



## 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.
- 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.
- H) Care & Cleaning:** Bushwacker fender flares are built to last; any detergent you use to wash your vehicle is sufficient to clean the flare. Do not use any harsh abrasive detergents.

# Jeep® Aluminum Tube Flares 2 Door & 4 Door Set of 4

Set Part #10930-19

Rev-0 3/21/2017

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

## TOOLS FOR EASY INSTALLATION:

- 1/2" open end wrench
- 1/4" Socket wrench
- 1/4" Socket extension
- 10mm socket
- Small bolt driver or small pry bar
- Corded or cordless drill
- 1/8" Drill bit
- 3/8" Drill bit
- 7/16" Drill bit
- 3/16" Hex key
- Push retainer removal tool
- Heavy shears or cut-off wheel
- Touch-up paint or clear coat
- Grease pencil, sharpie, or awl

**PLEASE READ:** Dirt and debris can become lodged between the fender flares and the vehicle's fenders, causing scratching and paint wear from vibration. Lund International is not responsible for any damage, and the installation of our fender flares is done with the buyer's understanding that this scratching and paint wear may occur.

## 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.  | 8.  |
| Hexagon Bolt<br>4 pcs  | M6 Button Head Bolt<br>8 pcs  | Socket Bolt M8X20<br>50 pcs   | Socket Bolt M8X30<br>10 pcs   | Clip Nut M6<br>4 pcs   | Flange Nut M8<br>44 pcs  | Clip Nut M8<br>10 pcs  | Socket Bolt M8X50<br>4 pcs   |
| 9.  | 10.  | 11.  | 12.  | 13.  |  |  |  |
| Flat Head Nut<br>15 pcs  | Light Assembly<br>2 pcs   | Washer Large<br>6 pcs   | Washer Small<br>12 pcs  | Rivnut Tool<br>1 pcs   |  |  |  |

# Components List:

Right Front x 1



Left Front x 1



Right Rear x 1



Left Rear x 1



Left Front Upper  
Bracket x 1



Right Front Upper  
Bracket x 1



Front Lower  
Bracket x 2



Front "L"  
Bracket x 4



Left Rear Upper  
Bracket x 1



Right Rear Upper  
Bracket x 1



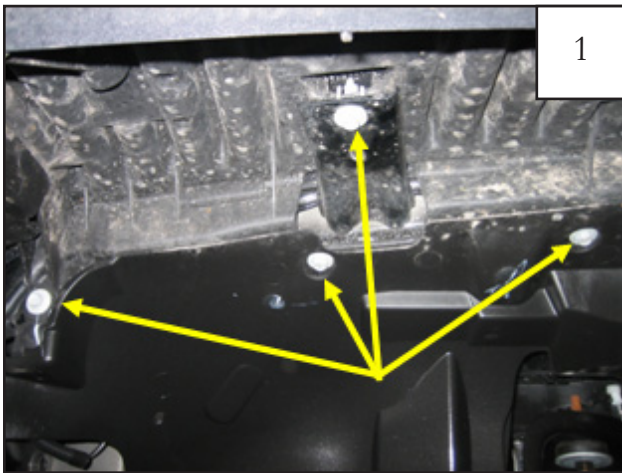
Left Rear Lower  
Bracket x 1



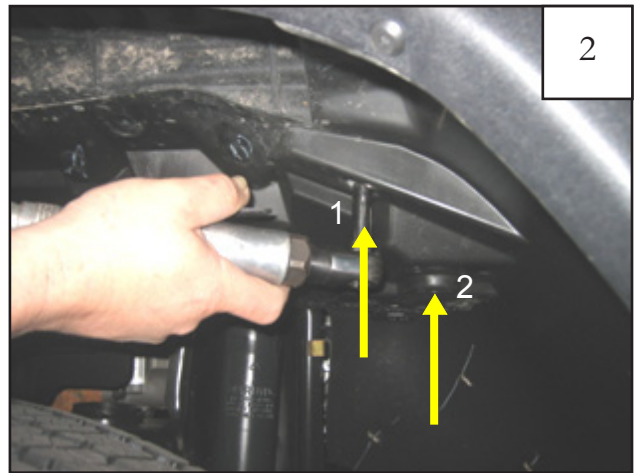
Right Rear Lower  
Bracket x 1



## Front Flare Installation Procedures:



Using a socket wrench with a 10mm socket, remove four factory bolts from inside of splash shield. Save bolts for reinstallation.



