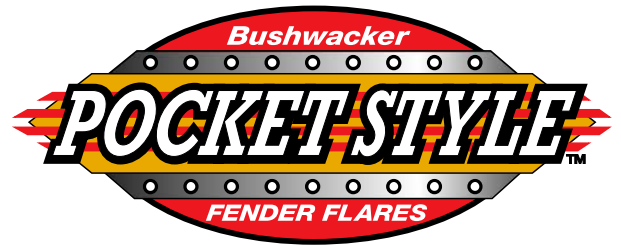


# Toyota Tacoma

2005 Regular Cab, Access Cab,  
Double Cab Long Bed  
Set Part # 31920  
Rev- B 10-31-05



## Step 1:

### Prior to Installation:

- A) **Fit:** Verify the fit of the flares to vehicle. (Some filing, sanding, or cutting may be necessary to ensure proper fit).
- B) **Painting:** (Optional) if paint is desired it must be done prior to installing flares on the vehicle clean outer surface with a good grade degreaser. **DO NOT USE LACQUER THINNER OR ENAMEL REDUCER AS A DEGREASER.** Wipe outer surface thoroughly with a tack rag prior to paint.  
Paint flares using a high quality enamel, or polyurethane automotive paint. (Application of a primer coat is optional)  
If painting edge trim (not recommended), use a flex additive.
- C) **Performance:** Using larger Tires may increase the area required to turn the vehicle. Some Tire/Rim combinations may require lowering bump stops and or installing steering stops to prevent tire from contacting flare.
- D) **Exhaust System:** Modifications may be necessary to maintain a minimum 4" clearance between flares and exhaust pipes.  
(Exhaust gases should not vent directly onto flares)
- E) **Metal Protection:** All exposed fasteners and bare metal should be treated with red oxide primer BEFORE installing flares. Spray inner fender wells with undercoating AFTER flare attachments have been completed.

## TOOLS FOR EASY INSTALLATION

- Electric Drill
- Vise Grips
- Trim Tool or Flat Head Screwdriver
- 10mm Socket
- #2 Phillips Bit
- 3/8" Wrench
- 7/16" Wrench
- 8mm Socket
- Grease Pencil
- 5/16" Drill Bit

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## FLARE INSTALLATION PROCEDURES

### Step 2: Edge Trim Installation (See Illustration #1)

- A) Peel two to three inches of red vinyl backing away from edge trim tape. Applying the adhesive side of the edge trim to the inner side of the flare, affix the edge trim to the top edge of the flare (the portion that comes in contact with the vehicle). **See Illustration #1**
- B) Press edge trim into place along the top edge of the flare in one-foot increments, pulling red vinyl backing free as you continue to work your way around the top edge of the flare.

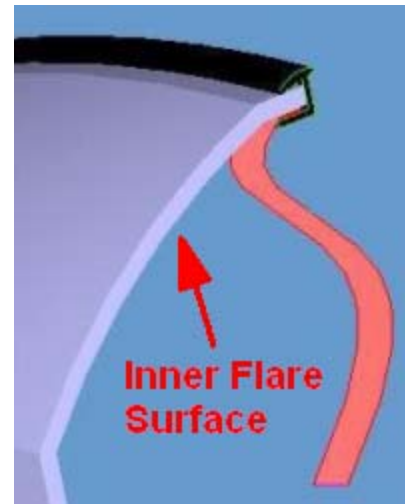
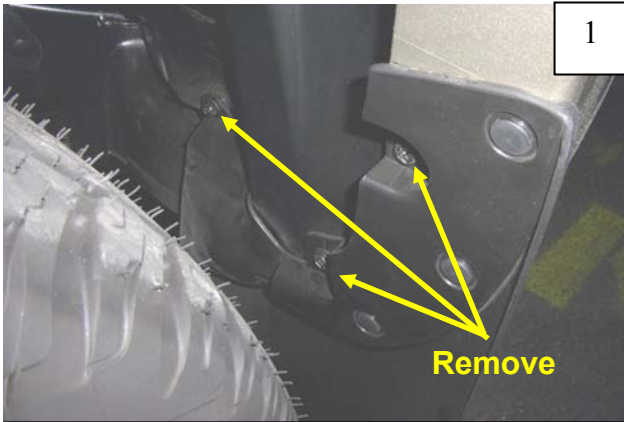


Illustration #1

### Step 3: Front Flare Installation (See Photos #1 through #33)



Remove three factory screws from the mud flap. Retain these screws for future use.



