

Toyota Tacoma 95.5-2004

Extended Cab/Standard Cab

Set Part # 31919

Rev- C 10-28-05

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
- 5/32" Drill Bit
- Grease Pencil
- Angle Grinder
- Reciprocating Saw
- Cut Off Wheel
- 10mm Socket
- Masking Tape
- #2 Phillips Bit
- Hammer

FLARE INSTALLATION PROCEDURES

Step 2: Preparing the Work Area

- A) Remove factory fender trim, mud flaps and mud flap brackets (when installed).

Step 3: Edge Trim Installation (See Illustration #1)

- A) Remove factory installed edge trim when necessary. 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 4: Front Fender Cutting and Installation (See Photos #1 through #18)



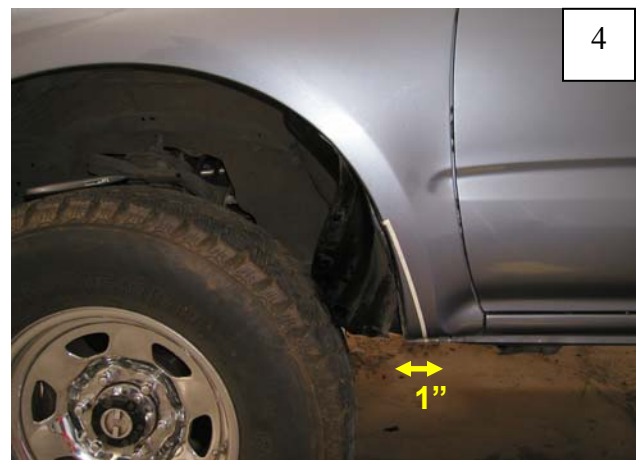
Remove mud flap.



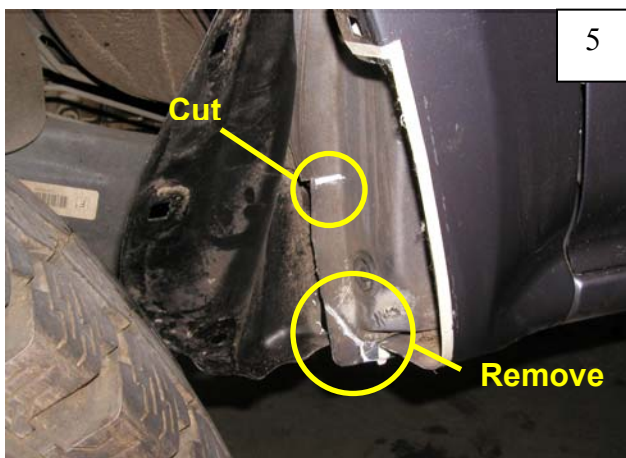
Remove 3 factory splash shield retainers as shown using a utility knife to cut flanges. Leave the retainer 4th from bottom in place.



Using the 3rd hole up from the bottom as a guide, make a tape line along lower edge of hole horizontally.



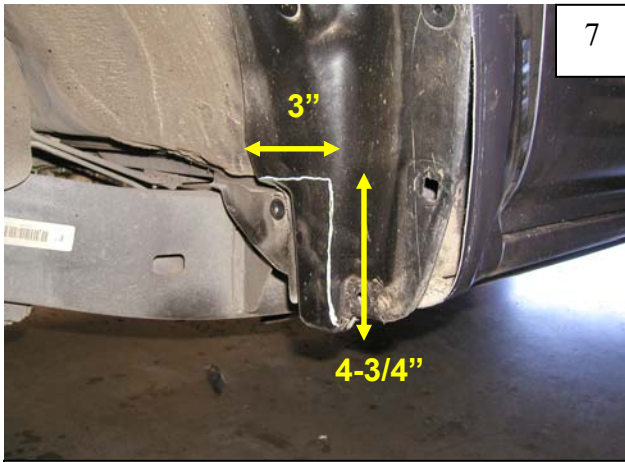
Measure out 1" at bottom of rocker. Make a tape line from bottom of rocker up, intersecting the first tape line. Using a reciprocating saw, cut fender on the inner edge of the tape line.