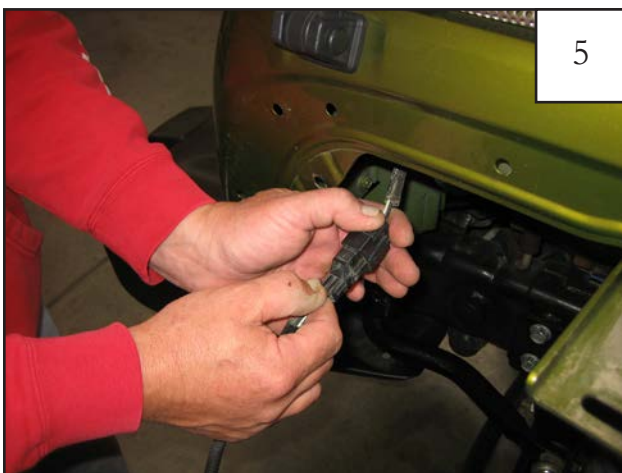
Using a 10mm socket, remove (2) bolts location 1 and 2. Save fasteners for reinstallation. *Note: 2007-2010 model years have a plastic thread engager in location 2. Remove and save for reinstallation.*



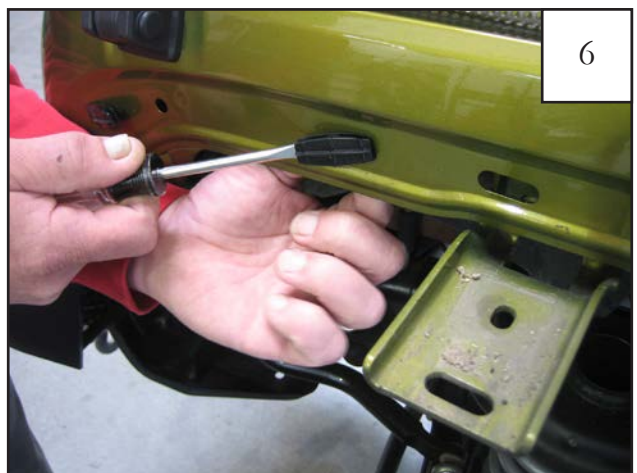
Remove light receptacle from light lens housing, letting it hang free of the housing.



Starting at front of flare, pull *firmly* to release flare and splash shield from fender, working your way to the back. You will hear popping noises as clips release. Clips will be discarded.



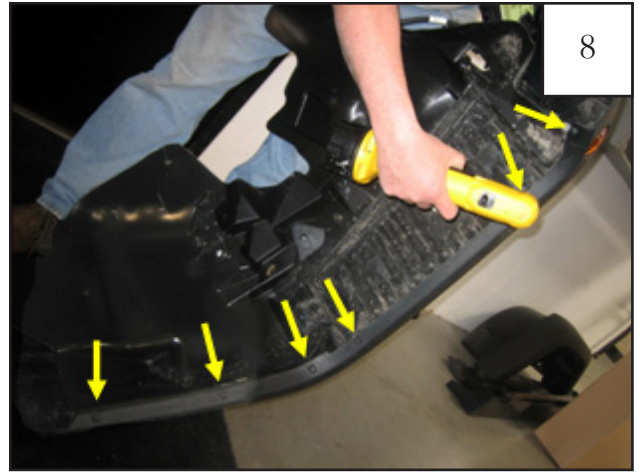
Once flare is free of fender, disconnect light connector. This will allow the flare to come away from fender completely. Save connector for reinstallation.



