



**INSTALLATION MANUAL**  
**BLACK STEEL FRONT BUMPER**  
**PRODUCT NUMBER: S496X**  
**APPLICATION: 2020 CHEVROLET HD**



## **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!

*Ereg Higgs*

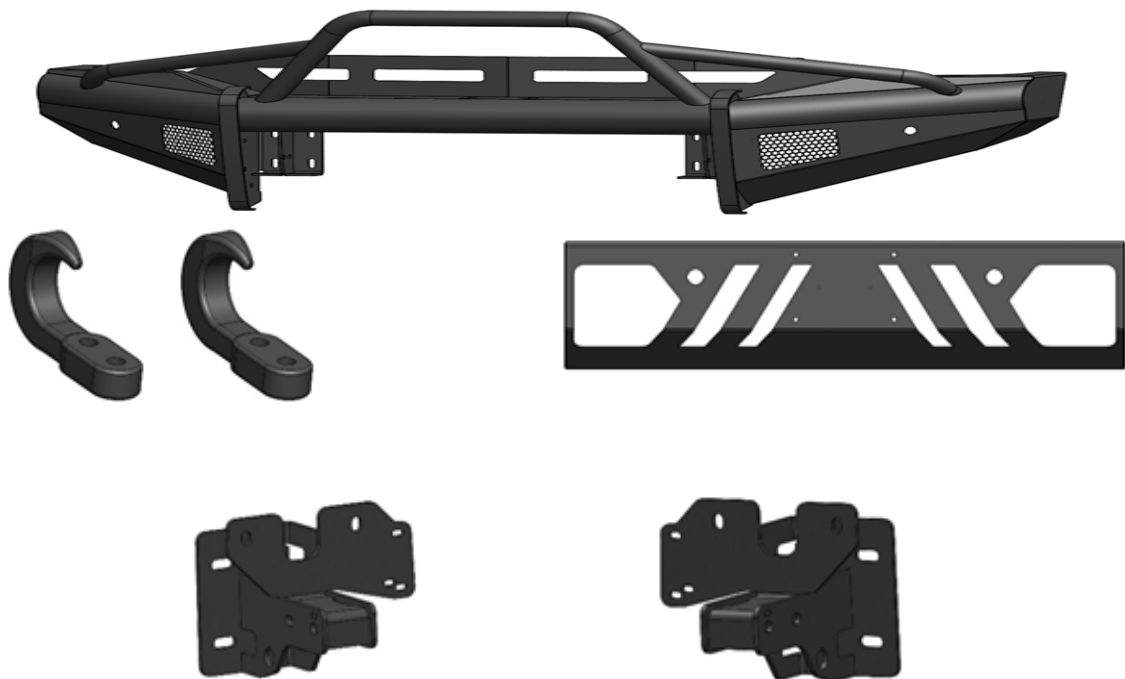
**FOUNDER, FAB FOURS**

# 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



S496X-IM

50217-HW  
20260-HW

61632  
QTY:2



22097



61366  
QTY: 2



22094

22095

## HARDWARE KIT | 50194/20260

FAB FOURS IDENTIFICATION	COMPONENT DESCRIPTION	QTY
50217-HW	1/4"-20 X 1", Yellow Zinc Hex Cap Bolt, Grade 8	10
50217-HW	1/4"-20, Yellow Zinc Hex Nut, Grade 8	10
50217-HW	1/4", Yellow Zinc Flat Washer, Grade 8	20
50217-HW	1/4", Yellow Zinc Lock Washer, Grade 8	10
50217-HW	1/2"-13 X 4.5", Yellow Zinc Hex Cap Bolt, Grade 8	4
50217--HW	1/2"-13 X 1.5", Yellow Zinc Hex Cap Bolt, Grade 8	8
50217-HW	1/2", Yellow Zinc Lock Washer, Grade 8	12
50217-HW	1/2", Yellow Zinc Flat Washer, Grade 8	24
20260-HW	1/2"-13 x 1" Yellow Zinc Hex Cap Bolt GR8	6
20260-HW	1/2"-13 x 2.25" Yellow Zin Hex Cap Bolt GR8	4
20260-HW	1/2" Yellow Zinc Flat Washer GR8	20
20260-HW	1/2" Yellow Zinc Lock Washer GR8	16
20260-HW	1/2"-13 Yellow Zinc Hex Nut GR8	10

## TOOLS REQUIRED

- 7mm socket wrench
- 18mm socket wrench
- 13mm socket wrench
- 15mm socket wrench
- 7/16" socket wrench
- 3/4" socket wrench
- 7/16" open end wrench
- 3/4" open end wrench
- T10 star head socket wrench
- wire cutters
- Plastic 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.