Cut fire wall weld seam in areas shown.

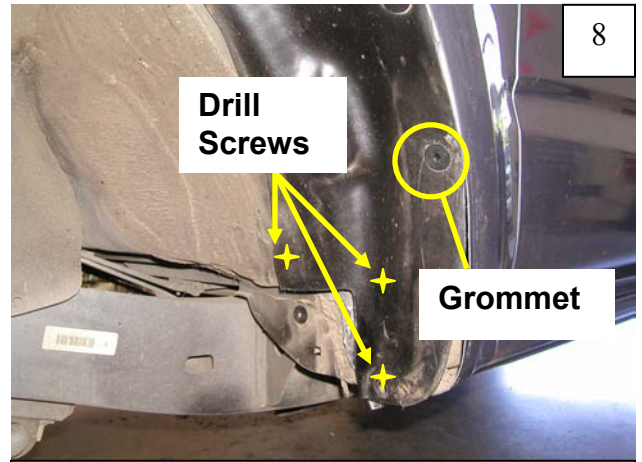


Using a hammer, flatten the fire wall weld seam as shown. Removing the wheel and tire is recommended for work clearance.



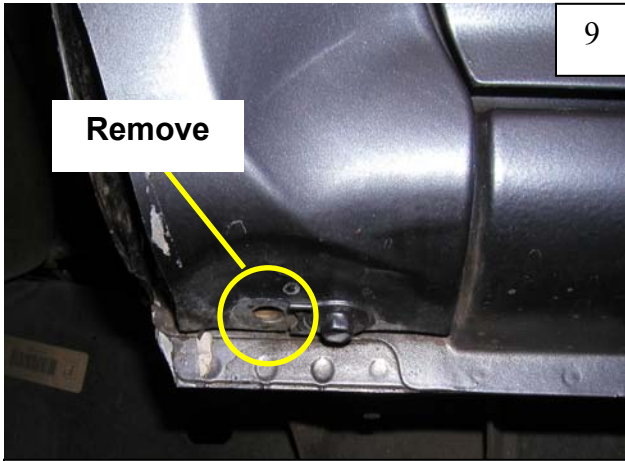
7

Trim splash shield as shown for optimum clearance. Measure up 4-3/4" from bottom and 3" in, intersecting the two lines.



8

Install kit-supplied drill screws and one kit-supplied grommet into the splash shield as shown, refastening the shield to the body.



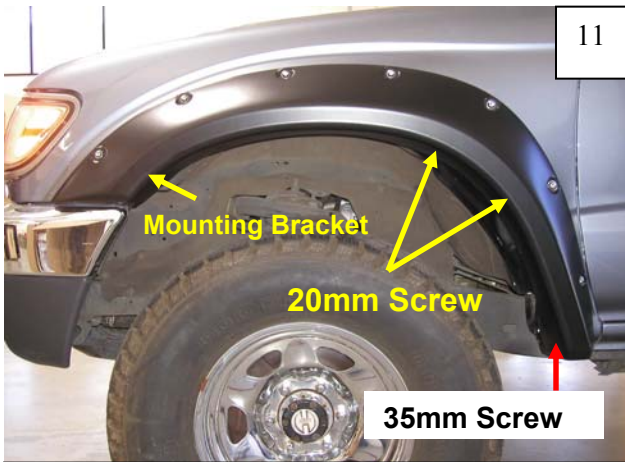
9

Remove fender bolt as shown, leaving second bolt in place.



10

Install the kit-supplied mounting bracket on the flare with a Tuf-Lok. The mounting bracket should angle down from the inner flare surface.



11

Place the flare on the vehicle to verify correct fit. Install two kit-supplied 20mm sheet metal screws and one kit-supplied 35mm sheet metal screw into position as shown.



