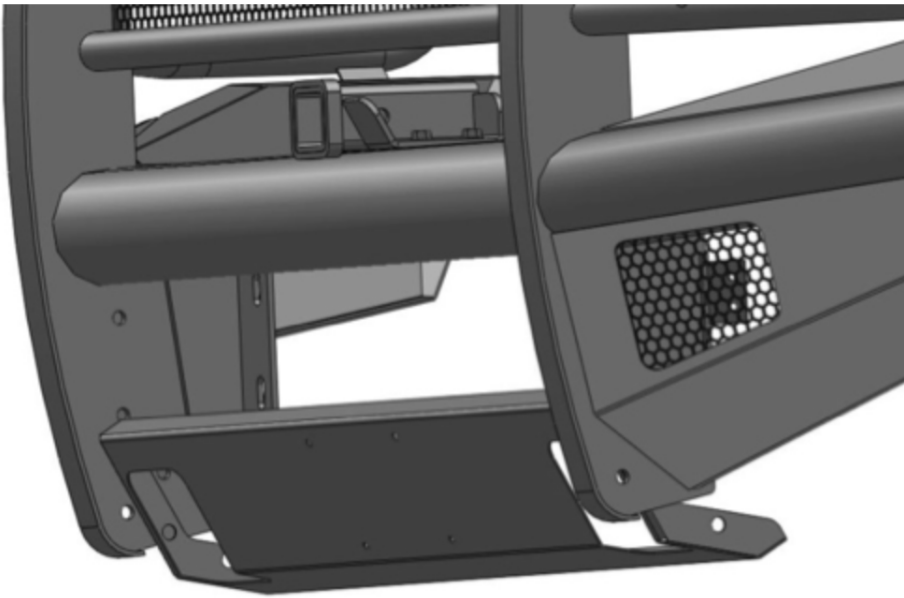


Figure 11

12. Install the frame brackets (23065) onto the frame using the bolt strips and nuts removed during step 4 along with the provided M14 hex head bolts, flat/lock washers, and nuts. Figure 12.



Figure 12

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13. With assistance, hold the bumper up to the truck and use the provided 1/2" hex head bolts with washers and nut (50424-HW) to fasten it to the frame brackets. Figure 13.



Figure 13

14. Use the provided 1/2" hex head bolts with washers and nuts to mount the two tow hooks (61366) to the bumper (20260-HW). Figure 14.

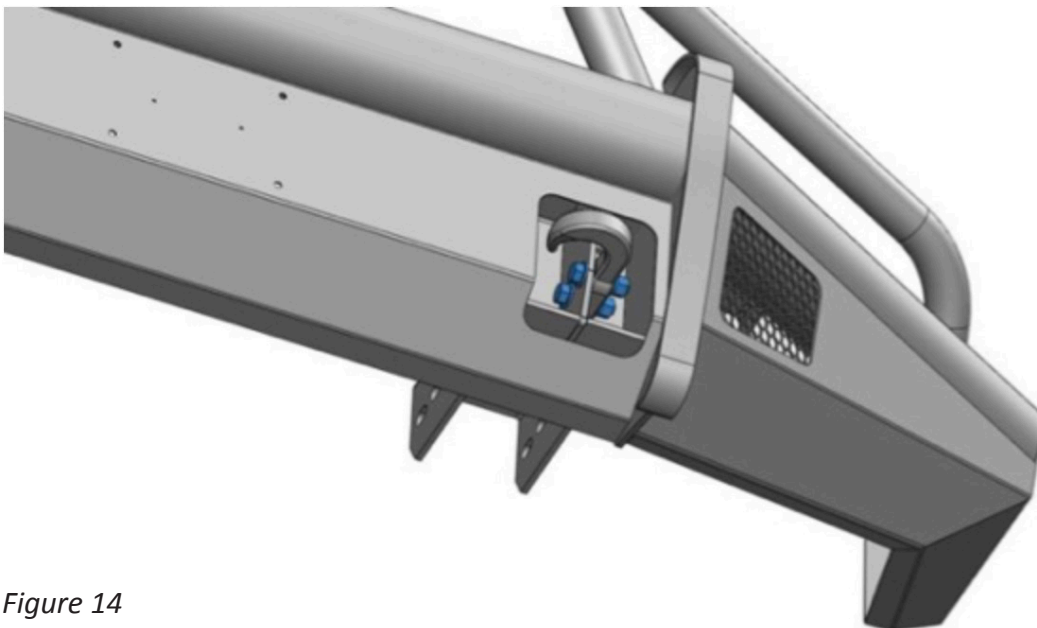


Figure 14

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15. Adjust the bumper as desired and fully tighten all mounting hardware. Plug in wiring harness if applicable.

**INSTALLATION COMPLETE**

# CONTACT INFORMATION

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**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**

