

# INSTALLATION MANUAL

1500203

## Level of Difficulty

Moderate

## Parts List

1	Driver / left fender flare
1	Passenger / right fender flare
2	Bolt spacer
12	Hex bolt, M6 x 20mm
12	Rivet nut, M6
12	Flat washer, M6
12	Lock washer, M6
2	Hex bolt, M8 x 100mm
2	Hex bolt, M8 x 25mm
4	Hex nut, M8
4	Lock washer, M8
8	Flat washer, M8
1	Left hand-nut, M8
1	Thread-set washer
1	Thread-set spacer

## Tools Required

Ratchet	Trim removal tool
Socket set	Paint marker
Wrench set	Drill
Plier-style thread set tool, M6	Drill bit, 25/64" or 10mm
Insert tool, M6	--

## Torque Specifications

Metric	M6 bolt	3 ft-lbs.
	M8 bolt	7 ft-lbs.
	M10 bolt	16 ft-lbs.
	M12 bolt	28 ft-lbs.
SAE	1/4" bolt	3 ft-lbs.
	5/16" bolt	7 ft-lbs.
	3/8" bolt	16 ft-lbs.
	7/16" bolt	20 ft-lbs.
	1/2" bolt	28 ft-lbs.

Use above torque setting unless otherwise noted

## Product Photo



## Notes and Maintenance

Before you begin installation, read all instructions thoroughly.

Proper tools will improve the quality of installation and reduce the time required.

To protect the product, wax after installing. Regular waxing is recommended to add a protective layer over the finish. Do not use any type of polish or wax that may contain abrasives that could damage the finish.

Mild automotive detergent may be used to clean the product. Do not use dish detergent, abrasive cleaners, abrasive pads, wire brushes or other similar products that may damage the finish.

Refer to the table to the left when securing hardware during the installation process to help prevent damage to the product or vehicle.

### Step 1

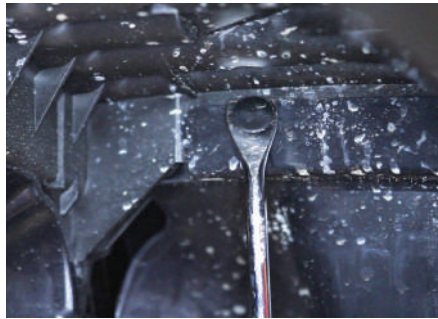
Starting on the driver side, remove the front inner fender wells using a socket set.



### Step 2

Remove all push-in retainers, taking care not to damage the plastic inner fender liner.

Once all retainers have been removed, remove the inner fender liner and set it aside.



### Step 3

Disconnect the side marker light from the factory harness.



#### Step 4

Remove the plastic trim retainer clips and the factory fender flare.



#### Step 5

Using the factory metal brace to help balance the inner liner, place the inner liner up against the Jeep body and align the mounting holes.



#### Step 6

Identify the matching holes from the new inner liner and the original holes.

Mark the locations where drilling is needed.



#### Step 7

Remove the fender flare and inner fender liner and drill 25/64" or 10mm holes to fit the M6 threaded metal inserts supplied with the fender flares.

Do not make the holes larger than required or the rivet nuts may fail to install.

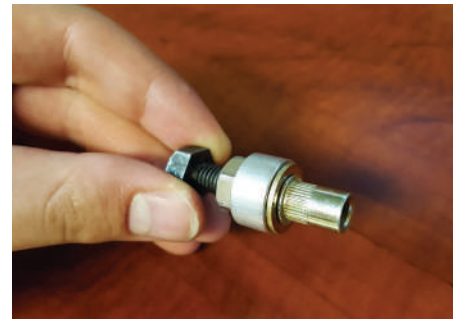


### Step 8

Screw the left hand-nut completely onto the thread-set tool. Slide the thread-set spacer onto the larger thread until it rests against the M8 left hand-nut.

Place an M6 flat washer on the small thread followed by an M6 rivet nut.

Thread the rivet nut onto the small end of the tool until it seats the washer against the shoulder between the M6 and M8 threads.



### Step 9

Insert the rivet nut into the drilled hole.

Using a 13mm wrench, hold the M8 nut on the thread-set tool. With a 13mm socket, turn the head of the bolt clockwise until the M8 nut and thread-set spacer contact the M6 washer and rivet nut. After tension is felt, carefully compress the rivet nut in the hole while applying slight pressure to keep it seated (approximately two full rotations).

**CAUTION:** Over tightening the rivet nut may damage the thread-set tool and / or vehicle panel. Only compress the rivet nut enough to seat it in the hole without rotating.



### Step 10

Drill a through-hole for an M8 bolt and insert an M8 bolt spacer.

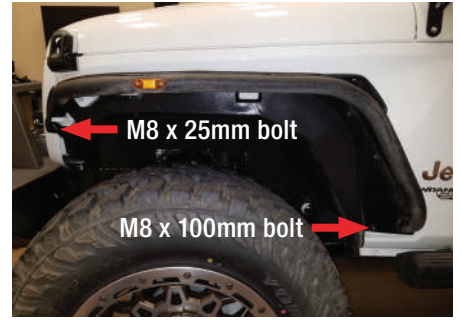


### Step 11

Place the fender back into place and secure using an M6 bolt, lock washer and flat washer.

With an M8 flat washer, insert an M8 x 100mm hex bolt through the bolt spacer and secure with an M8 flat washer, lock washer and hex nut.

With an M8 flat washer, insert an M8 x 25mm hex bolt through the front mounting location and secure with an M8 flat washer, lock washer and hex nut.



### Step 12

Tighten down all hardware and torque to the values specified on the first page of this manual.

Repeat this process on the passenger side.



### Step 13

Congratulations on the installation of your new ARIES fender flares.

With the fender flares installed, periodic inspections should be performed to ensure all mounting hardware remains tight.

Some states may require a side marker to be road legal. Refer to part number 1500240 and install if desired.

To protect your investment, see the 'Notes and Maintenance' section on the first page of this instruction manual.



[View other fender flares made by Aries on our website.](#)