



# Installation Instructions

## Toyota Tacoma Vengeance Rear

Product Number: E1651

Application: 05-15 Tacoma

## 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.**

## 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 new purchase of the industries' best and most stylish Rear Bumper available for the Toyota Tacoma! This Bumper has been engineered for strength while keeping the weight down.

Your Rear Bumper 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 Tacoma Rear Bumper from Fab Fours Inc.





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### II. Tools Required

- Socket Wrench with Extension
- Breaker Bar
- 19mm, 17mm, and 9mm Wrenches and Sockets
- Flat and Phillips Head Screw Drivers
- Allen wrench set

### III. Removal of Stock Bumper

***A. Remove the license plate lights by removing the small Phillips screws and pulling the housings from the bumper. You will have to disconnect the harnesses from each.***



***Figure 1 – License plate light removal***

***B. Remove the plastic caps that cover the two bolts holding the OEM bumper to the trailer hitch bar. Squeezing the caps with your fingers should help to pop them free.***

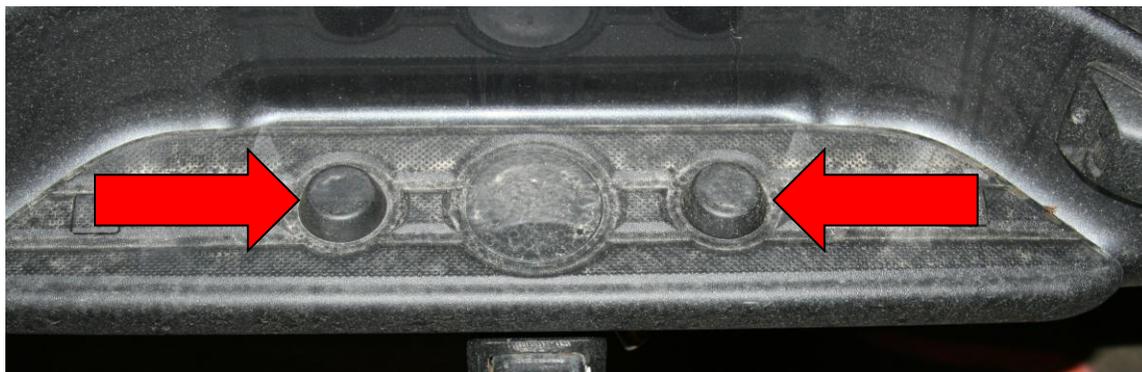




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**Figure 2 – Bolt cover removal**

**C. Using 19mm or 3/4" sockets and wrenches, remove the two vertical bolts holding the OEM bumper the trailer hitch bar. If this is the first time that the bumper has been removed, these may be difficult to break loose.**



**Figure 3 – Trailer hitch bolt removal**



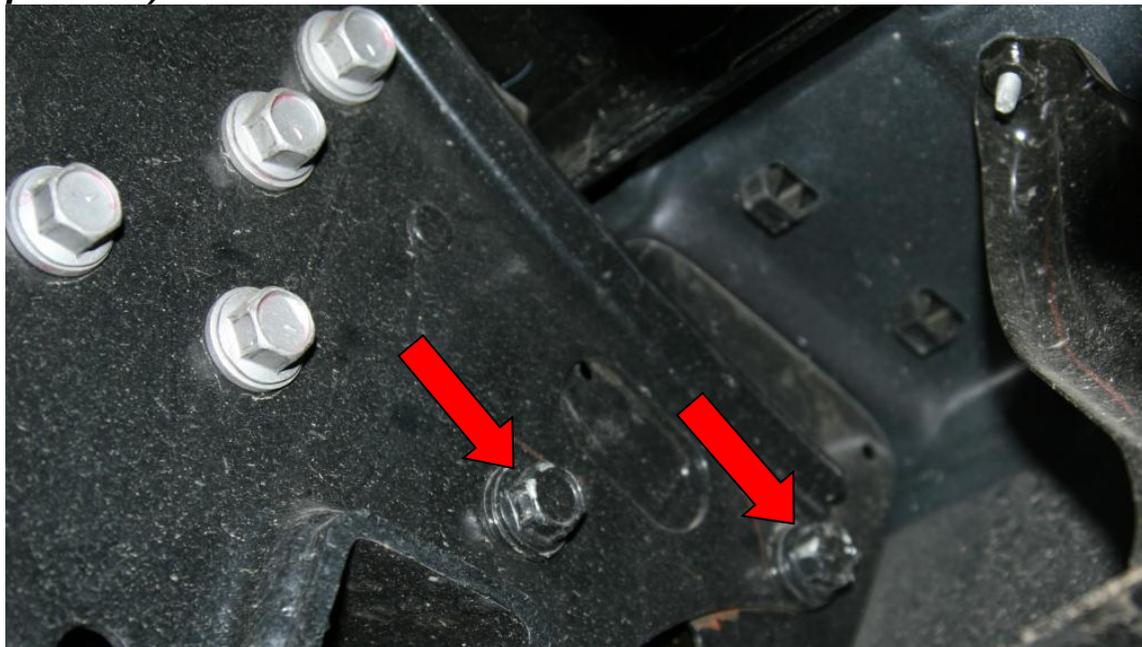


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***D. Using a 17mm socket or wrench, remove the bolts holding the OEM bumper to the frame rails of the vehicle (2 per side).***



***Figure 4 – OEM bumper bolt removal***

***E. Remove the OEM bumper from the vehicle. The factory bumper may be wedged between the chassis mounts rather tight. It is recommended to have a helper to assist in the removal of the bumper to avoid injury and damage to the vehicle.***





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### IV. Pre-Installation

- A. Remove Fab Fours bumper from the shipping carton and lay all items out on a blanket to prevent damage.
- B. Install provided license plate lights.
- C. Wire both lights into the existing lights on the stock harness.
- D. Prep the area shown below and attach the red LED strip in the location shown. Wire as desired depending on functionality. You have the following options: wire to your brake lights, running lights or tag lights.



*Figure 5 – LED Strip Location*





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### V. Rear Bumper Installation

**NOTE: The Following Installation steps apply to the installation of the. PLEASE READ THE ENTIRE MANUAL BEFORE ATTEMPTING INSTALLATION! Ignoring these steps will increase your probability of scratching the vehicle during product Installation!**

***A. With the help of two others mount the bumper to the truck and put the new ½” hardware provided into the stock mounting locations.***



***B. Very carefully open the tailgate watching the bottom edge of the tailgate in relation to the top of the bumper making sure they do not come in contact. Also make sure to allow space between the tailgate and the top of the bumper when tailgate is fully open.***

***C. Fully tighten all fasteners between bumper and brackets and brackets and frame.***

***D. Install supplied license plate plastic nut inserts and license plate.***

***E. Enjoy your bumper from Fab Fours!***





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### VI. Maintenance/Care

- Periodically check and tighten all fasteners.
- Stripped, fractured, or bent bolts or nuts need to be replaced.
- After washing of the vehicle make sure to fully dry all surfaces

