

**Cut Out Flares**  
INSTALLATION INSTRUCTIONS FOR  
**TOYOTA**  
**31009 / 31010 4WD P.U.**  
**31009 / 31022 4RUNNER**

**TOOLS REQUIRED FOR INSTALLATION:**

- 3/8" Drill Motor
- 1/4" Drill Bit
- #2 Phillips Driver Bit
- 10 mm Wrench
- 8 mm Wrench
- Sheet Metal Cutting Tool
- (Hacksaw, Saber Saw or Air Chisel)
- Hammer
- C-Clamp or Vise Grips
- Marking Pen
- Straight Edge (Flexible)
- Jack
- Jack Stands (2)

**IMPORTANT: READ BEFORE BEGINNING INSTALLATION**

**Verifying Fit** - Flares should be held to the vehicle surface to verify correct type and fit BEFORE beginning installation. Small fit adjustments can be made by trimming (filing, sanding, or scraping) flashing or excess plastic.

**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 shoulders from contacting flare.

**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.

**Metal Protection** - All exposed fasteners and bare metal should be treated with red oxide primer BEFORE installing flares.

\*DO NOTE USE: Loctite, SuperGlue, or similar products on the hardware or the flares.

**FLARE INSTALLATION PROCEDURES**

**Step 1: Painting**

**It is recommended that painting (when desired) be done prior to installation.**

- (A) Sand (optional) before application of paint.
- (B) 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 painting.
- (C) Paint flares using a high quality lacquer, enamel, or polyurethane automotive paint. Application of a primer coat is optional.

**Step 2: Disassembly (front) 31009**

- (A) Jack up vehicle and use jack stands.
- (B) Remove wheel and wheel well trim (if so equipped).
- (C) Remove (3) mud flap retaining screws.
- (D) Remove all screws retaining wheel well liner to fender lip. Do not remove liner. Bend rear portion of wheel well liner forward.

**Step 3: Cutting Sheet Metal (front) 31009**

- (A) Mark a line 1" out from existing wheel well opening (lower rear leg only). Photo #1.
- (B) Mark a straight line from Step 3A to a point tangent to opening. Photo #2.
- (C) Cut along line drawn in Step 3B.
- (D) Hammer back body seam. Photo #3.
- (E) Trim wheel well liner at lower rear. Photo #4.
- (F) Tuck wheel well liner behind last original mounting point on fender lip. Photo #4 (circled area). Secure wheel well liner with original mounting screws. The mounting point at inside rear will be secured by using a supplied drill screw. Photo #5.
- (G) Secure mud flap with original fastener on inside mounting point. At top center of mud flap and sheet metal secure with a supplied drill screw. Photo #6.

**Step 4: Fender Flare Installation (front) 31009**

Note: A #2 Phillips Driver Bit is needed to install drill screws

- (A) Fit flare tightly into fender well opening, making sure mud flap is on outside of flare. With everything



ready, drill screw last pocket on rear leg first (use indents in flare pockets as a guide). Don't forget the cap washer under rivet head. NOTE: Cap washers are applied to drill screw pockets only. Next, drill screw first pocket on front leg of flare. Drill screw in an alternating pattern front to rear until all outer pockets are secured. On underside of flare and fender lip secure with drill screws at (5) points. Photo #7. Complete flare attachment with drill screws on underside rear leg.

- (B) Secure mud flap and flare near original mounting hole with a drill screw. (Use a back up washer on inside of flare to catch drill screw). Photo #8.
- (D) Press trim caps onto outer flare cap washers.

#### Step 5: Disassemble (rear) 31010

- (A) Jack up vehicle and use jack stands.
- (B) Remove wheel and wheel well trim (if so equipped).
- (C) Remove screws holding mud flap bracket.
- (D) Using 1/4" drill bit, drill out spot welds holding support bracket to sheet metal. Photo #9. Retain bracket as it will be reattached later.