12

Install one kit-supplied 20mm screw into mounting bracket as shown.



Mark the hole locations in the fender using the 5/16" holes in the flare as guide.



Remove fasteners and flares and drill hole locations with a 5/32" drill bit, making sure to keep the drill level and perpendicular to fender surface.



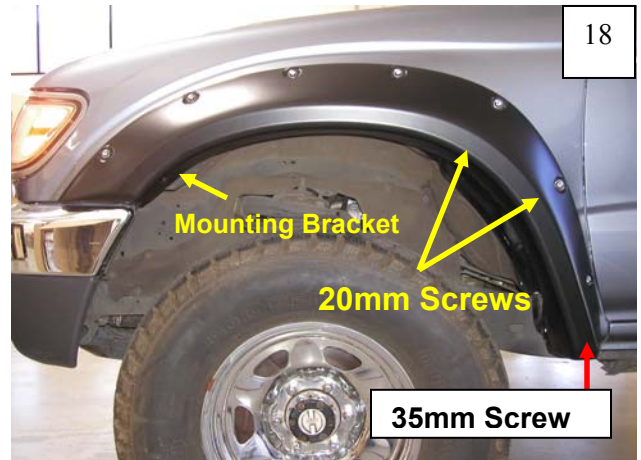
Insert a kit-supplied Torx screw and washer through each pocket hole on flare.



Install a kit-supplied 3/8" spacer and a 1/4" spacer on the screw from the backside of the pocket. Screw threads must protrude through spacer for proper attachment of flare. **Repeat for all pockets.**



Holding the flare in position on fender, align the screws with the holes drilled previously. Install each screw but **DO NOT** tighten!



Reinstall all sheet metal screws (three 20mm screws and one 35mm screw). Once these have been installed, tighten all screws. **Caution: Over-tightening screws may cause them to strip!**

Step 5: Rear Fender Cutting and Installation (See Photos #19 through #40)



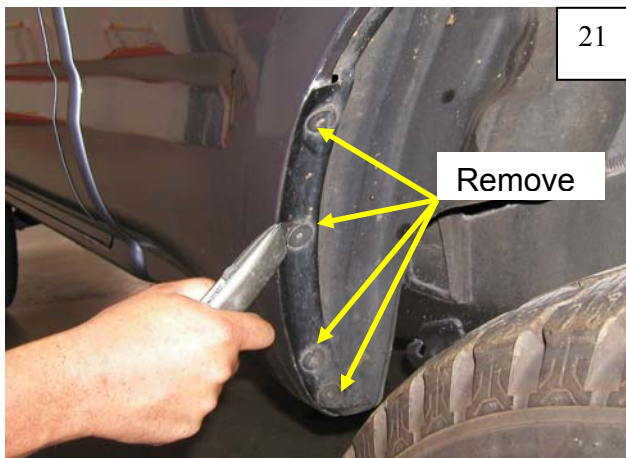
19

Remove mud flap.



20

Remove mud flap bracket, retaining bracket and hardware for later use.



21

Remove 4 FRONT factory splash shield retainers as shown using a utility knife to cut flanges.



22

Remove 3 REAR factory splash shield retainers as shown using a utility knife to cut flanges. Leave the uppermost retainer in place.



23

FRONT - Using the 4th hole up from the bottom as a guide, make a tape line along lower edge of hole horizontally.



24

Measure out 1" at bottom of rocker. Make a tape line from bottom of rocker up, intersecting the first tape line. Using a reciprocating saw, cut fender on the inner edge of tape line.



25

REAR – Using the 3rd hole up from the bottom as a guide, make a tape line along lower edge of hole horizontally.



26

Measure out 1" at bottom of rocker. Make a tape line from bottom of rocker up, intersecting the first tape line. Using a reciprocating saw, cut fender on the inner edge of tape line.



27

Trim REAR splash shield as shown for optimum clearance. Measure up 1" from bottom and 2" in, intersecting the two lines.



