



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.

Jeep® Cut-Out™ Fender Flares Rear Pair

Rear Part #10072-07

Rev-5 11/21/2013

For complete fitment info visit : www.bushwacker.com

TOOLS FOR EASY INSTALLATION:

- Grease Pencil or Scribe
- Heavy Hammer
- Reciprocating Saw
- Pliers, Sheet Metal Pliers
- Electric Drill
- 3/32", 3/16", 1/8" and 1/4" Drill Bits
- #2 Phillips Driver
- Utility Knife
- Cut-off Wheel
- Angle Grinder
- Sand Paper
- Urethane Caulking/Sealant
- Caulking Spreader
- Measuring Tap/Ruler
- Heat Gun
- Socket Wrench
- 3/8" , 5/16" Socket
- 10mm Deep Socket
- 3" Socket
- Extension
- Torque Wrench
- Impact Wrench
- Masking Tape
- Partner/Helper
- Pry Tool
- Measuring Tap/Ruler
- Car Jack/ Jack Stands
- Awl

NOTE: These instructions involve cutting parts of the vehicle. It is important to read all instructions prior to cutting and installing of flares.

LIMITED LIFETIME WARRANTY AGAINST ANY MANUFACTURING DEFECTS

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

Included in Hardware Kit:

- | | | | | | | |
|---|--|--|--|---|---|--|
| 1. 
AD1-0006,
ADHESIVE
PRIMER AMP,
2 pcs | 2. 
AD1-0010,
LARGE ALCOHOL
PREP PAD,
4 pcs | 3. 
COR-0002,
3" Core,
1 pc | 4. 
ET1-0002,
Edge Trim Tool,
1 pc | 5. 
GP1-0005,
Large Wiper Style
Edge Trim,
172 inches | 6. 
GP1-0020,
5/8" Black
Extruded Molding
104 inches | 7. 
MB1-0003,
GDB Mounting
Bracket,
4 pcs |
| 8. 
MT1-0025,
1/2" Double Sided
Tape,
32 pcs | 9. 
NU1-0004,
10-24 Nylock Nut,
4 pcs | 10. 
NU1-0011,
1/4-20 SS Serrated
Flange Nut,
4 pcs | 11. 
RV1-P008,
1/4" Panel
Retainer,
8 pcs | 12. 
SP1-0009,
3/8" x 5/8" x .187"
Neo Black Spacer,
18 pcs | 13. 
SW1-0006,
1/4-20 x 1" SS
Slotted Screw,
4 pcs | 14. 
SW1-0045,
#14-14 x 1"
Torx Screw,
16 pcs |

Included in Hardware Kit (continued):

- | | | | | | | | |
|-----|---|-----|---|-----|---|-----|---|
| 15. |  | 16. |  | 17. |  | 18. |  |
| | SW1-0052,
T-45 Torx Bit, | | SW1-0054,
8-32 x 1" Phillips
SS PH Screw, | | SW1-0056,
#8 x 3/4"
PH Screw, | | WA1-0014,
#10 SAE SS Black
1/2" Flat Washer, |
| | 1 pc | | 4 pcs | | 12 pcs | | 8 pcs |

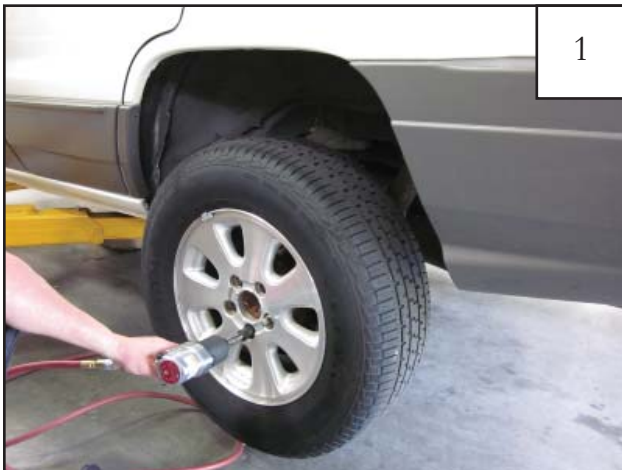
STEP 2 - EDGE TRIM INSTALLATION

A. If painting flares, see section C of Step 1 - Prior to Installation. 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 Steps 54 & 55 as reference)

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.



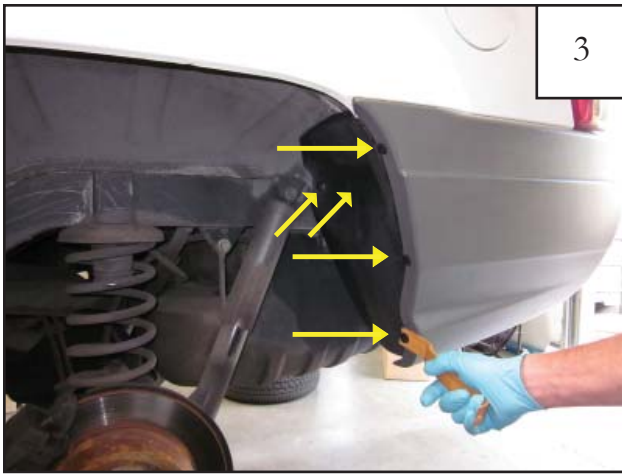
Rear Flare Installation Procedures (Driver's Side):



Remove tire using an impact wrench.