#### Step 6: Cutting Sheet Metal (rear) 31010

- (A) Mark a line at lower rear 1" out from original wheel well opening.
- (B) Mark a line at lower front 1-1/2" out from original wheel well opening.
- (C) Mark a straight line from Step 6A and 6B to a point tangent to wheel well opening. Photo #10 and #11.
- (D) Cut along lines marked in Step 6C.
- (E) Fit flare tightly into wheel well opening. Align notch in flare with gas door.
- (F) Mark a line on gas door using flare as a guide. Photo #12.
- (G) Remove flare.
- (H) Mark a line 1/4" above line drawn in Step 6F. This will be the cut line. Photo #13.
- (I) Remove (2) screws attaching gas door.
- (J) Cut along marked line. A portion of the hinge will be cut away. To reattach, Secure with a drill screw from back side as shown in Photo #14.
- (K) Reassemble gas door using original fasteners. Photo #15. Hold flare in place and check clearance between flare and door in its full swing. If necessary, cut more off door to gain clearance.
- (L) Reinstall mud flap bracket. Attach support bracket to mud flap bracket using original fastener. Swing support bracket over to sheet metal and C-clamp in place. Drill screw twice through sheet metal and support bracket. Photo #16 and #17.
- (M) Remove support bracket to mud flap bracket fastener. This will allow flare to be installed.

#### Step 7: Fender Flare Installation (rear) 31010

- (A) Fit flare tightly into fender well opening, making sure notch in flare is aligned with gas door. With everything ready, (using indents in flare pockets as a guide), drill screw (2) lower outer pockets on front leg first. Don't forget the cap washer under drill screw head. NOTE: Cap washers are applied to

outer drill screw pockets only. Next, drill screw last pocket on rear leg of flare. Install drill screws in an alternating pattern front to rear until all outer pockets are secured.

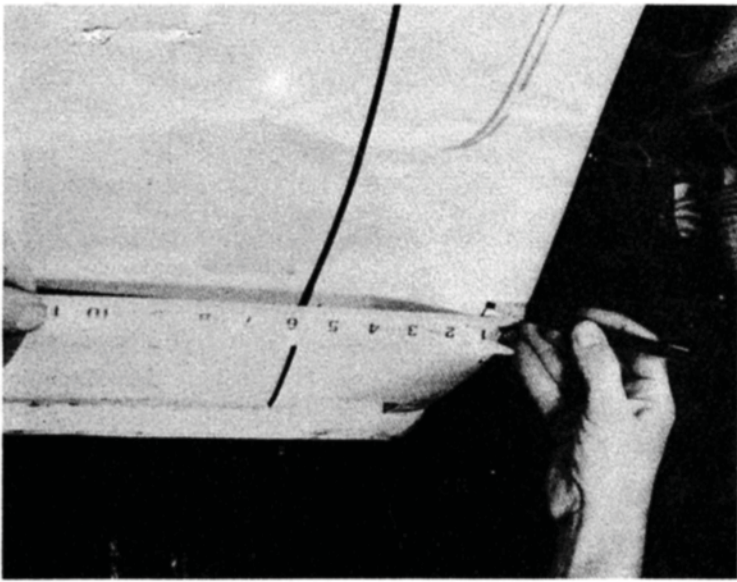
- (B) On flare with gas door cover proceed with the following. Place flare cover over gas door and align with flare. Mark a line along top of flare cover onto gas door. This line is for alignment reference only. Photo #18. Using (3) indents as a guide, place flare cover onto gas door and drill screw outer pocket first. Don't forget cap washer. Drill screw (2) lower indents.
- (C) Drill screw through flare and fender lip on underside center area in (3) locations.
- (D) Finish drill screws at (2) lower underside locations on front and rear legs.
- (E) Secure mud flap bracket and support bracket with original fasteners.
- (F) Press snap caps onto outer flare cap washers.

