



# Installation Instructions

## 2019 CHEVY 1500 Vengeance Bumper

Product Number: D405X

Application: '19 CHEVY 1500

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### SAFETY

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**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.

**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**

**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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Congratulations on your purchase of the industries' best and most stylish truck bumper available for the 2019 Chevy 1500! This bumper has been engineered for strength while keeping the weight down.

Your Front Bumper was 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 Chevy 1500 bumper from Fab Fours Inc.



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### PROVIDED MATERIAL

Fab Fours Component #	Component Description	BOM Qty
50155-HW	1/4"-20 x 1", HHCS , Zinc, GR8	2
50155-HW	1/4"-SAE x , Flat Washer , Zinc, GR8	4
50155-HW	1/4"-SAE x , Lock Washer , Zinc, GR8	2
50155-HW	1/4"-20 x , Hex Nut , Zinc, GR8	2
50155-HW	7/16"-14 x 1.25", HHCS , Zinc, GR8	6
50155-HW	7/16"-SAE x , Flat Washer, Zinc, GR8	6
50155-HW	7/16"-SAE x , Lock Washer , Zinc, GR8	6
50155-HW	3/8"-16 x 1", HHCS , Zinc, GR8	10
50155-HW	3/8"-SAE x , Flat Washer , Zinc, GR8	10
50155-HW	3/8"-SAE x , Lock Washer , Zinc, GR8	10
50155-HW	1/2"-13 x 1.25" Hex Bolt, Gr 8, Zinc	3
50155-HW	1/2 SAE FLAT WASHER GRADE 8 Z&Y	6
50155-HW	1/2"-SAE x , Lock Washer , Zinc, GR8	3
50155-HW	1/2"-13, x , Hex Nut , Zinc, GR8	3

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### REMOVAL OF OEM BUMPER

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

1. Disconnect the electrical connector on the passenger side of the bumper by pulling on the red tab and depressing the locking clip. **(Figure 1)**



Figure 1

2. Locate and remove the two (2) bolts on each the driver and passenger side holding the intermediate bumper brackets to the bumper. **(Figure 2)**



Figure 2

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3. Remove the two (2) bolts on each the driver and passenger side holding the outer bumper reinforcement bars to the frame (**Figure 3**)



**Figure 3**

4. With the bumper removed from the vehicle, remove the intermediate brackets from the frame by removing the three (3) bolts on each the driver and passenger side. (**Figure 4**)



**Figure 4**

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5. Remove the two (2) bolts attaching the lower portion of the bumper to the underside of the frame rails. (**Figure 5**)

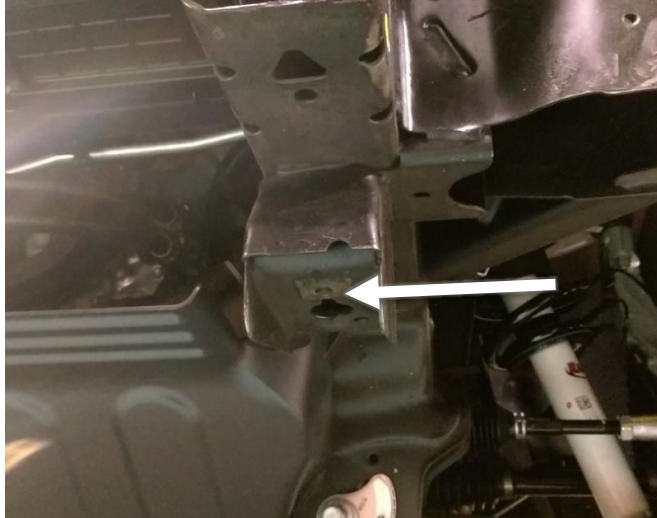


Figure 5

6. Remove OEM electrical harness from bumper by removing the push pins. (**Figure 6-7**)

**NOTE:** Document the location of each sensor housing for reference when reinstalling into your bumper.



Figure 6



Figure 7

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7. Disconnect the electrical harness from the fog lights in the bumper. **(Figure 8)**



Figure 8

8. Remove the sensor from the sensor housing by expanding both sides of the sensor housing and lifting up. **(Figure 9-10)**

***NOTE: Sensors are extremely delicate and must be handled with care! Do not push on face of sensors to remove!***



Figure 9



Figure 10

9. Remove the sensor housing from the bumper by depressing the four (4) tabs while pulling outward from the outside of the bumper. **(Figure 11-11.1)**

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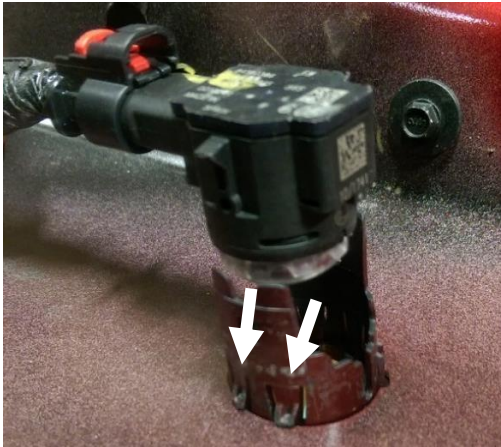


Figure 11



Figure 11.1

### BUMPER INSTALLATION

*NOTE: Use painters tape to protect any areas of the vehicle that may contact the Fab Fours product during installation.*

*NOTE: If installing any lights into the bumper, they can be installed prior to bumper installation. Follow the lighting manufacturer's instructions for installation. Two adjustable angle brackets are included for the center 20" opening.*

1. To install the two (2) wing inserts, place the spring tab into the tab hoop. Install a 3/8"-16 yellow zinc bolt, lock washer and flat washer, provided in the hardware kit, into each of the bolt tabs. **(Figure 12)**

