



### 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.

## Ford Cut-Out™ Fender Flares Rear Pair

Rear Part #20074-02

Rev-6 10/2/2014

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







### TOOLS FOR EASY INSTALLATION:

- Electric Drill
- 3/16” Drill Bit
- #2 Phillips Bit
- Trim Tool
- 7/32” Socket
- Tape Measure
- Grease Pencil
- Hammer
- Reciprocating Saw or Cut-Off Wheel
- Vise Grips or Pliers
- Utility Knife

### 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. |  |
|    | SW1-0066,<br>#8 x 5/8” Phillips<br>PH Drill Screw,<br>4 pcs                         |    | SW1-0056,<br>#8 x 3/4”<br>PH Screw,<br>2 pcs  |    | SW1-0048,<br>M6-.3 x 25 Hx Mag<br>Black Screw,<br>2 pcs                             |    | SW1-0045,<br>#14-14 x 1”<br>Torx Screw,<br>20 pcs                                   |    | SP1-0009,<br>3/8” x 5/8” x .187”<br>Neo Black Spacer,<br>22 pcs                      |    | SW1-0052,<br>T-45 Torx Bit,<br>1 pc   |    | ET1-0002,<br>Edge Trim Tool,<br>1 pc  |
| 8. |   |    |   |    |   |    |   |    |  |    |   |    |   |
|    | GP1-0005,<br>Large Wiper Style<br>Edge Trim,<br>167 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.



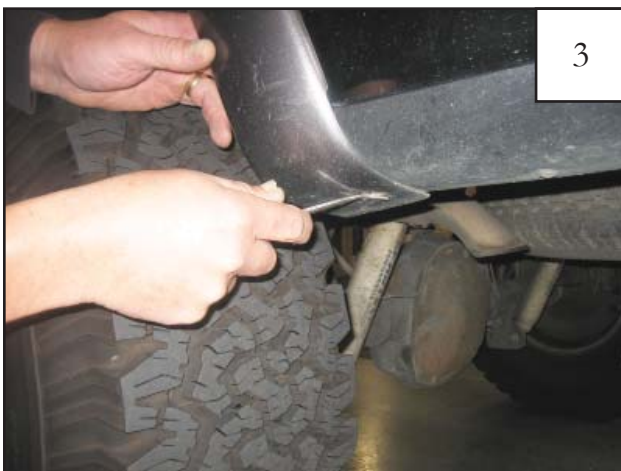
## Rear Flare Installation Procedures (Passenger Side):



Using a #2 Phillips bit, remove four factory screws located inside wheel well (at locations shown).



Use a trim tool to remove one plastic fastener located at bottom front of wheel well as shown.



Use a trim tool to remove one plastic fastener located at bottom rear of wheel well as shown.



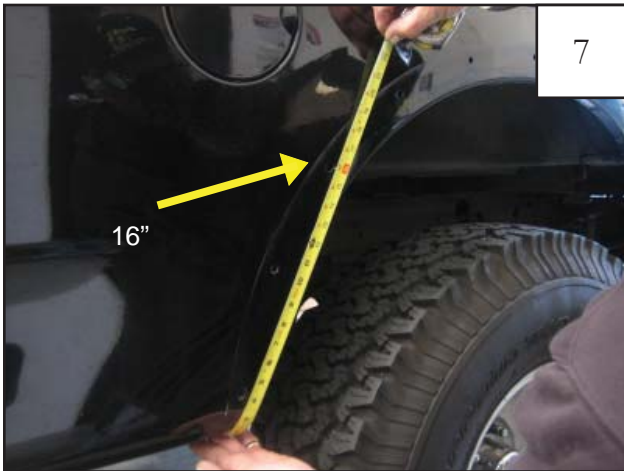
Starting at front of flare, pull firmly to release flare from fender, working your way to the back. You will hear popping noises as clips release. It is O.K. if clips break, they will be discarded.



