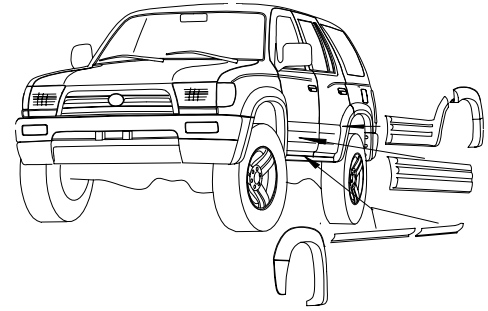




31401
03-30-05 Rev-B

INSTALLATION INSTRUCTIONS FOR
Limited Edition Package
4 Door Toyota 4Runner
Part Number 31401

IMPORTANT:
READ INSTRUCTIONS THOROUGHLY BEFORE
BEGINNING INSTALLATION



TOOLS REQUIRED FOR INSTALLATION:

- 10mm ,13mm Socket
- Utility Knife
- Grease Pencil
- Electric Drill
- Pop Rivet Gun
- 1/4,3/16,5/16,11/64 Drill Bits
- Jack and Jack Stands (Optional)
- Center Punch

FLARE INSTALLATION PROCEDURES

Step 1: Verifying fit

- (A) Verify Fit by holding Bushwacker flares and cladding against the vehicle body. Small fit adjustments can be made by trimming excess plastic.

Step 2: Painting.

Note: Painting (when desired) must be done after fit verification, but prior to full installation.

- (A) Clean outer surface of Flares and Cladding 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 painting.
- (B) Paint Flares and Cladding using a high quality lacquer, enamel, or polyurethane automotive paint. Sanding or application of a primer coat is optional.

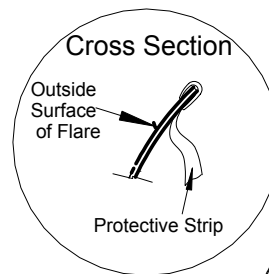
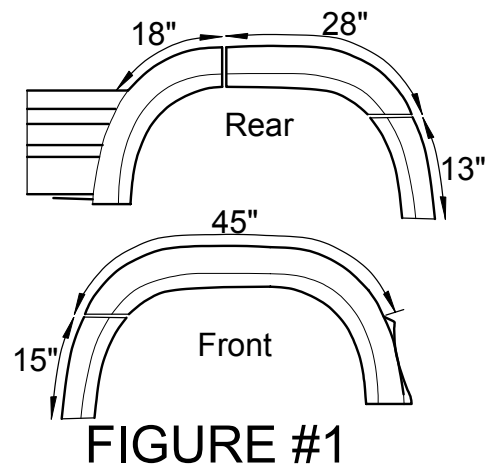
Step 3: Preparing the Work Area (Front and Rear)

- (A) Clean and wash vehicle making sure to remove all dirt and debris.
- (B) Remove wheels and support vehicle using jack and jack stands. (Optional)

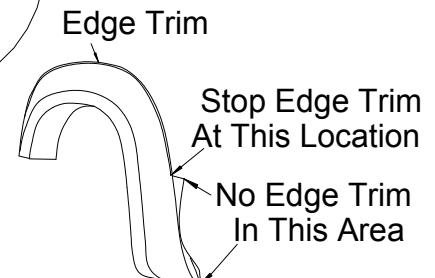
Step 4: Edge Trim Installation

- (A) The 20' roll of edge trim that is included with each kit needs to be cut to the following lengths: two 13" pieces, two 15" pieces, two 18" pieces, two 28" pieces, and two 45" pieces.
- (B) Peel two to three inches of red protective 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).
- (C) 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 & #2 for placement.



Front Edge Trim Installation



Step 5: Flare Installation (Front)

There are two parts to each front flare: the Front Bumper Cap and the Body Flare. This set includes Front Bumper Caps for both 96-98 and 99-Up model years. **See FIGURE #3** to determine the correct part for your vehicle.

