



INSTALLATION MANUAL
VENGEANCE FRONT BUMPER
PRODUCT NUMBER: V505X
APPLICATION: 2020 GMC HD



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

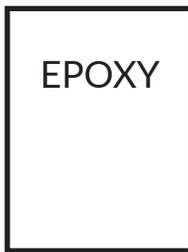
GETTING STARTED

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.

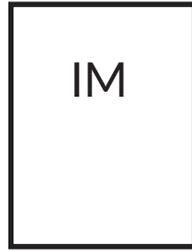
Failure to fully account for all components before beginning installation may leave vehicle immobile until part is acquired. Refer to the next pages as an inventory check.



PROVIDED MATERIALS



61632 x 2



V505X-IM



22219

TOOLS REQUIRED

- 7mm Socket Wrench
- 10mm socket wrench
- 15mm socket wrench
- 18mm socket wrench
- 7/16" Socket wrench
- 7/16" Open End wrench
- T10 Star Head wrench
- Pliers
- Body Pry Tool
- Wire Cutters

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.

DISASSEMBLY

NOTE: Sensors are extremely delicate and must be handled with care! Do not push on face of sensors to remove! Retain all OEM removed parts until installation is complete.

1. Open the hood and remove the nine (9) push pins holding the grill cover on using a body pry tool. Use a T15H star socket wrench to remove the two (2) bolts holding the hood latch on and remove the hood latch. Remove the grill cover from the truck and set aside for later install. (Figure 1)

2. Use a 10mm socket wrench to remove the four (4) bolts holding the top of the grill to the truck. Carefully pull the grill off the truck by disengaging the body clips. (Figure 2)