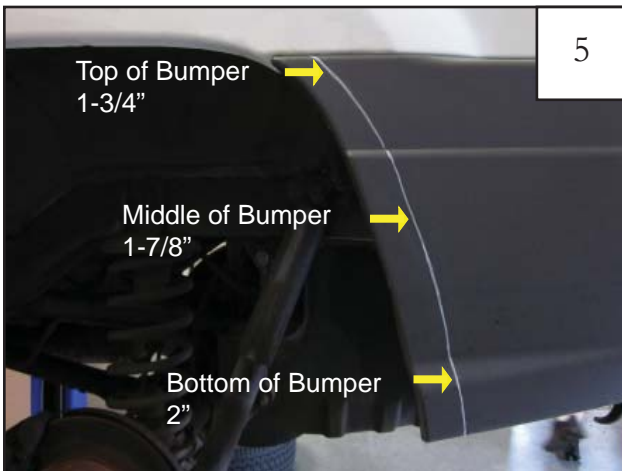
Using a #2 Phillips Screwdriver, remove factory screws from upper side cladding (3 places). Remove cladding.



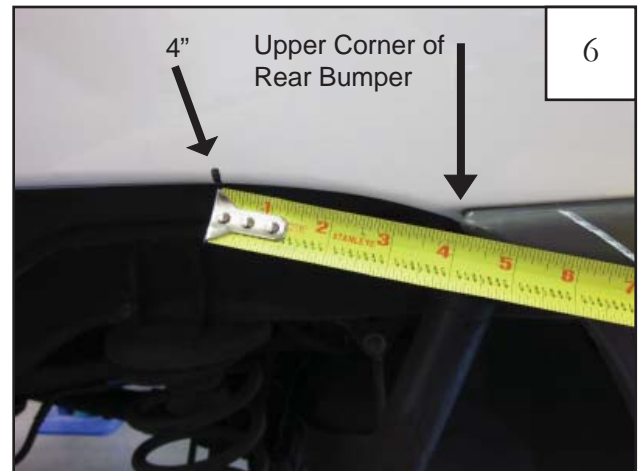
Using a pry tool or utility knife, remove plastic retainers from the rear bumper piece and inner splash shield (5 places). Remove inner splash shield.



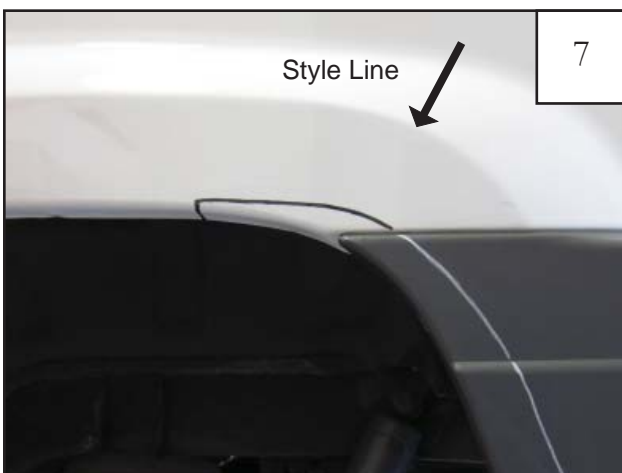
Using a 10mm deep socket and wrench, remove bolts on inner side of fender lip (2 locations).



Mark rear bumper for cutting: 1-3/4" at top of bumper, tapering to 1-7/8" in middle of bumper and 2" at bottom of bumper.



Starting at the upper corner of the rear bumper, measure forward 4" along upper edge of fender lip and make a mark extending up 1/4".



Make a line connecting the marks made in steps 57 and 58. The line should be parallel to the style line of the fender as shown.



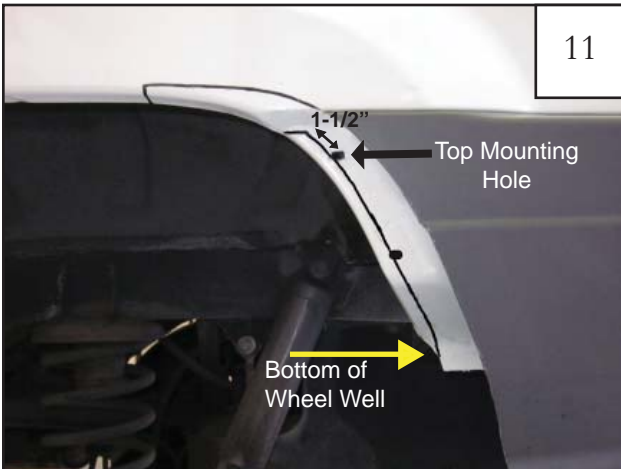
Using a cut off wheel, sawsall or other suitable tool, cut along line marked on bumper only. **NOTE: DO NOT CUT SHEET METAL AT THIS TIME.**



Use a cutoff wheel to trim the bumper support bracket parallel to trimmed bumper.



