



**INSTALLATION MANUAL**  
**VENGEANCE FRONT BUMPER**  
**PRODUCT NUMBER: D425X**  
**APPLICATION: 2019 DODGE RAM 1500**



## **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 WILL 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

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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 it's 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!

*Ereg Higgs*

**FOUNDER, FAB FOURS**

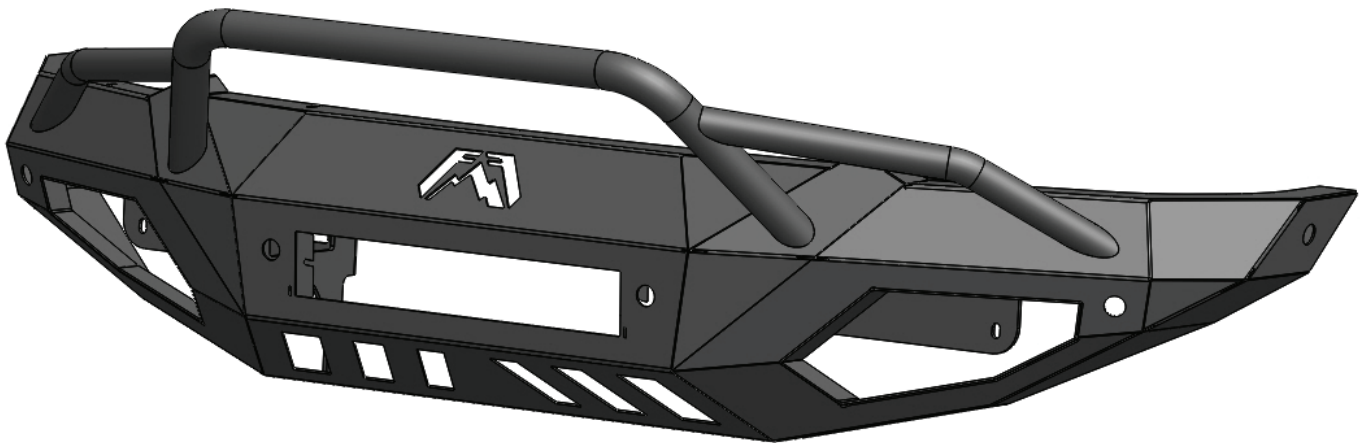


# GETTING STARTED

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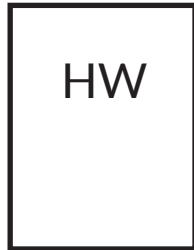
Before you begin the installation process of your new Fab Fours product, we suggest laying out all materials and parts on a pad or protective surface.

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.

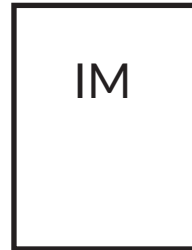


# PROVIDED MATERIALS

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50166-HW



D425X-IM



# HARDWARE KIT | 50166

FAB FOURS IDENTIFICATION	COMPONENT DESCRIPTION	QTY
50166- HW	7/16"-14 X 1 1/2 stainless steel button socket cap, 18/8	2
50166- HW	7/16"-14 x 1.25", yellow zinc hex cap screw, Grade 8	4
50166- HW	7/16"-14, stainless steel hex nut, 18/8SS	2
50166- HW	7/16"-14 x, yellow zinc hex nut, Grade 8	4
50166- HW	7/16", stainless steel washer, USS, 18-8	4
50166- HW	7/16"-SAE x, yellow zinc flat washer, Grade 8	8
50166- HW	7/16"-SAE x, yellow zinc lock washer, Grade 8	4
50166- HW	7/16", stainless steel lock washer, 18-8	2

## TOOLS REQUIRED

- 10mm socket
- 18mm socket
- 5/8" socket/wrench
- 11/16" socket/wrench
- Allen wrench hex key set

## INSTALLATION

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.

