



## 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.
- 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.

# Ford Cut-Out™ Fender Flares Front Pair

Front Part #20043-02

Rev-10 1/28/2016

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

## TOOLS FOR EASY INSTALLATION:









- Drill
- 3/16" Drill Bit
- 1/4" Drill Bit
- 5/16" Drill Bit
- #2 Phillips Bit and Driver
- Phillips Screw Driver
- Reciprocating Saw
- Air Powered "Nibbler"
- Socket Driver
- 7/32" Socket
- 5/16" Socket
- Angle Grinder
- Hammer
- T45 Torx Bit

**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. |  |
|    | GP1-0008,<br>Duro (NC02/S 70)<br>Edge Trim,<br>156 inches                           |    | MB1-0003,<br>GDB Mounting<br>Bracket,<br>2 pcs                                      |    | SW1-0066,<br>#8 x 5/8" Phillips<br>PH Drill Screw,<br>4 pcs                         |    | RV1-P001,<br>1/4" Black Nylon<br>Retainer,<br>14 pcs                                |    | SW1-0016,<br>8 x 1-1/2"<br>Phillips Screw,<br>2 pcs                                  |    | SW1-0045,<br>#14-14 x 1"<br>Torx Screw,<br>14 pcs                                     |    | SP1-0009,<br>3/8" x 5/8" x .187"<br>Neo Black Spacer,<br>20 pcs                       |
| 8. |  |    |   |    |   |    |   |    |  |    |   |    |   |
|    | SW1-0052,<br>T-45 Torx Bit,<br><br>1 pc   |    |   |    |   |    |   |    |  |    |   |    |   |

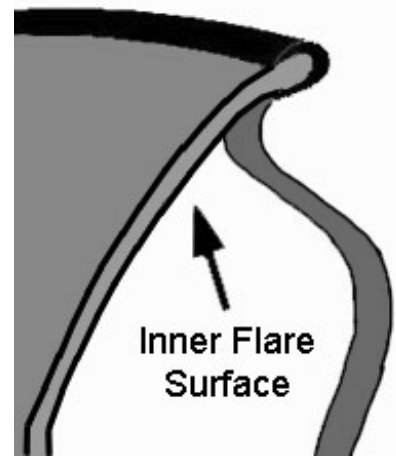
# Flare Installation Procedures:

## STEP 2 - Prepping Work Area (Front):

- A) Remove factory fender trim and mud flaps (if installed).

## STEP 3 - Edge Trim Installation: Illustration #1

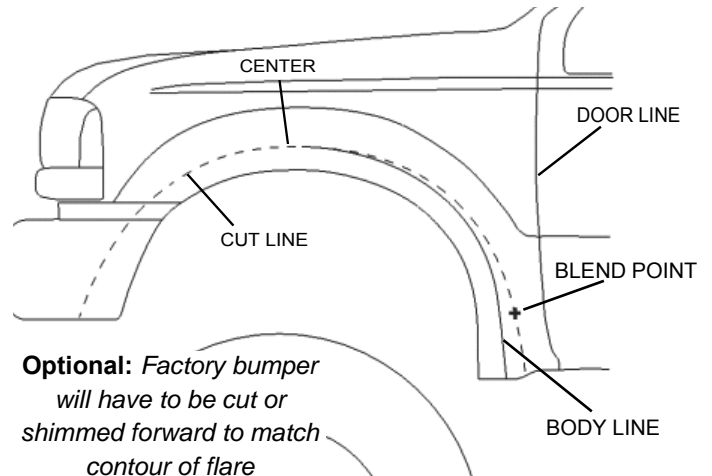
- A) Peel two to three inches of red vinyl backing away from edge trim tape. Applying the adhesive side of the edge trim to the inner side of the flare, affix the edge trim to the top edge of the flare (the portion that comes in contact with the vehicle).
- B) Press edge trim into place along the top 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. Repeat steps 3A and 3B for remaining flares.



