



# Installation Instructions

## Vengeance Rear Bumper

Product Number: E4351

Application: 2017 Ford Raptor

### SAFETY

**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.

**Read and understand all safety precautions and instructions before installing this product.**

**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.**

### Injury hazard

**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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### I. Overview

Congratulations on your purchase of the industries' best and most stylish Ford Raptor Rear Bumper! This bumper has been **engineered** for strength while keeping the weight down.

This product has also been **engineered** to allow alignment in two directions so you end up with a very professional fit.

Your bumper was designed in 3-D, fabricated, and powder coated... all in the U.S.A.

Enjoy the fit and finish of a quality Ford Raptor Rear Bumper from Fab Fours Inc!



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### II. Vehicle Preparation

1. Start by locating the trailer, tag lights, and sensor plugs. Unplug all of these.



2. Carefully remove the plastic cover on the top of the bumper using your hands only. Start at one end and work each clip slowly to prevent damage to stock components.



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3. Next using a T40 Torx Bit, remove the 5 bolts holding each side of the bumper to the truck. (Two are hidden in the picture below on the outside of the bumper)



### III. Sensor Installation

1. Remove sensors for rear bumper and place them in corresponding location in Fab Fours Bumper. Sensor harness routing shown below. Each sensor remains in it's stock location (i.e. driver's side inner stays in the driver's side inner location)

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2. Sensor housings should be epoxied only AFTER testing to ensure that they still work.



Drivers side sensor harness orientation. Passenger side is mirrored.

### **IV. Bumper Installation**

1. Install the black license plate lights into the bumper by first separating the black lens from the metal housing. Clamp the bumper between the two halves using the supplied #8 hardware. These will be wired once the bumper is installed.
2. Drill the OEM Trailer Hitch Plug using a #16 Drill Bit (.177") in the locations pointed out with arrows below. Use care to drill directly in the center of the circles in the plastic.

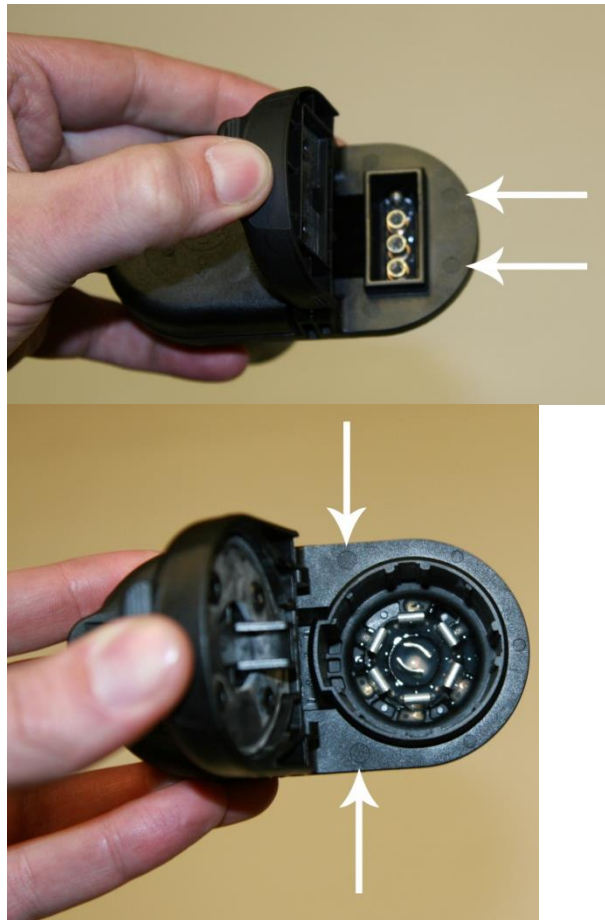
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3. Install the trailer plug into the cutout in the new bumper using the #8 supplied hardware.
4. Next using provided terminals splice into factory tag light wiring.

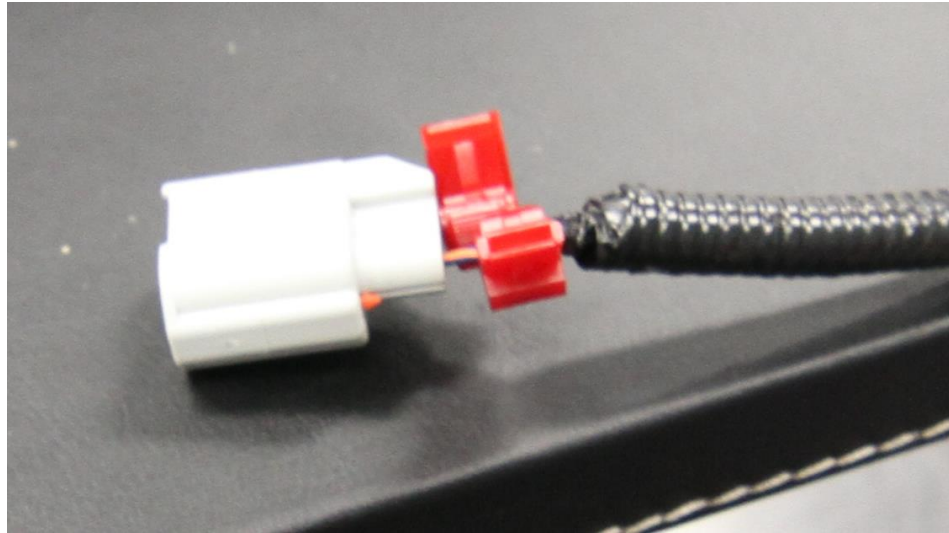
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5. Next slide bumper into place by line up Fab Fours mounting bracket with OEM mounting location on the outside of the frame.
6. Loosely install the provided 7/16 bolts with washers, lock washers, and nuts.
7. Finally position bumper into desired location and tighten all loose hardware.
8. To complete installation you can now hook up tag lights and plug in the trailer plug connector.

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#### V. Maintenance/Care

- Periodically check and tighten all fasteners.
- Stripped, fractured, or bent bolts or nuts need to be replaced.
- Keep all surfaces free of dirt, road grime, and standing water to ensure finish longevity.

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