Remove trimmed bumper support bracket.



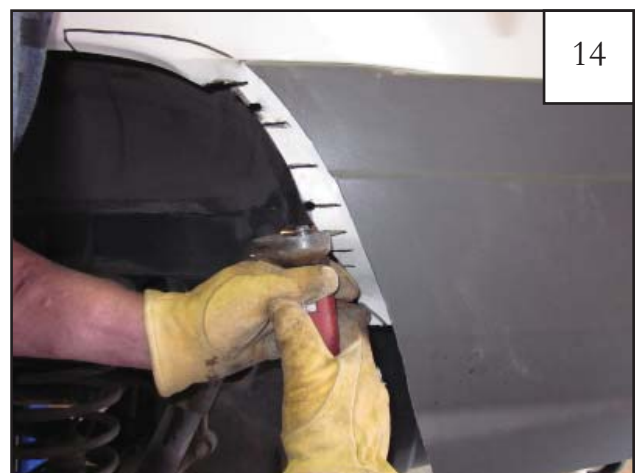
Make line extending from the bottom of the wheel well to approximately 1-1/2" above the top mounting hole. The line should be 1/4" in from edge of the wheel well.



Using a cut off wheel or other suitable tool, cut along line marked in step 11 removing the inner flange.



Mark vehicle for cutting: Make lines on sheet metal as shown in picture.



Using a cut off wheel or suitable tool, cut along marks made in previous step to create tabs.



15

Using a hammer, pound the tabs made in the inner sheet metal flat against wheel well.



16

Mark vehicle for cutting: Make lines on sheet metal as shown in picture.



17

Using a cut off wheel or suitable tool, cut along marks made in previous step to create tabs.



18

Use pliers to straighten and flatten out tabs.
Note: May need to cut away additional portion of tab on the radius to allow room to flatten tab to inner wheel well.



19

Use sheet metal pliers to bend straightened tabs back and up into wheel well.



20

Use hammer to flatten tabs against inner wheel well.



21

Using an angle grinder or sandpaper, sand the chipped paint along bent edges of the fender lip and wheel well.



22

Using a 7/16" wrench and 3/8" socket, bolt rear main flare to bumper piece using supplied screws (SW1-0006) and nuts (NU1-0011). Do not fully tighten screws. Parts are marked on the inside. Driver's side: D3 for main flare, D4 for bumper piece.



23

Check alignment of main flare and bumper piece to each other. Line up the three style lines.



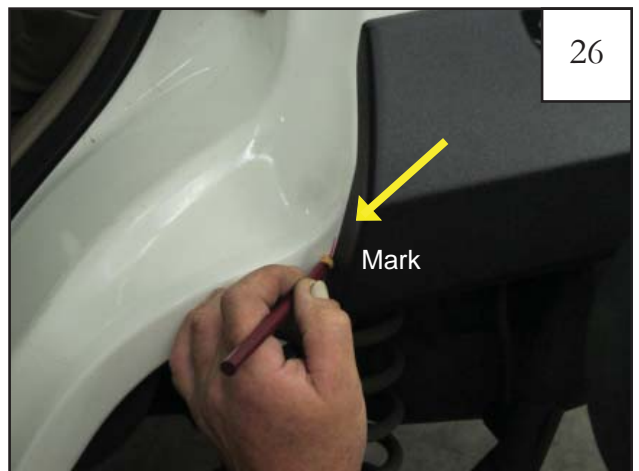
24

Once satisfied with alignment, tighten all screws.



25

Hold assembled flare in place on vehicle aligning forward edge with the door seam and inside edge of rear main part with fender lip. Confirm fit cut areas and make adjustments as needed.



26

Mark Vehicle for cutting: With assembled flare held in place and aligned with door seam, make a line along front edge of flare.



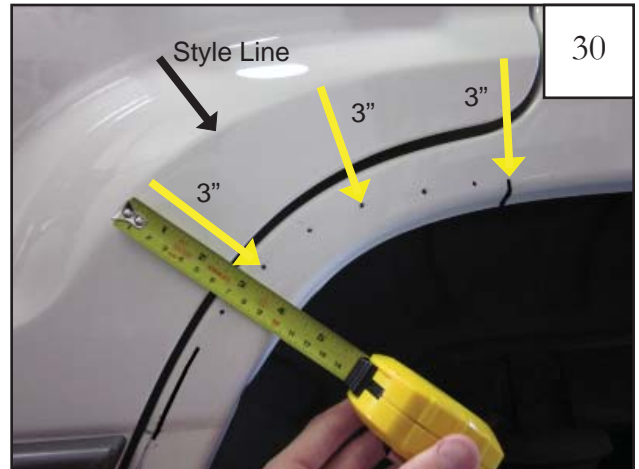
Measure 3/4" toward the front of the vehicle from the mark made in previous step along fender lip. Using a grease pencil, make a mark.



