

## 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.

## Toyota Cut-Out™ Fender Flares Set of 4

Set Part #31919-02

Rev-12 11/3/2014

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




### TOOLS FOR EASY INSTALLATION:

- Electric Drill
- 3/16" Drill Bit
- 1/4" Drill Bit
- Grease Pencil
- Angle Grinder
- Reciprocating Saw
- Cut Off Wheel
- 10mm Socket
- Hammer
- Masking Tape
- #2 Phillips Bit and Driver

### LIMITED LIFETIME WARRANTY AGAINST ANY MANUFACTURING DEFECTS

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

## Included in Hardware Kit:

- |   |  |  |  |   |  |  |
|---|--|--|--|---|--|--|
| 1.<br><br>GR1-0001,<br>#14 Screw Nylon<br>Grommet,<br>8 pcs      | 2.<br><br>RV1-P001,<br>1/4" Black Nylon<br>Retainer,<br>2 pcs | 3.<br><br>SP1-0009,<br>3/8" x 5/8" x .187"<br>Neo Black Spacer,<br>27 pcs | 4.<br><br>SP1-0011,<br>1/4" x 5/8" x .187"<br>Neo Black Spacer,<br>27 pcs | 5.<br><br>SW1-0066,<br>#8 x 5/8" Phillips<br>PH Drill Screw,<br>6 pcs | 6.<br><br>SW1-0036,<br>M6-.3 x 20mm Hex<br>Magni Black Screw,<br>16 pcs | 7.<br><br>SW1-0045,<br>#14-14 x 1"<br>Torx Screw,<br>29 pcs |
| 8.<br><br>MB1-0008,<br>BKT SS 20GA<br>Mounting Bracket,<br>2 pcs | 9.<br><br>NU1-0021,<br>14-4 Flat Nut,<br>2 pcs                | 10.<br><br>SW1-0025,<br>M6-1 x 35mm<br>Screw w/ Washer,<br>6 pcs          | 11.<br><br>SW1-0052,<br>T-45 Torx Bit,<br>1 pc                            | 12.<br><br>ET1-0002,<br>Edge Trim Tool,<br>1 pc                       | 13.<br><br>GP1-0005,<br>Large Wiper Style<br>Edge Trim,<br>270 inches   |  |

## STEP 2 - EDGE TRIM INSTALLATION

A. Peel two to three inches of red vinyl backing away from Edge Trim (GP1-0005) 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.



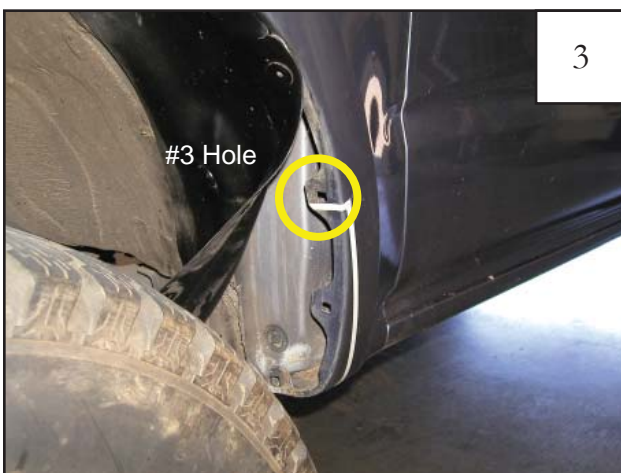
## Front Flare Installation Procedures (Driver Side):



Remove factory fender trim, mud flaps and mud flap brackets (when installed).



