



INSTALLATION MANUAL
TUBE DOORS- 4 DOOR
PRODUCT NUMBER: TT1030
APPLICATION: 2016-19 TOYOTA TACOMA



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.

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



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!

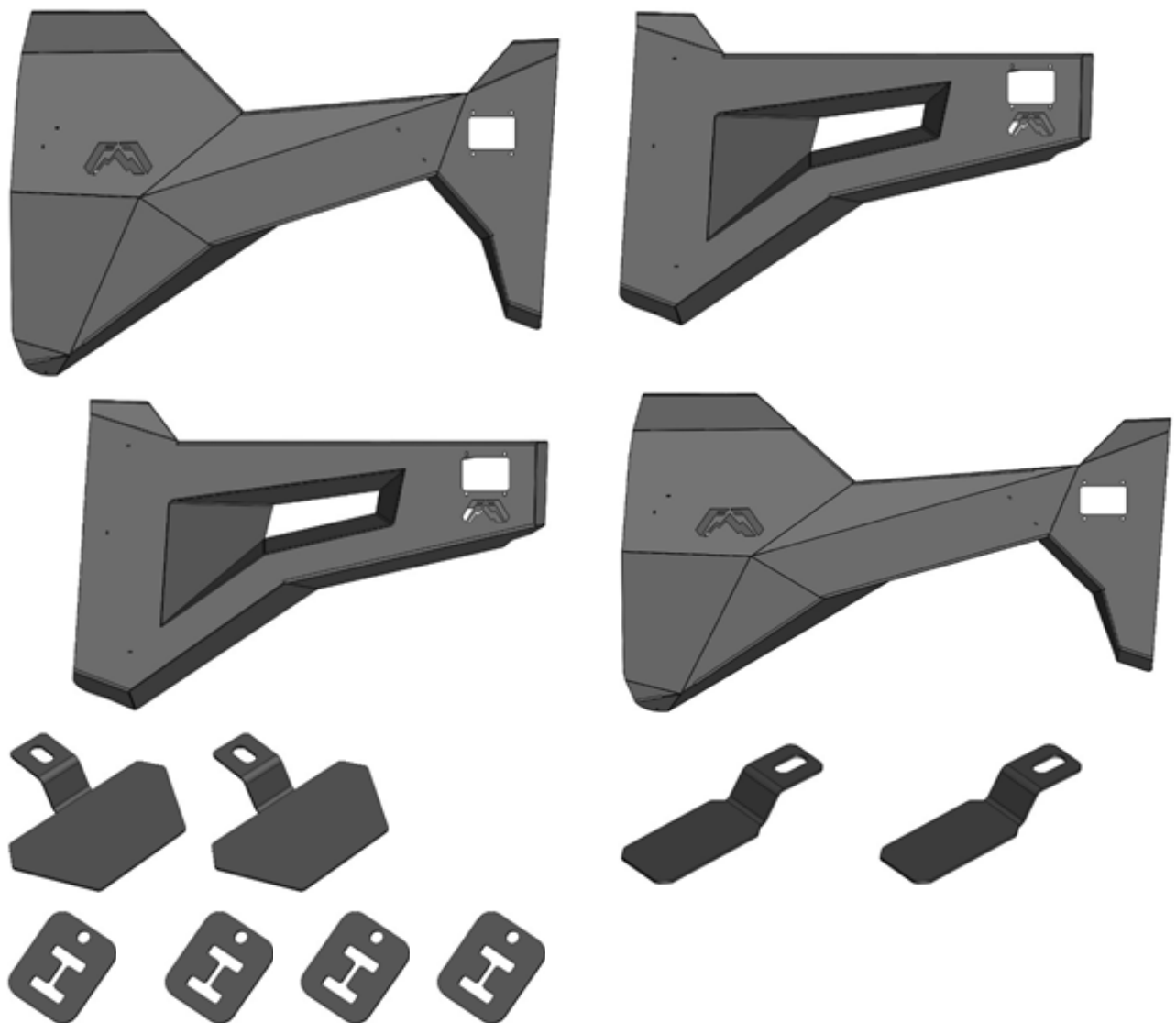
Greg Higgs

FOUNDER, FAB FOURS

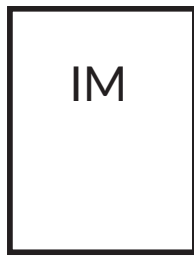
GETTING STARTED

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.



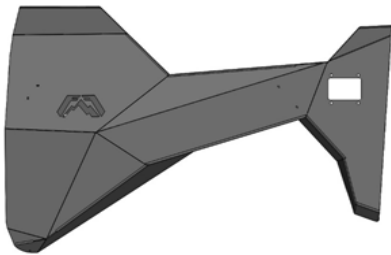
PROVIDED MATERIALS



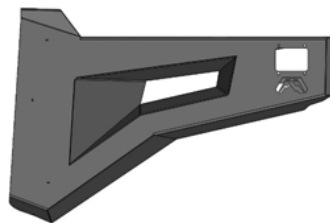
TT1030-IM



50231-HW



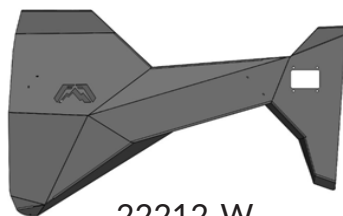
22210-W



22211-W



22213-W



22212-W



22216



22217



22222



22223



22224 x4

TOOLS REQUIRED

- Body pry tool
- 10mm Socket wrench
- 12mm Socket wrench
- 3/8" Socket wrench
- 1/2" Socket wrench
- 9/16" Socket wrench
- 1/8" Allen wrench

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.

