



# Toyota "OE" Style® Fender Flares Set of 4

Set Part #30913-02

Rev-6 7/23/2013

For complete fitment info visit : [www.bushwacker.com](http://www.bushwacker.com)

## STEP 1 – PRIOR TO INSTALLATION

- A) Bushwacker only approves installing the flares according to these written instructions with the hardware provided. WARNING:** Failure to install according to these instructions will invalidate the warranty. This includes, but is not limited to using alternative installation methods, hardware, or materials. **DO NOT USE:** Loctite, SuperGlue, or similar products on the hardware or the flares.
- B) Fit:** Verify the fit of the flares to vehicle. (Some filing, sanding, or cutting may be necessary to ensure proper fit).
- C) Painting:** (Optional) if paint is desired it must be done prior to installing flares on 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. Application of plastic adhesion promoter for ABS plastic as per your paint system manufacturer's recommendations is required. Paint flares using a high quality enamel, or polyurethane automotive paint. If painting edge trim (not recommended), use a flex additive.
- D) 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.
- E) 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)
- F) Metal Protection:** All exposed fasteners and bare metal should be treated with rust resistant paint BEFORE installing flares. Spray inner fender wells with undercoating AFTER flare attachments have been completed.
- G) Decals:** Flares may interfere with existing decals on vehicle. If you wish, remove decals prior to installation of flares.









## TOOLS FOR EASY INSTALLATION:

- Socket Wrench
- 10mm Socket
- #2 Phillips Screwdriver
- T30 Torx Bit
- Ratcheting Spring Clamp
- Pry Tool
- Grease Pencil
- Masking Tape
- 4" Deep Reach Ratcheting Spring Clamp
- Poly Foam packing material (Wrapping material for door pieces)

## LIMITED LIFETIME WARRANTY AGAINST ANY MANUFACTURING DEFECTS

- To claim a warranty, you must provide Proof of Purchase.

## Included in Hardware Kit:

- |    |   |    |   |    |   |    |   |    |  |    |   |    |   |
|----|---|----|---|----|---|----|---|----|--|----|---|----|---|
| 1. |   | 2. |  | 3. |  | 4. |  | 5. |  | 6. |  | 7. |  |
|    | AD1-0006,<br>ADHESIVE<br>PRIMER AMP,<br>2 pcs                                       |    | CL1-0005,<br>Dacromet "U"<br>Spring Clip,<br>10 pcs                                 |    | GP1-0008,<br>Duro (NC02/S 70)<br>Edge Trim,<br>384 inches                           |    | MT1-0002,<br>1" x1" x.017"<br>Black Tab,<br>10 pcs                                  |    | NU1-0007,<br>#12 "U" Spring<br>Nut,<br>2 pcs   |    | NU1-0013,<br>#14 Black "U"<br>Spring Nut,<br>2 pcs                                    |    | SW1-0048,<br>M6-.3 x 25 Hx Mag<br>Black Screw,<br>20 pcs                              |
| 8. |  |    |   |    |   |    |   |    |  |    |   |    |   |
|    | ET1-0002,<br>Edge Trim Tool,<br>1 pc  |    |   |    |   |    |   |    |  |    |   |    |   |

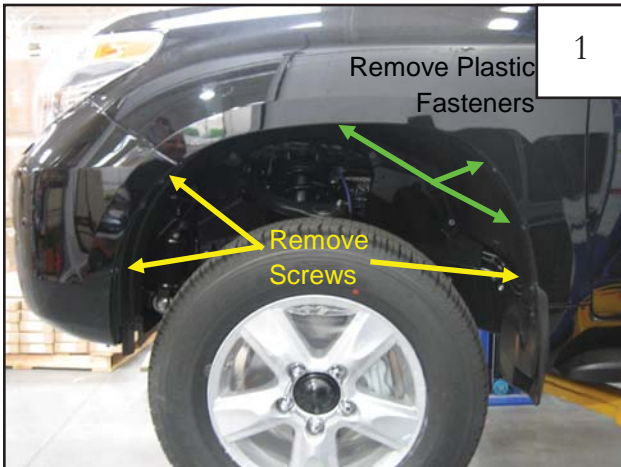
## STEP 2 - EDGE TRIM INSTALLATION

A. Peel two to three inches of red vinyl backing away from Edge Trim (GP1-0008) 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).

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.



