



**INSTALLATION MANUAL**  
**BLACK STEEL & BLACK STEEL ELITE REAR BUMPER**  
**PRODUCT NUMBERS: T5950 & U5950**  
**APPLICATION: 2023 FORD SUPER DUTY**



## **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



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

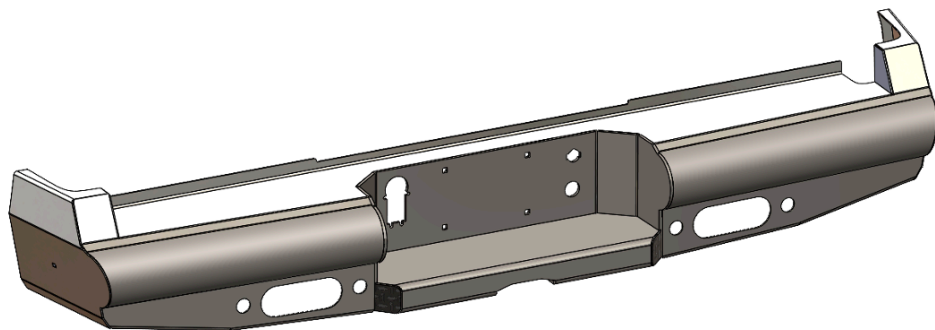
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Before you begin the installation process of your new Fab Fours product, we suggest laying out all materials and parts on a pad or protective surface.

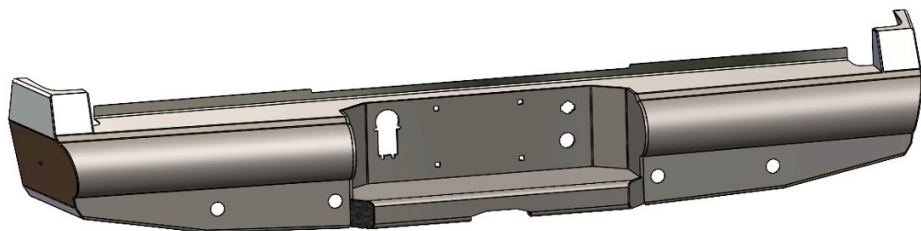
Failure to fully account for all components before beginning installation may leave vehicle immobile until part is acquired. Refer to the next pages as an inventory check.

# PROVIDED MATERIALS

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23072 (T5950) - REAR BUMPER



23072 (U5950) - REAR BUMPER

## TOOLS REQUIRED

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- 21MM SOCKET WRENCH
- 13MM SOCKET WRENCH
- STRAIGHT SCREWDRIVER
- PICK

## ASSISTANCE

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We recommend two people perform the installation as items are heavy and may need to be held in place while installing.

## ORGANIZATION

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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.

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## HARDWARE KIT | 50076-HW

IDENTIFICATION NUMBER	COMPONENT DESCRIPTION	QTY
50076-HW	1/4" LICENSE PLATE NUT NYLON	2
50076-HW	#8-32 3/4", STAINLESS CAP SCREW	4
50076-HW	#8-32 NYLOCK, HEX NUT	4
50076-HW	#8 FLAT WASHER ZINC	4
50076-HW	1 3/8"- GROMMET	4
50076-HW	PLASTIC PLUG	4

# INSTALLATION

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1. Locate trailer plug and main wire harness plug behind rear bumper and disconnect. (Figure 1)



Figure 1

2. Using 13mm socket wrench, remove two (2) bolts located on either side of receiver hitch tube. (Figure 2)



Figure 2



3. Using 21mm socket, unbolt OEM bolts from bumper (two per side) and remove bumper from truck. (Figure 3)



4. Remove OEM bolt strip from OEM bumper by removing metal retainer washers. These will be used to mount new bumper (23072).

**NOTE:** If truck is NOT equipped with parking sensors, skip to step 9.

5. Remove wire harness from OEM bumper. Be sure to note orientation of wire harness for installation into new bumper.
6. Remove sensors housing from OEM bumper, noting location and orientation of each housing.
7. Install housings into new bumper in same location and orientation. Use sensor cutouts as guide for orientation. Use provided epoxy to secure housings into bumper.
8. Once epoxy has dried, install sensors into housings and plug in harness to sensors.

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9. If installing a T5951 Black Steel, install rear backup lights into bumper by seating rubber light grommet into light cutouts then inserting LED backup lights into grommets until fully seated. Wire Lights as desired. (Figure 4)



Figure 4

10. Use pick tool to remove silver clips from trailer plug. Insert plug into bumper. While holding in place, insert clips into plug and use straight screwdriver to bend clips until they are fully seated into plug (Figure 5&6)



Figure 5



Figure 6

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11. Transfer spare tire lock from OEM bumper to new bumper.

12. Install the provided tag light into the 1 ¼" hole in the center section. Ensure light is facing towards where license plate will go.

13. Next use provided terminals to splice into both wires on factory tag light harness. (Figure 7)

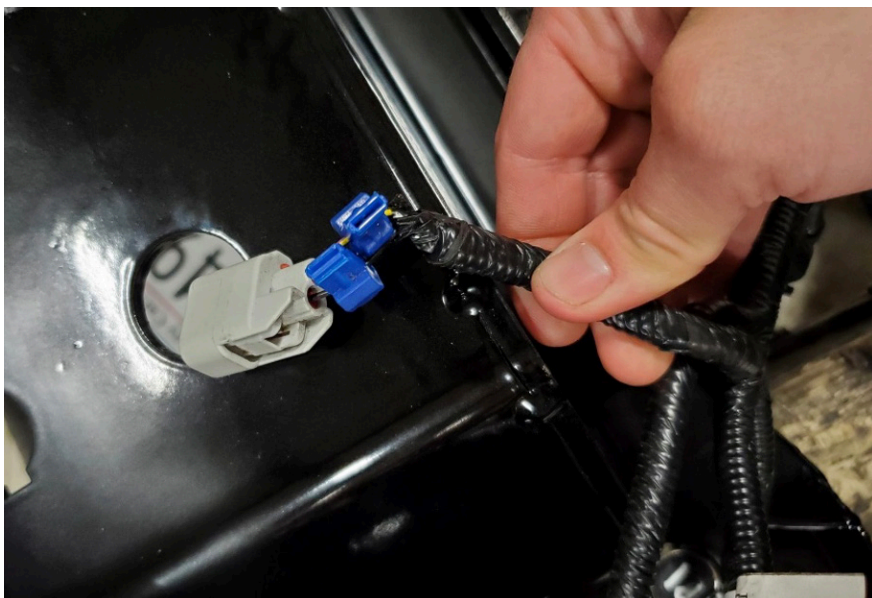


Figure 7

14. Plug in tag light (installed in step 10) to blue splices.

15. Insert OEM bolt strips removed in step 4 into new bumper mounts (23072), facing towards front of vehicle. Tape may be used to hold bolt strips in place during installation.

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16. With assistance, line up bumper on truck and insert bolts into OEM bumper mounts. Thread on OEM nuts (Figure 8).



Figure 8

17. Align bumper with truck and tighten nuts.

**INSTALLATION COMPLETE**

# 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**

