



**INSTALLATION MANUAL**  
**RED STEEL REAR BUMPER**  
**PRODUCT NUMBER: TT07-RT1550**  
**APPLICATION: 2007-13 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.**

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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.

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# A MESSAGE FROM THE OWNER

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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!

A handwritten signature in black ink that reads "Greg Higgs". The signature is written in a cursive, flowing style.

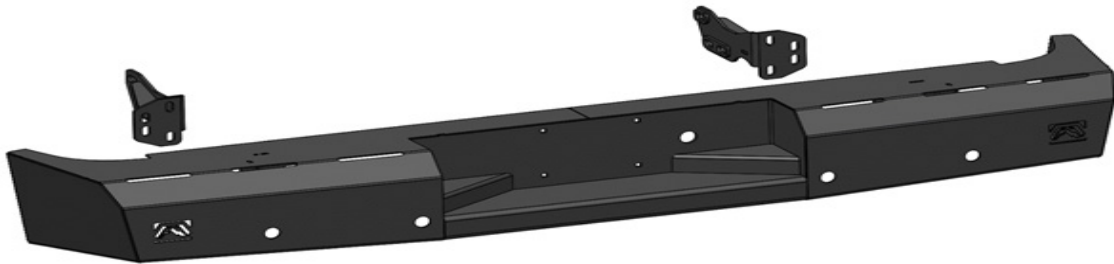
**FOUNDER, FAB FOURS**

# GETTING STARTED

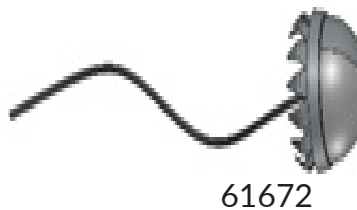
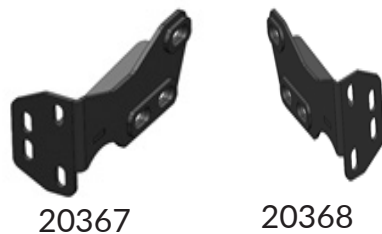
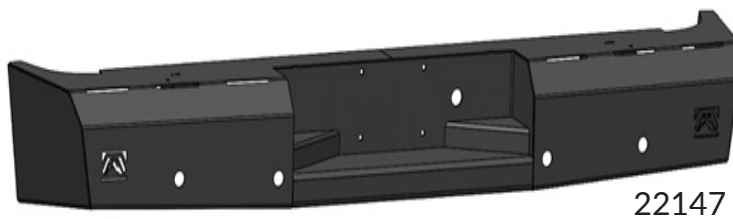
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Before you begin the installation process of your new Fab Fours product, we suggest laying out all materials and parts on a pad or protective surface.

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



## HARDWARE KIT | TXX50

FAB FOURS IDENTIFICATION	COMPONENT DESCRIPTION	QTY
61374-HW	½" License Plate Nut, Plastic	4
61374-HW	½"-13 Hex Nut, Yellow Zinc, Grade 8	8
61374-HW	½" Lock Washer, Yellow Zinc, Grade 8	8
61374-HW	½" Flat Washer, Yellow Zinc, Grade 8	8
61374-HW	1-¾" Rubber Grommet, Plastic	4
61374-HW	Plastic Plug	4
61374-HW		

## TOOLS REQUIRED

- 3/8" Socket wrench
- 3/4" Socket wrench
- 15mm Socket wrench
- 18mm Socket wrench
- 22mm Socket wrench
- 3/8" Box end wrench
- 3/4" Box end wrench
- 15mm Box end wrench
- 18mm Box end wrench
- 22mm Box end wrench
- Flat head screwdriver
- Phillips head screwdriver
- 5/32" Allen key

## 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: Save all OEM parts until installation is complete!*

1. Using a screwdriver, remove the license plate from your OEM bumper.
2. Using a screwdriver, remove the one (1) screw that sits behind the license plate area. (Figure 1)
3. Disconnect the OEM wiring harness from the license plate lights, trailer plug receptacle, and back up sensors if applicable.
4. Remove the plastic corner pieces from the top of the OEM bumper by pulling up from the outside edge. If the plastic is being stubborn during removal the plastic clips can be popped loose from the bottom side of the bumper. (Figure 2)



Figure 1



Figure 2

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**5. Pop the plastic clips loose on the bottom side of the main piece of plastic on the top side of the bumper allowing access to the Oem fasteners. (Figure 3)**



*Figure 3*

**6. With assistance, support the bumper on both sides in preparation of bumper removal.**

**7. Using a 12mm socket wrench, remove the eight (8) Oem fasteners holding the Oem bumper shell to the receiver hitch.**

**8. Remove the Oem bumper and set aside.**



# INSTALLATION

9. Using a 19mm socket and wrench to remove the three bolts from each side of the hitch frame plate.

10. Using the OE Hardware install the supplied intermediate mounting brackets (20367 & 20368) to the hitch frame plate. Four (4) stud plates (20296) should be inserted into the slots of the mounts after mounting the brackets (20367 & 20368) to the frame rails. Complete on both driver and passenger sides of vehicle. Do not fully tighten, snug up only. (Figure 4)

11. With the help of two friends and possibly a floor jack to help support the center of the bumper, lift the rear bumper into place.