#### Step 8: Fender Flare Installation (Rear) 31022

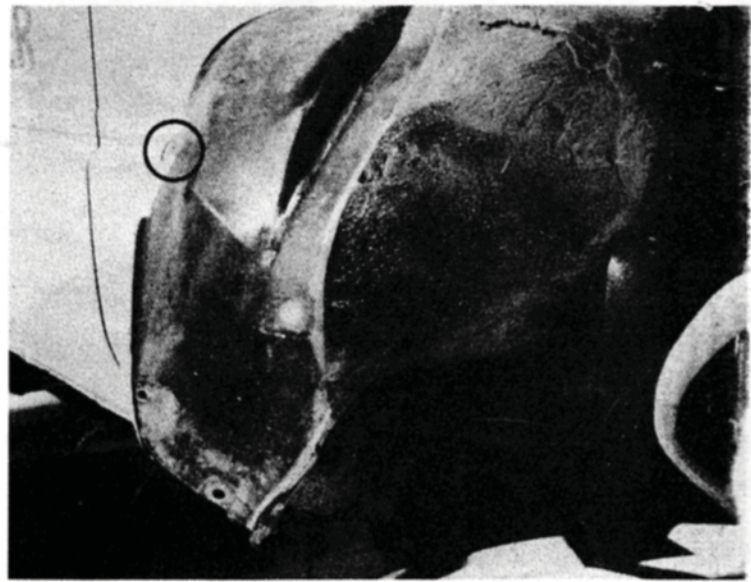
**NOTE:** Toyota 4Runner rear flare requires **NO CUTTING** to install. Follow steps 1 thru 4 of front flare installation.

- (A) If your 4Runner is equipped with a stone guard on the front leg of opening, it will be necessary to do one of the following:
  - 1) Removing stone guard: there are fasteners holding the stone guard that will leave exposed holes in the body when removed. It will require filling and paint to cover.
  - 2) Cutting stone guard: position flare in place and mark a line onto guard where flare overlaps. Remove flare and cut guard on marked line. If you're using the fender gimp (supplied) between the flare and sheet metal, cut an additional 3/16" off stone guard.
  - 3) Install flare over top of stone guard: you can install flare over the stone guard. There will be a slight gap at the top.
- (B) Place flare into wheel well opening. Make sure flare is tight against the body and contours align. Slip leg of gimp between flare and sheet metal at lower front. Bulb of gimp should be tight against flare. Assemble drill screw with a #8 flat washer into cap washer. (see illustration # A-1). Install drill screw, cap, washer into lower front through flare, gimp and sheet metal. Apply a dab of silicone or body sealer to hole to seal. Repeat same procedure for pocket above. All other pockets (except lower rear on bumper) are drilled **WITHOUT** #8 flat washer. Lower rear pocket uses the assembly in illustration #A-1. Secure under side center area with (3) drill screws. Secure bottom of front and rear legs with #8 flat washer under head of drill screw.
- (C) Trim gimp off at roll-under. Apply snap caps to outer drill screw pockets.