# DISASSEMBLY

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

**1. Use a T10 star head socket wrench to remove the two (2) bolts from both the passenger and driver side wheel wells. Figure 1.**

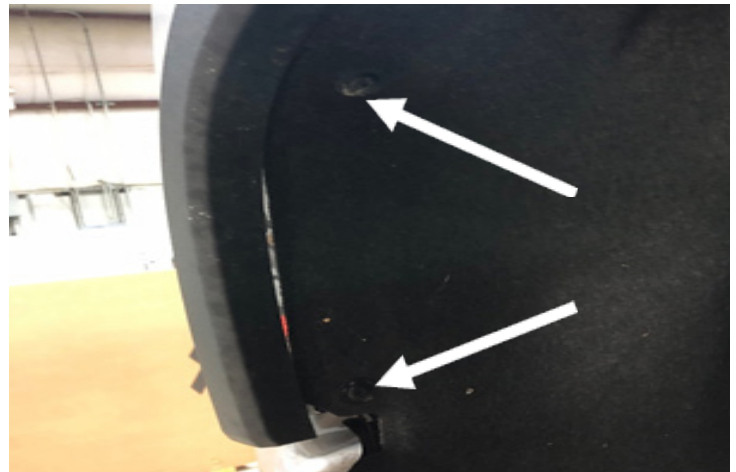


Figure 1

**2. Use a body pry tool to carefully remove the front of the fender flare away from the body. Use a 7mm socket wrench to remove the bolt on the valance. Figure 2.**



Figure 2

*NOTE: Driver side shown. Passenger side disassembly process is similar.*

**3. With the 7mm bolt removed use a body pry tool to remove the valance from the truck. Figure 3.**



Figure 3

4. Use a 10mm socket wrench to remove the two (2) bolts at the base of the grill. Figure 4.



Figure 4

5. Use a body pry tool to remove the nine (9) push pins holding the grill cover. Figure 5.

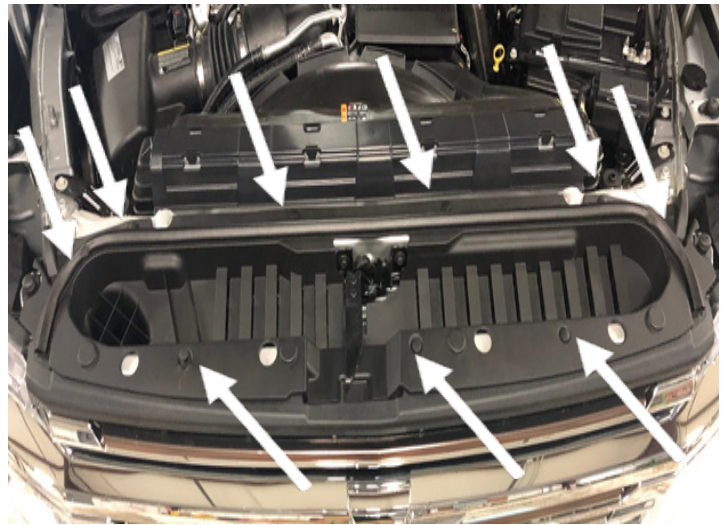


Figure 5

6. Use a T10 socket wrench to remove the two bolts holding the hood latch on. With the hood latch taken off you can remove the grill cover. Figure 6.



Figure 6



**7. Use a 10mm socket wrench to remove the four (4) bolts on the top of the grill. Figure 7.**

*NOTE: the factory tow hooks stay in the frame rail while extracting the front bumper from the frame rail ends.*



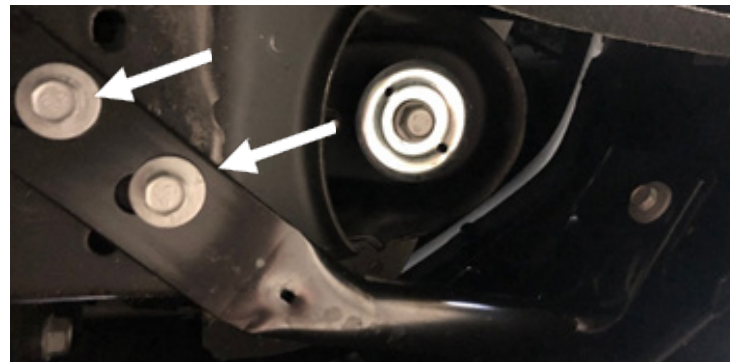
*Figure 7*

**8. With the bolts removed, carefully take the grill off the truck. While taking off the grill, unplug the camera harness on the passenger side of the truck. Figure 8.**