- (A) Remove and save top forward three screws and two lower screws that secure the fender liner, fender trim, and mud flap to the fender using a 10mm socket. (Note: there are four lower screws if factory fender trim is installed). Save the screws.
- (B) Pre-drill all mounting holes in Body Flare with a 5/16" drill bit, using the indents formed into the flare as a guide. Pre-drill the indents in the Front Bumper Cap using a 3/16" drill bit.
- (C) Attach the mounting brackets to the Body Flare at forward three hole locations using kit supplied Tuflok® fasteners.
- (D) Position flare on fender and **loosely** secure using 10mm screws. Applying pressure to outside surface of the flare, install screws through brackets and tighten, then tighten remaining four screws to vehicle. **See FIGURE #4.**
- (E) Aligning Bumper Cap with Body Flare, mark hole locations through holes drilled in Bumper Cap on chrome part of bumper.
- (F) Center punch marked locations and drill with a 1/8" drill bit.
- (G) Attach Bumper Cap using kit supplied drill screws.

Step 6: Flare Installation (Rear)

There are four parts to each rear flare assembly: the Inner Door Piece, the Outer Door/Cladding Part, the Center Flare, and the Bumper Cap.

- (A) Remove the factory mud flap and wheel trim (when installed). Save the screws.
- (B) Pre-drill all mounting holes in Center Flare with a 3/16" drill bit, using the indents formed into the flare as a guide. Pre-drill the indents in the Rear Bumper Cap using a 5/16" drill bit.
- (C) Fasten the Rear Bumper Cap to the bumper with screws removed from the mud flap through pre-drilled holes. Apply one Barbed Clip to the under side of Rear Bumper Cap by the Edge Trim, clipping it to the bumper.

See FIGURE #5

- (D) Attach the Center Flare to the body with drill screws through Pre-drilled holes in flare, aligning it with the door seam and the Rear Bumper Cap. If factory wheel trim was removed, the holes in the flare should match the holes in the fender. If no factory wheel trim was removed, then fasten through sheet metal with drill tip screws.

