



**INSTALLATION MANUAL**  
**PREMIUM REAR BUMPER**  
**PRODUCT NUMBER: Y5251**  
**APPLICATION: 2021 FORD BRONCO**



## **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!

*Greg Higgs*

FOUNDER, FAB FOURS

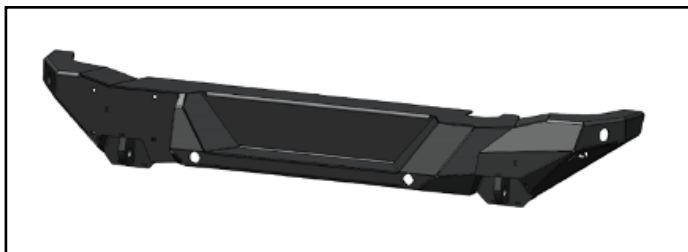
# GETTING STARTED

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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



22539 – PREMIUM REAR BUMPER

61632 – EPOXY  
QTY 2

50300-HW –  
HARDWARE KIT

## HARDWARE KIT | Y5251

FAB FOURS IDENTIFICATION	COMPONENT DESCRIPTION	QTY
50300	7/16"-14 x 1.25", Hex Head Cap Screw, Grade 8, Yellow-Zinc	2
50300	7/16", Lock Washer, Grade 8, Yellow-Zinc	2
50300	7/16", USS Flat Washer, Yellow-Zinc	4
50300	7/16"-14, Hex Nut, Grade 8, Yellow-Zinc	2
50300	1/2" License Plate Nut	4
50300	Round Plastic Plug	4
50300	1 3/8", Rubber Grommet	4

## TOOLS REQUIRED

- 13mm Socket Wrench
- 15mm Socket Wrench
- 18mm Socket Wrench
- 5/8" Socket Wrench
- 5/8" Combination Wrench
- Body Panel Pry Tool

## 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.

## ASSISTANCE

This manual shows the six sensor configuration for illustration purposes but your specific installation may vary.

# DISASSEMBLY

1. Disconnect the wiring harness located on the driver side of the vehicle between the frame and the bumper by depressing the tab on the side of the connector and pulling the two halves apart. Figure 1. Repeat on the passenger side if applicable.

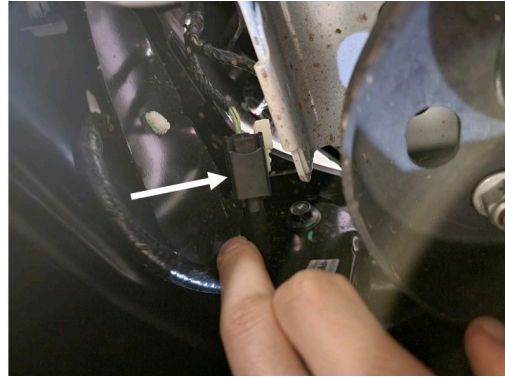


Figure 1

2. If your vehicle is equipped with two tow hooks use an 18mm socket wrench to remove the two (2) bolts per side holding the bumper to the frame. If your vehicle has only one (1) tow hook, you will also need a 15mm socket wrench. Figure 2.