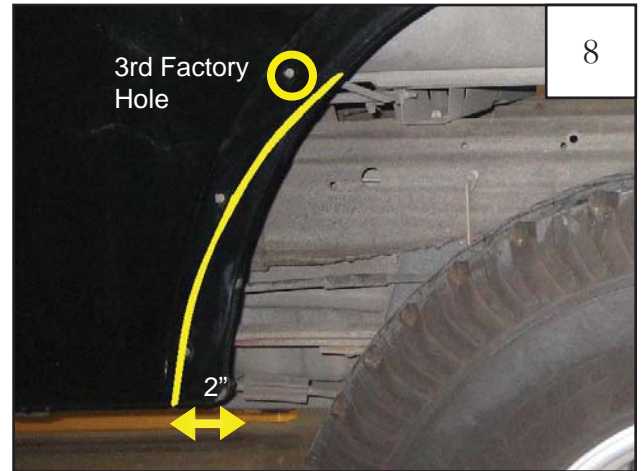
At FRONT of wheel well, use a tape measure and a grease pencil to mark a line 2" toward front of vehicle from fender lip (at bottom edge).



At fender lip, make a mark horizontal to the third factory hole up from bottom front of fender well.



**For trucks without factory flares ONLY:** Wrapping tape measure up from underside of fender, measure up 16" and make a mark on fender lip where tape measure intersects.



Draw a line from mark made in Step 5 up to mark made in Step 6 or Step 7, curving gradually to connect the marks. The line should be as shown.



At 1-1/2" intervals, make horizontal lines from fender lip to line drawn in Step 8. These lines will be cut later, forming tabs to be hammered in.



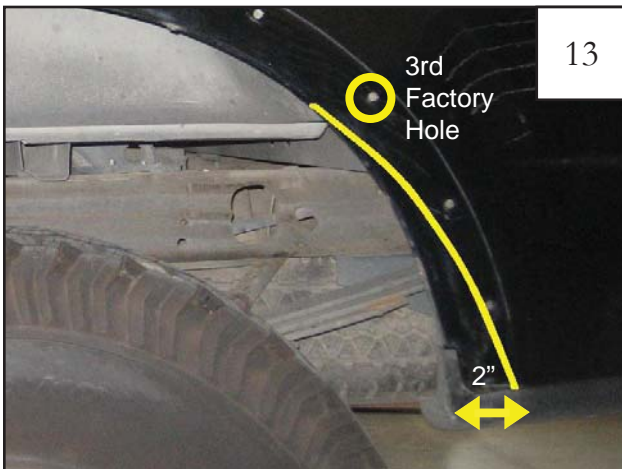
At REAR of wheel well, use a tape measure and a grease pencil to mark a line 2" toward rear of vehicle from fender lip (at bottom edge).



At fender lip, mark a line horizontal to the third factory hole up from bottom front of fender well.



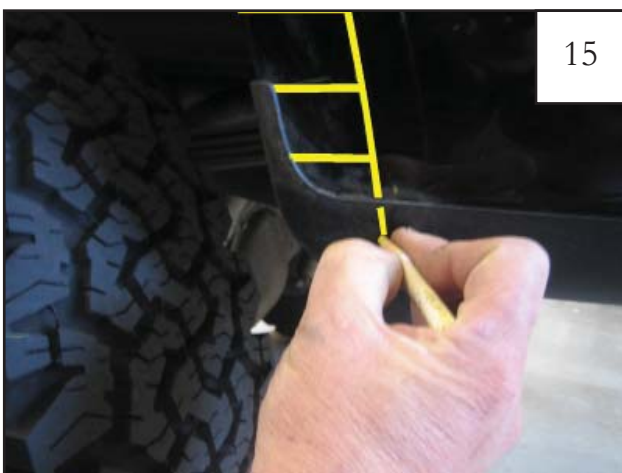
**For trucks without factory flares ONLY:** Wrapping tape measure up from underside of fender, measure up 18" and make a mark on fender lip where tape measure intersects.



Draw a line from mark made in Step 10 up to mark made in Step 11 or Step 12, curving gradually to connect the marks. The line should be as shown.



At 1-1/2" intervals, make horizontal lines from fender lip to line drawn in Step 13. These lines will be cut later, forming tabs to be hammered in.



Continue line down plastic rock guard, curving underneath.



Using a utility knife, cut rock guard along line drawn in Step 15. Peel and discard forward portion of rock guard, leaving rearward portion on the vehicle.



Cut horizontal lines made in Step 9 & Step 14. Use pliers or vise grips to bend the sheet metal tabs straight.



Using a hammer, bend the tabs of sheet metal into fender well as shown.