# FACTORY BUMPER REMOVAL

1. Remove the five (5) 10mm bolts located under the driver and passenger side wheel wells. Once the bolts have been removed, remove the plastic wheel well covers from the vehicle. (Figure 1, Figure 2)

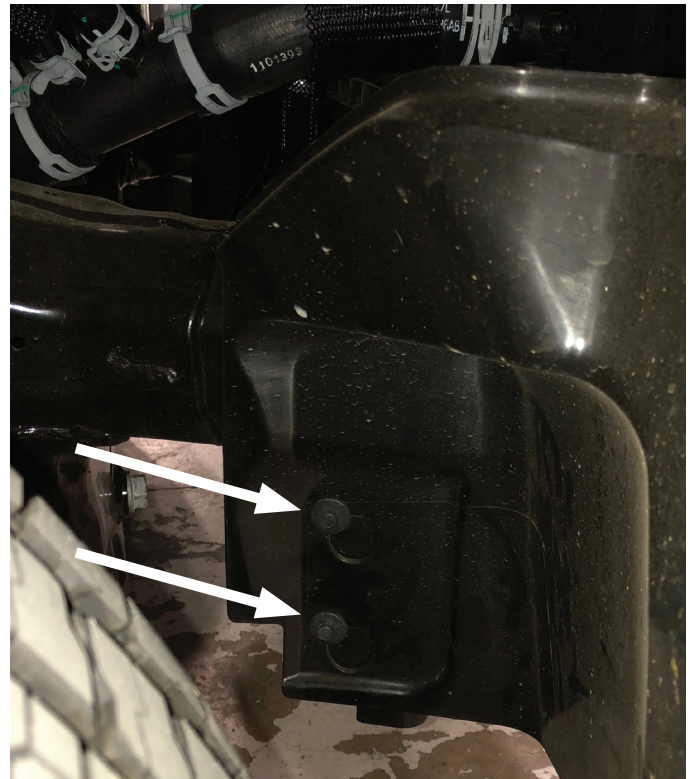


Figure 1



Figure 2



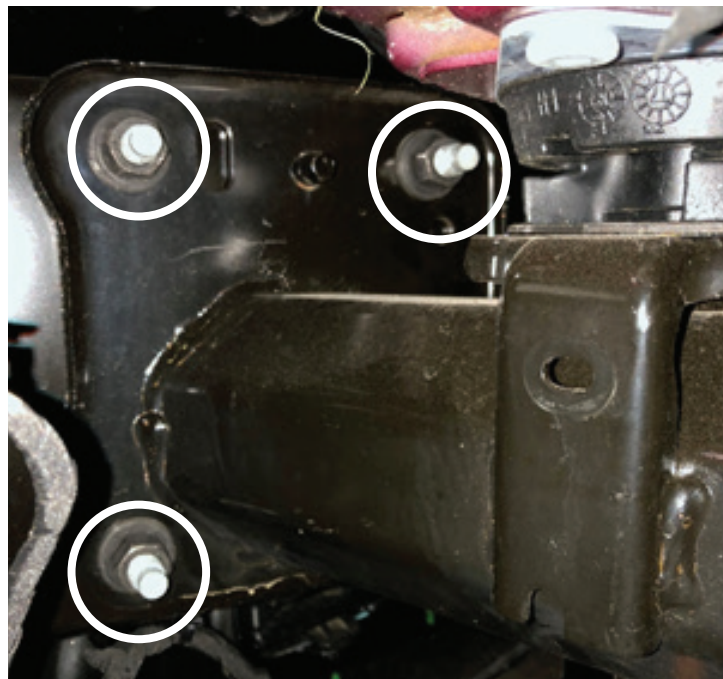
**2. Locate the harness plug on the driver side of the vehicle and disconnect it. (Figure 3)**



*Figure 3*

**3. Using a 18mm socket, remove the three (3) OEM nuts from both sides of the frame rail to disconnect the bumper from the truck. (Figure 4)**

**4. Remove the OEM bumper from the truck and set it aside.**



*Figure 4*

**5. Remove the OEM electrical harness from bumper by removing the push pins. (Figure 5, Figure 6)**

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



Figure 5



Figure 6

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



Figure 7



**7. Remove the sensor from the sensor housing by expanding both sides of the sensor housing and lift up. (Figure 8, Figure 9)**

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



*Figure 8*



*Figure 9*

8. Remove the sensor housing from the bumper by depressing the four (4) tabs while pulling outward from the outside of the bumper. (Figure 10, Figure 11)