28

Install kit-supplied grommet into the FRONT splash shield as shown, refastening the shield to the body.



29

Install kit-supplied grommet into the REAR splash shield as shown, refastening the shield to the body.



30

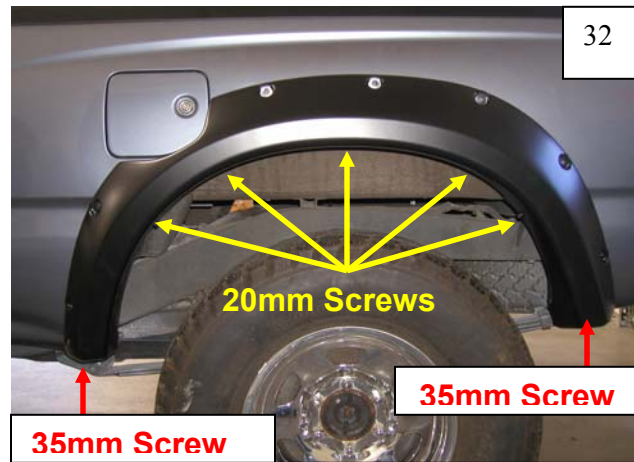
Remove front fender bolt as shown.



31

Remove

Remove rear fender bolt as shown, leaving second bolt in place.



32

20mm Screws

35mm Screw

35mm Screw

Place the flare on the vehicle to verify correct fit. Install five kit-supplied 20mm sheet metal screws and two kit-supplied 35mm sheet metal screws into position as shown.



33

Mark the hole locations in the fender using the 5/16" holes in the flare as a guide.



34

Remove fasteners and flare and drill hole locations with a 5/32" drill bit, making sure to keep the drill level and perpendicular to fender surface.



35

Insert a kit-supplied Torx screw and washer through each pocket hole on the flare.

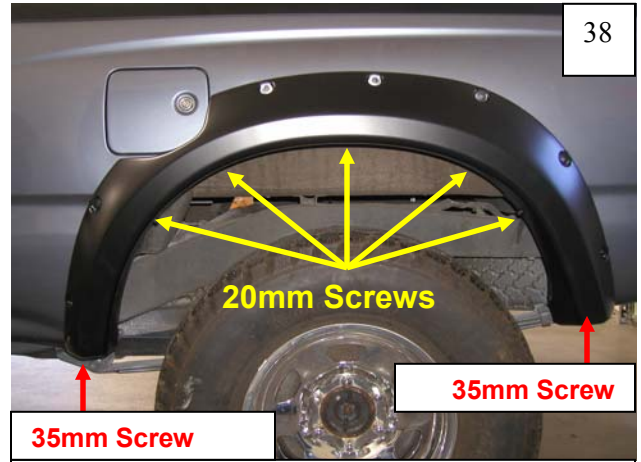


36

Install a kit-supplied 3/8" spacer and a 1/4" spacer on the screw from the backside of the pocket. Screw threads must protrude through spacer for proper attachment of flare. Repeat for all pockets.



Holding the flare in position on fender, align the screws with the holes drilled previously. Install each screw but **DO NOT** tighten!



35mm Screw

20mm Screws

35mm Screw

Reinstall all sheet metal screws (five 20mm screws and two 35mm screws). Once these have been installed, tighten all screws. **Caution: Over-tightening screws may cause them to strip!**



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.



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.

The Mud Flap Bracket can be cut two ways, as per the options below:



Option A: If you would like to reinstall the mud flap after the flare has been installed, cut the mud flap bracket as shown. Reinstall mud flap and bracket using factory hardware.



Option B: If you would like additional tire clearance but would not like to reinstall the mud flap, cut the mud flap bracket as shown. Reinstall bracket using factory hardware. **DO NOT SELECT THIS OPTION IF YOU WANT TO REINSTALL YOUR MUD FLAP.**