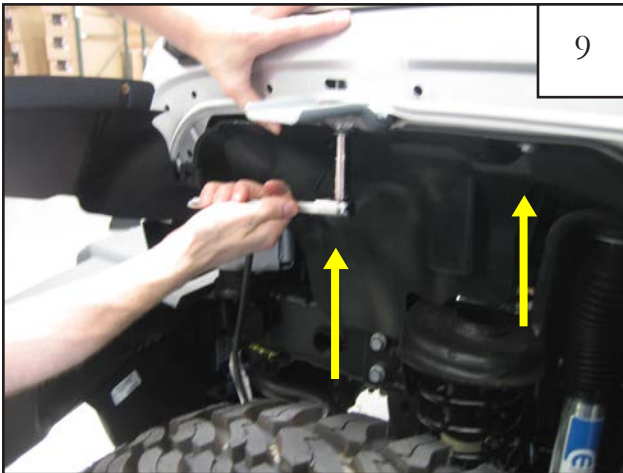
Using a pry tool or flat head Boltdriver, remove any plastic clips still in fender.



Use a pry tool or flat head Boltdriver to remove four plastic fasteners.



Use a drill with 5/16" bit to drill through six plastic rivets along edge of flare/splash shield. Discard flare. Save splash shield for reinstallation.



Reinstall the splash shield, in preparation for marking before cutting, using supplied 1.25" Washer on factory bolt/washer assembly and reinstall through factory threads in sheet metal (2 locations).



Mark the front portion of the splash shield with a grease pencil in location shown. The splash shield should be flush with the sheet metal after being trimmed. *NOTE: If trimmed too little, flare won't fit; if trimmed to much, shield won't stay behind flare.*



Using sheet metal as a guide, mark the rear portion of the splash shield with a grease pencil. The splash shield should be flush with the sheet metal after being trimmed. *NOTE: If trimmed too little, flare won't fit; if trimmed to much, shield won't stay behind flare.*



Remove splash shield. Save factory hardware for reinstallation. Using a metal hacksaw, pneumatic hand saw, or other suitable cutting device, trim the splash shield along the marked lines.



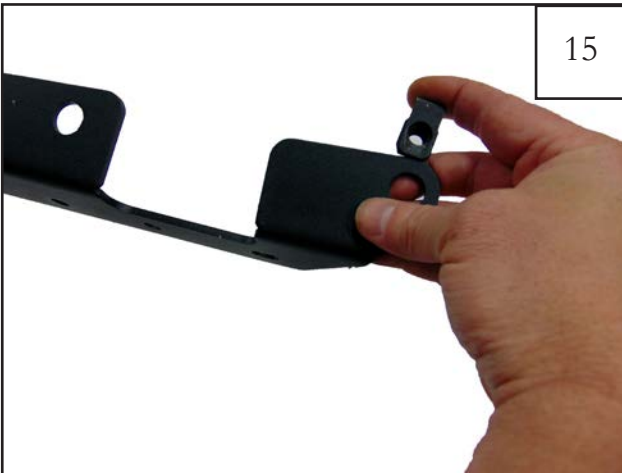
13

Hold splash shield up to inner wheel well to ensure that the edge is flush with the sheet metal. Remove from wheel well and trim or sand if splash shield extends beyond the sheet metal.



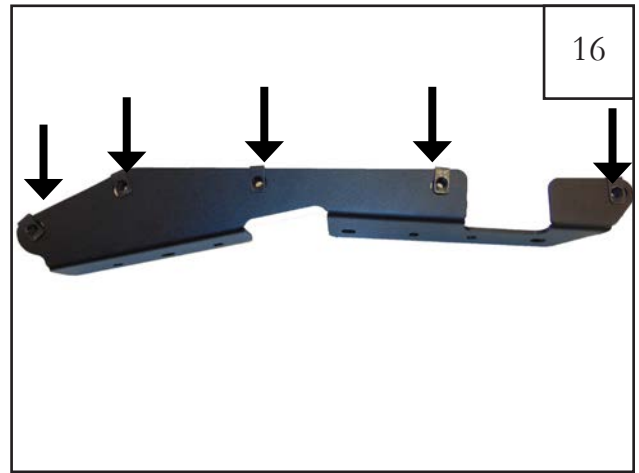
14

Thoroughly clean the exposed metal fender with a damp cloth and dry.



15

Install (5) M8 Clip Nuts on the Front Upper Brackets.



16

M8 (5) Clip Nuts installed on the bracket.



17

Align the Front Upper Bracket as shown, and slide it upward between the outer fender sheet metal and the inner tub brace. (It may be a tight fit.) Position it so that the threads of the clip nuts are roughly aligned with the 5 corresponding holes in the outer fender.



