



INSTALLATION MANUAL
WINCH MOUNT FRONT BUMPER
PRODUCT NUMBER: N365X
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!

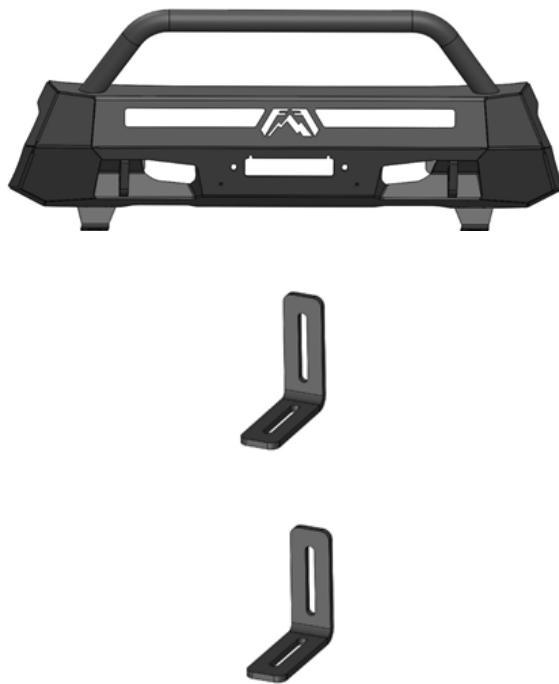
Greg Higgs

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



HARDWARE KIT | 50228

FAB FOURS IDENTIFICATION	COMPONENT DESCRIPTION	QTY
50228-HW	1/4"-20, Yellow Zinc Hex Cap Bolt, Grade 8	2
50228-HW	1/4"-20, Yellow Zinc Hex Nut, Grade 8	2
50228-HW	1/4", Yellow Zinc Flat Washer, Grade 8	4
50228-HW	1/4", Yellow Zinc Lock Washer, Grade 8	2

TOOLS REQUIRED

- 5/16" Socket wrench
- 3/8" Socket wrench
- 3/4" Socket wrench
- 5/16" Open-end wrench
- 10mm Socket wrench
- 14mm Socket wrench
- 17mm Socket wrench
- Needle nose pliers
- Flat head screwdriver
- Plastic panel pry tool
- Silver sharpie
- Body saw
- Angle grinder w/ flat disk pad
- Painters tape

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. Using a 10mm socket wrench, remove the two (2) screws holding the grille to the core support. (Figure 1)



Figure 1

2. Using a plastic body panel pry tool, remove the push lock clip from the outer edge of the grille on either side near the headlights. To release these clips, lift up on the center portion and then pull the whole clip upwards. With the clips removed, pull firmly outward on the grille shell and it should pop loose. (Figure 2)



Figure 2

3. Using a 10mm socket wrench, remove the nine (9) screws attaching the black plastic valance to the lower portion of the bumper cover on the outside. (Figure 3)



Figure 3

4. Using a 10mm socket wrench, remove the three (3) screws attaching the black plastic valance and inner fender to the lower portion of the bumper cover on the inside of each side of the vehicle. (Figure 4)



Figure 4

5. Using a 10mm socket wrench, remove the two (2) screws at the bottom center of the bumper cover. (Figure 5)



Figure 5

6. Using a 10mm socket wrench and a flat head screwdriver, remove the screw and the twist lock clip attaching the inner fender to the bumper cover. (Figure 6)



