



20043
03-31-05
Rev-B

INSTALLATION INSTRUCTIONS FORD SUPER DUTY

Cut-Out® Flares – 20043 Front, 20044 Rear Short Bed, 20046 Rear Long Bed

TOOLS REQUIRED FOR INSTALLATION:

- Drill
- 1/16" 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

FLARE INSTALLATION PROCEDURES

Step 1: Painting (Optional)

- (A) It is recommended that painting be done prior to installation.
- (B) Sand (optional) before application of paint.
- (C) Clean outer surface with a high-grade degreaser. **DO NOT USE LACQUER THINNER OR ENAMEL REDUCER AS A DEGREASER.** Wipe outer surface thoroughly with a tack rag prior to painting.
- (D) Paint flares using a high quality lacquer, enamel, or polyurethane automotive paint. Application of a primer coat is optional.

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

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

Step 3: Edge Trim Installation (See 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.

Step 4: Cutting Front (See 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.

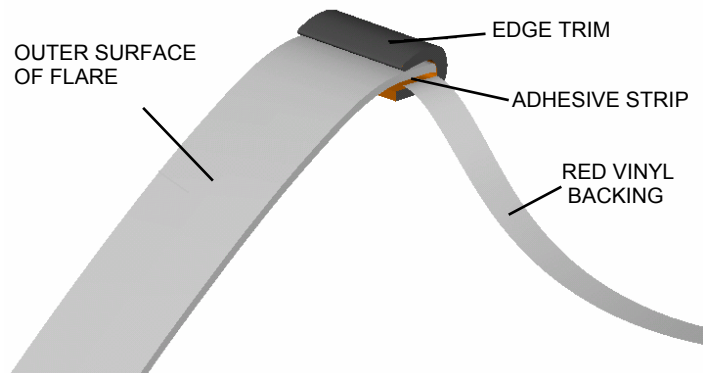


ILLUSTRATION #1

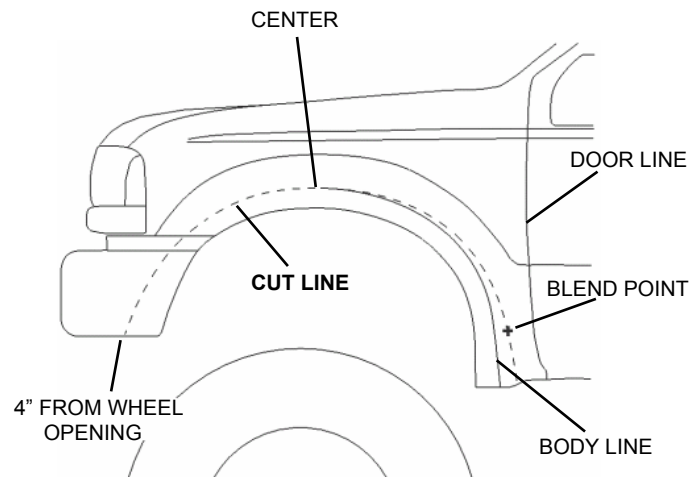


ILLUSTRATION #2

- (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.
- (H) Using a Reciprocating saw, cut the bumper and the black plastic fender extension along the line.
- (I) Deburr the cut sheet metal edge, and round the lower corner of the bumper using an angle grinder.
- (J) Using the cut edge of the fender as a guide, mark the inner sheet metal structure to match.
- (K) 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.
- (L) 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.
- (M) Spray all cut edges with primer to help prevent rust
- (N) 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.
- (O) 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.
- (P) Push the fender liner toward the bracket, and mark the liner through the hole in the bracket.
- (Q) 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.

Step 5: Cutting Rear

- (A) Following the bodyline that is 2" from the wheel opening, mark a line from front to back.
- (B) Using air powered "Nibbler," cut along the marked line. **Note:** The top of wheel opening has two panels. Use a Reciprocating saw in this area so that it is flush with the outer panel.
- (C) Spray all cut edges with primer to help prevent rust

Step 6: Flare Installation

- (A) Drill the flare at all the pockets with a 5/16" drill bit, using the indents that are formed into the part as a guide.
- (B) Holding the flare in place on the vehicle, mark the hole locations onto the vehicle fender using the holes in the flare as a guide.
- (C) Remove the flare.
- (D) Drill vehicle fender at all marked positions with a 1/16" drill bit.
- (E) Install the snap cap washers onto the screws.
- (F) Holding the flare into position on the fender, fasten the flare to the vehicle through the holes drilled in the fender. Install snap caps to screws on outside of flare. **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.
- (G) Locate the indents (6 in each front, 2 in each rear) formed into the fender liner area of the flare.
- (H) 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 indents in the flare as a guide.
- (I) Fasten the flare to the fender liner with Tuflok® fasteners.

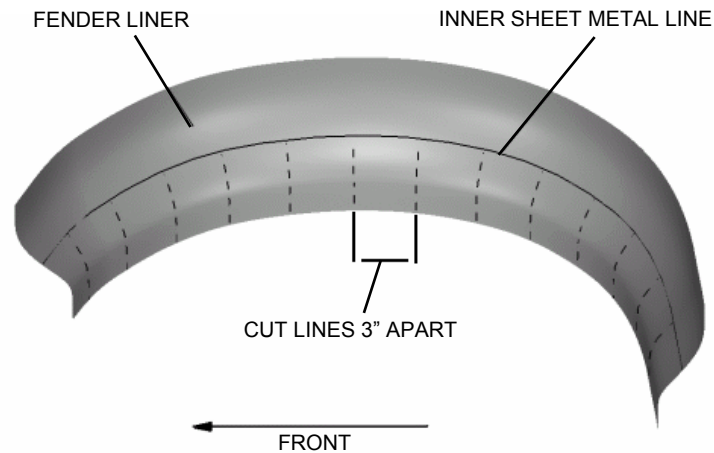


ILLUSTRATION #3

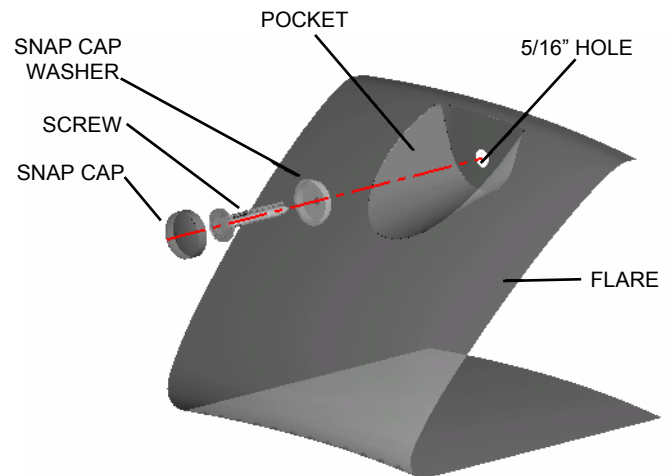


ILLUSTRATION #4