18

Re-use (3) of the OEM metric hex head bolts to attach the Front Upper Bracket, bolting through the holes along the bottom of the bracket.



19

Apply masking tape to the fender, around the area where the flare will be installed to protect paint.



20

Mark lip area to be trimmed and removed.



21

Trim along edge marked in **Step 20**. Use a grinder to smooth edge. Apply paint over bare metal in order to prevent rust.



22

Test fit flare and verify fender has been trimmed sufficiently. Adjust trim as needed so that fender flare fits flush against fender.



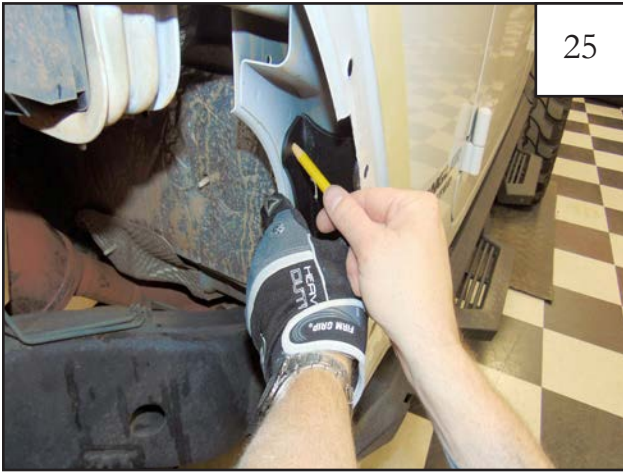
23

Temporarily mount fender flare in place using mounting hardware. Use a grease pencil or awl to mark (5) locations to be drilled.



24

Remove fender flare and inner bracket. Drill pilot holes using a 1/8" drill bit at locations marked in **Step 23**. Drill the final holes using a 3/8" drill bit.



25

Align front lower bracket with existing holes in outside of fender. Mark (2) hole locations on inner pinch seam for drilling, using a 3/8" drill bit.



26

Mount lower bracket in place using (2) M8x20 bolts and (2) M8 Flange Nuts. Do not fully tighten at this time.



27

Hold upper inner bracket in place and loosely mount flare using (5) M8x20 bolts. Do not fully tighten at this time.



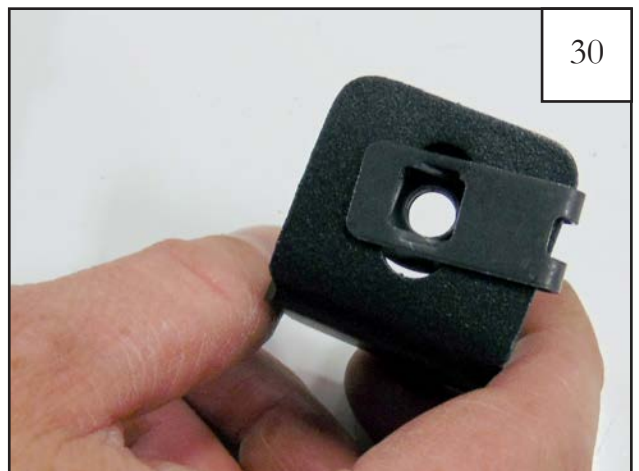
28

Install (2) M8x30 bolts and (2) M8 Flange Nuts as shown. Do not fully tighten at this time.



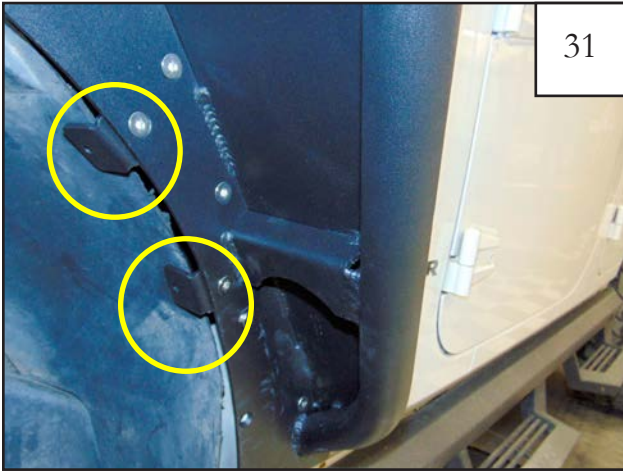
29

Install M8x20 bolts and M8 flange nuts in (4) remaining holes.