Position fender flare on fender. Verify that parts fit and no additional cutting is needed. Maintaining part position, mark the hole locations in the fender using the holes in the flare as guide (10 places).



Remove flare 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 a pocket hole on flare.

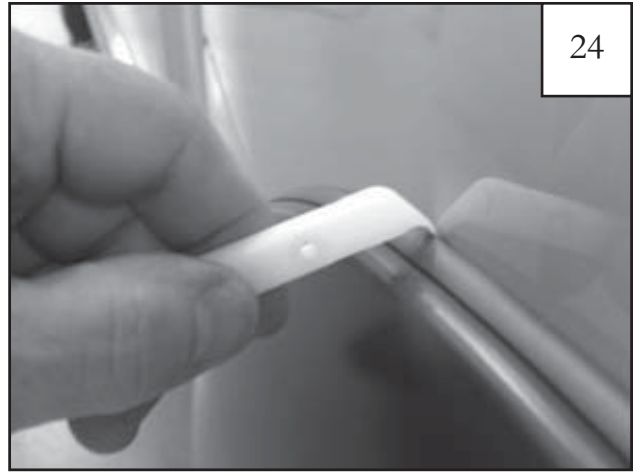


Install a kit-supplied Spacer (SP1-0009) on each Screw from the backside of the pocket using drill with supplied Torx Bit (SW1-0052). Screw threads must protrude through spacer for proper attachment of flare. *Repeat for all pockets.*



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Holding the flare in position on fender, align and start the Screws through the holes in the vehicle. **Make sure edge trim isn't folded over before tightening screws.**



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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.



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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.



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Tighten each Screw using supplied Torx Bit (SW1-0052) at 24 in-lb (2 ft-lb) speed. **Over-tightening screws may cause them to strip!**



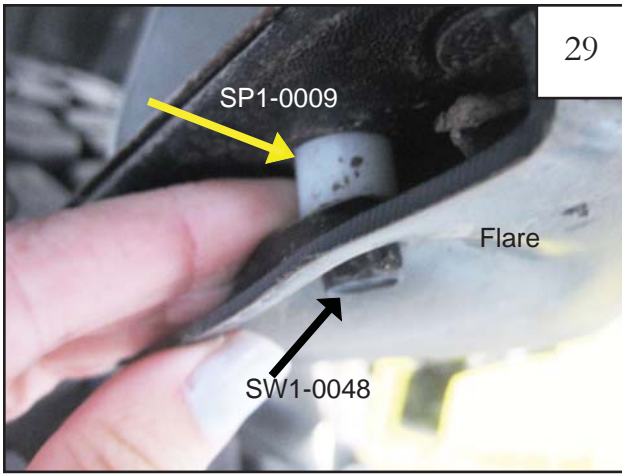
27

Use a #2 Phillips bit to install two supplied Screws (SW1-0066) through fender flare and into sheet metal of wheel well at locations shown (there are pockets in fender flare at these locations)



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Install one supplied Screw (SW1-0056) through the lower FRONT pocket in fender flare and into sheet metal.

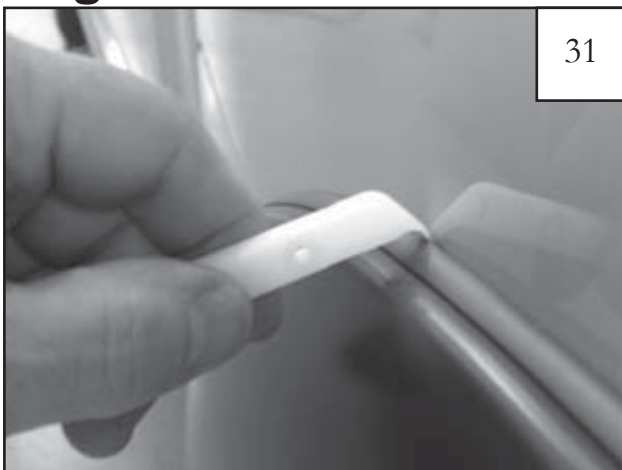


At lower REAR underside of flare, slip a supplied Spacer (SP1-0009) between flare and bumper (spacer is white in picture for visibility). Then install a supplied Bolt (SW1-0048) through hole in flare and spacer, and into bumper skin.



Bolt (SW1-0048) and Spacer (SP1-0009) location.

## 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.