Remove four factory screws from under the fender lip. Retain these screws for future use. Remove flare by pulling part away from side of vehicle.



Using a clockwise twisting motion, remove eight factory plastic clips from fender. See Step 4 for details.



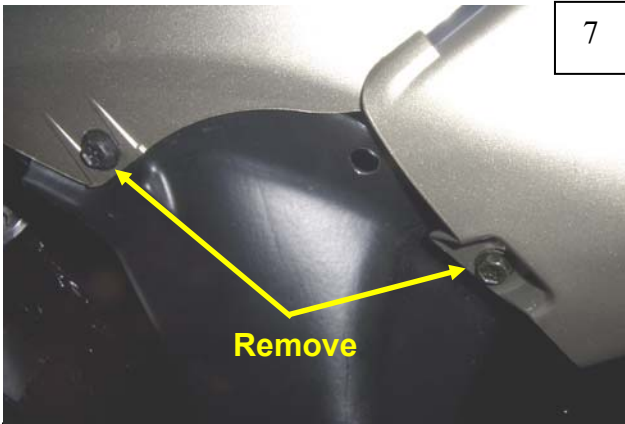
Clip locations.



Remove one clip from front using vise grips, pulling with a rocking motion. See Step 4 for details.



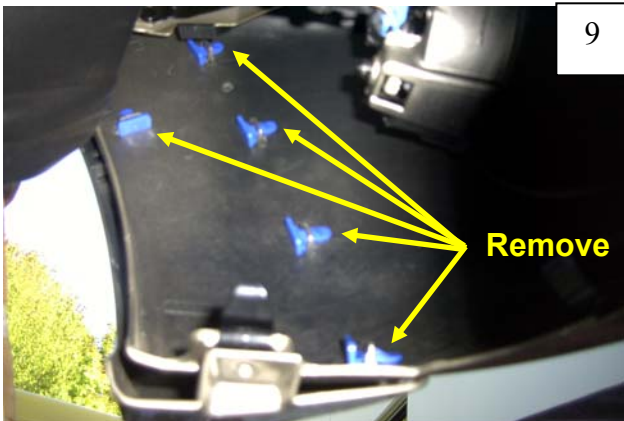
Remove two factory screws from front bumper fender extension. Retain screws for future use.



Remove two factory screws underneath the bumper cover.



Pull down bumper cover and splash shield.



Using a flat head screwdriver, with a pressing motion, remove five plastic clips located inside of bumper cover. Remove front bumper extension.



Remove plastic screw located at front of wheel well by turning clockwise 1/2 turn with a flat head screwdriver and prying out.



Replace uppermost factory screw removed in Step 6 at top of bumper cover.



Prior to paint, use a drill with 5/16" bit to drill holes at indents in pockets (9 places Front Main Flare, 2 places Front Bumper Piece). Drill from inside of parts.



13

Use a drill with 5/16" bit to drill holes at indents located at ends of Front Main Flare and Front Bumper Piece (2 places each part)



14

Slide a supplied Small Washer onto a supplied Short Torx Screw.



15

Insert one Screw/Washer assembly through each pocket hole drilled *in the Front Main Flare only* in Step 12. The Front Bumper Piece will be assembled later.



16

Place a supplied 8mm Serrated Flange Nut on the backside of the screw and tighten using an 8mm socket and supplied Torx bit.



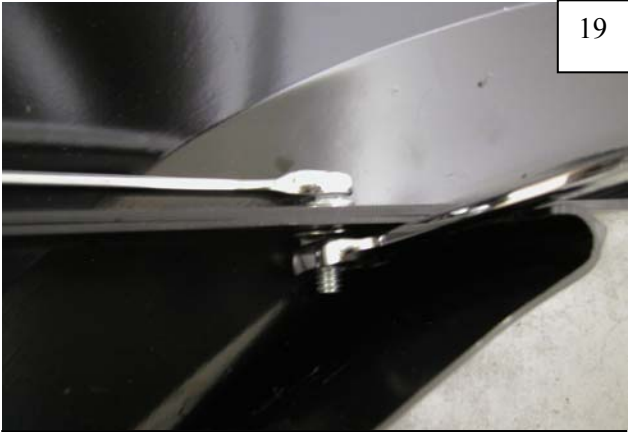
17

Slide a supplied washer onto a supplied Hex Bolt.