Figure 6

7. Using a plastic body panel pry tool, remove the six (6) push lock clips from the top of the bumper cover. (Figure 7)

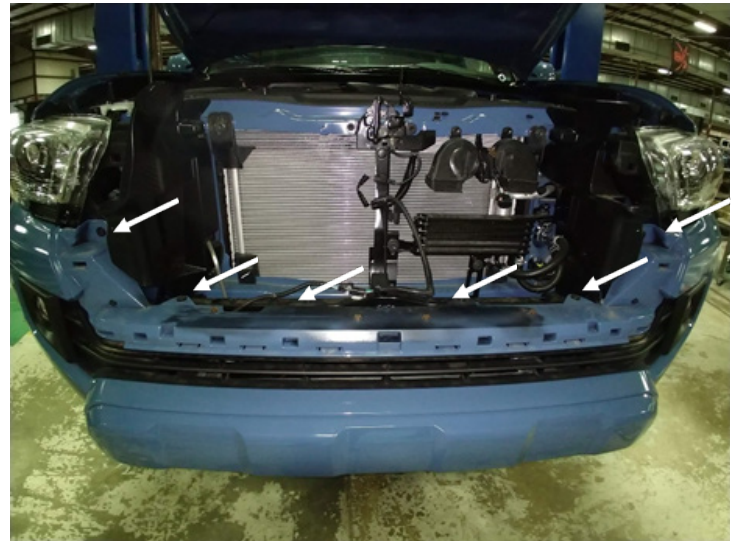


Figure 7

8. Using a plastic body panel pry tool, reach inside the bumper cover and pinch the two (2) clips holding the flare to the bumper cover and pull out on the flare. (Figure 8) With the flares pulled out of the cover remove the bumper cover from the vehicle.



Figure 8

9. Using a 14mm socket wrench, remove the three (3) nuts per side holding the impact bar to the core support. (Figure 9)

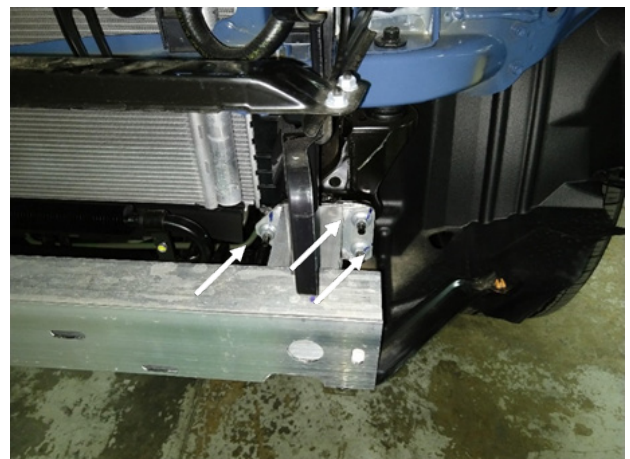


Figure 9

10. Using a pair of needle nose pliers, remove the plastic captured nut from the inner fender and support bar. (Figure 10) Remove the impact bar from the vehicle.



Figure 10

11. Using a 17mm socket wrench, remove the screw on either end of the bottom of the core support. Leave the crash bars in place. (Figure 11)



