

Toyota 4WD

Set Part # 31005

Rev B 6-04



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.

TOOLS FOR EASY INSTALLATION

- 3/8" Drill
- 3/16" Drill Bit
- Pop Rivet Gun
- 8mm Wrench
- 10mm Wrench
- Hacksaw
- Jack with Jack Stands

FLARE INSTALLATION PROCEDURES

Step 2: Disassembly (Front) See Illustrations #1 and #2

- A) Jack up vehicle and use jack stands.
- B) Remove wheel and wheel well trim (if so equipped).
- C) Remove two outer mud flap retaining screws and fold mud flap inward.
- D) Remove all wheel well housing retaining screws around fender lip. **See Illustrations #1 and #2.**

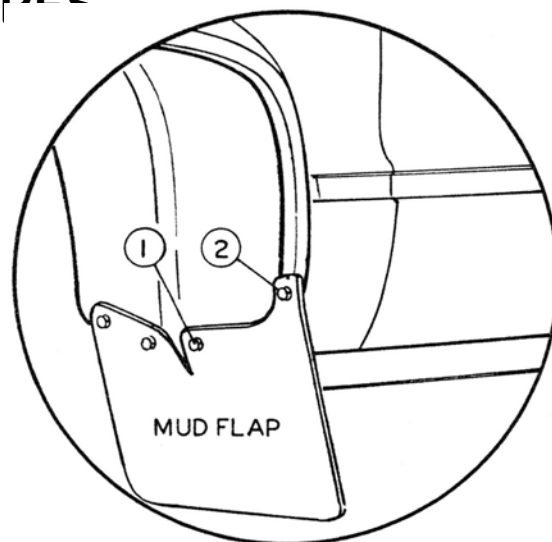


Illustration #1

Step 3: Side Molding Modifications (See Illustration #3)

On vehicles with body side moldings, it will be necessary to cut either the flare or the moldings. Note: cutting moldings usually produces better results.

Option 1: Cutting Side Molding

- A) Place flare into wheel well opening and mark a line where flare intersects molding.
- B) Remove flare and cut molding on marked line.
- C) Protect vehicle surface and sand molding end with 360 grit sandpaper to smooth finish.

Option 2: Cutting Flare

- A) Place flare side against molding end at point of intersection and trace molding contour on flare.
- B) Cut flare on marked line. **See Illustration #3.**

Step 4: Flare Attachment (Front) (See Illustrations #1 through #7)

- A) With flare off vehicle: Pre-Drill all pop rivet locating indents with a 3/16" drill bit. **DO NOT DRILL SHEET METAL WITH 3/16" DRILL BIT.** To avoid damaging flare with drill motor chuck, wrap tape around drill bit to serve as a stop. **See Illustration #4.**
- B) Place flare into wheel well opening with flare flange sandwiched between fender lip and inner wheel well panel. **See Illustration #5.**
- C) Using 3/16" re-drilled holes as a guide, drill sheet metal with drill bit supplied. Again, wrapped tape around depth stop on the bit will prevent damage to flare when drilling through.
- D) Pop rivet flare to fender using riveting sequence shown in **Illustration #6.** Don't forget cup washer under rivet head. Note: Cup washers and caps are used with pop rivets at pocket locations only.
- E) Drill and pop rivet flare to fender lip at four equally spaced points. Do not rivet flare to wheel well liner. **See Illustration #7.**
- F) Press trim caps onto outer rivet washers.
- G) Re-attach inner wheel well panel and mud flap.

Step 5: Flare Attachment (Rear) (See Illustrations #8 through #10)

Rear flares are installed using the same procedures listed in Step 4 with two differences: There are no wheel liners over the rear wheels and the gas cap door must be trimmed for proper fit. **See Illustration #10 for riveting sequence.**

Gas Door Modifications

- A) Remove stock flares and two outer mud flap screws.