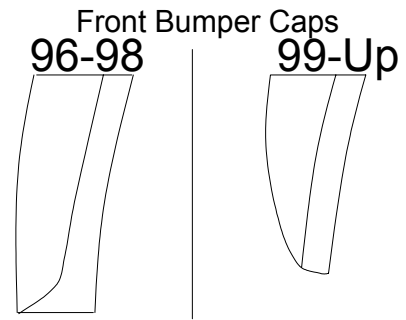


FIGURE #3

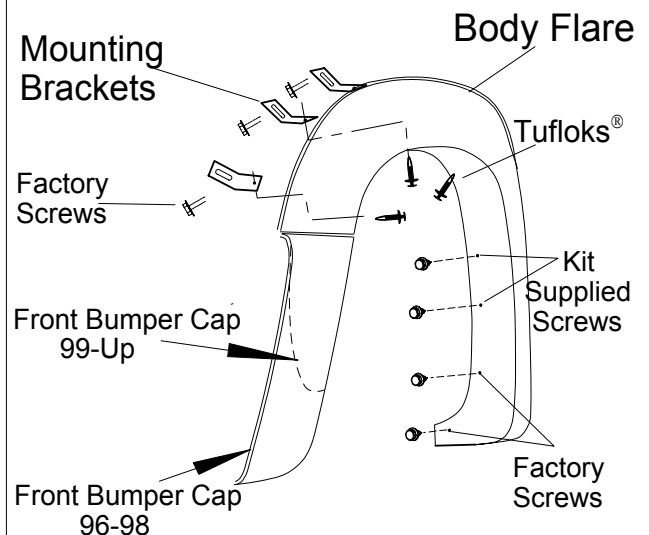


FIGURE #4

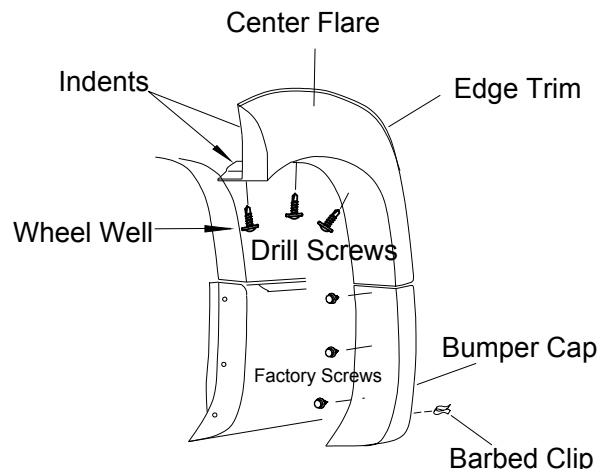


FIGURE #5

Step 7: Installing Double Stick Tape

- (A) Apply Double stick tape to the Cladding and Rocker Panel Covers at all the dashed line areas in **FIGURE #6**. Use 1/2" tape only where indicated. Use one foot long pieces of 1/2" tape on the Rear Door Cladding.
- (B) Ensure proper adhesion of tape to Cladding and Rocker Panel Covers by applying 30 Lbs. of pressure per square inch of tape with a roller or putty knife.

Step 8: Pre-fitting Cladding and Rocker Panel Pieces

- (A) Prior to removal of the red protective backing from the double-stick tape, verify Cladding fit by aligning the bottom edge with the bottom of the door, and rear edge to the rear edge of the door and the front edge with the front edge of the door.
- (B) To fit rocker panel covers, open doors and place the Front Rocker Panel Cover on the rocker panel with the Lower Tape Flange touching the pinch seam. On vehicles with factory running boards it may be necessary to loosen the running board from the brackets with a 13mm socket to allow the Rocker Panel Covers to contact the pinch seam. Place the Rear Rocker Panel Cover on the rocker

panel overlapping the Front Rocker Panel Cover where they meet.

- (C) Check that all doors open and close freely with no interference from Rocker Panel Covers. Minor trimming may be necessary for proper fit on some vehicles.

Step 9: Installing Rocker Panel Covers

- (A) Peel off red protective backing from tape and open vehicle doors.
- (B) Place Front Rocker Panel Cover on first. Press firmly to make sure tape is secure.
- (C) Apply rear part so that it overlaps the front part and press firmly to make sure that the tape is secure.

See **FIGURE #6**.

Step 10: Installing Front Door Cladding

- (A) Peel off red protective backing from 1/2" tape. Peel a 2" strip of red protective backing from each end of each strip of 1/4" tape.
- (B) Aligning with door edges and bottom of door, press Cladding at bottom edge first, and continue pressing at all tape areas until full contact is made. NOTE: ONCE TAPE HAS MADE CONTACT WITH DOOR, ADJUSTMENTS WILL BE DIFFICULT.
- (C) Peel off red vinyl backing from behind Cladding by pulling on the 2" strip.