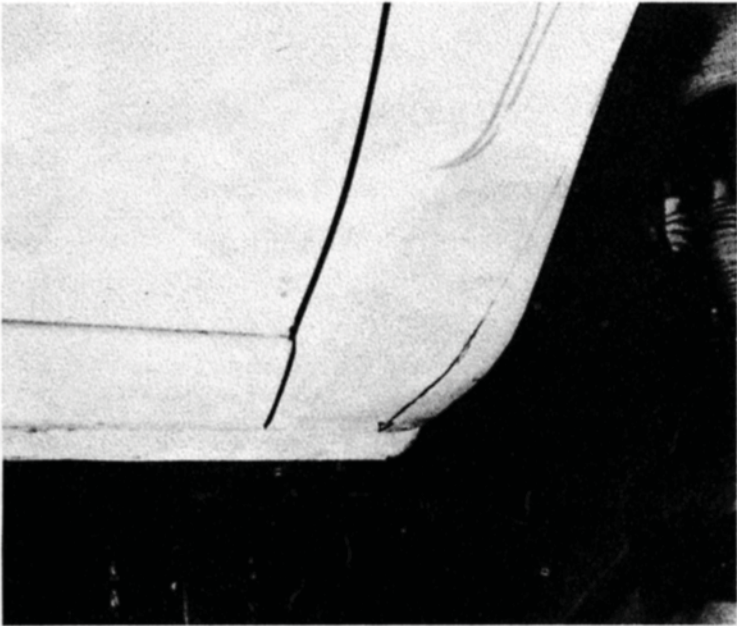




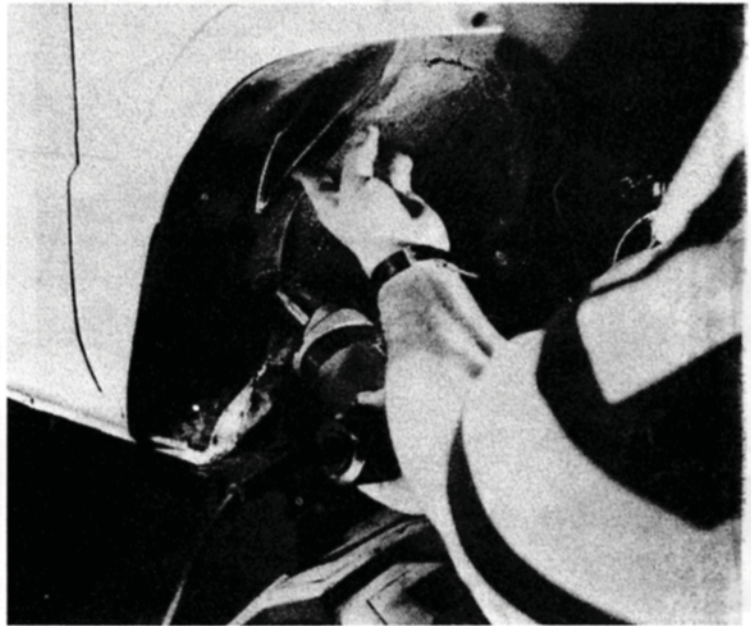
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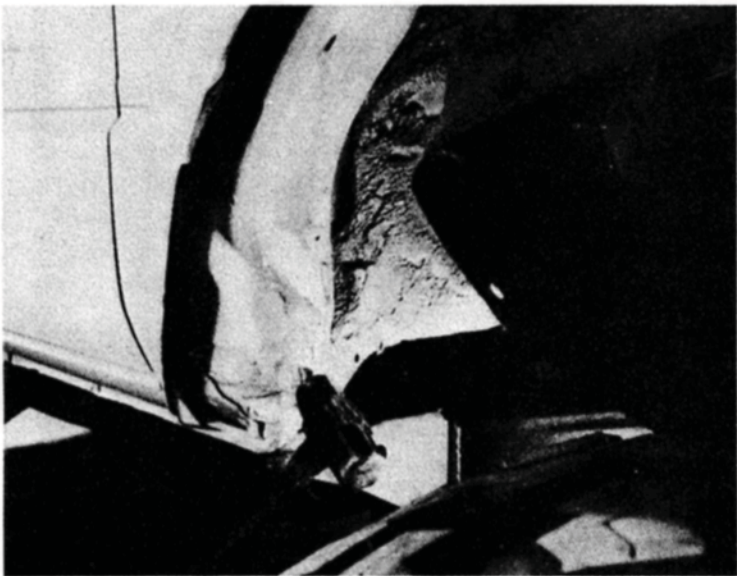
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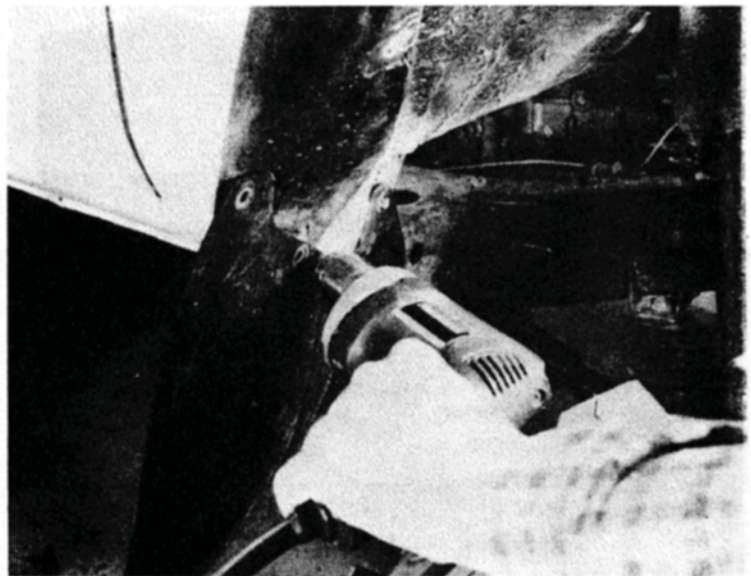
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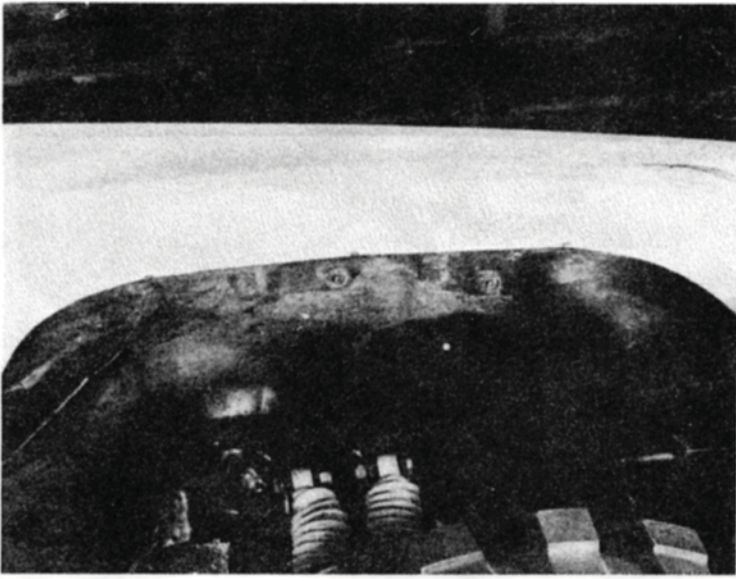