3. Use a 15mm socket wrench underneath the bumper to remove the four (4) bumper support bracket bolts. (Figure 3)



Figure 1



Figure 2



Figure 3

4. Use an 18mm socket wrench to remove the four (4) mounting bolts. (Figure 4)

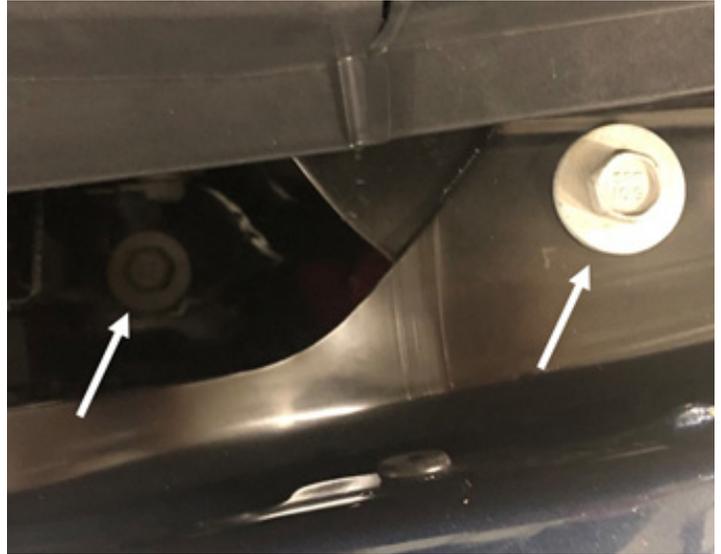


Figure 4

5. Unplug the four (4) bumper sensor harnesses before remove the bumper from the truck.

6. Use a 7mm socket wrench to remove the lower louvers from the mounting brackets. (Figure 5)



Figure 5

7. Use a 15mm socket wrench to remove the four (4) bolts holding the mounting brackets on. (Figure 6)

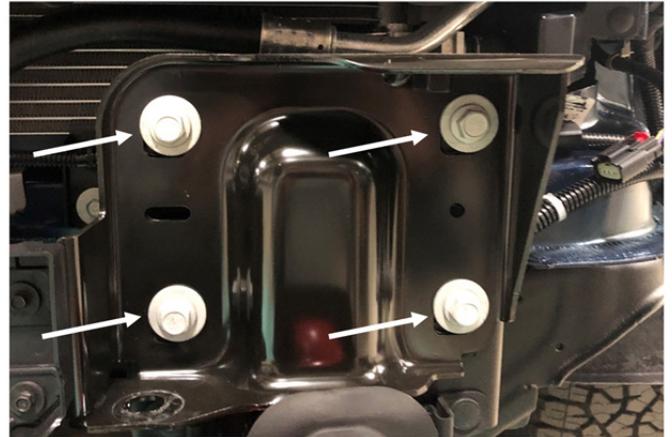


Figure 6

8. Remove the clip nuts from the mounting brackets using a pair of pliers to press the clips in. set aside for later use with the 7mm bolts. (Figure 7)

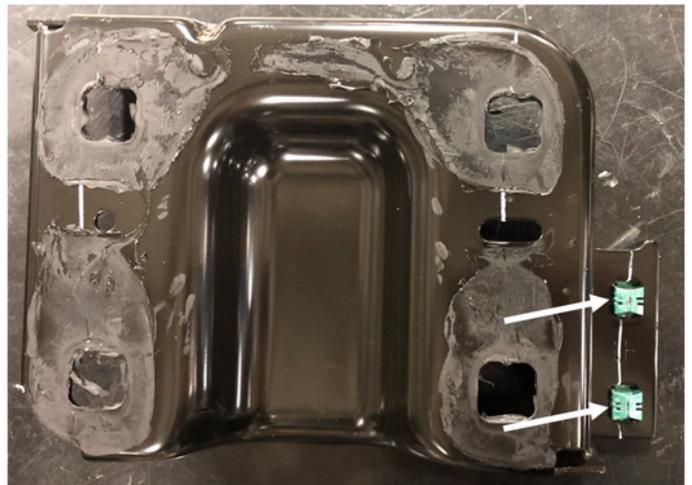


Figure 7

9. Use an 18mm socket wrench to remove the two (2) bolts holding the factory tow hooks onto the frame. (Figure 8)



Figure 8

10. Use a 15mm socket wrench to remove the nine (9) bolts holding the bumper structure on. Remove the metal structure from the bumper to access the sensor harness and Oem fog lights. (Figure 9)

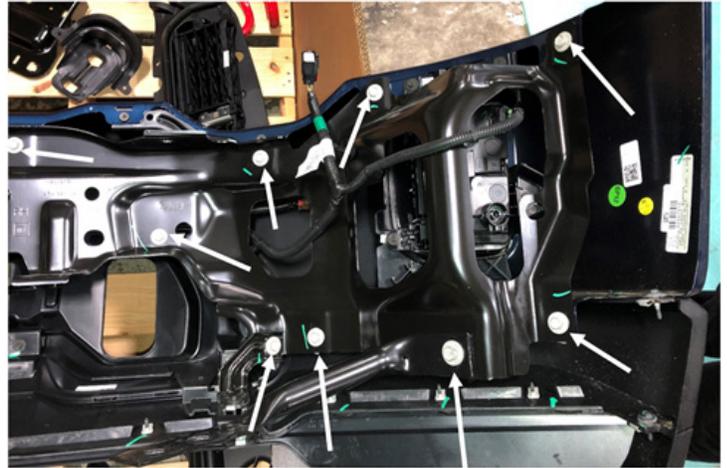


Figure 9

11. Unclip all the plugs holding the sensor harness to the bumper using a body pry tool. Carefully remove the sensor from the housing by pushing the housing apart and removing the sensor by pushing up. (Figure 10)