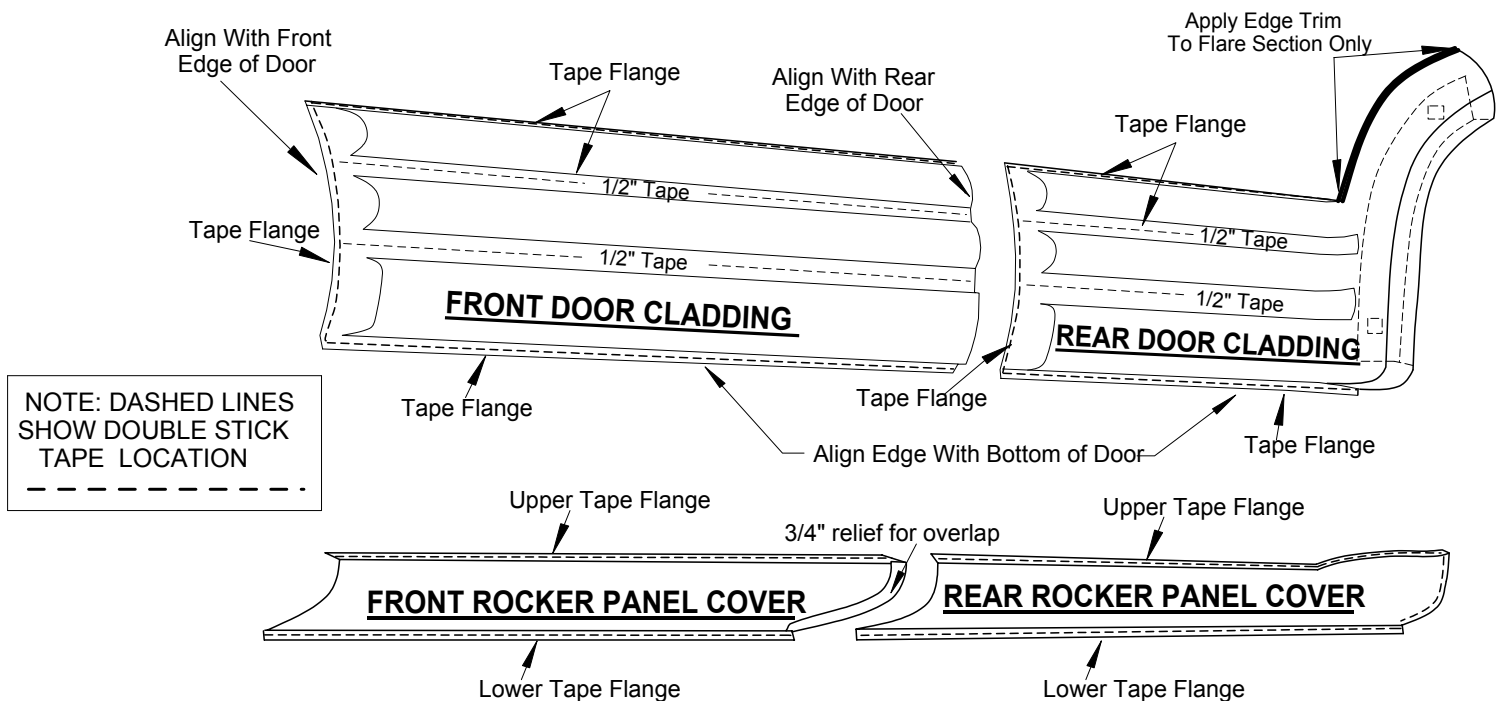


FIGURE #6

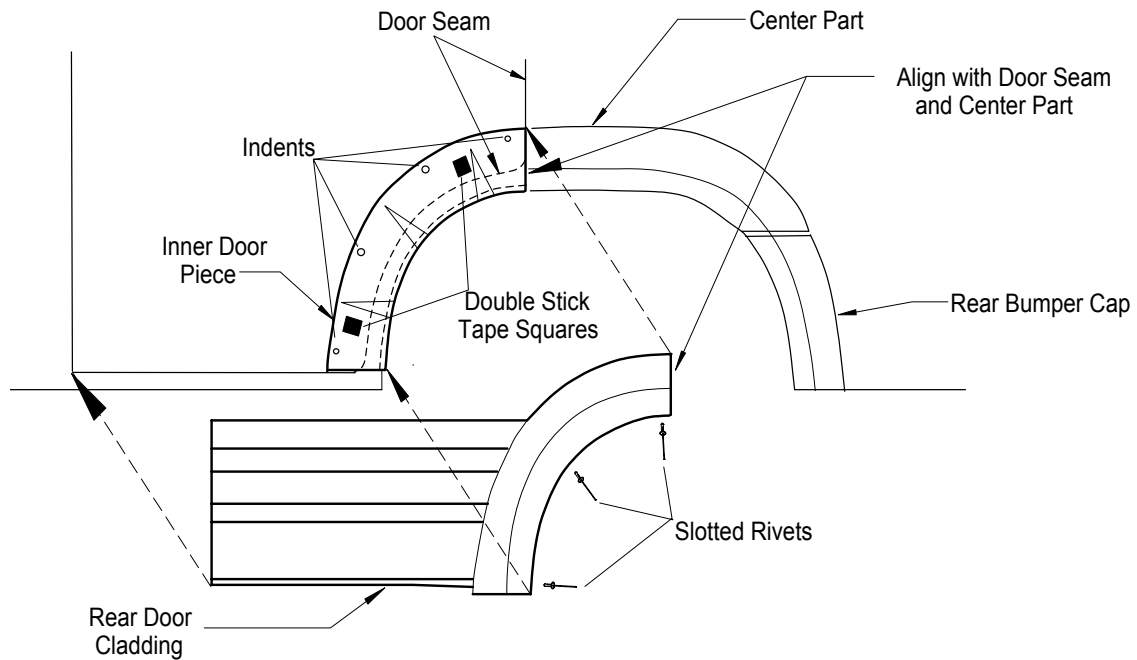


FIGURE #7

Step 11: Installing Rear Door Cladding

- (A) Pre-drill the three indents in Rear Door Cladding with an 11/64" drill bit. Pre-drill four holes in Inner Door Piece with a 3/16" drill bit. **See FIGURE #7 for hole locations.**
- (B) Attach two kit supplied double stick tape squares to the Inner Door Piece. Position part on door (use door seam location line and center part as a guide), and press into place.
- (C) Hold the Rear Door Cladding in position on Inner Door Piece to confirm fit and alignment with Center Flare and vehicle door. A gap of approximately 1/8" between wheel well rim and flare is correct to allow for proper door operation. Confirm part to part and part to door seam alignment. **See FIGURE #8.**