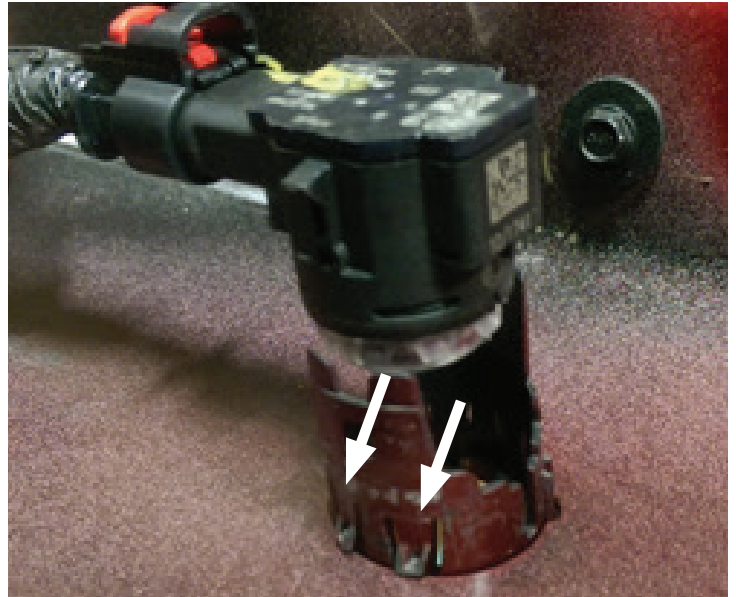


Figure 10



Figure 11



# VENGEANCE 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.*

- 1. Remove the bumper from its packaging and place it face down to install the OEM sensor housings and harness**

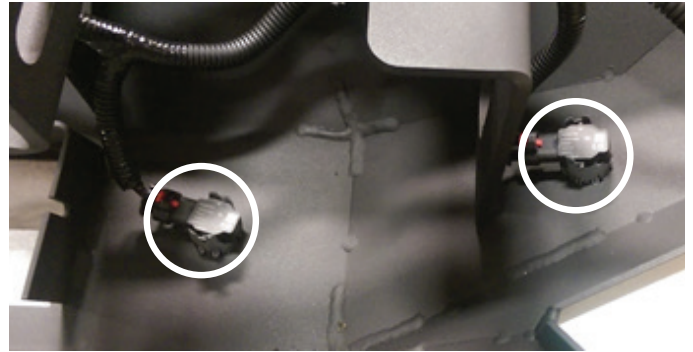
*Note: Make sure the harness plug is on the driver side of the bumper when installing.*

- 2. Install the sensor housings into the appropriate slots by inserting each housing from the outside of the bumper in. (Figure 12)**



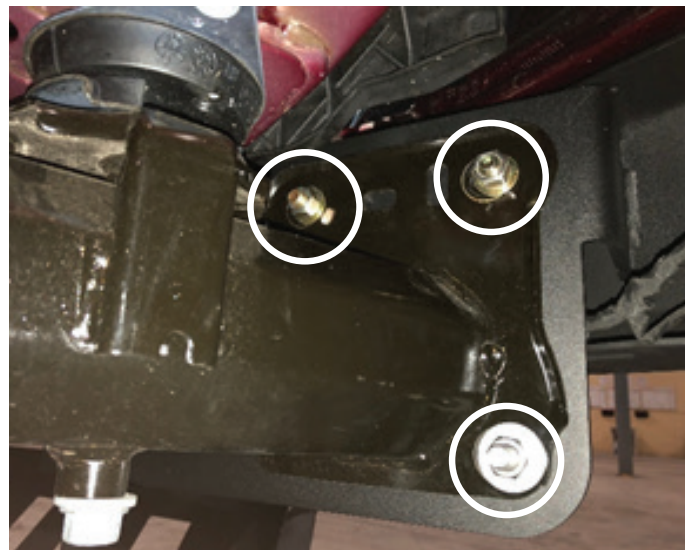
Figure 12

**3. Replace the sensors in the appropriate housings and zip-tie any loose harness to the bumper. (Figure 13)**



*Figure 13*

**4. With assistance, hold the bumper to the frame and use the four (4) 7/16" yellow zinc bolts with washers to loosely install the bumper to the top portion of the frame. (Figure 14)**



*Figure 14*

**5. Use the two (2) stainless steel button head 7/16" bolts and washers to fasten the third lower frame mount. (Figure 15)**



*Figure 15*

**6. Adjust your bumper to the desired location on the truck. Fully tighten all mounting bolts.**