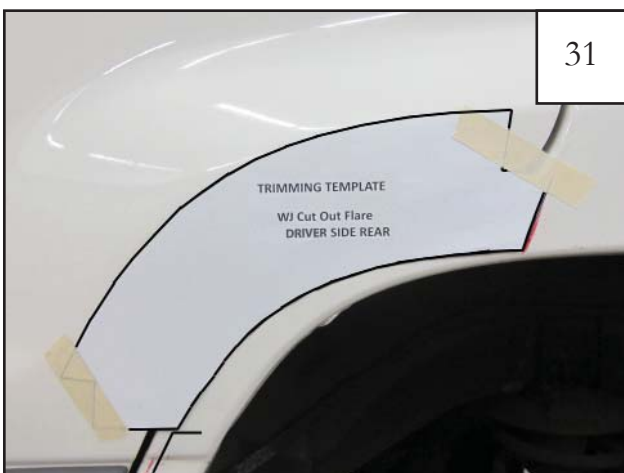
Marks should be as shown.



Mark vehicle for cutting: Make a line 1-1/4" in from the edge of the wheel well extending up from the bottom pinch weld to 1-3/4" above the top of the cladding.



Using a measuring tape and following the contour of the sheet metal style line, measure 3" perpendicular to style line toward inner wheel well to make guide marks.



Using marks made in step 29 and 30 as a guide, set your supplied paper template on vehicle. Template should line up with both marks on either end. Outside curve of template should lay along style line on door. Template should be printed side up.



Using a grease pencil, draw a line along the lower edge of the template to connect marks made in previous steps.



33

Markings should be as shown.



34

Mark vehicle for cutting: Make marks from inner wheel well to line drawn in previous steps about 2" apart as shown in picture. Make marks closer together around tight corners and style lines.



35

Using a cut off wheel, sawsall or other suitable tool, cut along horizontal marks from wheel well to vertical line. **NOTE: DO NOT OVERCUT!**



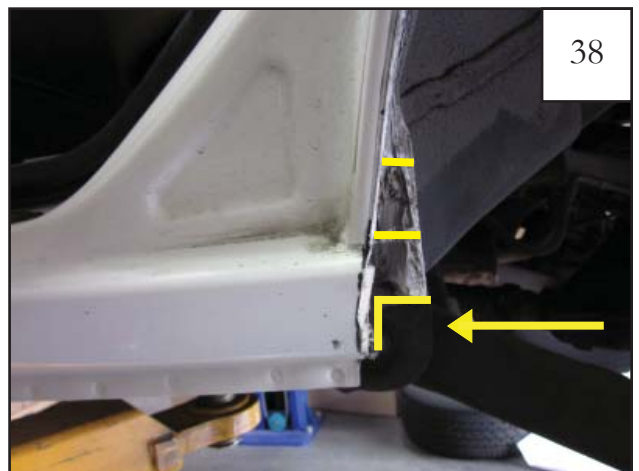
36

Using a cut off wheel, reciprocating saw or other suitable tool, remove tabs cut in previous step. *Tip: Using a reciprocating saw works best for this cut.* **NOTE: DO NOT OVERCUT!**



37

Mark vehicle for cutting: Make horizontal marks on the inner pinch weld flange approximately 1-1/2" apart.



38

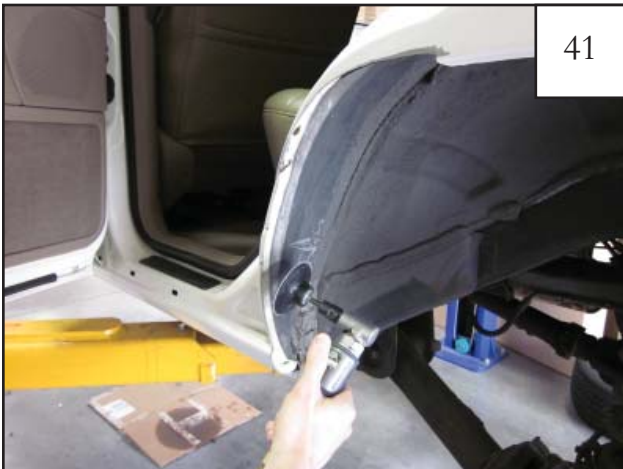
Cut away lower corner of pinch weld.



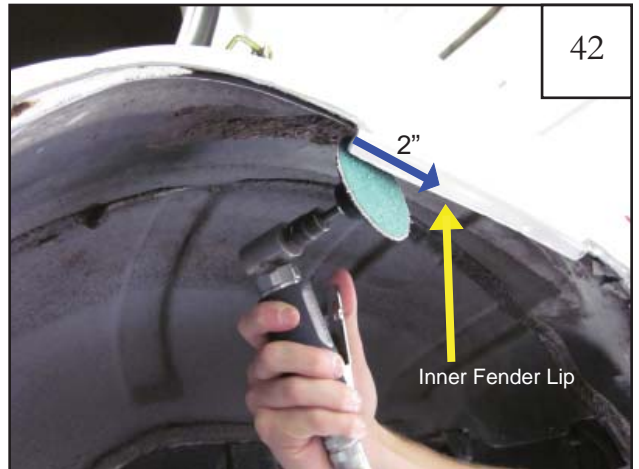
Using a cut off wheel or other suitable tool, cut along horizontal marks made in step 37.