## Front Flare Installation Procedures (Driver's Side):



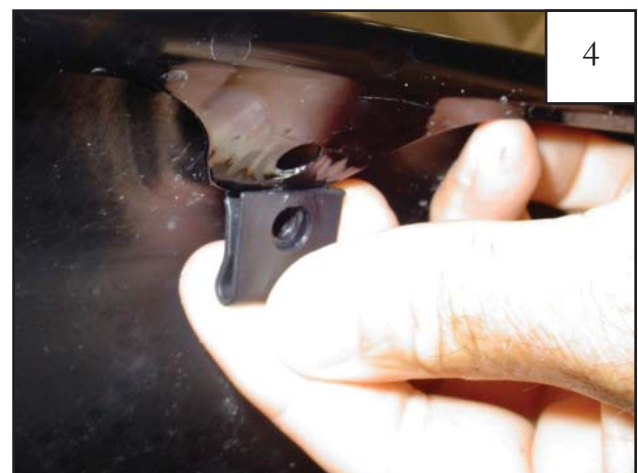
Using a socket with a T30 Torx bit, remove three factory screws. Use a trim tool or flat head screwdriver to remove three factory plastic fasteners located in rear of wheel well one located in the top center of wheel well. Discard.



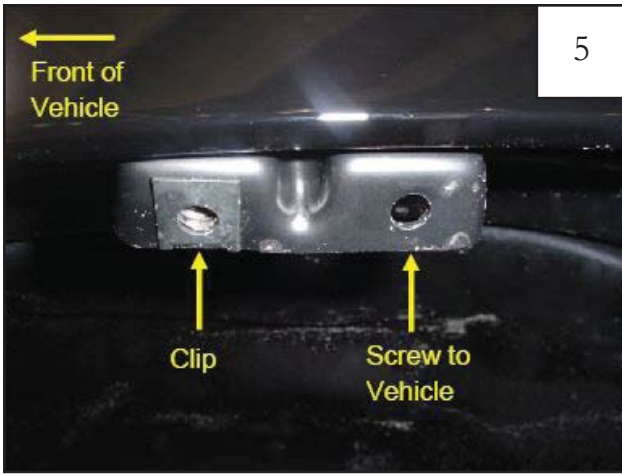
Using a 10mm socket, remove one factory bolt located at front underside of bumper. Discard.



Install plastic clip onto factory sheet metal below the inner splash shield.



The splash shield needs to be pushed behind metal fastening point to access where the clip needs to be installed.



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Install supplied plastic bracket using large Hex Screw into the plastic clip installed in step 10. The screw goes in rearward hole and the clip fastens over the forward hole.



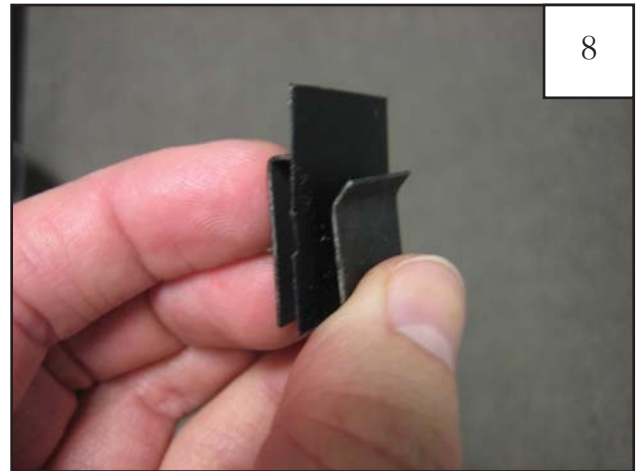
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Reposition Front Flare on Fender. Hand start five supplied Hex Screws through flare and into hole locations shown (three in wheel well, one at front underside of bumper, and one through the "U" Clip installed on bracket in Step 11). Do not tighten.



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Install two supplied Plastic Tuf-Loks through rearward holes in Flare.



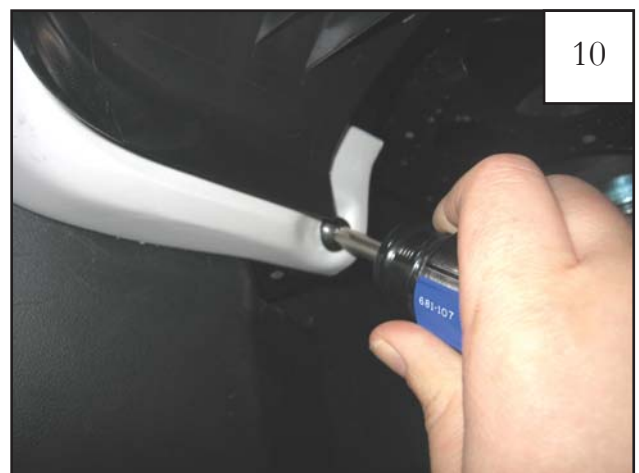
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Peel paper backing from supplied Black Tab. Adhere tab to supplied "S" Clip.