*Figure 8*

**9. From under the truck: use a 15mm socket wrench to remove the two (2) back bolts on the bumper support bracket on both sides. Figure 9.**

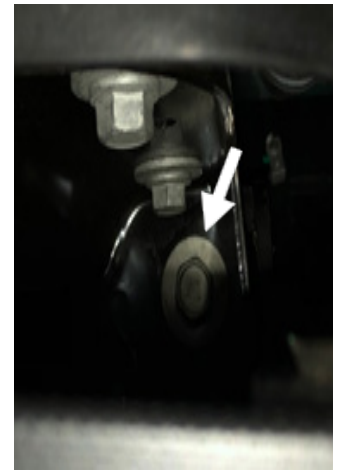


*Figure 9*

**10.** With the grill gone you can access the bumper mounting bolts on the top deck. Use a 15mm socket wrench to remove the two (2) bolts one of the top (Figure 9) and one on the bottom (Figure 10). The bumper can now be removed from the truck. Figure 10-11.



*Figure 10*



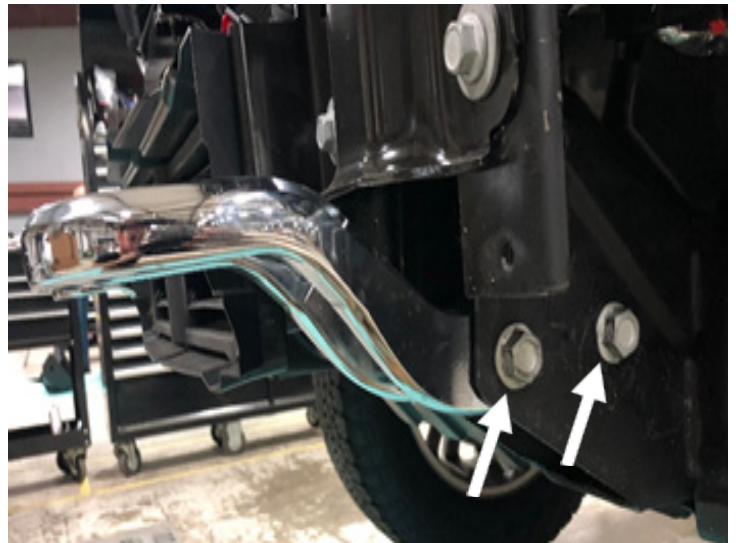
*Figure 11*

**11.** As you remove the bumper, unplug the sensor, heater plug, and lower louver harnesses located on the driver side of the truck. Figure 12.



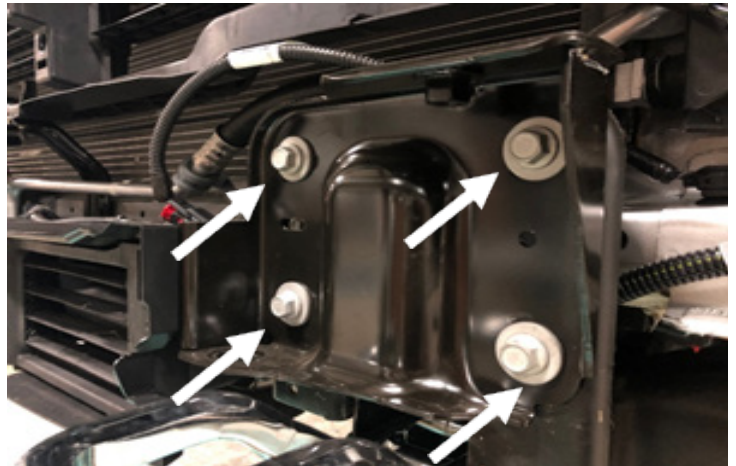
*Figure 12*

**12.** If equipped, remove the factory tow hooks by using an 18mm socket wrench to unfasten the two (2) bolts in the frame. Figure 13.