Remove 3 factory splash shield retainers as shown using a utility knife to cut flanges. *Leave the retainer 4th from bottom in place.*

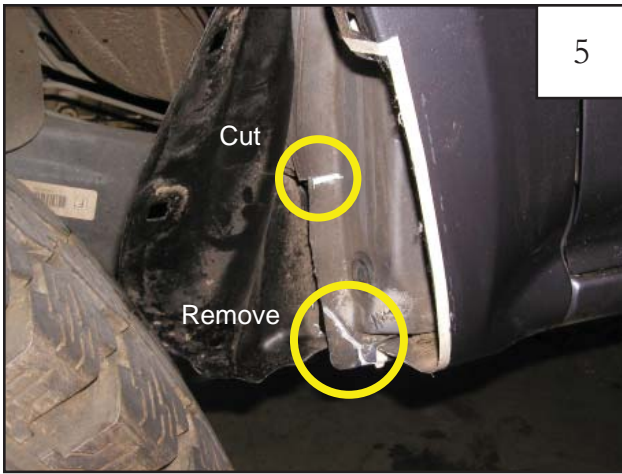


Using the 3rd hole up from the bottom as a guide, make a tape line along lower edge of hole horizontally.



Measure out 1" at bottom of rocker. Make a tape line from bottom of rocker up, intersecting the first tape line. Using a reciprocating saw, cut fender on the inner edge of the tape line.

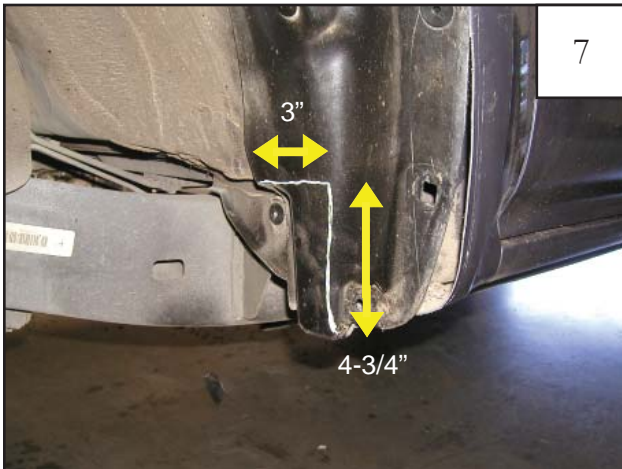




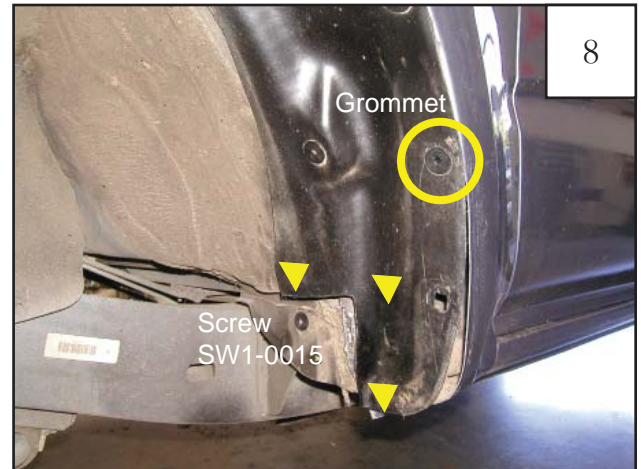
Cut fire wall weld seam in areas shown.



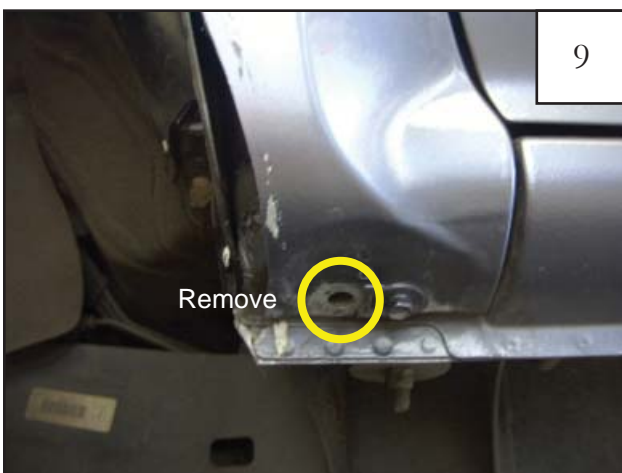
Using a hammer, flatten the fire wall weld seam as shown. Removing the wheel and tire is recommended for work clearance.