- (D) Remove Rear Door Cladding and reposition Inner Door Piece if necessary.
- (E) When fit is confirmed, attach Inner Door Piece to door with drill screws through holes in part.
- (F) Holding the Rear Door Cladding onto the Inner Door Piece, drill three holes with an 11/64" drill bit into the Inner Door Piece using the holes in the Rear Door Cladding as a guide.
- (G) Peel the red protective backing off of the tape on the inside of the Rear Door Cladding and position it onto the door.
- (H) Attach the Rear Door Cladding to the Inner Door Piece with Slotted Rivets through the three holes. Making sure that the Cladding is in the correct position, press it onto the door. **See FIGURE #7.**

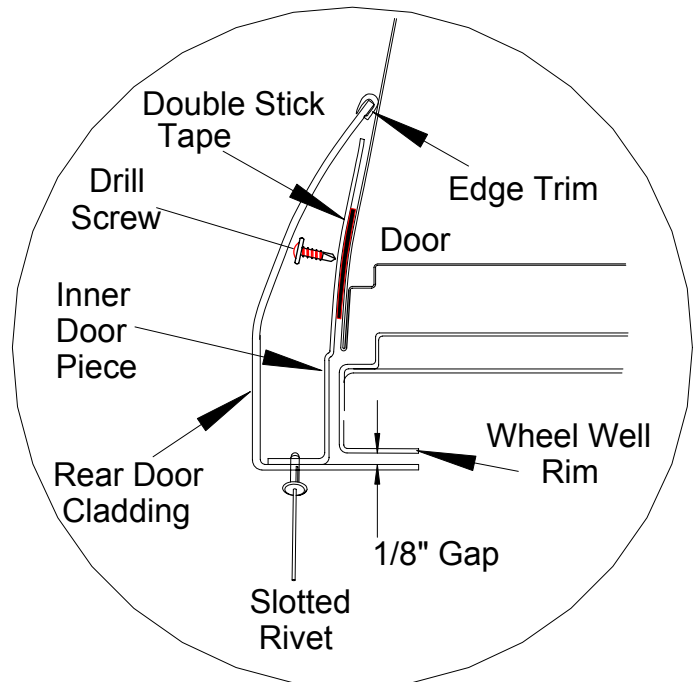


FIGURE #8