9

Slide "S" Clip/Black Tab combination onto sheet metal lip near rocker panel, at rear bottom of flare, aligning hole in clip with hole in flare.



10

Start a supplied Serrated-Flange screw through lower rear hole in flare and into "S" Clip installed in Step 9. Tighten all screws.

# Rear Flare Installation Procedures (Driver's Side):



Using a socket with a T30 Torx bit, remove three factory screws. Discard.



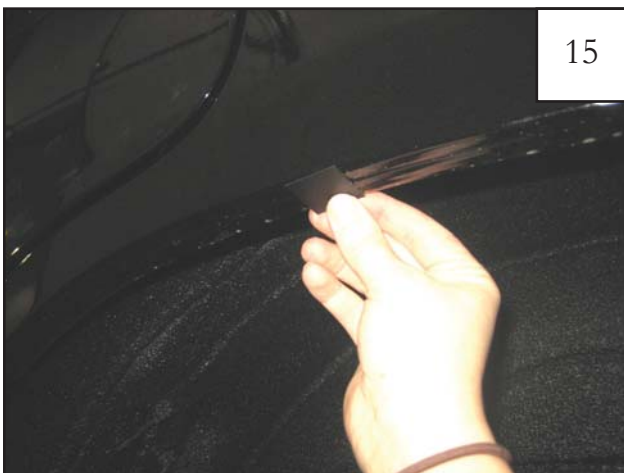
Using a 10mm socket, remove one factory bolt from underside of bumper at mud flap area. Discard.



Position Rear Main Flare on fender, and hand start three supplied Hex Screws in rear of rear wheel well, starting with the top screw and working your way down.



Using a grease pencil, mark four clip locations on fender of flare, using holes in flare as a guide. Remove screws and remove flare from fender.



Peel paper backing from supplied Black Tab. Center four tabs over marks made in Step 14.

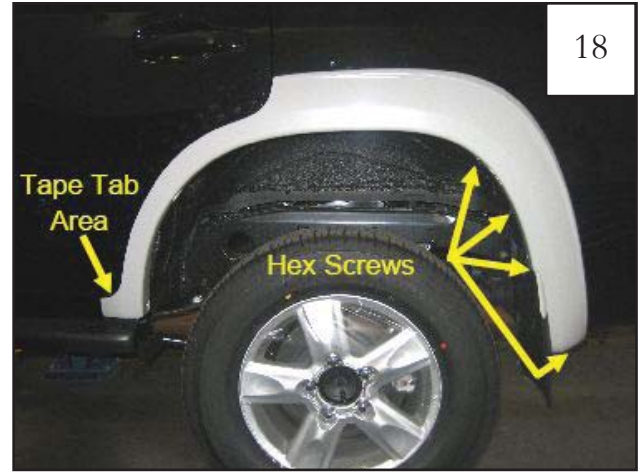


Tab Locations.



17

Position four "S" Clips onto fender lip over Black Tabs.



18

Reposition Rear Main Flare on fender. Hand start four supplied Hex Screws through flare and into hole locations shown (three in wheel well, one at rear underside of bumper). *Do not tighten*. Make sure that tape tab at front of flare is accessible.



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While holding bottom front edge of flare in place, pull the tape tab. Press part into place, applying 30 PSI for a minimum of 15 seconds for proper bond. Once tape adheres, parts should not be adjusted in this area.



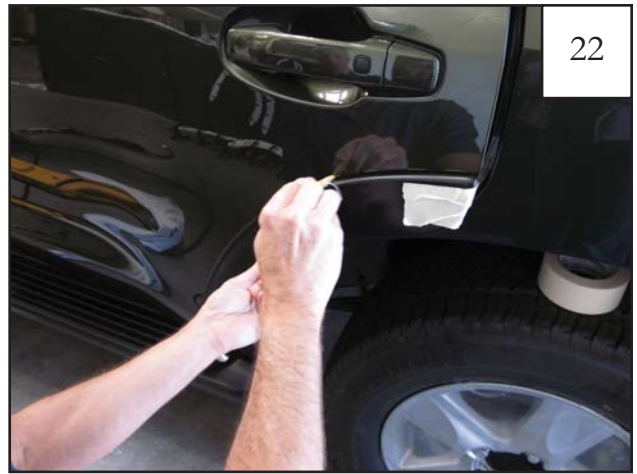
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Start four supplied Serrated-Flange Screws through forward holes in flare and into "S" Clips installed in Step 17, starting with topmost hole and working your way down. Once last screw is started, tighten all screws.