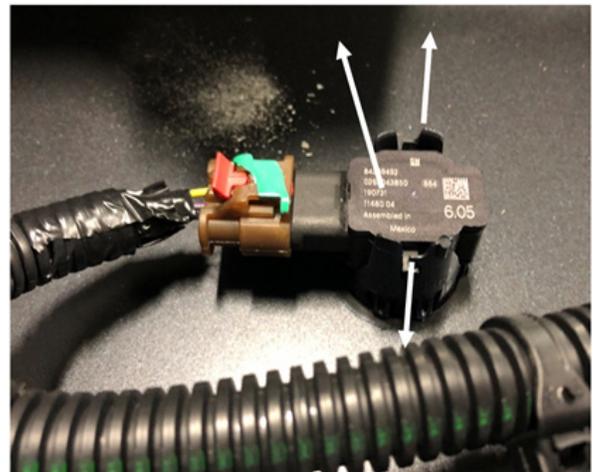


Figure 10

12. Remove the sensor housings from the bumper by pressing the four (4) clips in and pushing it out of the bumper. Make sure to mark what side of the bumper the housing came out of to install into the Fab Fours bumper. (Figure 11)



Figure 11

13. Remove the engine heater plug from the bumper by pressing in on the spring and turning clockwise. (Figure 12)



Figure 12

14. Disconnect the wiring harness from the lower louver system and reconnect it to the vehicle with the tail ending between the two frame rail ends. (Figure 13)



Figure 13

INSTALLATION

14. Using the provided epoxy, secure all four (4) Oem sensor housings in their appropriate sensor cutout in the bumper (22219). Allow twenty (20) minutes of time for the epoxy to cure. (Figure 14)



Figure 14

15. Route the Oem wiring harness through the bumper with the main wiring harness connector being on the passenger side of the bumper. (Figure 15)



Figure 15

16. Connect all four sensors to the wiring harness. Secure the wiring harness to the bumper using zip-ties. (Figure 16)



Figure 16

17. Install the center light at this time following the manufacturers instructions and using the manufacturers provided hardware.

18. Using the four (4) factory bolts and sheet metal clip nuts removed in step 8, fully secure the lower louver system to the mounts of the bumper. (Figure 17)

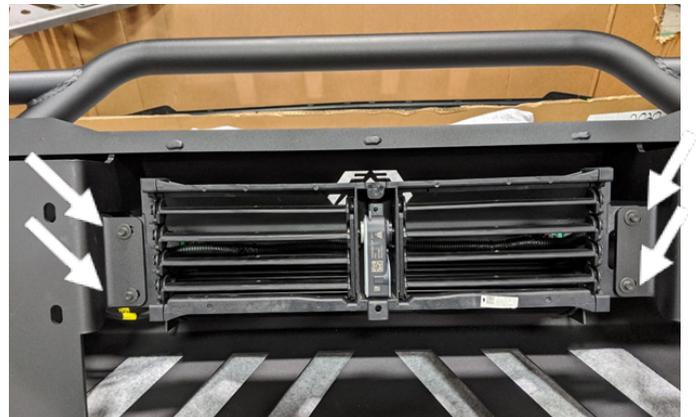


Figure 17

19. Install the Oem block heater harness to the mount of the bumper (22219) with the plug-in port facing forward towards the front of the bumper. (Figure 18)



Figure 18

20. With assistance of two other people, lift and align the bumper (22219) up to the frame rail ends.

***Note: Lights are intentionally left out of the fog light openings in order to provide additional access to the mounting bolts. Additional access to the bolts is available through the outer most slot in the bottom of the bumper.

21. Using the eight (8) Oem bumper bolts previously removed during step 7, loosely secure the bumper (22219) to the vehicle.

22. With assistance of two other people, lift and align the bumper with a consistent gap below the headlight valance. Using a 15mm socket wrench, fully tighten down the bumper to the frame rail ends.

23. Reconnect the lower louver system, block heater wiring harnesses.

24. Install any additional lights into the fog light openings using the manufacturers instructions and manufacturers provided hardware.
(Figure 19)

***Note: Figure 19 shown off the truck for visibility.

25. Secure any loose wiring with zip-ties.

26. Reconnect the main factory wiring harness.



Figure 19

CONTACT INFORMATION

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

- GREG HIGGS

