



30905
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REV-B

Toyota 4 Runner

TOOLS REQUIRED FOR INSTALLATION

- Scissors
- Utility Knife
- 10mm Socket
- 11mm Socket
- 13mm Socket
- Ratchet
- # 2 Phillips Driver
- # 30 Torx Bit

FLARE INSTALLATION PROCEDURES

Step 1: Painting Flares (When Required)

Dupont or equivalent paint system

(A) Preparation:

1. Wash part thoroughly with soap and warm water to release water-soluble mold release.
2. Wash part again with 2319S Plastics Prep.
3. Scuff all areas to be painted thoroughly with a red Scotch Brite or equivalent grade scuff pad.
4. Wash part again prior to painting with 2319S to remove any remaining mold release.

Note: To test if part is thoroughly clean, pour a capful of 2319S over the cleaned surface. If the liquid flows smoothly over the surface, the part is cleaned properly. If the liquid shows evidence of fisheyes or distortion as if you poured water over an oily surface, the part needs to be cleaned more thoroughly.

(B) Adhesion Promoter:

1. Apply one medium wet coat of 2322S and allow to flash for a minimum of 15 minutes but no more than 1 hour.
2. If the 2322S has dried for more than 1 hour, apply another medium coat and allow 15 minutes flash.

(C) Basecoat Application:

1. Apply ChromaBase™ Color to achieve hiding, usually 2 to 4 coats depending on color.
2. Allow 5 to 10 minutes flash time between.
3. After the last coat of color allow 15 to 30 minutes flash time before applying ChromaClear.™

(D) Clearcoat:

- Apply any ChromaClear™ per labeled directions.
- 2 to 3 coats 7500S or 7600S
 - 2 coats 7800S

(E) Single Stage Application: When Applicable.

Chroma One™ Acrylic Urethane 2 to 3 coats per labeled directions.
Imron® Polyurethane Enamel 2 to 3 coats per labeled directions.

Step 2: Preparing Flare

Note: Flare and Edge Trim must be above 55° F for complete bonding of tape.

(A) Lightly sand any overspray on backside of flare where tape is to be applied. Clean application area with a 50/50 alcohol/water solution, and dry with a clean cloth.

(B) 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 side of the vehicle). 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.

(See FIGURE 1, FIGURE 3, and FIGURE 4.)

(C) Repeat Steps 2A and 2B for remaining flares.

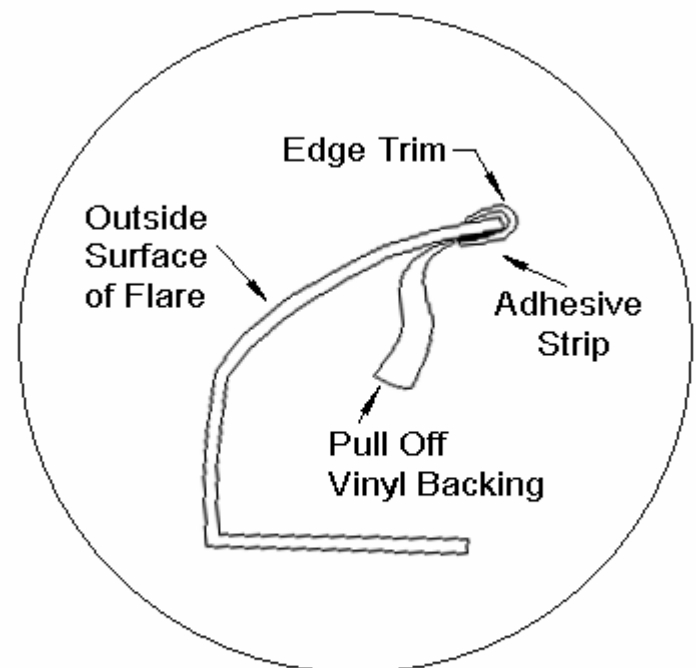


FIGURE 1

Step 3: Preparing Vehicle

- (A) If installed, remove factory wheel well trim, mud flaps, and running board end caps using a 10mm socket, a 13mm socket and a Phillips screw driver. Save any factory hardware for later use.
- (B) To remove the front factory wheel well trim, two of the plastic grommets must be cut with a utility knife. Replace these grommets with the ones in the supplied hardware kit. **(See FIGURE 2).**
- (C) If the vehicle does not have a factory running board attached, install Toyota running board (part numbers: black PT228-35994-01, chrome PT228-35994-13). Do not install the factory running board end caps.
- (D) If the vehicle does have a factory running board installed, some adjustments to the running board position may be necessary to properly install the flares.

Step 4: Front Flare Installation.