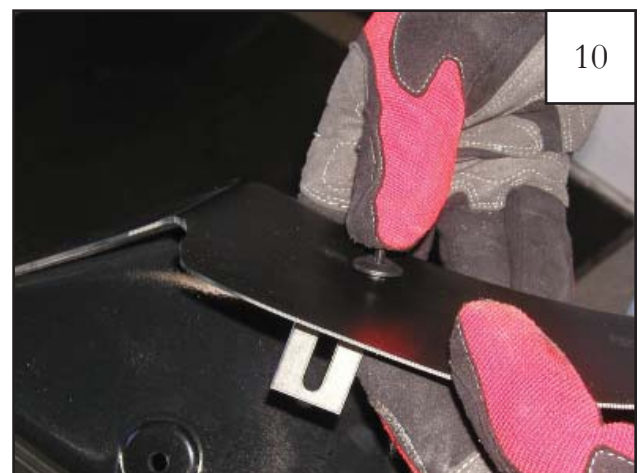
Trim splash shield as shown for optimum clearance. Measure up 4-3/4" from bottom and 3" in, intersecting the two lines.



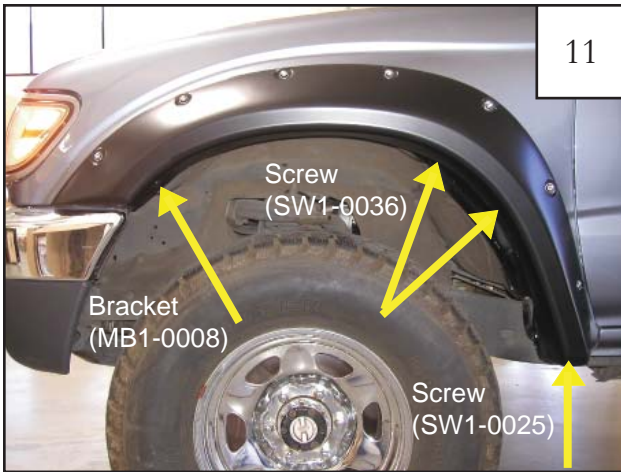
Install kit-supplied Screw (SW1-0066) and one kitsupplied Grommet (GR1-0001) into the splash shield as shown, refastening the shield to the body.



Remove fender bolt as shown, leaving second bolt in place.



Install the kit-supplied Bracket (MB1-0008) on the flare with a Retainer (RV1-P001). The Bracket should angle down from the inner flare surface.



Place the flare on the vehicle to verify correct fit. Install two kit-supplied Screws (SW1-0036) and one kit-supplied Screw (SW1-0025) into position as shown.



Install one kit-supplied Screw (SW1-0036) into mounting bracket as shown.



Mark the hole locations in the fender with a grease pencil using the 5/16" holes in the flare as a guide. Make sure the pencil is perpendicular to the flat pocket surface.



Remove fasteners and flares and drill hole locations with a 3/16" drill bit, making sure to keep the drill level and perpendicular to fender surface.



Insert a kit-supplied Screw (SW1-0045) through each pocket hole on flare.



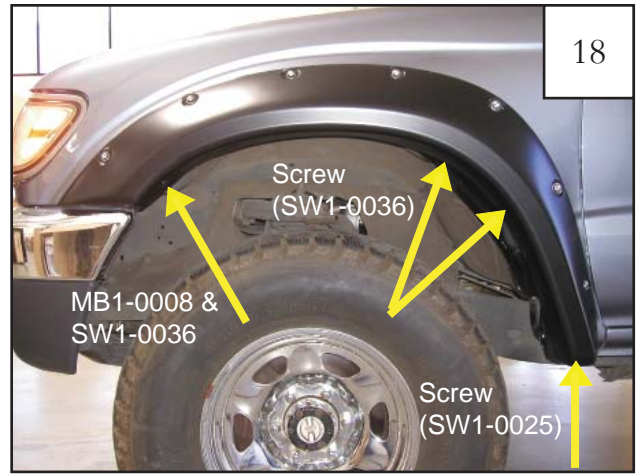
Install a kit-supplied Spacer (SP-0009) and a Spacer (SP1-0011) on the Screw from the backside of the pocket. Screw threads must protrude through spacer for proper attachment of flare. **Repeat for all pockets.**