Using a hammer, flatten pinch weld tabs against inner wheel well.



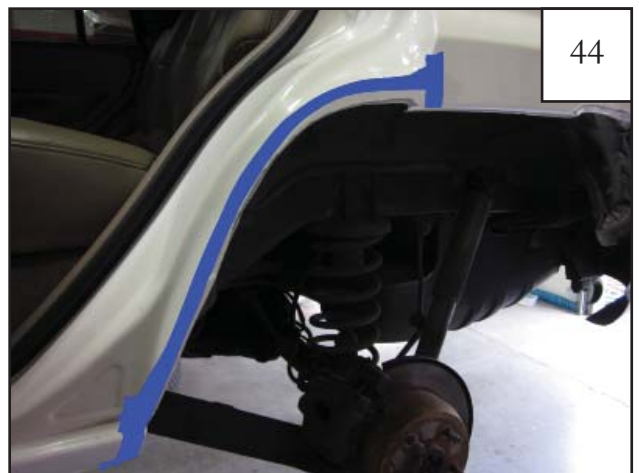
Using an angle grinder or sandpaper, sand and smooth cut along fender lip.



Using an angle grinder or sandpaper, smooth inner edge of fender lip 2" back from edge of cut.



Hold cut cover piece in place on vehicle. Confirm fit to cut areas and make adjustments as needed. Parts are marked on the inside. Driver's side: D2 for cut cover piece.



With door open, run masking tape along cut edges around door seam in preparation for sealing/caulking.



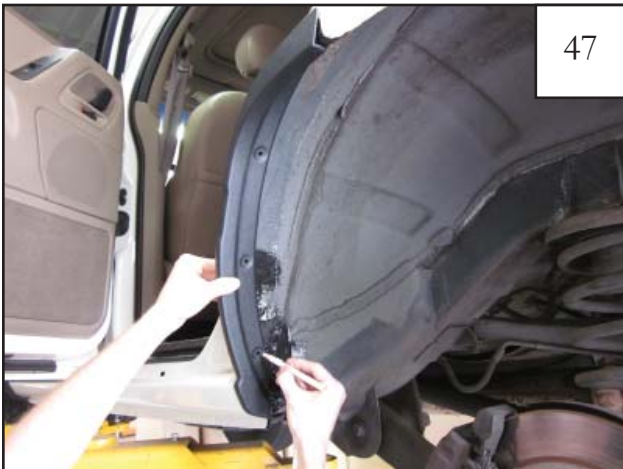
45

Apply urethane caulking or primer to all cut areas of wheel well to seal any exposed sheet metal for rust prevention.



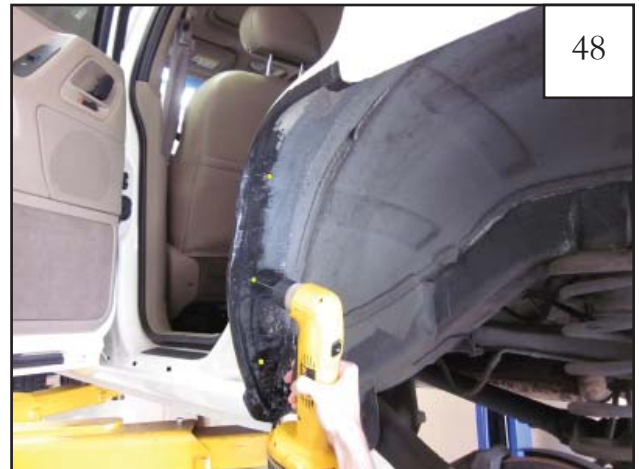
46

Use a spreader to smooth and evenly spread caulking along cut areas. Allow caulking or primer to partly dry before proceeding. Does not need to be fully cured.



47

Hold cut cover in place and mark inner wheel well through holes in part (4 locations).



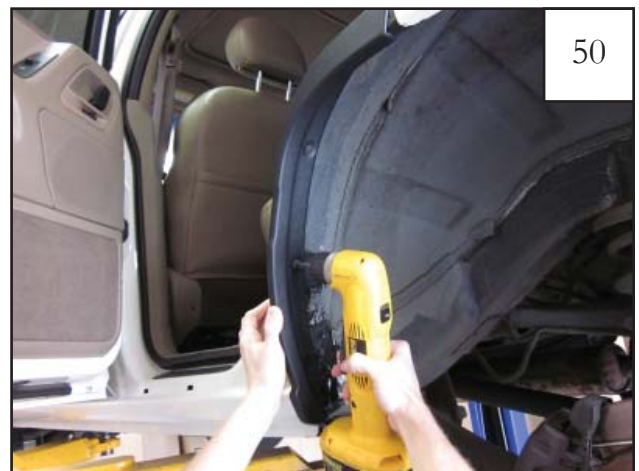
48

Remove part and drill marked locations using a 3/32" drill bit (4 locations).