# Rear Door Piece Installation Procedures:



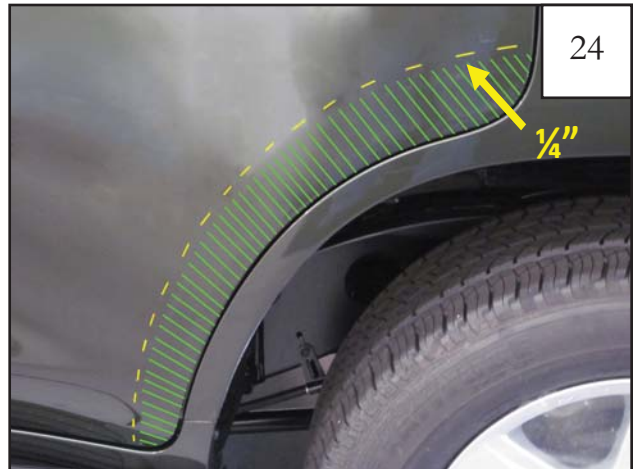
Position Door Piece (without edge trim) on door. Line up with the top and bottom of door edge. Use masking tape to hold flare in place.



Using a grease pencil, mark a line along top edge of flare.



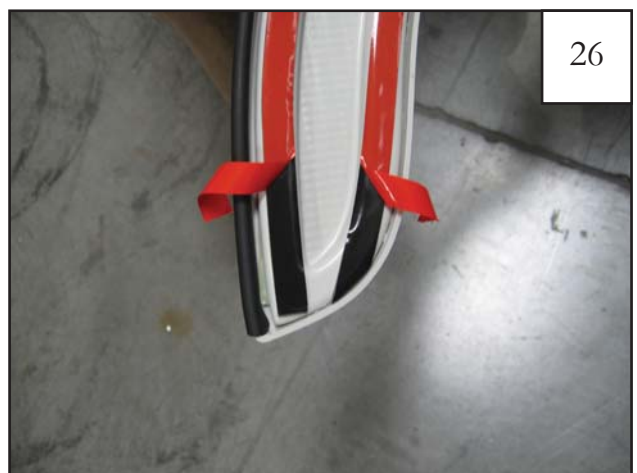
Using Primer Ampoule, apply primer to door  $\frac{1}{4}$ " below the line marked with grease pencil. *NOTE: Allow primer to dry for five (5) minutes before continuing installation.*



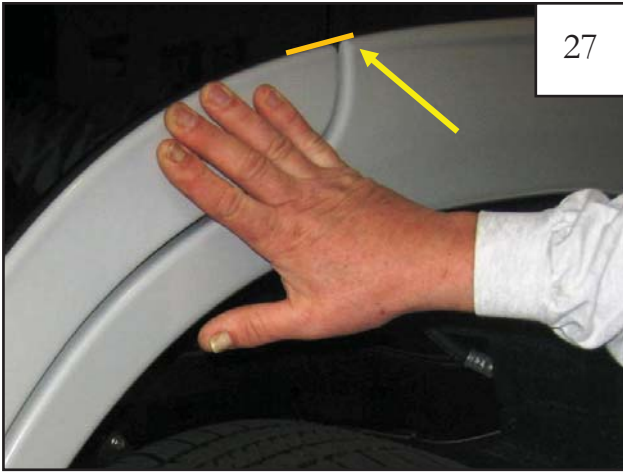
Primer application area.



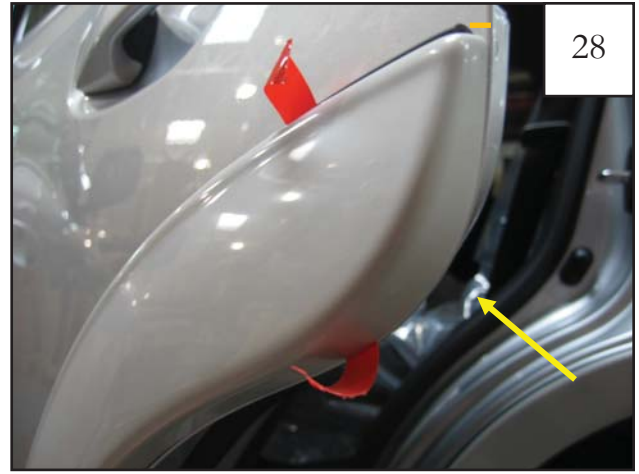
Install Edge Trim on Door Piece. Refer to Edge Trim Installation section for instructions.