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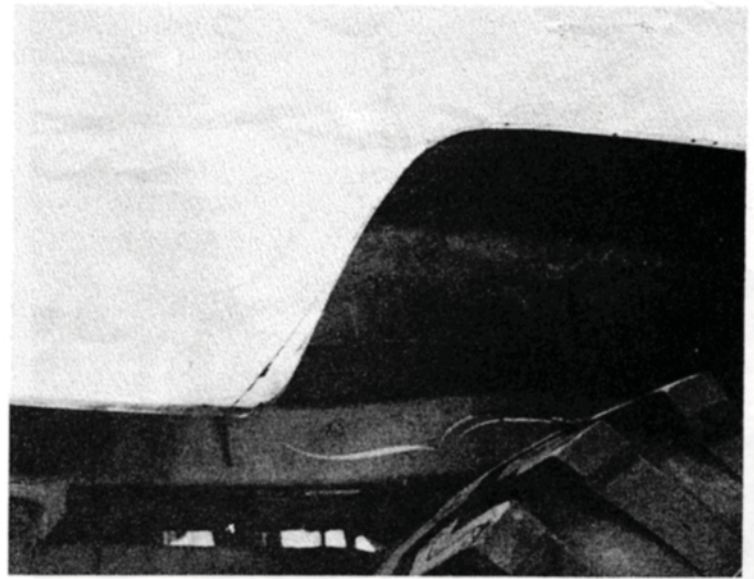


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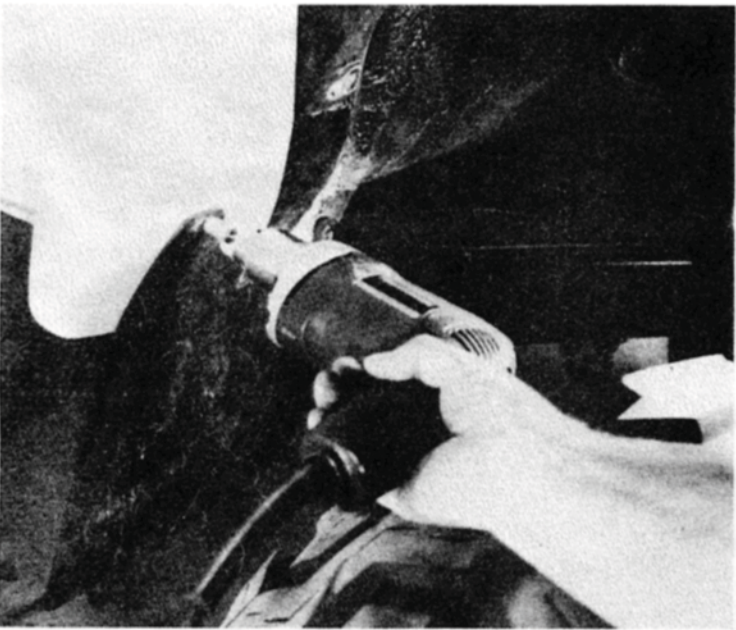