*Figure 13*

**13. Use a 15mm socket wrench to take four (4) bolts holding the mounting plates and lower louvers to the frame horns. Figure 14.**



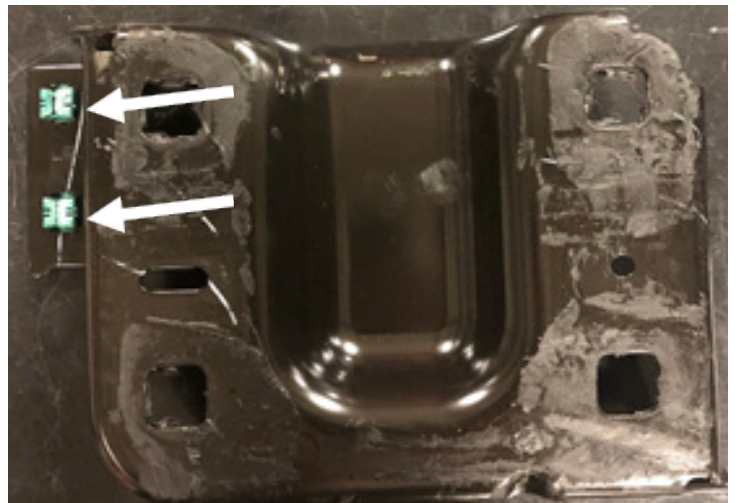
*Figure 14*

**14. Disconnect the lower louvers from the mounting plates by using a 7mm socket wrench to remove the six (6) bolts. Set bolts aside for later use. Figure 15.**



*Figure 15*

**15. Use a pair of pliers to remove the two (2) clip nuts from both mounting plates to use in the bumper install. Figure 16**



*Figure 16*



# INSTALLATION

16. With the louvers removed, use a cutting tool to remove the plugs on both sides. Figure 17.

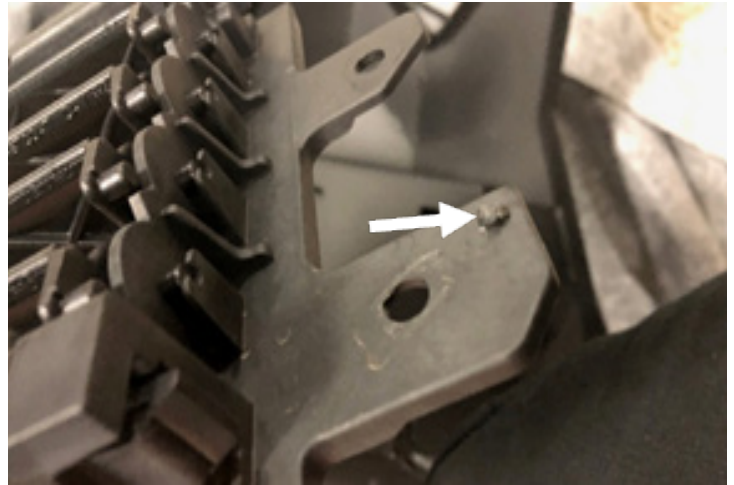


Figure 17

17. If equipped, remove the engine heater plug located on the driver side of the truck bumper. Push the bumper in against the spring and turn counterclockwise, once unclipped pull out from the bumper. Figure 18.



Figure 18

*NOTE: Make sure to mark the position of each housing for installing inot the Fab Fours bumper in the same manner as removed.*

18. Carefully remove the four sensors and sensor housings from the bumper by spreading the housing clips out and pushing the sensor out simultaneously. (Figure 19)

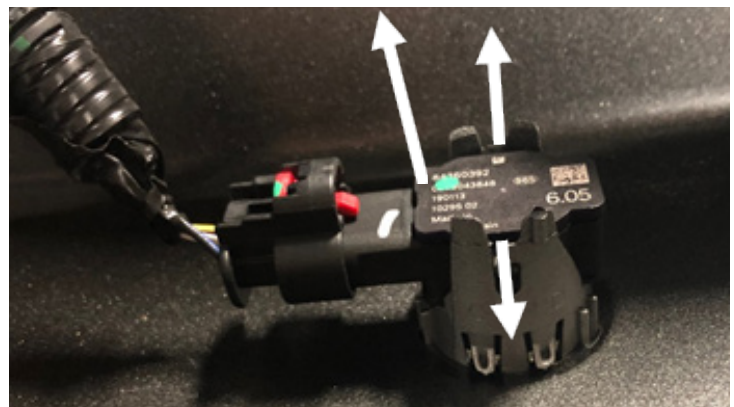


Figure 19

19. Remove the sensor housings from the bumper by pressing the retainer clips in on the sides and pushing the housing out. Figure 20.