49

Prior to installation of the cut cover, apply another layer of caulking to help keep cut cover in place.



50

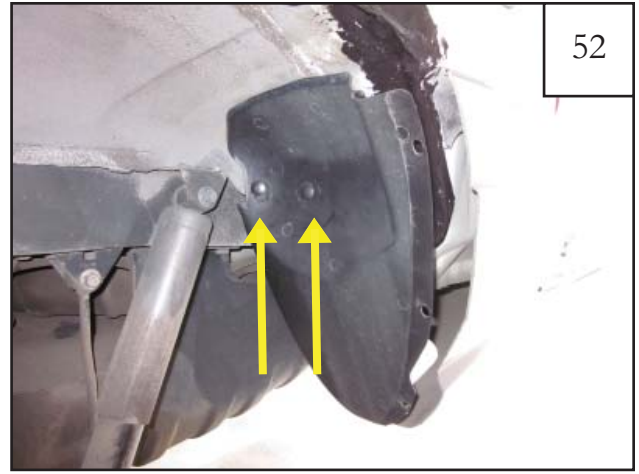
Place cover piece back on vehicle. Using a #2 phillips head, install screws (SW1-0056) through cover piece into holes drilled in step 100. Remove excess caulking along edges if needed.

Tip: A power drill works best, do not overtighten.



51

Installed cut cover.



52

Re-install splash shield using supplied panel retainers (RV1-P008). *NOTE: Do not fully install push retainers. Splash shield must be re-molded. See step 53.*



53

Using a heat gun, heat splash shield until pliable and use heavy work gloves to push and mold splash shield into place aligning with inner wheel well. Hold in place and allow to cool. Then fully install push retainers into splash shield.



54

For Edge trim application on rear main flare and bumper piece, follow steps as listed at the beginning of the instructions set. To apply edge trim around area where the two pieces connect, refer to this image and the next.



55

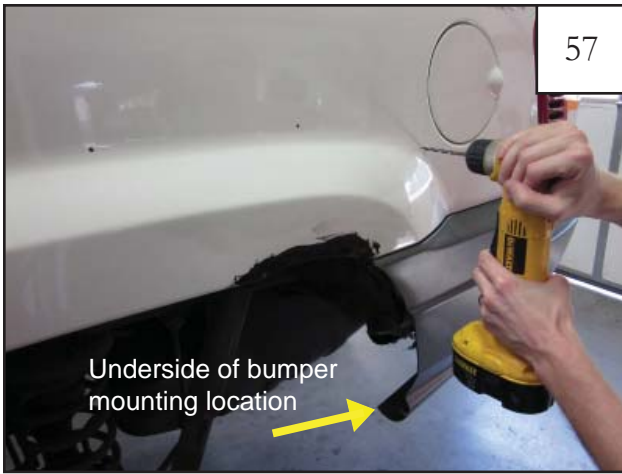
The Edge Trim (GP1-0005) on the sharp inside radius of bumper piece may need to be notched to fit correctly.



56

Underside of bumper mounting location

Hold flare in place on vehicle. Using an awl or grease pencil, mark hole locations onto fender through holes drilled in pockets of flares. Also mark mounting hole location on underside of bumper piece.



57
Underside of bumper mounting location
Drill holes in fender and bumper at marks with a 3/16" drill bit. Use 1/4" drill bit to drill mark on underside of bumper.



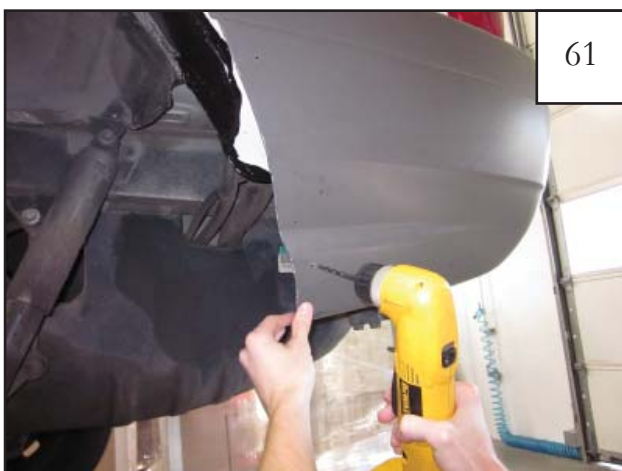
58
Install one screw (SW1-0045) in top front hole of flare to hold it in place while making marks in the next step.