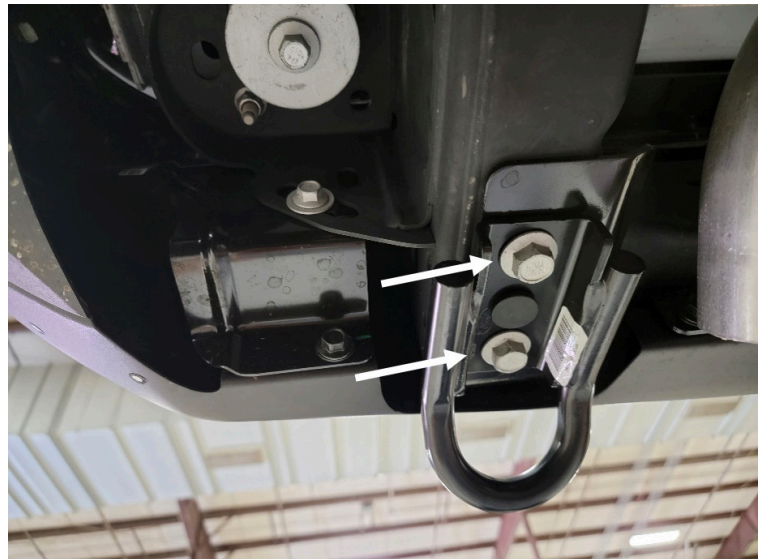


Figure 2

3. Using a 13mm socket wrench, remove the one (1) bolt per side holding the bumper to the body mount and remove the bumper from the vehicle. Figure 3.



Figure 3

4. If vehicle is equipped with sensors; carefully remove them from their housings by gently pulling the housing clips away from the sensor and pushing the sensor out. Remove the housings from the OEM bumper by compressing the clips on the inside and pushing the housing out of the bumper. NOTE: Both the sensors and the housings are delicate and should be handled with care. Mark the location of every sensor and its respective housing for installation into the new bumper. Figure 4-7



Figure 4

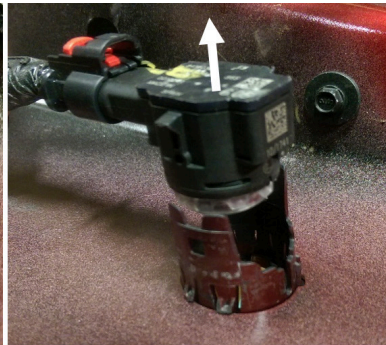


Figure 5

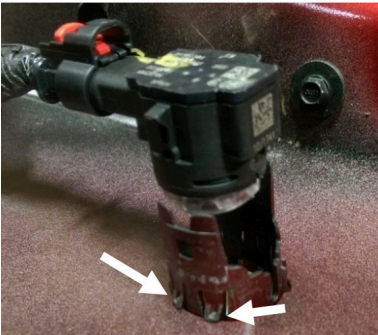


Figure 6



Figure 7

5. With the sensors removed from their housings and the tag light removed, the sensor harness can be removed from the bumper using a body panel pry tool to remove the push pins.

6. Using the provided epoxy (61632), install the previously removed sensor housings into the premium rear bumper (22539) in the same orientation and in which they were removed from the OEM bumper. Figure 8



Figure 8



7. Install the previously removed tag light in the same orientation in which it was removed from the OEM bumper into the premium rear bumper (22539). Apply the provided epoxy (61632) around the perimeter of the light to secure it. Figure 9



Figure 9

8. After letting the previously applied epoxy cure, reinstall the sensors into their respective housing by reversing the method used for removal. Then, route the sensor harness through the premium rear bumper (22539) and reconnect it to each sensor and the tag light. Figure 10



Figure 10

9. Loosely install the premium rear bumper on onto the bottom part of the frame by reversing the method in which the OEM bumper was removed using the OEM hardware. Figure 11



Figure 11

**10. Loosely install the provided 7/16" hex head screws, flat washers, lock washers, and nuts (50300-HW) in the positions which the OEM hardware was previously removed from the body mounts. Figure 12**



*Figure 12*

**11. Reconnect the sensor harness to the vehicle by reversing the method used to remove it previously. Figure 13&14**



*Figure 13*



*Figure 14*

**12. After centering the premium rear bumper on the vehicle, use a 15mm socket wrench and/or an 18mm socket wrench to tighten the two (2) previously installed OEM bolts on the bottom of the frame per side.**

**13. Using a 5/8" socket wrench and a 5/8" combination wrench, tighten the previously installed provided 7/16" hardware to the body mounts.**

# CONTACT INFORMATION

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**FABFOURS.COM**



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

**- GREG HIGGS**