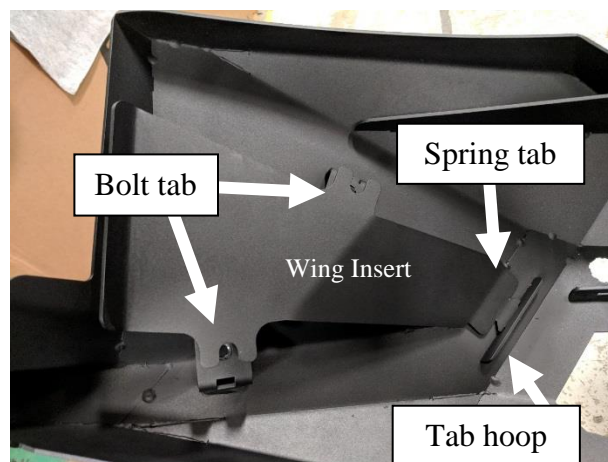


Figure 12

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- Using the 3/8"-16 yellow zinc bolt, lock washer and flat washer provided in the hardware kit, install the two (2) tow hook boxes into the bumper. (Figure 13)

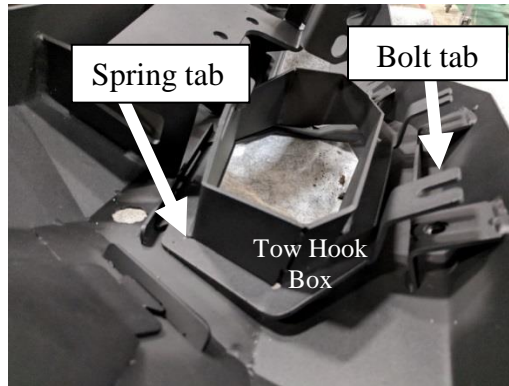


Figure 13

- Install the angle bracket, short end against the driver side bumper mounting bracket, using the 1/2"-20 yellow zinc bolt, flat washer, lock washer bolt stacks provided in the hardware kit. (Figure 14)

**NOTE:** The angle bracket is intended for mounting a 20" lightbar or the optional Fab Fours Vengeance Mesh Insert Cover.



Figure 14

- Repeat step 3 for the passenger side.



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5. Install the sensor housings into the bumper in the OEM orientations documented when removed. Route the electrical harness to each sensor housing, reinserting the sensors into their corresponding housing. **DO NOT EPOXY AT THIS TIME!**
6. With assistance, lift the bumper into position. Loosely install three (3) 7/16"-14 yellow zinc bolt, lock washer and flat washer sets through the back side of the frame horn on the driver side into the nuts attached to the bumper mounts. (**Figure 15**)

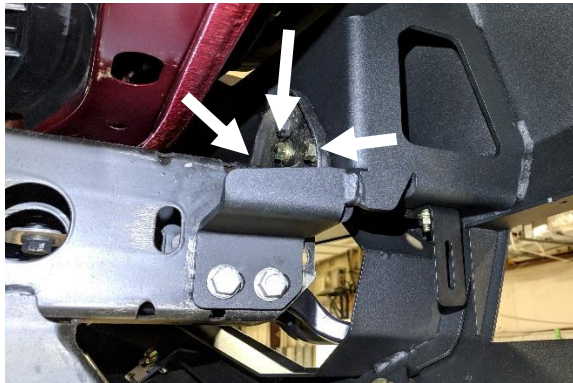


Figure 15

7. Loosely install two (2) of the provided 1/2"-13 yellow zinc bolt, lock washer and flat washer bolt stacks on the inside of the driver side frame rail if not equipped with factory tow hooks. If reinstalling the factory tow hooks, reinstall using the OEM hardware. (**Figure 16**)

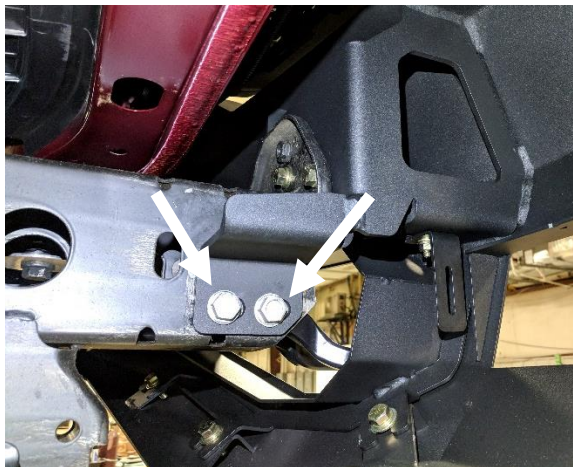


Figure 16

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8. Repeat step 7 for the passenger side. If not equipped with factory tow hooks, use one (1) of the provided 1/2"-13 yellow zinc bolt, lock washer and flat washer bolt stacks.
9. With assistance, align the bumper center with the vehicle and ensure the gap between the bumper and bottom of headlight are consistent on each side. While holding the bumper in place, fully tighten all six (6) 7/16"-14 bolt stacks loosely installed in step 6.
10. Fully tighten the three (3) 1/2"-13 bolt stacks or factory tow hooks to each side of the frame rails that were loosely installed in step 7.
11. After ensuring sensors work in current orientation, epoxy should be applied to the housing on inside of bumper and allowed to dry.

***NOTE: We recommend using painter's tape on the outside of the bumper to hold the sensor housing in the proper orientation while the epoxy dries.***

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### Maintenance/Care

- Periodically check and tighten all fasteners.
- Stripped, fractured, or bent bolts or nuts need to be replaced.

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