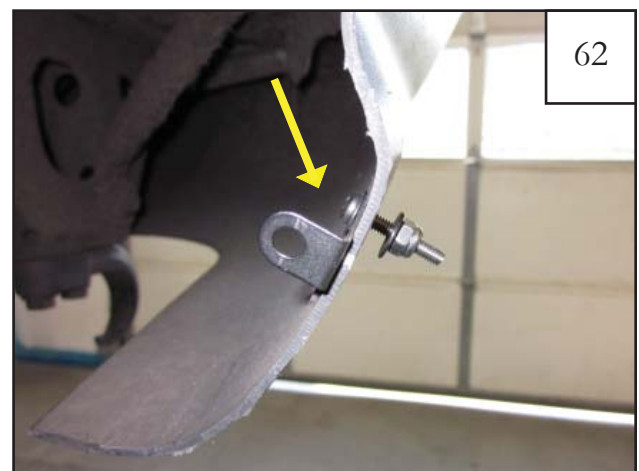
59
Hold flare and bumper piece in place so that the holes in the bumper piece barely overlap the cut bumper and mark the locations on the edge of the bumper. Use an awl if needed (2 locations).



60
Mark
Hold mounting bracket (MB1-0003) in line with mark made in step 59 and make a mark through the hole location in the bracket. Repeat for second bracket.



61
Using a 3/16" drill bit, drill the two holes marked in step 60.



62
Start a washer (WA1-0014), screw (SW1-0054) and nut (NU1-0004) combination through the holes and brackets in bumper. Use a washer for both screw head and nut. The bracket should face inward and the screw head should be on the inside if of the bumper.



63

Using a Phillips screwdriver and a 3/8" socket wrench, tighten the nut and screw together.
NOTE: Some adjustments may need to be made to the bracket for proper flare positioning. Once brackets have been adjusted properly, fully tighten.



64

Put screw (SW1-0045) through holes in pockets of rear main flare and bumper piece and secure with rubber grommet (SP1-0009) using supplied #45 Torx bit (SW1-0052). Drive screw into grommet until tight. Repeat for all pockets.



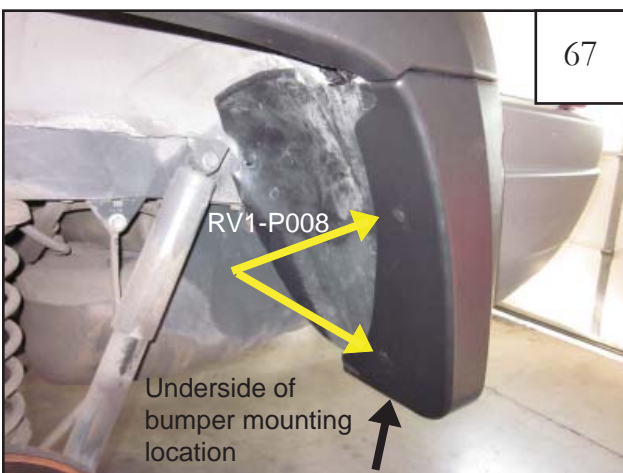
65

Hold flare in place on fender. Using the provided torx bit driver and ratchet with 3" extension, start each screw into drilled holes.



66

Once all screws have been started, snug screws to vehicle. Torque to 24 in•lb (2 ft•lb). **DO NOT OVERTIGHTEN!**



67

Install three panel retainers (RV1-P008) through flare and into mounting brackets and underside of bumper mounting location as shown.



68

Predrill fender lip at top horizontal area with a 1/8" drill bit through holes in rear main flare (2 places).



Secure flare to fender with panhead screw (SW1-0056) through holes drilled in step 68.



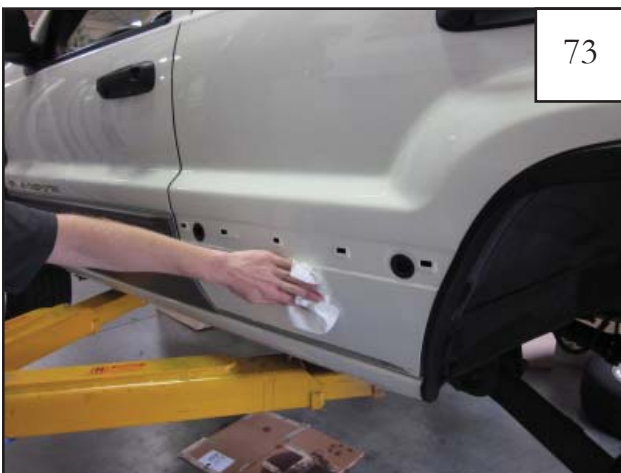
Close rear door. Hold door piece in place on door aligning it with rear main flare and trace outer edge of flare onto cladding



Using a pry tool, separate the factory side cladding from the sheet metal along the bottom taped edge.



Pull firmly to remove upper factory side cladding piece from fender.



Clean exposed sheet metal.



Using a reciprocating saw or other suitable tool, cut the factory side cladding approximately 1/4" back from the line drawn in step 70.

NOTE: Do not cut cladding short as it may not fit snugly against installed door piece flare. Make sure 1/4" cut is toward the installed door piece. Adjust as needed.



75

Using sand paper, smooth cut edge of the factory side cladding.