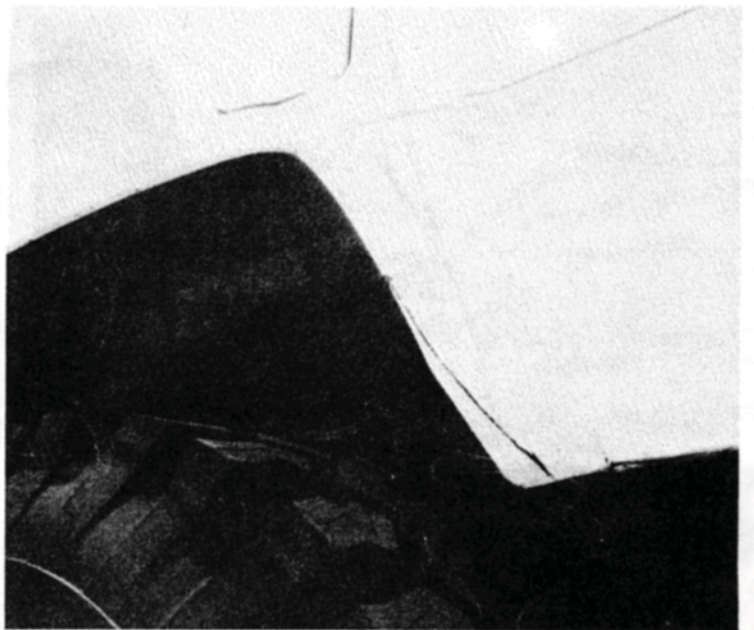
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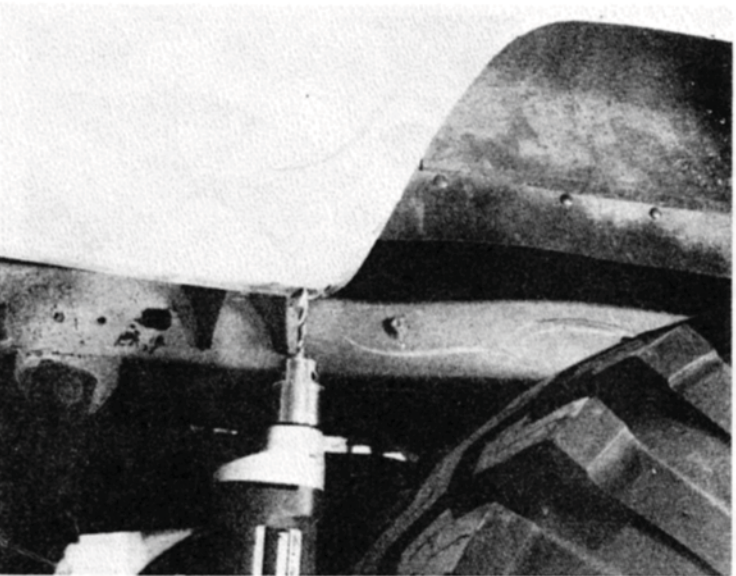
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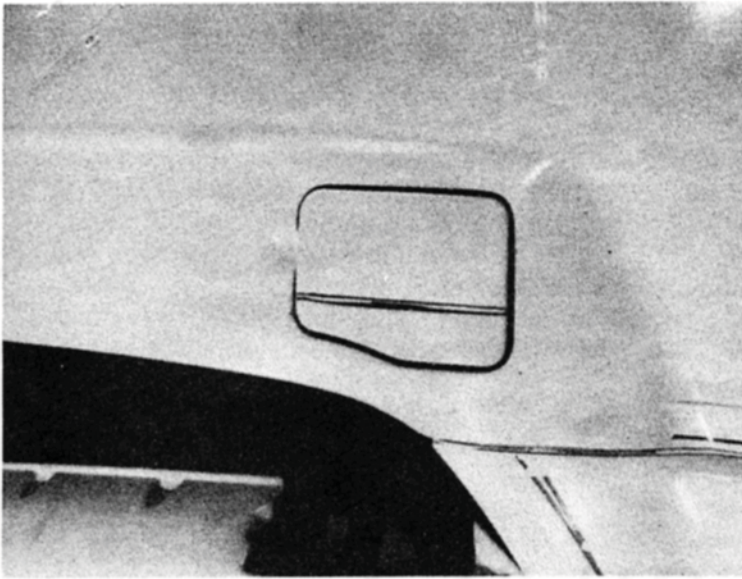