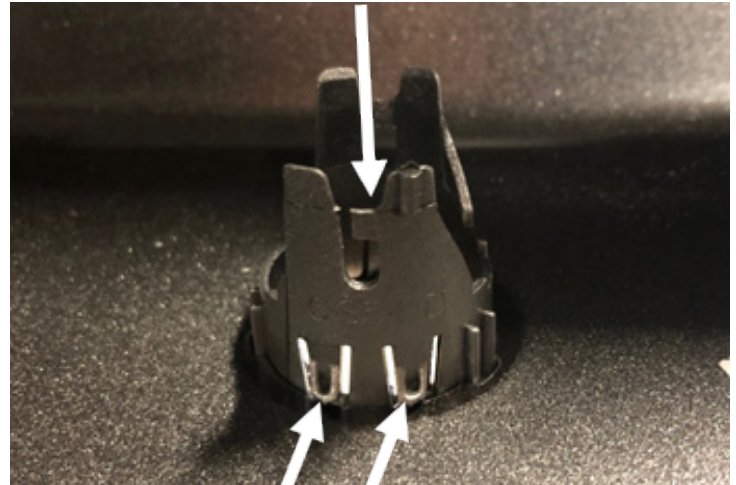


Figure 20

20. Insert both brackets into the frame rail ends and very loosely install two (2) Oem bolts into the frame rail end flange just supporting both brackets. Figure 21

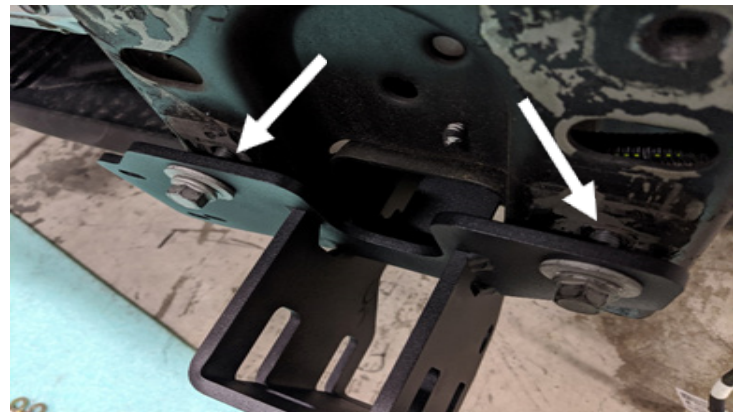


Figure 21

21. Using the provided four (4) bolt stacks of ¼"-20 yellow zinc hex bolt, flat washers, lock washer, and hex nut, loosely install the factory louver system with the bolts pointing forward. (50217-HW). Figure 22

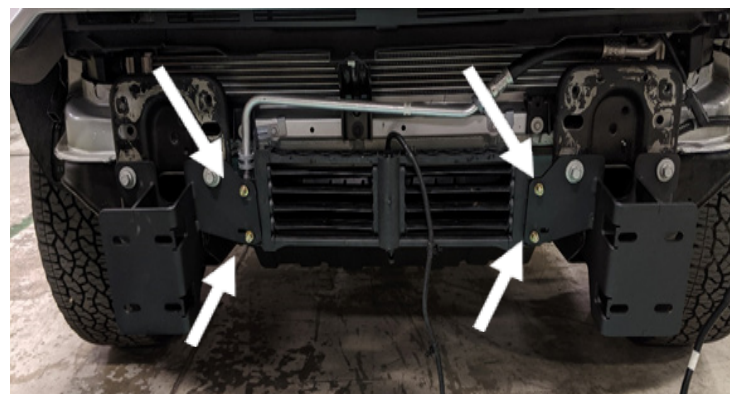


Figure 22

22. Using the provided four (4) bolt stacks of 1/2"-13 x 4.5" yellow zinc hex bolt, flat washers, lock washer, and hex nut, loosely install them into each frame rail and bracket (22094 & 22095) (50217-HW). Figure 23

23. Using a 15mm socket wrench fully tighten down the four (4) Oem frame end bolts on both brackets (22094 & 22095). Figure 21

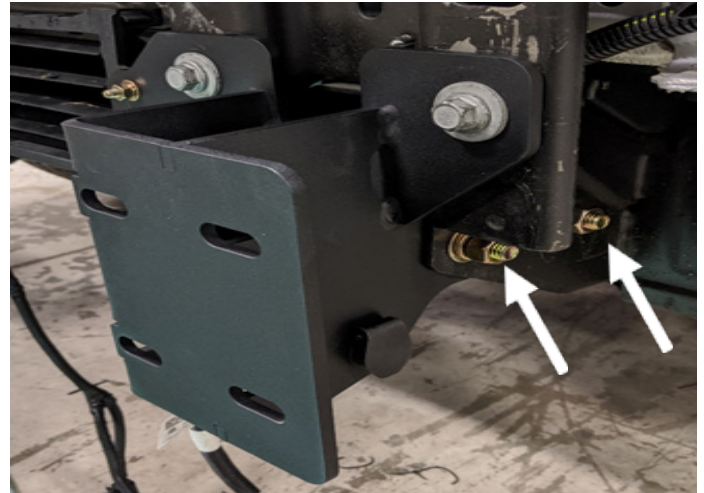


Figure 23

24. Using both a 3/4" socket wrench and 3/4" open end wrench, fully tighten down the four (4) 1/2"-13 hex bolts on both frame rails. Figure 23