30

Install Clip Nut on L bracket.



31

Install (2) L brackets in locations indicated using (2) M8x20 Bolts and (2) M8 Flange Nuts.



32

Reinstall inner fender liner using factory hardware. **NOTE:** Some trimming of fender liner may be required to fit.



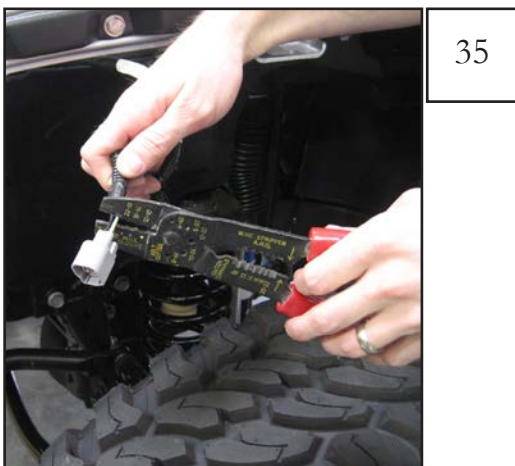
33

Drill (2) holes in the inner fender liner aligned with the L bracket installed in **Step 30**. Use (2) M6 Button Head Bolts to secure inner fender liner to L brackets.



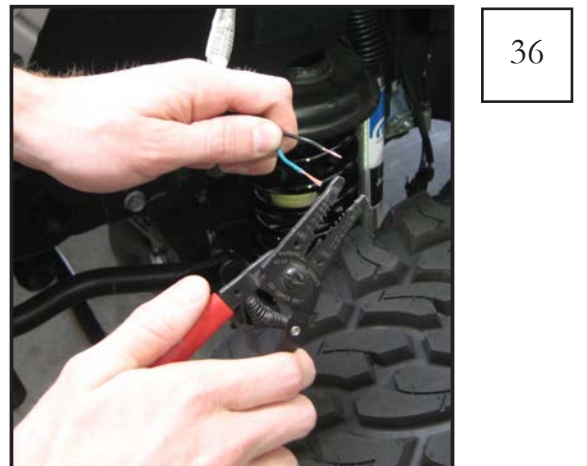
34

Fully tighten all mounting hardware at this time.



35

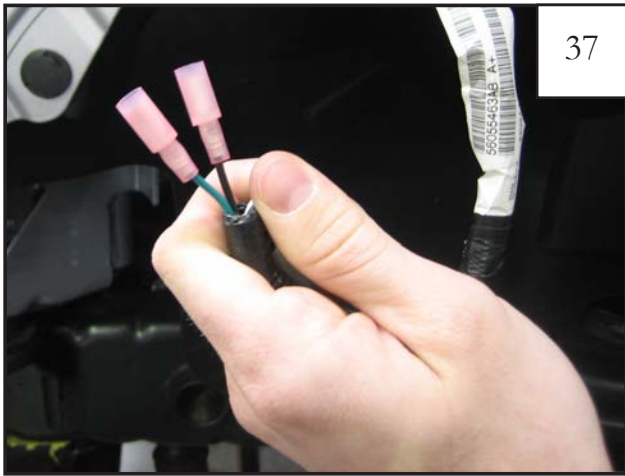
Use wire cutters to cut the two wires at the base of the factory side marker lamp.



36

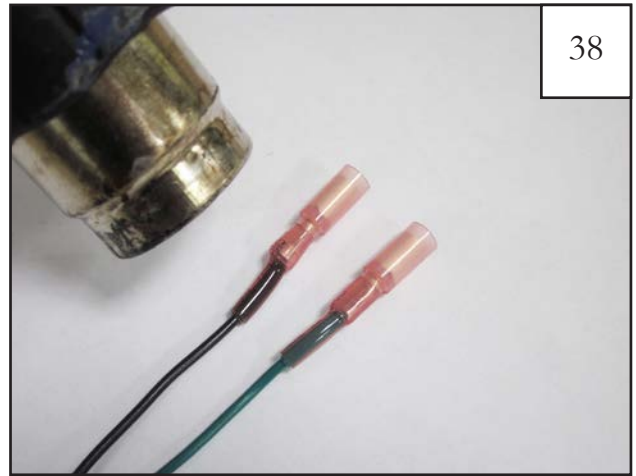
Use wire strippers to strip away approximately 3/8" of wire covering from the factory installed side marker lamp wires.