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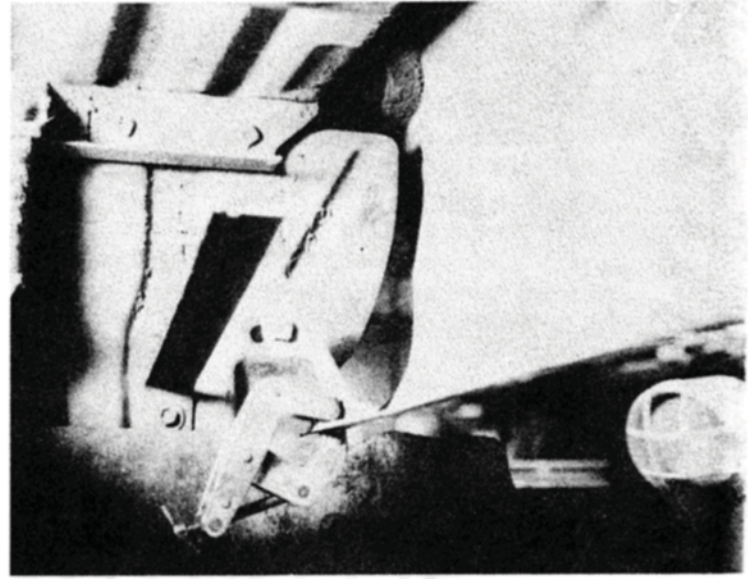


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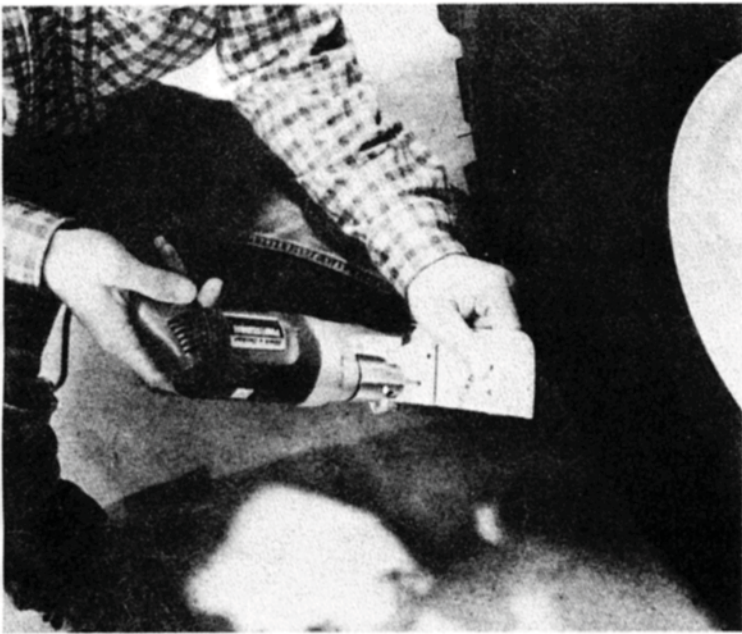