25. If equipped, install the engine heater plug into the driver side bracket (22094) in a manner opposite of the removal. Figure 23

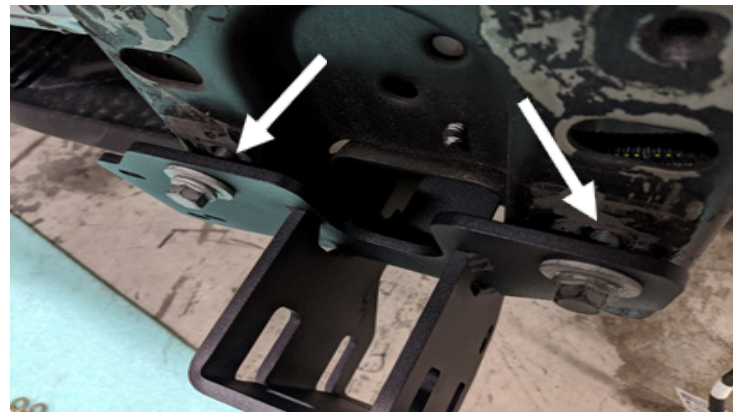


Figure 21

26. If equipped, route and reconnect the engine heater plug wiring harness around the back side of the driver side bracket. Figure 24



Figure 24



27. Route and reconnect the two (2) Oem wiring harness plugs from the factory louver system behind the frame rail end of the driver side fame rail end. If equipped, route the engine heater plug wiring behind the fame rail also. Zip tie and secure the wiring bundles as desired. Figure 25

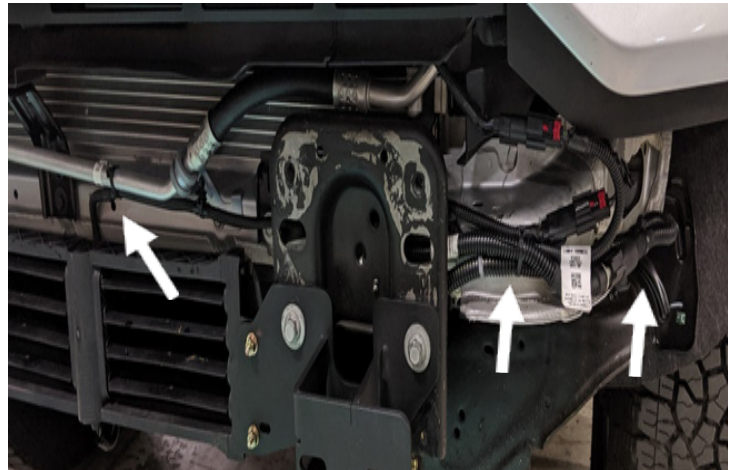


Figure 25

28. Using the provided epoxy, secure all four (4) Oem sensor housings in their appropriate sensor cutout. Figure 26

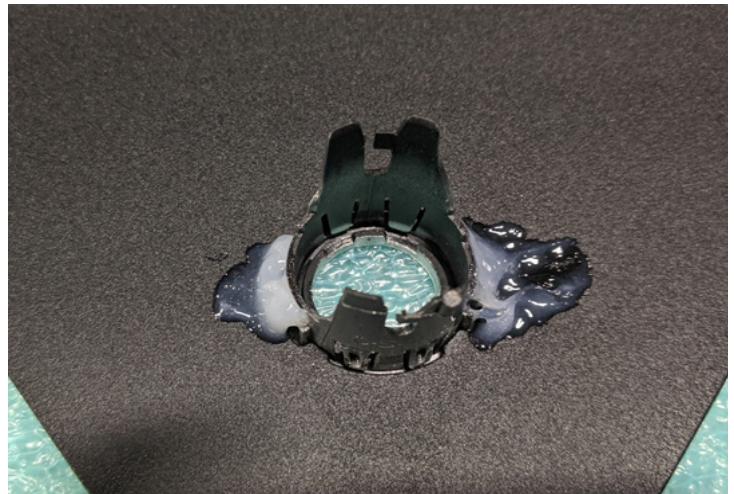


Figure 26

*NOTE: The driver side fog light mounts to the bumper on the passenger side and upside down. The passenger side fog light mounts on the driver side and upside down.*