**Illustration #1**

## STEP 4 - Cutting Sheet Metal (Front): Illustration #2

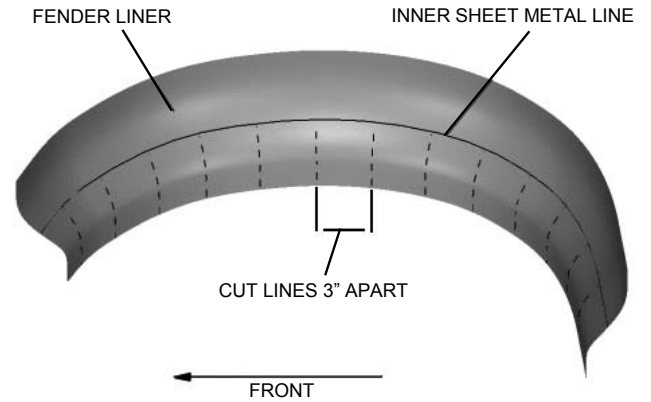
- A) Remove the 7/32" factory screws that fasten inner splash shield (fender liner) to the fender.
- B) Following the body line that is 2" from the wheel opening, mark a line from the top center of the fender to the front of the fender.
- C) Starting at the front of the fender, continue that arc onto the black plastic fender extension and the bumper ending at a point 4" away from the wheel opening.
- D) Measure from the bottom of the lower rocker panel up along the door seam 8 1/2" and mark that point with a grease pencil. From that point, measure horizontally 3 3/8" from the door seam towards wheel opening and mark with a grease pencil.
- E) Beginning at the center of the fender, draw an arc blending the previously marked line with the point on the fender (8 1/2" up 3 3/8" over). Continue that arc to the bottom of the fender.
- F) There are two 5/16" factory fasteners holding the bottom of the fender to the rocker panel. Remove the fastener located closest to the wheel opening.
- G) Using an air powered "Nibbler," cut along the line drawn on the fender.



**Illustration #2**

#### STEP 4 - Continued (Front): Illustration #3

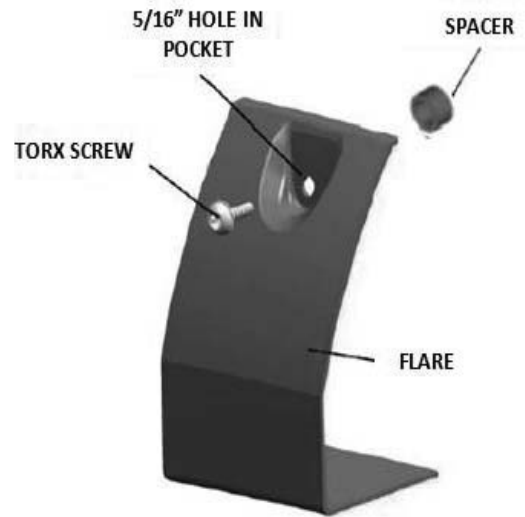
- H) Using the cut edge of the fender as a guide, mark the inner sheet metal structure to match.
- I) Using a Reciprocating saw, cut away the inner sheet metal as marked. Use caution: Do not cut the wiring harness that runs along the inner sheet metal. Do not cut the center tab on the inner structure that holds the fender liner in place. Use a hammer to bend the tab upward into the wheel well to allow for fender flare clearance
- J) Using a Reciprocating saw, make a cut in the fender liner from the inner sheet metal to the outside edge of the liner. Continue cutting every 3" until you reach the other end of the fender liner. This allows the fender liner to "stretch" and accommodate the larger wheel opening. Again, use caution: Do not cut into the wiring harness or the computer box
- K) Spray all cut edges with primer to help prevent rust.
- L) Drill a 5/16" hole through the inner sheet metal at the rear of wheel well 4" up from the bottom and 1" in from the cut edge.
- M) Attach the supplied "L" shaped bracket with a drill screw, so that the short leg is flush with the cut edge of the inner sheet metal.
- N) Push the fender liner toward the bracket, and mark the liner through the hole in the bracket.
- O) Drill a 5/16" hole in the fender liner at the mark and attach it to the "L" shaped bracket with a supplied Tuflok® fastener.
- P) **(Optional: Factory bumper will have to be cut or shimmed forward to match contour of flare)** Using a Reciprocating saw, cut the bumper and the black plastic fender extension along the line.
- Q) Deburr the cut sheet metal edge, and round the lower corner of the bumper using an angle grinder.



**Illustration #3**

### STEP 5 - Flare Installation (Front):

- A) Holding the flare in place on the vehicle, mark the hole locations onto the the vehicle fender using the holes in the flare as a guide.
- B) Remove the flare.
- C) Drill vehicle fender at all marked positions with a 3/16" drill bit.
- D) Apply supplied Torx Screws to fender flare. Apply supplied Spacers to each of the Torx screws on the back side of the flare.
- E) While holding the flare into position on the fender, align Torx screws with holes drilled into fender. Fasten the flare to the vehicle by tightening the Torx Screws through the holes drill in the fender. **Use caution: Do not over tighten the screws. Over tightening will not allow the flare to expand and contract with temperature changes after the flare is installed (Illustration #4).**
- F) Evenly mark 6 locations on each front flare for attaching the Tuflok® fasteners.
- G) Applying moderate pressure to the outside surface of the flare, drill through the flare and the fender liner with a 1/4" drill bit, using the marks made on the flares as a guide.
- H) Attach the flare to the fender liner with Tuflok® fasteners through holes drilled.



**Illustration #4**