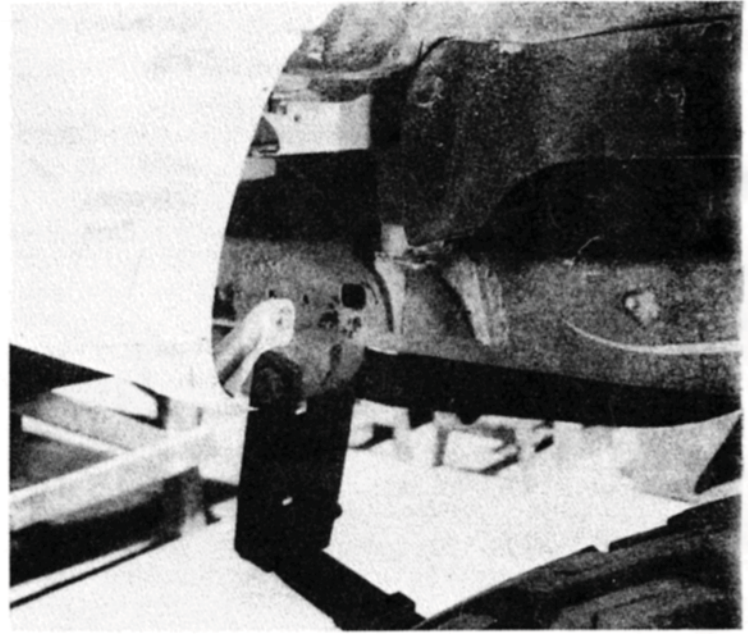
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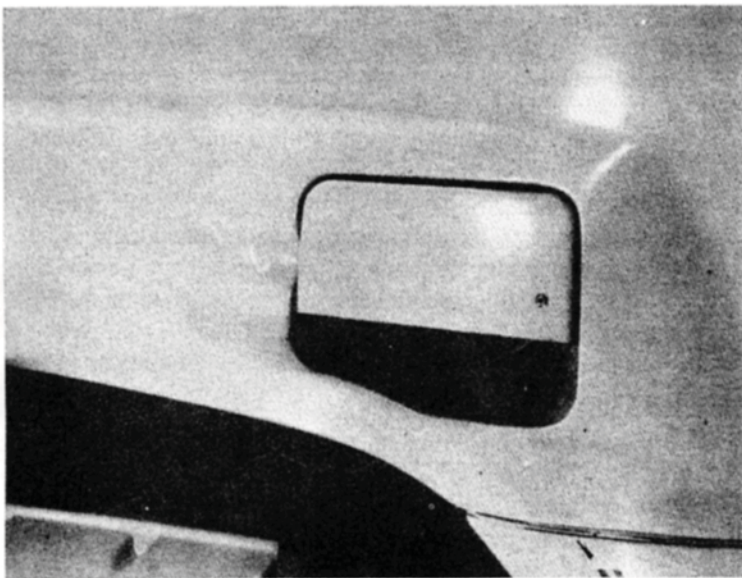
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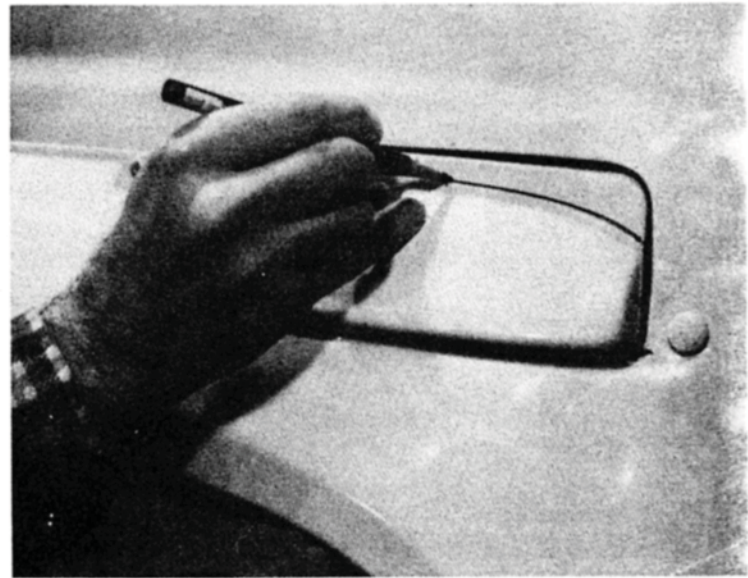
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# ILLUSTRATION #A-1