- (A) Holding the flare in position, apply moderate pressure to the outside surface of the flare and fasten the flare to the plastic grommets in the vehicle fender with the kit-supplied 10mm hex head screws. Do not fasten at the lower rear hole location.

Step 5: Running Board End Cap Installation.

- (A) Front running board end cap.
 1. Place edge trim on front boot along edge toward vehicle. **(See FIGURE 3).**
 2. Position the front running board end cap on the running board so that the two threaded studs go through the slots in the running board, and the top and inner edges of the end cap are flush with the flare and the wheel well opening.
 3. Fasten the front running board end cap to the plastic grommets in the vehicle fender with the kit-supplied 10mm hex head screws. The top screw of the end cap should go through the lower rear hole location of the front flare.
 4. Install one kit supplied 3/4" diameter nylon washer and one 1/4"x20 nut onto each of the two threaded studs under the running board and tighten with an 11mm socket. **(See FIGURE 3).**
- (B) Rear running board end cap.
 1. Position the rear running board end cap on the running board so that the two threaded studs go through the slots in the running board, and the rear edge of the end cap is flush with the wheel well opening.
 2. Install a kit supplied 1/4"x20 nut onto each of the two threaded studs under the running board and tighten with an 11mm socket.

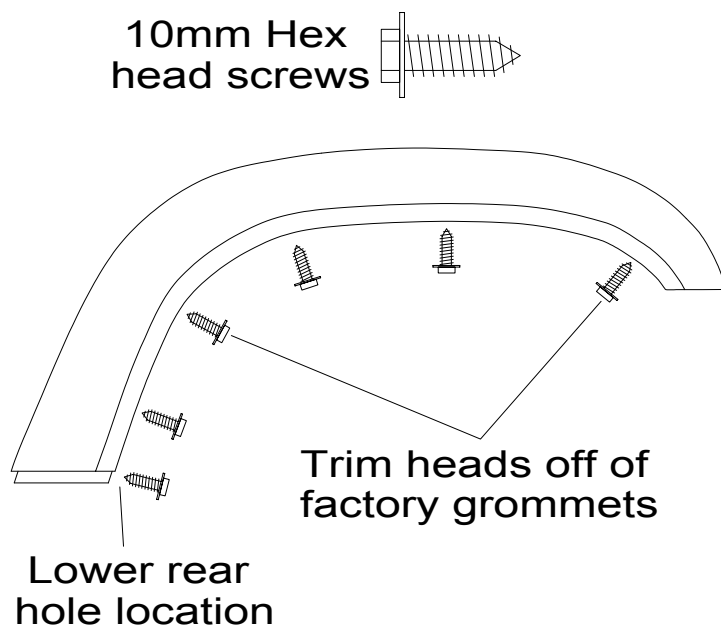


FIGURE 2

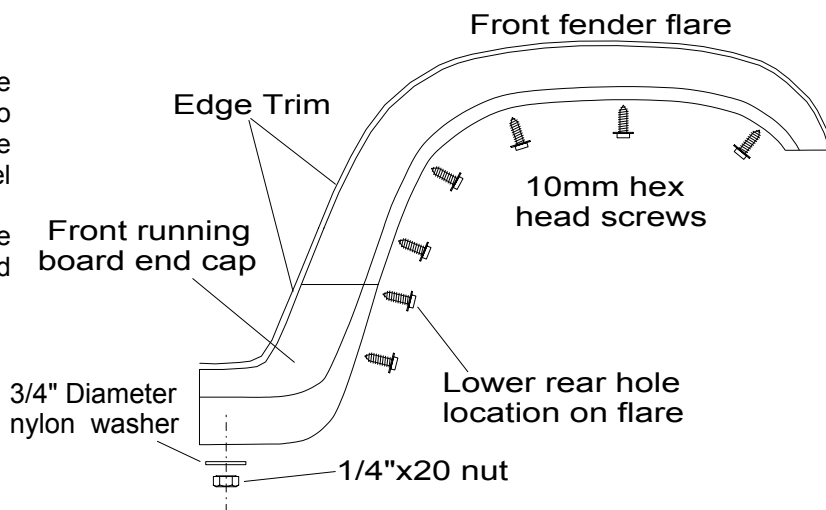


FIGURE 3

Step 6: Rear Flare Installation.