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Holding the flare in position on fender, align the Screws with the holes drilled previously. Install each screw using a Torx Bit (SW1-0052) but **DO NOT tighten!**



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Reinstall all Screws (three SW1-0036 and one SW1-0025). Once these have been installed, tighten all screws. **Caution: Over-tightening screws may cause them to strip!**

## Rear Flare Installation Procedures (Driver Side):



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Remove factory fender trim, mud flaps and mud flap brackets (when installed).



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Remove mud flap bracket. Save *bracket and hardware for later use.*



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Remove 4 FRONT factory splash shield retainers as shown using a utility knife to cut flanges.



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Remove 3 REAR factory splash shield retainers as shown using a utility knife to cut flanges. Leave the uppermost retainer in place.



FRONT - Using the 4th hole up from the bottom as a guide, make a tape line along lower edge of hole horizontally.



Measure out 1" at bottom of rocker. Make a tape line from bottom of rocker up, intersecting the first tape line. Using a reciprocating saw, cut fender on the inner edge of tape line.



REAR – Using the 3rd hole up from the bottom as a guide, make a tape line along lower edge of hole horizontally.



Measure out 1" at bottom of rocker. Make a tape line from bottom of rocker up, intersecting the first tape line. Using a reciprocating saw, cut fender on the inner edge of tape line.



Trim REAR splash shield as shown for optimum clearance. Measure up 1" from bottom and 2" in, intersecting the two lines.



Install kit-supplied Grommet (GR1-0001) into the FRONT splash shield as shown, refastening the shield to the body.





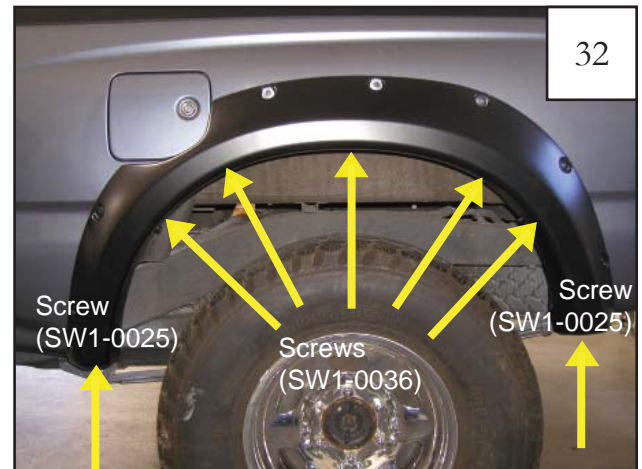
Install kit-supplied Grommet (GR1-0001) into the REAR splash shield as shown, refastening the shield to the body.



Remove front fender bolt as shown.



Remove rear fender bolt as shown, leaving second bolt in place.



Place the flare on the vehicle to verify correct fit. Install five kit-supplied 20mm sheet metal screws and two kitsupplied 35mm sheet metal screws into position as shown.



Mark the hole locations in the fender with a grease pencil using the 5/16" holes in the flare as a guide. Make sure the pencil is perpendicular to the flat pocket surface.



Remove fasteners and flare. For hole specified in photo, drill hole with a 1/4" drill bit, ensuring to keep the drill level and perpendicular to fender surface.



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Drill remaining hole locations with a 3/16" drill bit, ensuring to keep the drill level and perpendicular to fender surface.



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Insert a kit-supplied Screw (SW1-0045) through each pocket hole on the flare.



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Locate the pocket on the flare corresponding to the 1/4" hole drilled in step 34. Place a Screw (SW1-0045) through this pocket and secure with a kit supplied Nut (NU1-0021).