18

Insert the Hex Bolt/Washer assembly through the hole drilled in the end of the Front Main Flare in Step 13 and into the corresponding hole drilled in the Front Bumper Piece (2 places).



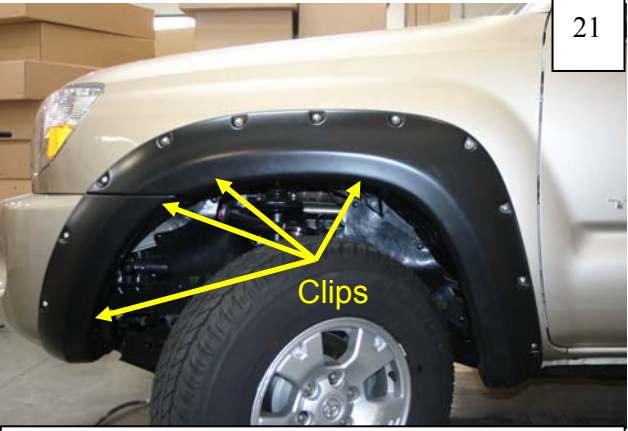
19

Install a supplied 7/16" Flange Nut on ends of Hex Bolts and tighten.



20

Hold the flare firmly on the fender. Using a grease pencil, mark four clip locations using existing holes in flares. See Step 21 for clip



21

Clip locations.



22

Remove flare from fender. Stick a supplied Black Tab over mark made in Step 20, aligning edge of tab with inner edge of fender lip (4 places).



23

Slide a supplied "S" Clip over the Black Tab (4 places).



24

Reposition flare on fender and install four factory fasteners through holes in flare and into factory holes as shown.



25

Install a supplied Serrated Flange Screw through hole in flare and into clip installed in Step 23 (4 places).



26

Using a grease pencil, mark hole locations for Front Bumper Piece pockets (2 places).



27

Remove fasteners installed in Steps 24 – 25 and remove flare from fender. Drill at marked places with a 5/16" bit.



28

Slide a supplied Small Washer onto a supplied Long Torx Screw.



29

Install Screw/Washer Assembly through pocket holes drilled in Step 12. Place a supplied black spacer on the back of the screw.



30

Situate flare on bumper, inserting screws through holes drilled in bumper in Step 27.



Reinstall four factory fasteners through holes in flare and into factory holes as shown.



Reinstall four supplied Serrated Flange Screws through holes in flare and into clips.



Repeat Steps 25-26. Install a supplied Large Washer and a supplied 8mm Serrated Flange Nut on back of Screw. Tighten.

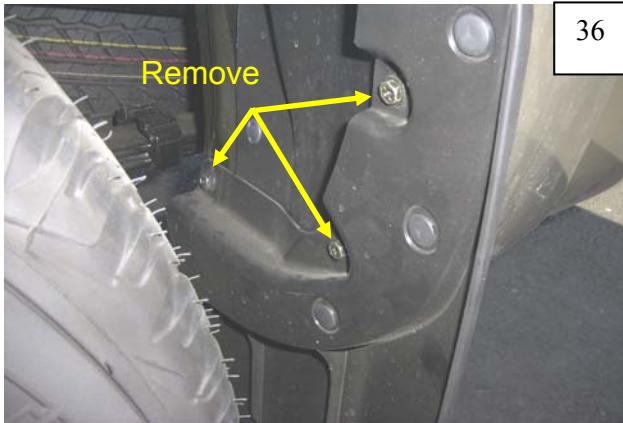


Pull down bumper cover and slide splash shield back in place. Replace factory screw in front of bumper cover to fasten splash shield to bumper cover.



At bottom of Front Bumper Piece, install a supplied 1-3/4" #14 Truss-Head Screw through a supplied 3/4" Spacer and into factory hole.