PROVIDED MATERIALS

HARDWARE KIT | 50231-HW

FAB FOURS IDENTIFICATION	COMPONENT DESCRIPTION	QTY
50231-HW	5/16"-18, Yellow Zinc Hex Head Bolt, Grade 8	
50231-HW	5/16" 1 1/2" OD Flat Fender Washer	
50231-HW	5/16", Yellow Zinc Lock Washer, Grade 8	
50231-HW	3/8"-16, Yellow Zinc Hex Head Bolt, Grade 8	
50231-HW	3/8"-16, Yellow Zinc Hex Nut, Grade 8	
50231-HW	3/8", Yellow Zinc Flat Washer, Grade 8	
50231-HW	3/8", Yellow Zinc Lock Washer, Grade 8	
50231-HW	10-24 x 3/4", Stainless Steel Button Head Bolt	
50231-HW	10-24 x 3/4", Stainless Steel Nut	

FAB FOURS IDENTIFICATION	COMPONENT DESCRIPTION	QTY
50231-HW	#10 Stainless Steel Flat Washer	
50231-HW	#10 Stainless Steel Lock Washer	
50231-HW	5/16"-18, Stainless Steel Hex Nut	
50231-HW	5/16", Stainless Steel Flat Washer	
50231-HW	5/16", Stainless Steel Lock Washer	
61769	3/4" 1 1/4" Rubber Bump Stop	
61692	Limiting Straps	4
61681	Door Latches	4

DISASSEMBLY

NOTE: Save all OEM parts until installation is complete!

1. Use a body pry tool to remove the kick board next to the front seats. (Figure 1)



Figure 1

2. With the kick board removed use a body pry tool to remove the plastic panel cover located in underneath the steering wheel and glove compartment. (Figure 2)



Figure 2

3. With the cover removed you will have access to the door wiring harness. Unplug all plugs coming from the door wiring harness (1-3 plugs depending on truck model). (Figure 3)



Figure 3

4. To remove the rear door wiring harness: use a body pry tool to remove the weather seal and unplug the harness. (Figure 4)



Figure 4

5. Use a 10mm socket wrench to remove the bolt in the door limiter. (Figure 5)



Figure 5

6. With assistance, use a 12mm socket wrench to remove the four (4) bolts (per door) from the hinges and remove the doors from the truck. (Figure 6)



Figure 6

INSTALLATION

****Please note that the door latches are mounted and installed from the inside of the door****

7. Use the provided 10-24 Bolts, flat and lock washers with nuts with a 3/8" socket wrench and 1/8" allen wrench to loosely install the front and rear door hinges. When installing the hinges make sure to note the hinge orientation: the front door hinge must be in the lower position while the rear door hinge is in the upper. (Figure 7-8)



Figure 7 (Front door latch orientation)

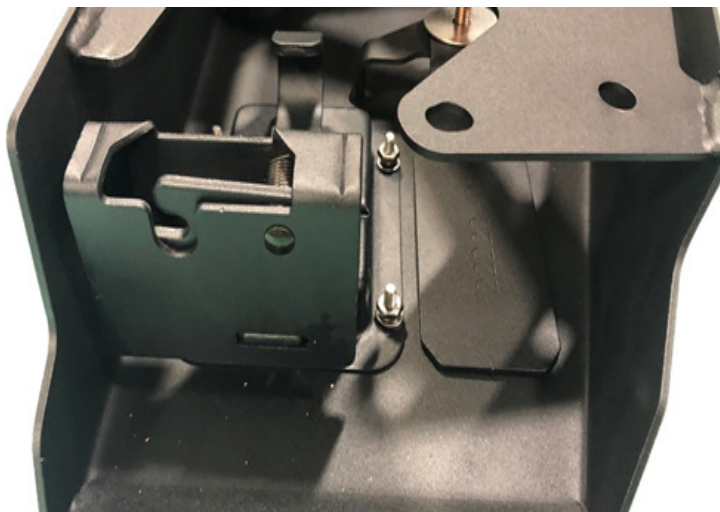


Figure 8 (Rear door latch orientation)

8. Use a 1/2" socket wrench to install the front and rear logo color plates (22222-22223) with the 5/16" bolts, flat and lock washers (50231-HW). (Figure 9-10)