37

Install a Female Bullet Connector to the end of *each* factory side marker light wire and secure by pressing firmly with a wire crimp.



38

Seal heat shrink tubing on wire using a heat gun.



39

Install turn lights.

Repeat **Steps 1-39** for opposite side.

# Rear Flare Installation Procedures:



40

Remove tail light assembly.



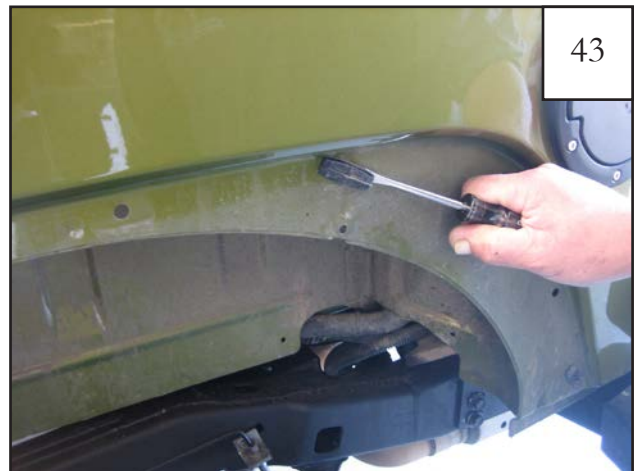
41

Using a pry tool, pliers, or flat head Boltdriver, remove four plastic fasteners from inside of splash shield.



42

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



43

Using a pry tool or flat head Boltdriver, remove any plastic clips still in fender.



44

Thoroughly clean the exposed metal fender with a damp cloth then dry, and apply masking tape to protect painted surface.



45

**OPTIONAL:** If reinstalling inner fender liner, follow **Steps 45-51**. Use a drill with a 5/16" bit to drill through six plastic rivets along edge of flare/splash shield. Discard the flare. Save splash shield for reinstallation.



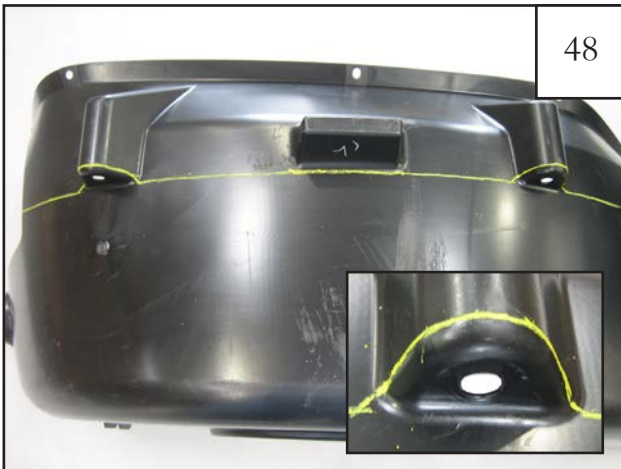
46

Hold the splash shield in place using supplied 1/4" Panel Retainers through factory holes halfway. *Do not fully install Retainers, leave them half out. They are only used to hold splash shield in place for marking.*



47

Using sheet metal as a guide, mark the splash shield with a grease pencil in preparation for trimming. The splash shield should be flush with the sheet metal after being trimmed. **NOTE:** *If trimmed too little, flare won't fit; if trimmed to much, shield won't stay behind flare.*



48

Remove splash shield. Trace around upper mounting tabs with grease pencil as shown. Mounting tabs are necessary for reinstallation.



49

Using a metal hacksaw, pneumatic hand saw, or other suitable cutting device, trim the splash shield along the marked lines.



50

After trimming, mark the rear portion of the splash shield as shown and trim. **NOTE:** *If trimmed too little, flare won't fit; if trimmed to much, shield won't stay behind flare.*



51

Sand mounting tabs flat using an angle grinder or sand paper.



Test fit rear flare and use a grease pencil or awl to mark (2) hole locations in preparation for drilling.