## Step 4: Rear Fender Flare Installation (See Photos #36 through #49)



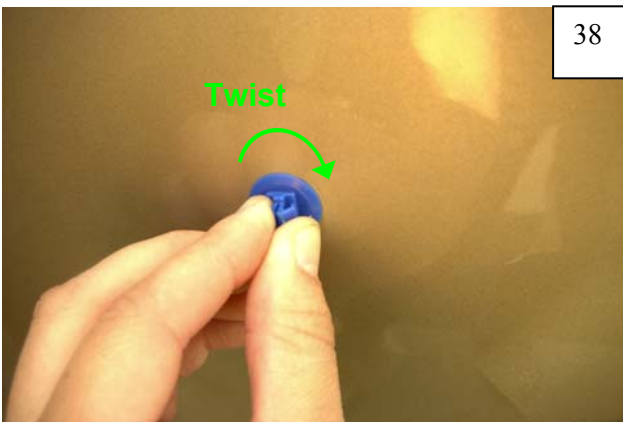
36

Remove three factory screws from mud flap. Retain these screws for future use. Discard mud flap.



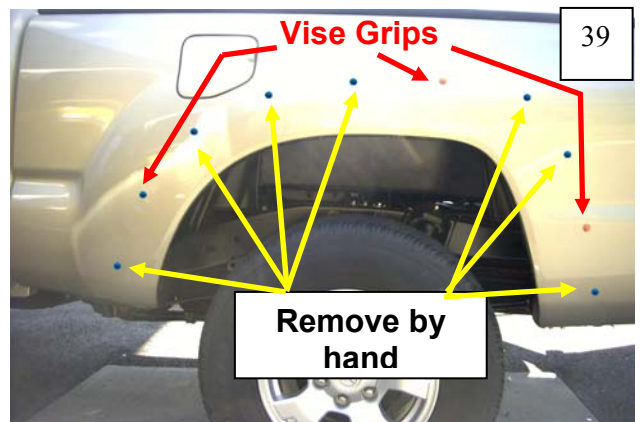
37

Remove five factory screws. Retain these screws for future use. Remove flare by pulling part away from side of vehicle.



38

Using a clockwise twisting motion, remove eight factory plastic clips from fender. See Step 39 for details.



39

Clip locations.



40

Remove three clips from fender using vise grips, pulling with a rocking motion. See Step 39 for details.



41

Prior to paint, use a drill with 11/32" bit to drill holes at indents in pockets (10 places). Drill from inside of parts.



42



Slide a supplied Small Washer onto a supplied Short Torx Screw.

43



Insert one Screw/Washer assembly through each pocket hole drilled in Step 41.

44



Place a supplied 8mm Serrated Flange Nut on the backside of the screw and tighten using an 8mm socket and supplied Torx bit.

45



Position flare on fender and install seven factory fasteners through holes in flare and into factory holes as shown.

46



At bottom front of flare, install a supplied #14 Hex Screw and a 1/4" Spacer.

47



At bottom rear of flare, install a supplied 1-3/4" #14 Truss-Head Screw and a 1" Spacer.



48

Using supplied Edge Trim Tool, seat edge trim against vehicle by hooking curved end under edge trim at one end of flare. Next, slide around outer edge of flare to the other end.



49

Using flat end of supplied Edge Trim Tool, seat edge trim against flare by inserting straight end between edge trim and flare at one end. Next, slide around entire edge to the other end.

### If Installing Front Flares with an Aftermarket Bumper:

Follow steps to install the Front Flares but disregard all steps to install the Front Bumper Piece. The Front Bumper Piece may be discarded. Variations on installation for the Front Flares are shown below.



1

Slide a supplied Small Washer onto a supplied Long Torx Screw.



2

Install Screw/Washer Assembly through FOREMOST pocket hole in the Front Main Flare. Place a supplied black spacer on the back of the screw. Remaining pockets will use Short Torx Screws (Steps 14 – 16)



3

Pull back splash shield. Install a supplied Large Washer and a supplied 8mm Serrated Flange Nut on back of Screw. Tighten.

Install aftermarket bumper as suggested by manufacturer.