Fold red liner of Door Piece tape toward the outside of the part. (Make sure the tabs are folded toward the outside of the part.)



With door closed, line up the door piece rubber edge to line up with main rear rubber edge and mark the door with a grease pencil or piece of tape



With the door open align curve of door piece as flush as possible with lower door edge keeping the edge trim of the door piece lined up with wax pencil mark or tape edge placed earlier on door.



Align lower curve of Door Piece flush with lower door edge.



While holding the Door Piece in place, pull upper tape liner tab.



Press the part into place. Brace fingers on inside of door and use thumbs to press firmly against part and repeat along full length of part at upper tape liner location. *Tape reaches maximum adhesive bond after 24 hours of contact.*



While holding Door Piece in place, pull lower tape liner tab.



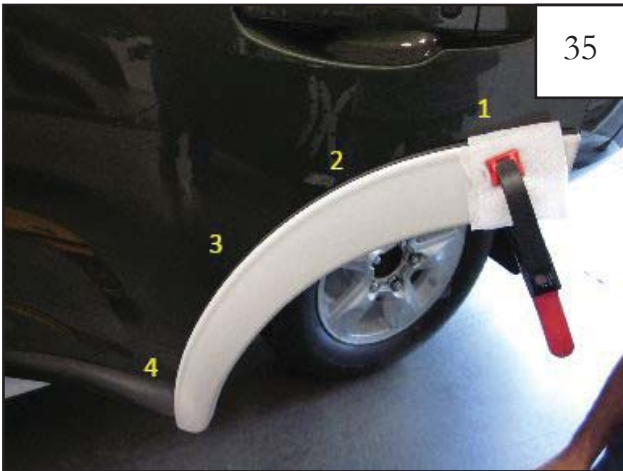
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Brace fingers on inside of door and use thumbs to press firmly against part and repeat along full length of part at lower tape liner location. *Tape reaches maximum adhesive bond after 24 hours of contact.*



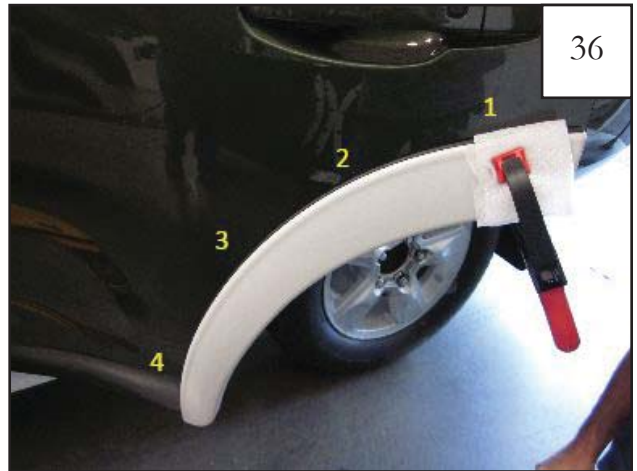
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Cut a piece of poly foam packing material approx. 2" x 4".



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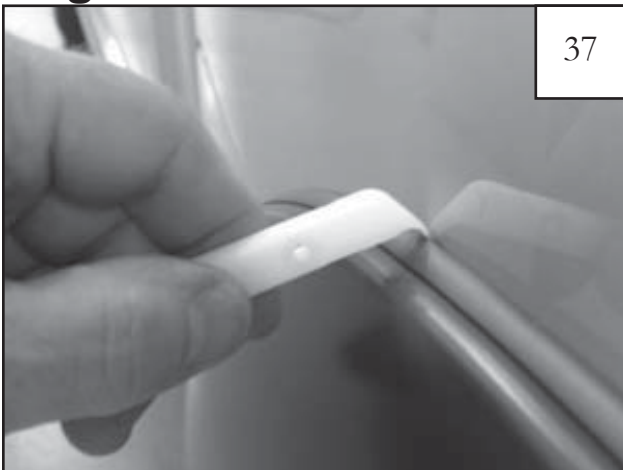
Using foam pad between the Door Piece and the ratcheting clamp, Attach clamp on upper part of Door Piece in position 1 and tighten. Leave clamp in place for 1 minute. Repeat clamping method for positions 2, 3 and 4. Leave clamp in place for 1 minute in each position.



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Position of clamp on back of door.

## Edge Trim Tool Procedures:



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Using supplied Edge Trim Tool (ET1-0001), 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.



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Using flat end of supplied Edge Trim Tool (ET1-0001), 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.