Figure 11

12. Use a cutting tool to trim the air dams on either side of the radiator along the line shown below. (Figure 12)

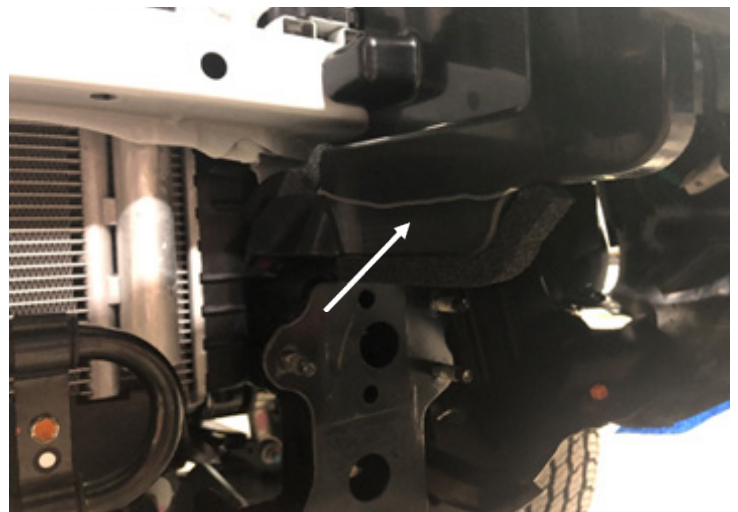


Figure 12

INSTALLATION

13. Use a 17mm socket wrench to remove the two bolts holding the passenger side tow hook. (Figure13)

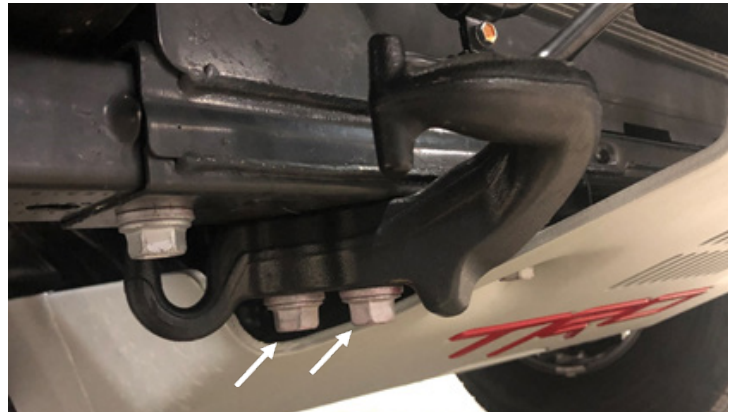


Figure 13

14. Take the OEM bumper and use 1" blue tape to create a cutting line around the plastic insert. On the lower face align the tape along the black plastic insert. On the upper face align the tape along the chamfered edge that surrounds the insert. Cut along the outside edge of the blue tape. (Figure 14-15)



Figure 14

15. Reverse the steps 1-8 to reinstall the bumper and grill.

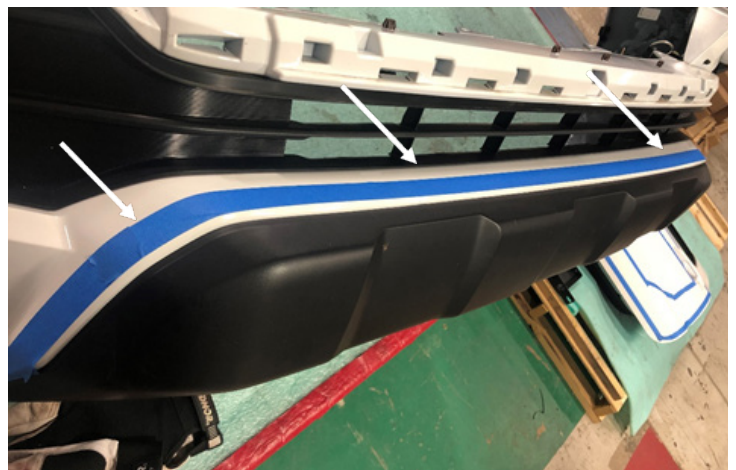


Figure 15

16. If installing a 30" light bar: Use the provided L-brackets (21871) along with 7/16" socket wrench to tighten the 1/4" bolts, flat and lock washers with nuts (50228-HW). (Figure 16)

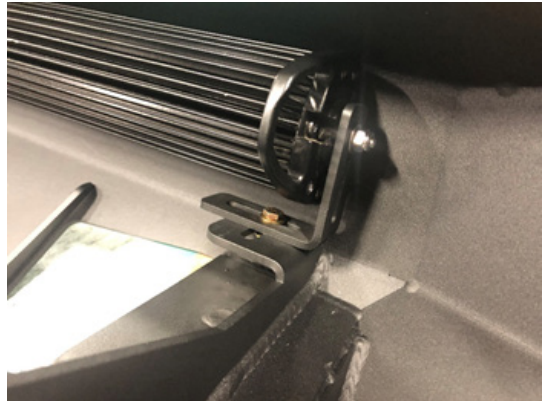


Figure 16

17. If installing a winch: Do so now by installing the front winch bolts into the winch leaving them a 1/4" loose. Slide the winch into place and tighten the front bolts with a wrench. The rear winch bolts can be installed through the lower access holes.

18. With assistance, hold the bumper up to the studs and use the OEM nuts removed during step 9 along with a 14mm socket wrench to tighten them in place. (Figure 17)



Figure 17

19. Use a 17mm socket wrench to install the OEM bolt removed during step 11. (Figure 18)



Figure 18

20. Fully tighten all mounting hardware.

****Maintenance & Care****

- Periodically check and tighten all fasteners
- Stripped, fractured or bent bolts/nuts need to be replaced