76

In preparation for applying new tape, use a supplied alcohol wipe (AD1-0010) to clean plastic and remove factory tape from side cladding.



77

In preparation for applying new tape, apply primer using supplied primer applicator (AD1-0006) to plastic along bottom edge of side cladding.



78

Apply supplied double sided tape (MT1-0025) to plastic where primer was applied in previous step.



79

For edge trim application on rear door piece, follow steps as listed at the beginning of this instruction. Apply edge trim (GP1-0005) only to the outer edge of the door piece.



80

Press door piece firmly against vehicle aligning with rear main flare. Mark hole locations on fender through holes drilled in pockets of door piece. Parts are marked on the inside. Driver's side: D1 for door piece.



81

Using a 3/16" drill bit, drill holes marked in step 80.



82

Hold flare in place on fender. Using the provided torx bit driver and ratchet with 3" extension, start each screw into drilled holes.



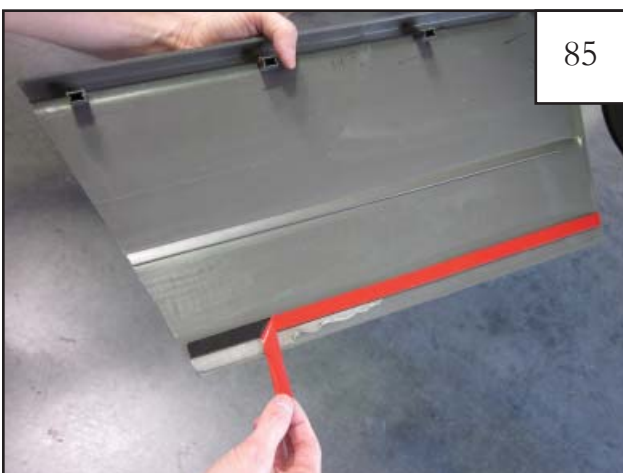
83

Once all screws have been started, snug screws to vehicle. Torque screws to 24 in•lb (2 ft•lb). **DO NOT OVERTIGHTEN!**



84

Prior to re-installation of the cladding, use a supplied alcohol prep pad to clean the sheet metal and any factory tape residue.



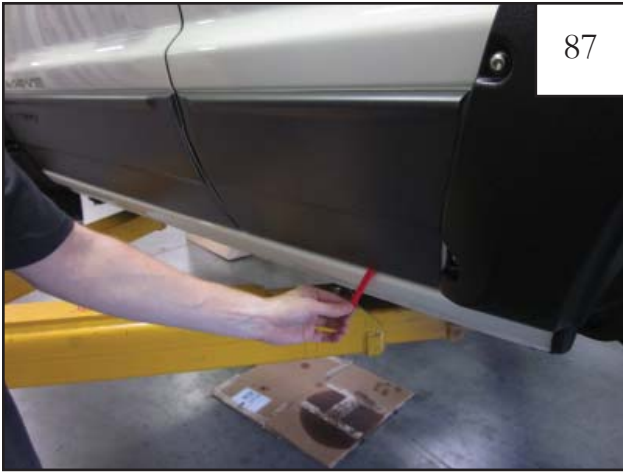
85

Peel back tape liner 1" to 2" to and fold to outside edge of side cladding.



86

Hold cladding in place on vehicle and re-attach by pressing firmly along upper edge to fasten into factory hole locations on sheet metal.



87

Remove tape liner and apply pressure to side cladding to adhere tape to sheet metal.



88

(NOTE: For models with previously removed Rocker Panels) Open front and rear doors. Remove dirt and debris from rocker area around holes in sheet metal. Then use supplied alcohol prep pad to clean and prep area prior to molding installation.



89

Remove tape liner from molding (GP1-0020) and starting at front hole, install molding along rocker area to cover holes in sheet metal.



90

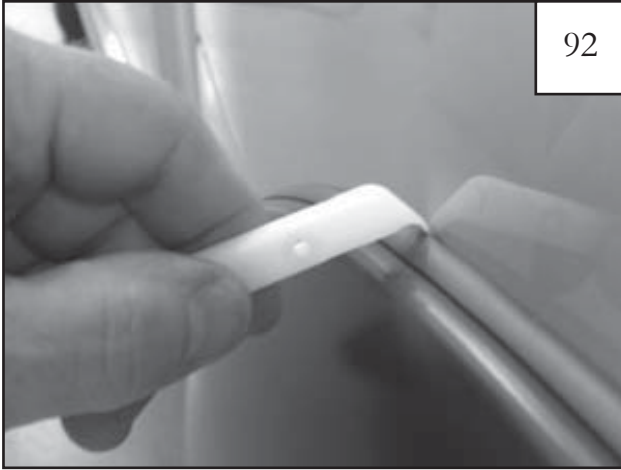
Use an impact wrench to re-install tire.



91

Completed rear flare installation.

Edge Trim Tool Procedures:



Using supplied Edge Trim Tool (ET1-0002), 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 (ET1-0002), 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.