29. Use a pair of 7/16" wrenches and the provided six (6) bolt stacks of 1/4"-20 x 1", yellow zinc hex bolt, flat washers, lock washer, and hex nut, fully install the Oem fog lights into the bumper (22091)(50217-HW). Figure 27

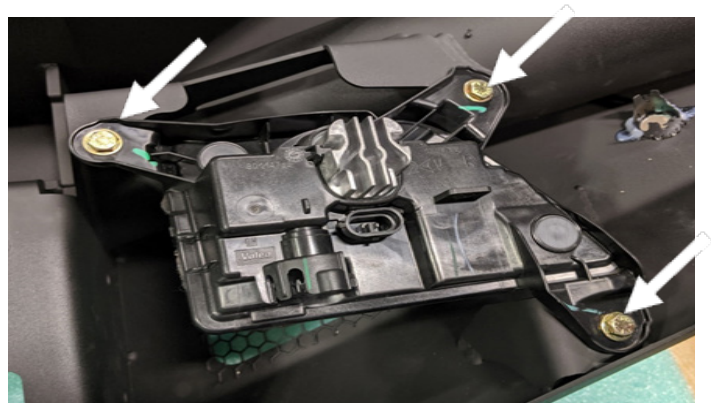


Figure 27

**30. Using a pair of wire snips, clip off all the push retainers from the factory wiring harness.**  
Figure 28



Figure 28

**31. After the epoxy has cured, fully seat all four (4) sensors into the sensor housings being mindful not to distort the rubber sensor isolator that sits around the sensor tip. Be sure both sides of the sensor housing are fully clipped on the sensor. Figure 29 & Figure 30**

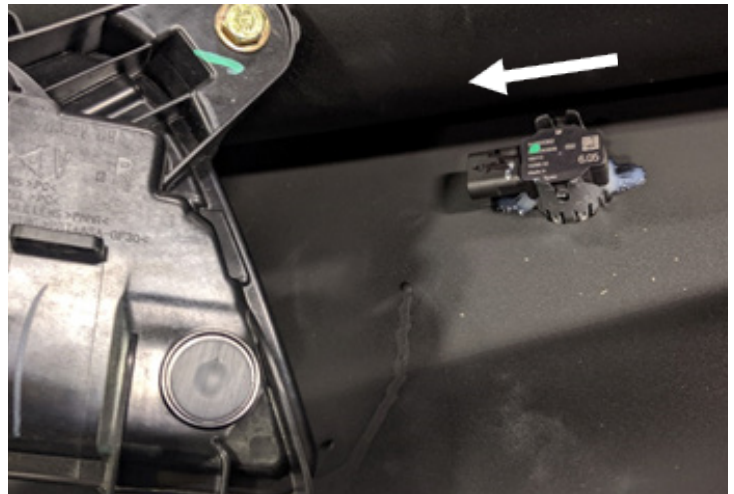


Figure 29

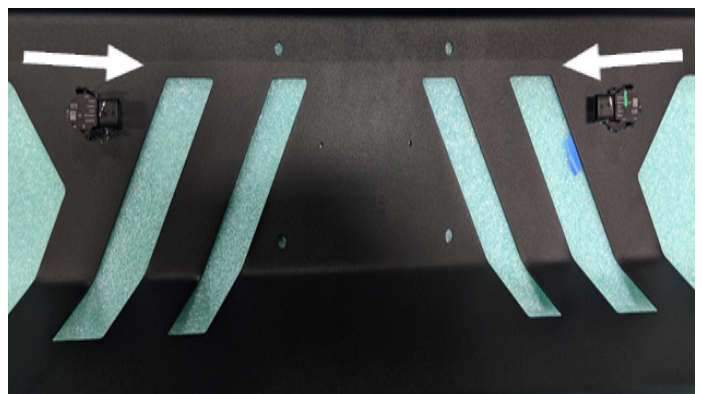


Figure 30



32. Use a pair of 3/4" wrenches and the provided six (6) bolt stacks of 1/2"-13 x 1", yellow zinc hex bolt, flat washers, lock washer, and hex nut, fully install the bumper lower guard(22097 or 22098) into the bumper(22091). (20260-HW) Figure 31