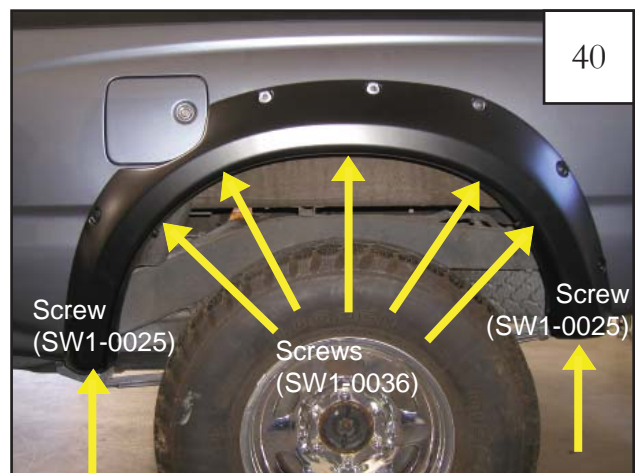
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For all remaining pockets, install a kit-supplied Spacer (SP1-0009) and a Spacer (SW1-0011) on the Screw from the backside of the pocket. Screw threads must protrude through Spacer for proper attachment of flare.



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Holding the flare in position on fender, align the screws with the holes drilled previously. Install each screw with a Torx Bit (SW1-0052) but **DO NOT tighten!**

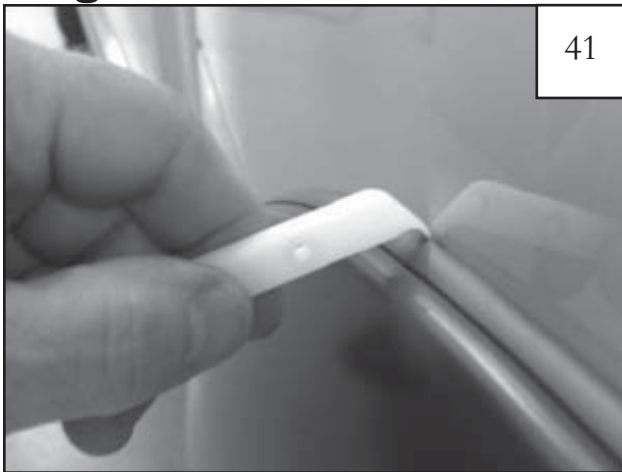


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Reinstall all Screws (five SW1-0036 and two SW1-0025). Once these have been installed, tighten all screws. **Caution: Over-tightening screws may cause them to strip!**



## 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.

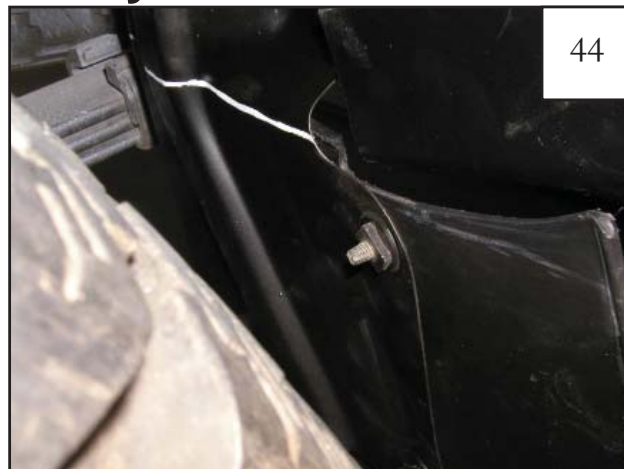


Using flat end of supplied Edge Trim Tool (ET1-0002), seat edge trim against flare by inserting straight end between edge trim and flare at one end. Next, slide around entire edge to the other end.

## Rear Mudflap Options: Cut two ways as shown



**Option A:** If you would like to reinstall the mud flap after the flare has been installed, cut the mud flap bracket as shown. Reinstall mud flap and bracket using factory hardware.



**Option B:** If you would like additional tire clearance but would not like to reinstall the mud flap, cut the mud flap bracket as shown. Reinstall bracket using factory hardware. ***DO NOT SELECT THIS OPTION IF YOU WANT TO REINSTALL YOUR MUD FLAP.***