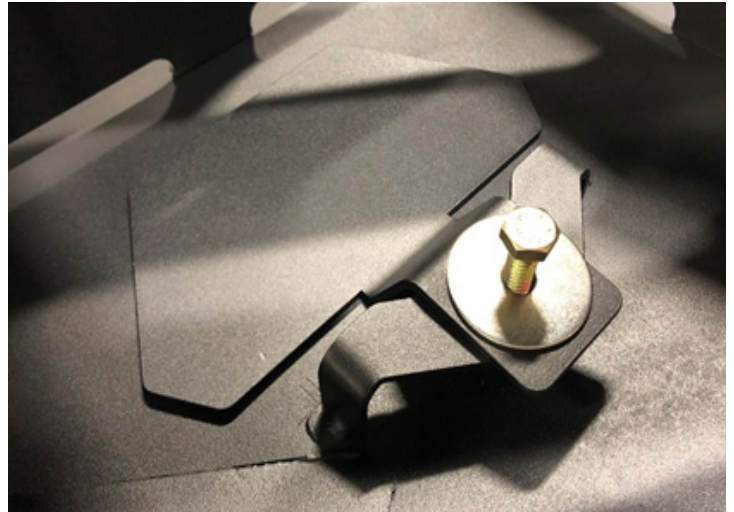


Figure 9



Figure 10

9. Install the rubber bump stops in the front and rear doors using two (2) 5/16" nuts, two (2) washers and one (1) lock washer per bumper stop. Loosely install for later adjustment on the truck. (Figure 11-12)



Figure 11



Figure 12

10. With assistance, hold the front door up to the front hinges and use a 9/16" socket wrench to install the 3/8" bolts, flat and lock washers and nuts (50231-HW). (Figure 13)

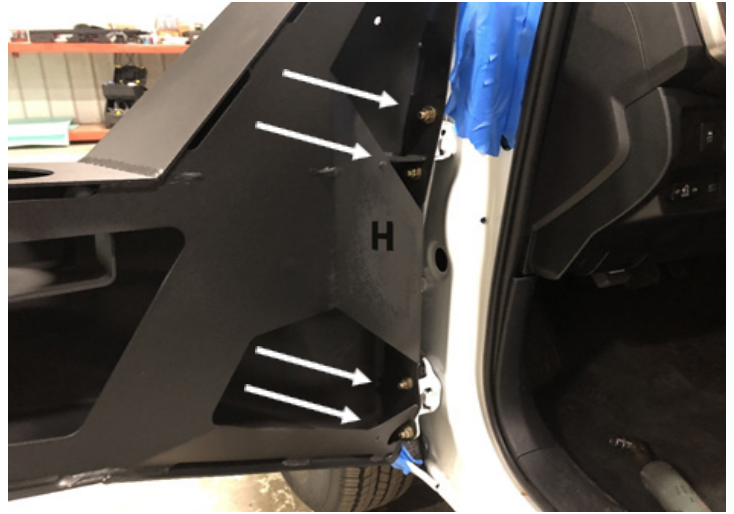


Figure 13

11. Repeat step 10 to install the rear door. (Figure 14)

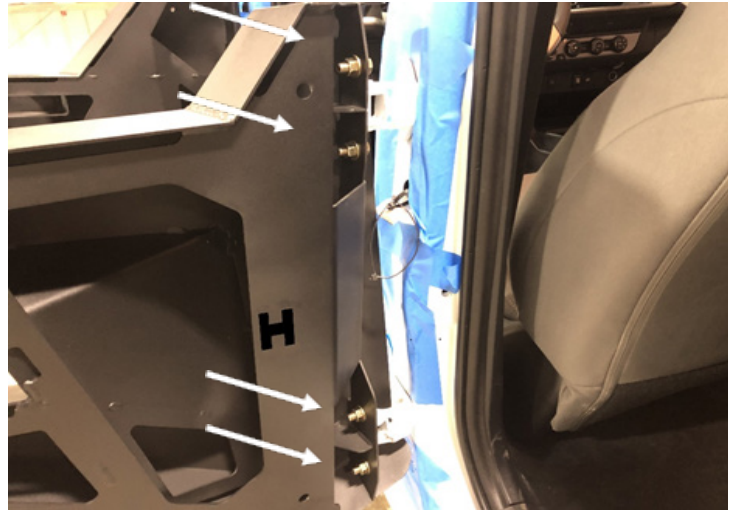


Figure 14

12. Close the doors until the latch engages. With the doors closed position the latch so that it does not rub on the striker and use a 3/8" socket wrench with 1/8" allen wrench to tighten the hinges in place.

13. With the doors closed. Adjust the rubber bump stops until it fully closes the door ajar sensor located on the door jam. Once in position use a 1/2" socket wrench to tighten it in place. (Figure 15)



Figure 15

14. Use the 10mm bolt removed during step 5 to attach the limiting strap bracket to the door jam. Attach the limiting strap to the door jam bracket and the door. (Figure 16)



Figure 16

15. Fully tighten all mounting hardware

****Note: Mirrors are not included. You will need to purchase mirrors separately and install onto doors per your preference. This will require you to follow the instructions included with the mirrors and may require drilling into the doors.****