- (A) **For vehicles without factory wheel trim installed.**
- (B) Align the holes on the flare with the holes in the bumper and fasten the flare to the bumper with three torx screws.
1. Hold the flare in position on the vehicle fender and mark the hole locations onto the rear wheel well opening, using the holes in the flare as a guide.
 2. Align the door seam at the top and bottom, drill the top door seam hole first, and screw fastener in to hold flare in position. Drill all remaining holes. Drill all holes with a 1/8" bit.
- (C) **For vehicles that had factory wheel trim installed, use existing holes for flare installation.**
- (D) Align the holes on the flare with the holes in the bumper and fasten the flare to the bumper with three torx screws.
- (E) Holding the flare in position, apply moderate pressure to the outside surface of the flare and fasten the flare to the vehicle fender with the kit supplied #8 Phillips head screws.
- (F) Secure the rear under side of the flare to the bumper with a 35mm long, 10mm hex head screw, using the kit supplied nylon spacer between the flare and the bumper.

Step 7: Rear Splashguard Installation

- (A) Remove the 3 metal bushings from the splashguard and discard.
- (B) Attach rear splashguard to the holes in the flare with 4 kit supplied Christmas tree fasteners.

Step 8: Door Piece Installation.

See Figure #5 & #6

- (A) Adhere double stick tape along inner edge of the door piece and peel the red vinyl backing away from the tape.
- (B) With the door closed, align the door piece with the Rear Flare and the door seam, place the Door Piece on the door and press firmly into position.
- (C) While holding the flare in position, open the door and adhere the supplied mylar tabs on the inner door lip covering the slots in the door piece. **(See Figure # 5)**
- (D) Install the supplied barbed clips by pushing the long side of the clip over the mylar tab and into the slot of the door piece.
- (E) Close the door and verify alignment of the door piece with the vehicle bodylines, the door seam, and the Main Rear Flare. Adjust if necessary.

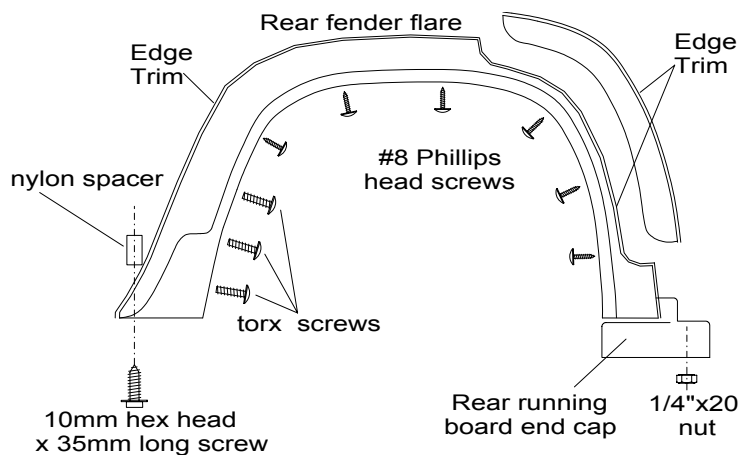


FIGURE 4

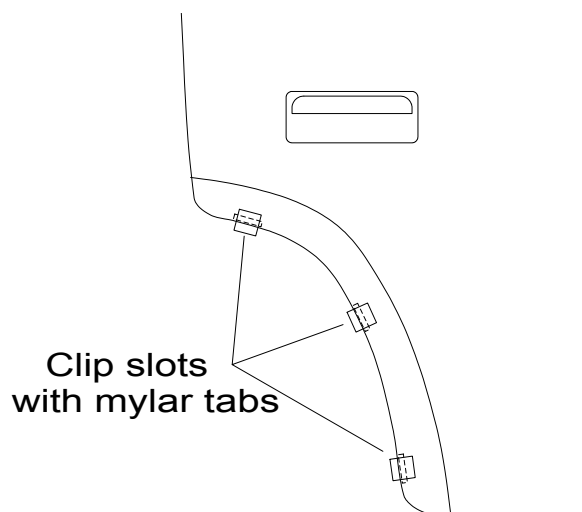


FIGURE 5

DOOR PIECE CROSS SECTION

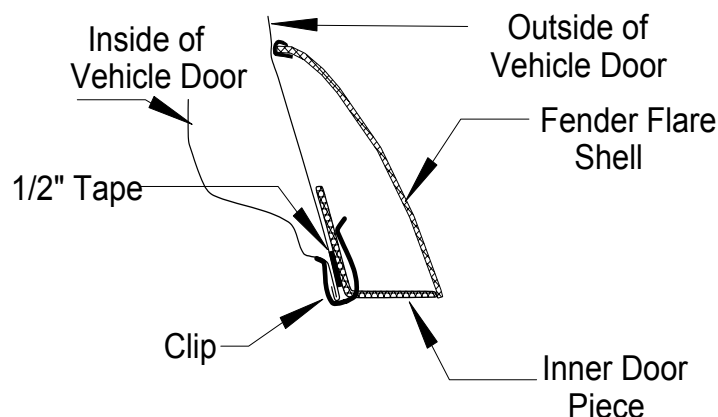


FIGURE 6