



31019  
06-29-11  
Rev-2

## CUT OUT STYLE FLARES INSTALLATION INSTRUCTIONS FOR 31019, 31020 TOYOTA 4WD

### Tools Required for Installation:

- Drill
- 1/8" and 3/16" Drill Bits
- #2 Phillips Driver Bit
- Utility Knife

### IMPORTANT: READ BEFORE BEGINNING INSTALLATION

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.

**Verifying Fit** - Flares should be held to the vehicle surface to verify correct type and fit BEFORE beginning installation or painting. The inner flare edge should be in contact with the wheel well rim, and the outer flare edge should conform to vehicle fender contours. Small fit adjustments can be made by trimming (filing, sanding or scraping) excess plastic.

**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 shoulders from contacting flare.

**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.

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### NO CUTTING OF SHEET METAL REQUIRED

**Note:** largest tire that can be used with this flare (without a lift kit) is a 31 x 10.50 x 15 on an 8½" wide rim.

#### Step 1: Painting

It is recommended that painting (when desired) be done prior to installation.

- Sand (optional) before application of paint.
- 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 painting.
- Paint flares using a high quality lacquer, enamel, or polyurethane automotive paint. Application of a primer coat is optional.
- If painting edge trim (not recommended) use a flex additive.

#### Step 2: Preparing the Work Area (Front and Rear)

- Support and remove wheel using jack and jack stands. (Optional)
- Remove factory fender trim and mud flaps (when installed).

#### Flare Attachment

- Place flare into wheel well opening. Make sure outer edge of flare is tight against vehicle body.
- Using the holes in the flare as a guide, drill sheet metal with a 1/8" drill bit.  
**NOTE:** wrapping tape around the drill bit as a depth stop will prevent damage to the flare when drilling through.
- Hold the flare against the body with the gimp between the flare and the vehicle.
- Holding the cup washers over the outer holes, attach the flare with screws at the pockets through holes drilled in vehicle.  
**Note:** Cup washers are applied to outer mounting pockets only.
- Using drill screws, attach the flare to fender roll under lip.
- Press trim caps onto cup washers.