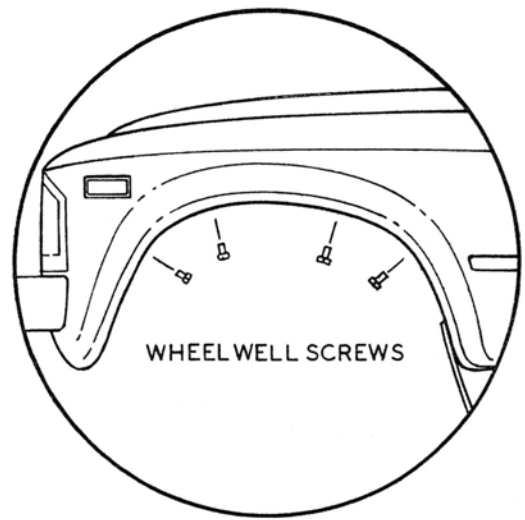


Illustration #2

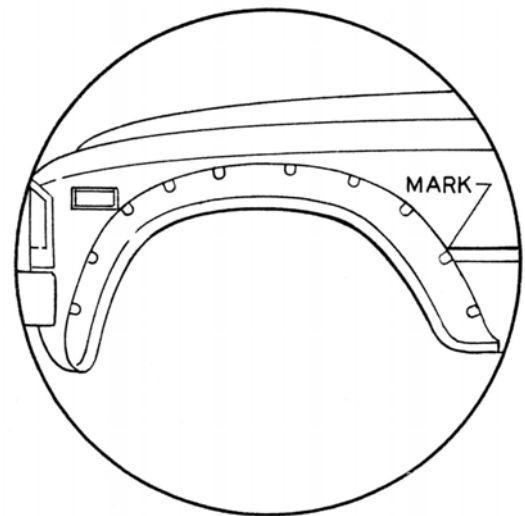


Illustration #3

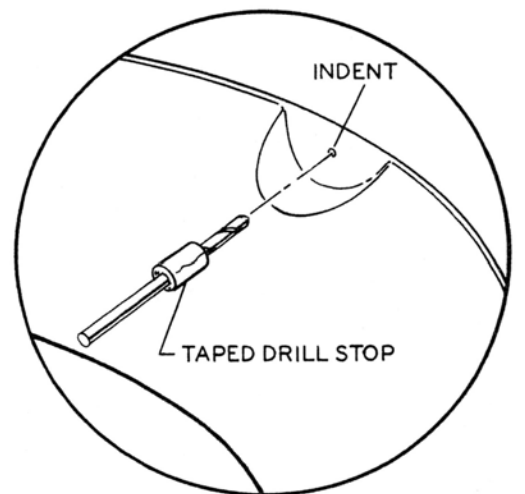


Illustration #4

- B) Holding flare in position, mark a line on gas door 1/8" from flare edge. **See Illustration #8.** Remove flare and gas door.
- C) Cut gas door on marked line. Note: Be careful not to cut the closure dip on the inside of door. Holding the hack saw blade at an angle as you cut will help. **See Illustration #9.**
- D) Paint cut edge of gas door to prevent rust. Clear nail polish will also do the trick.