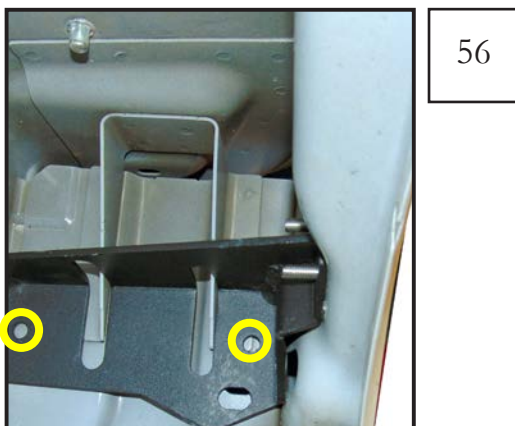
Drill (2) pilot holes using 1/8" drill bit, and finish with a 3/8" drill bit.



Drill out (6) factory hole locations shown above using 7/16" drill bit, in preparation for installing rivnuts.

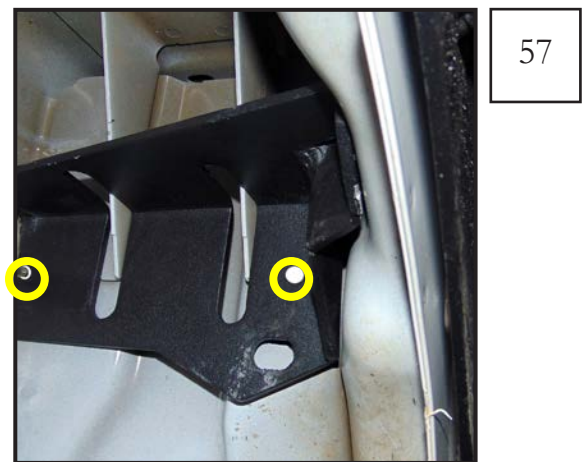


Install rivnuts in locations drilled in **Step 54**, using rivnut installation tool.



Temporarily install Rear Upper Bracket with (2) M8x50 Bolts and mark (2) holes for drilling. Remove bracket and drill pilot holes with 1/8" drill bit, and finish with 3/8" drill bit.

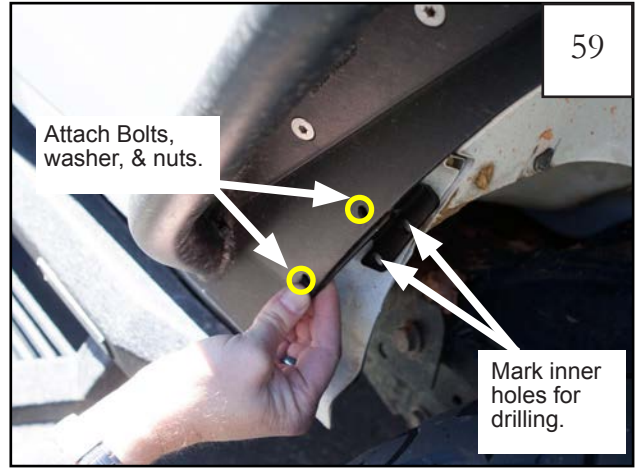
**NOTE:** Use extreme caution not to damage fuel tank filler hoses.



Install Rear Upper Bracket using (2) Hexagon Bolts and (2) M8 Flange Nuts. **NOTE:** To install Flange Nuts utilize the opening made by removing the tail light assembly in **Step 40**.



Temporarily install fender flare. Note (2) hole locations indicated where Lower Rear Bracket will be installed.



Temporarily install Lower Rear Bracket at location shown using (2) M6 Button Head Bolts, (2) Small Washers, and and (2) M6 Flange Nuts. Mark inner holes for drilling.

Remove Fender Flare with Lower Rear Bracket attached. Drill a pilot hole using a 1/8" drill bit and finish with a 3/8" drill bit.



Reinstall fender flare, taking care to align all hole positions. Secure Lower Rear Bracket, using additional M6 Button Head Bolts, small washers, and M6 Flange Nuts to inner pinch seam. Tighten all mounting hardware at this time.



Reinstall tail light assembly.  
Repeat **Steps 40-61** for opposite side.

**OPTIONAL:** Reinstall inner fender liner.