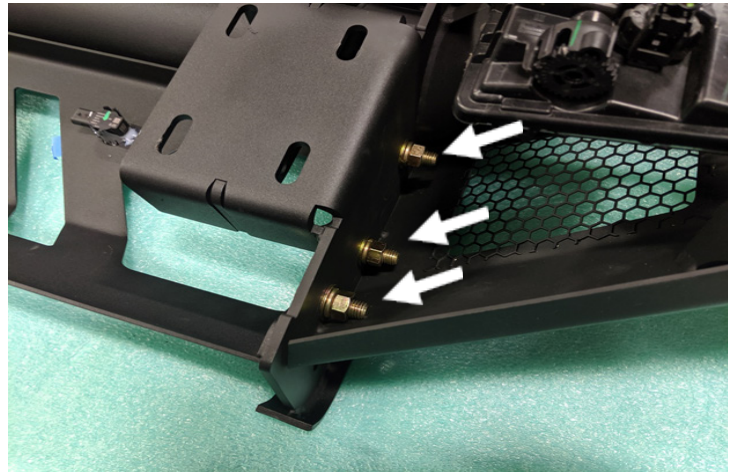


Figure 31

33. Route and zip tie the factory wiring harness to the bumper. Figures 32-34

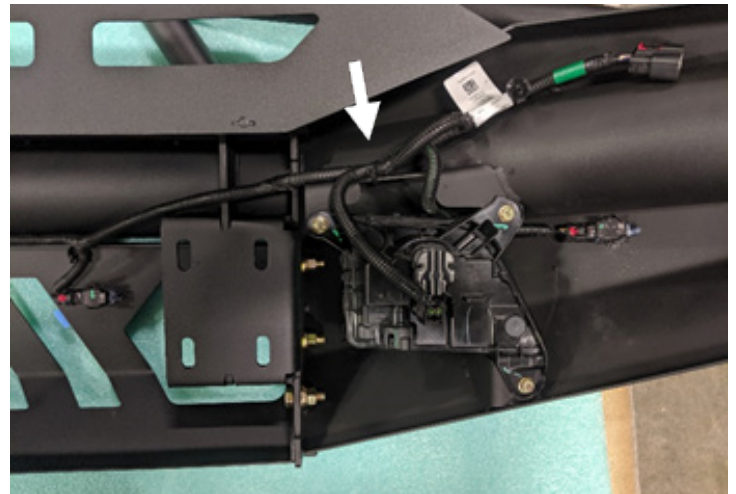


Figure 32

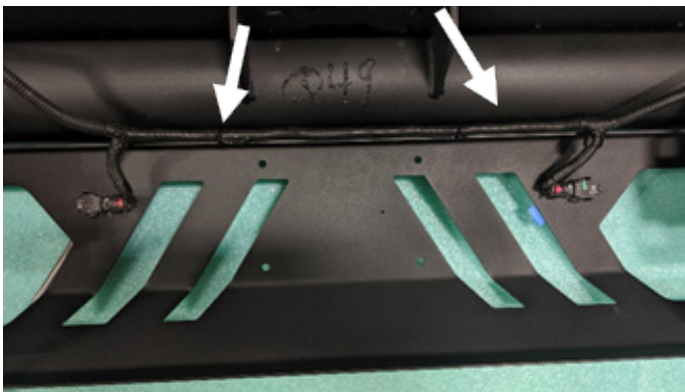


Figure 33

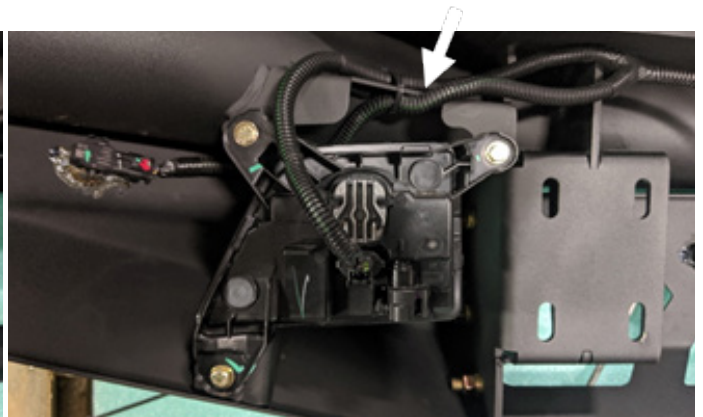


Figure 34



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36. Reconnect the factory wiring harness.

37. Install the tow hooks (61366) using the 3/4" socket wrench and two (2) 1/2"-13x2.25" bolts, flat and lock washers with nuts (20260-HW).  
Figure 35



Figure 35



Figure 36

# CONTACT INFORMATION

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

**- GREG HIGGS**