12. With the bumper held into place insert the four (4) stud plates (20296) through the intermediate brackets (20367 & 20368) and into the bumper brackets placing the eight (8) 1/2"-13 yellow zinc hex nuts, lock washer and flat washer on the front side of the frame mount. Do not fully tighten, snug up only. (Figure 5 & 6) (61374-HW)

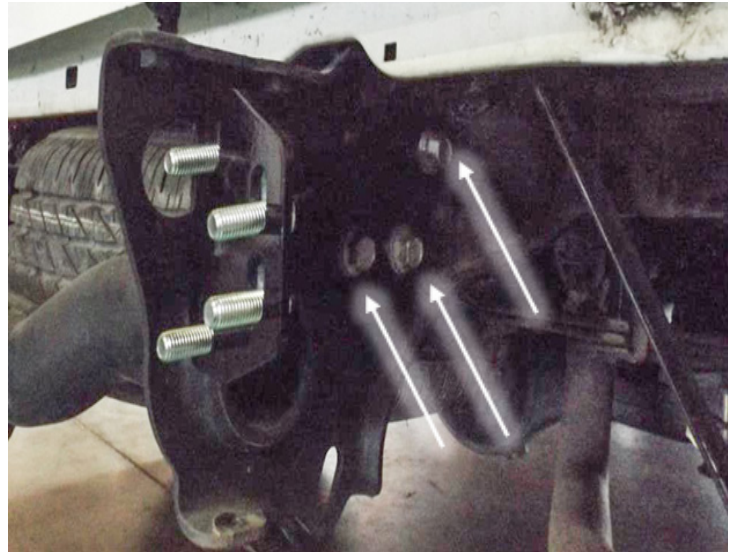


Figure 4

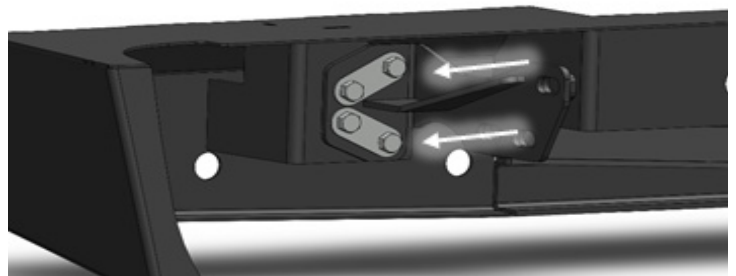


Figure 5



Figure 6

# INSTALLATION

13. Align the bumper side to side and top to bottom to ensure a perfect fit to the truck. Allow for a 0.5" clearance to all painted surfaces if possible, to allow for frame flex.

14. Check that the tailgate does not interfere with the bumper by opening it very carefully and lowering it into place. If tailgate is too close to the bumper, adjust bumper lower.

15. Using a 19mm socket wrench, fully tighten all fasteners between intermediate brackets (20367 & 20368) and frame.

16. Using a ¾" socket wrench, fully tighten all fasteners between intermediate brackets (20367 & 20368) and bumper (22147).

17. Install the supplied license plate light by inserting it into the round hole. Tap into OEM wiring.

18. Install supplied license plate plastic nut inserts and license plate. (Figure 7) (61374-HW)

19. Install grommets into sensor holes of the bumper (22147). (61374-HW) If equipped, insert sensors from the back side. If not equipped, install provided plugs into the grommets. (61374-HW)

20. Reconnect the bumper wiring harness to the vehicle harness connector.

21. Secure all loose wiring and harnesses to the frame or bumper with zip ties.

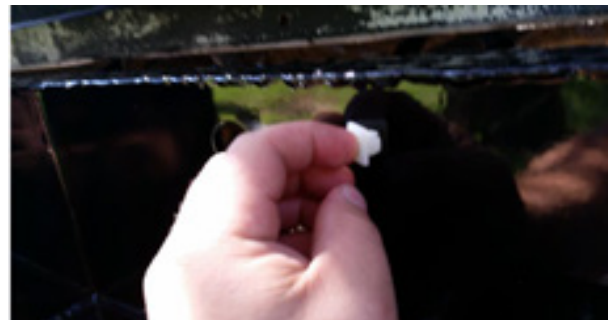


Figure 7