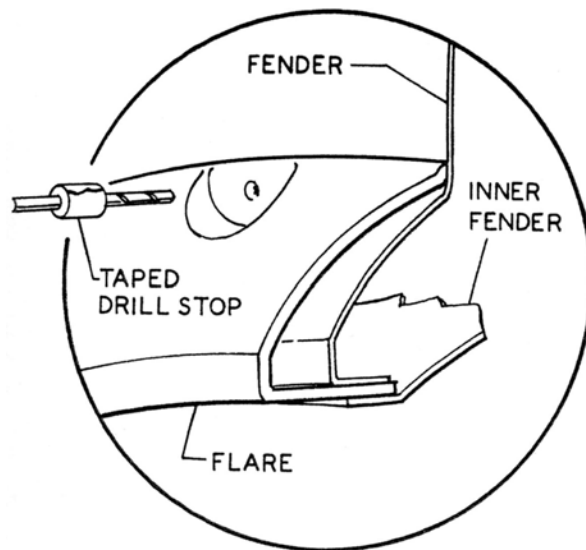


Illustration #5

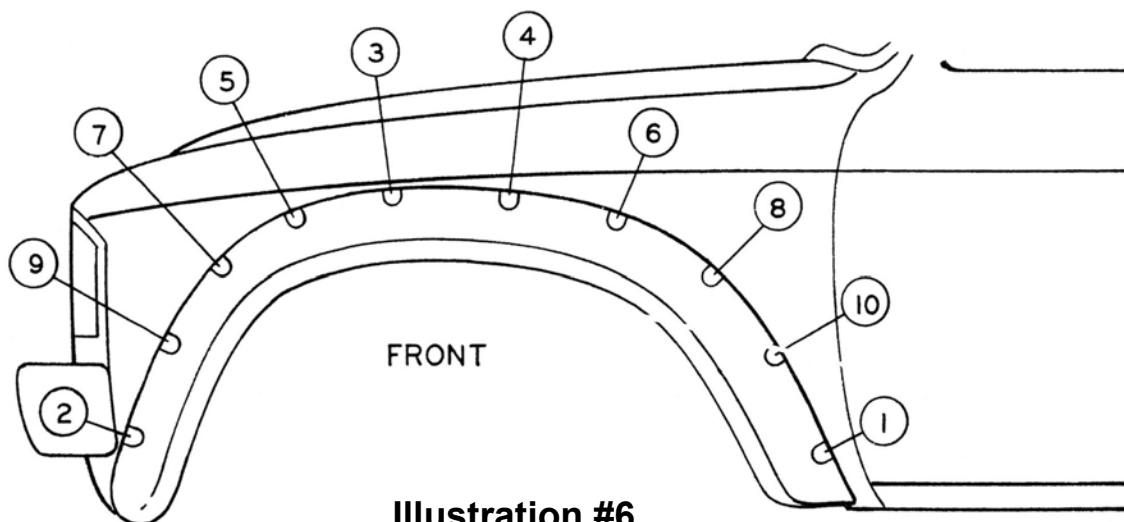


Illustration #6

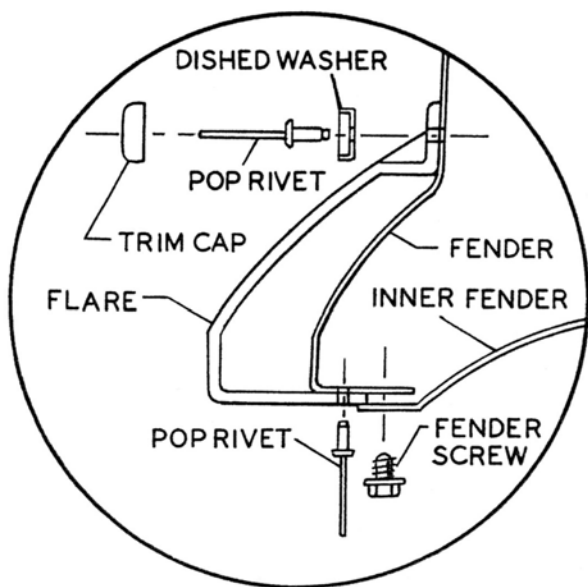


Illustration #7

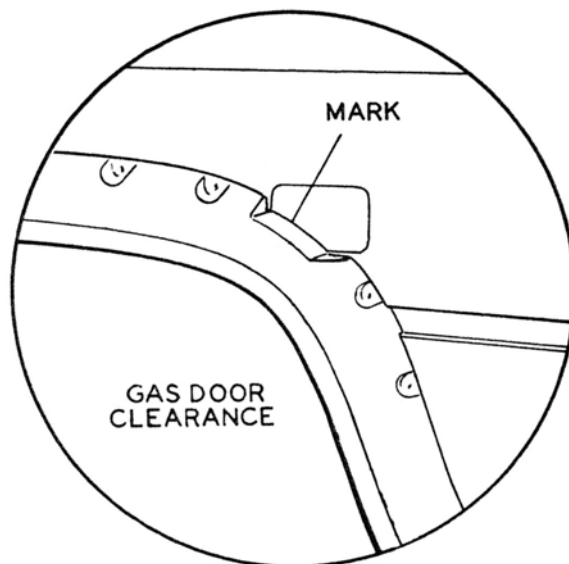


Illustration #8

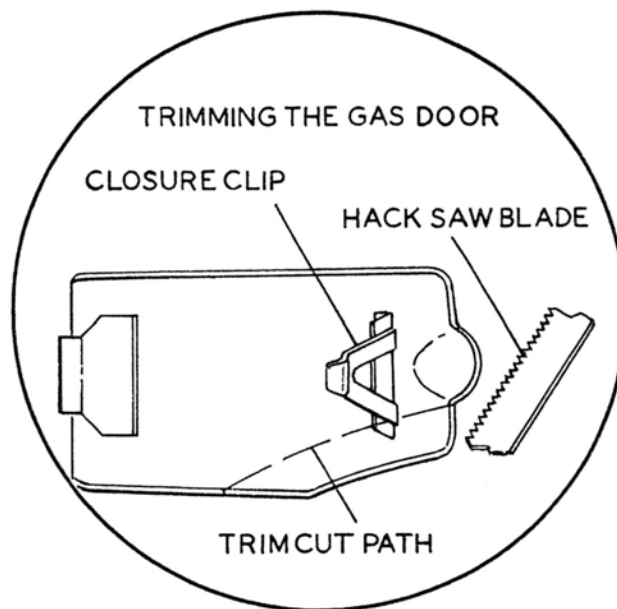


Illustration #9

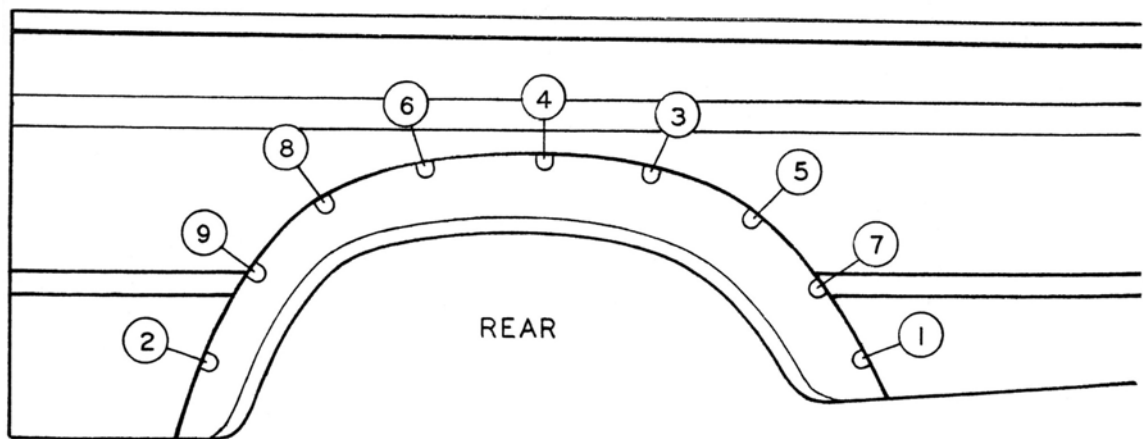


Illustration #10



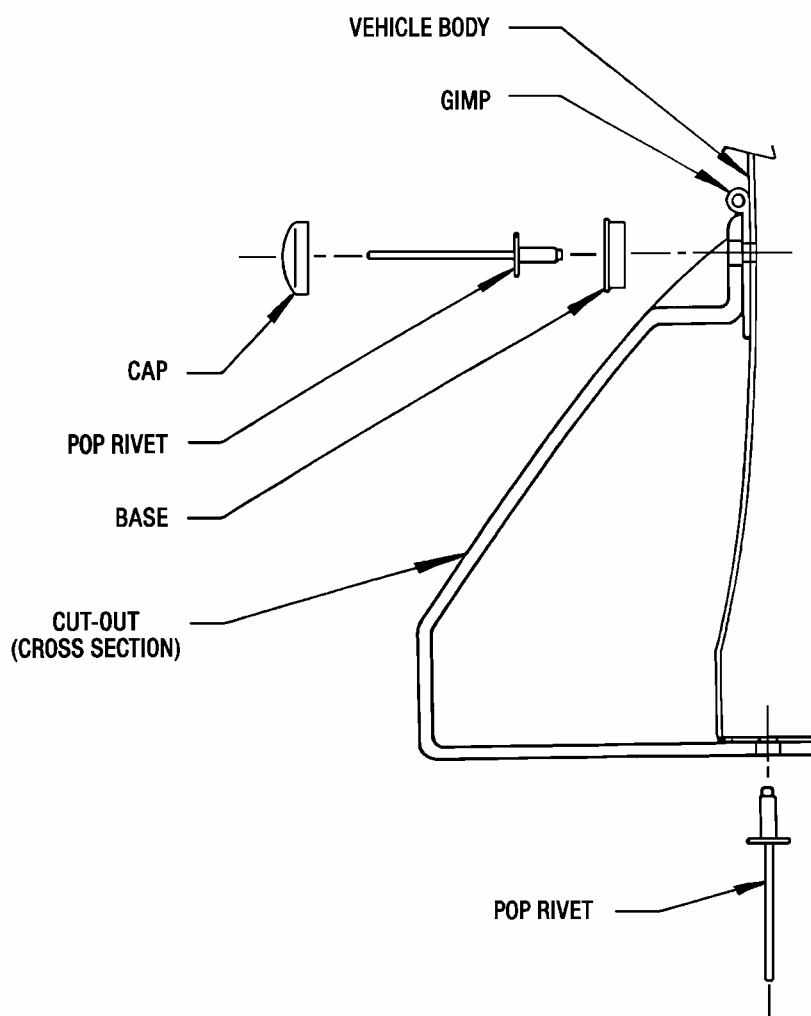
INSTALLATION INSTRUCTIONS FOR **CUT-OUT FLARE GIMP**

Tools Required for Installation:

A. Nail or Awl

STEP 1: APPLICATION:

Follow flare installation instructions to the point of drilling first hole through sheet metal with the supplied bit. Sandwich gimp between flare and sheet metal; pierce a hole through gimp using pre-drilled hole in flare as a guide. Secure and continue as flare installation instructions direct. **NOTE:** make sure bulb of gimp is tight against top of flare when securing.





IN1-S001

ATTENTION:

To help benefit the consumer, Bushwacker fender flares are now supplied with drill tip screws in place of aluminum rivets. If you receive the fastener kit including drill tip screws, use the instructions provided with the following exceptions:

Fender flare attachment

1. Hold flare in place on fender.
2. Applying moderate pressure to outside surface of flare, fasten with kit supplied drill tip screws using indents in flare as a guide. Drill through the plastic into the sheet metal. Take care not to strip out the sheet metal.