



Toyota Highlander

Set Part #30914-02

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.













TOOLS FOR EASY INSTALLATION:

- 3mm Allen Wrench
- 10mm Socket Wrench
- Electric Drill
- 5/16" Drill Bit
- 1/4" Drill Bit
- #2 Phillips Driver
- Grease Pencil
- Awl
- Pry Tool
- Scissors or similar cutting tool
- 4" Deep Reach Ratcheting Spring Clamp (Bessey - Part # XCRU5 available at Lowe's and MSC Industrial Supply)
- Polyfoam packing material wrapping inner pieces

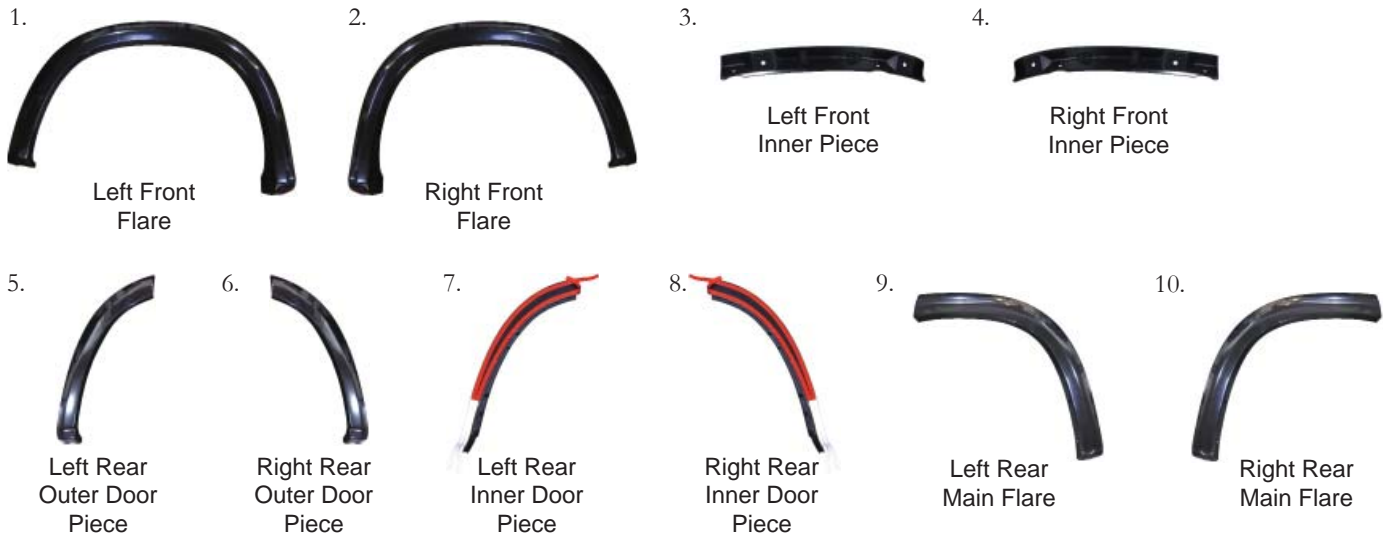
LIMITED LIFETIME WARRANTY AGAINST ANY MANUFACTURING DEFECTS

- To claim a warranty, you must provide Proof of Purchase.

Included in Hardware Kit

- | | | | | | | |
|--|---|--|---|---|---|--|
| 1.

CL1-0023,
#8 "U" SPRING
NUT MAGNI565
6 pcs | 2.

CL1-0022,
#10 "U" Clip,
12 pcs | 3.

CL1-0009,
Long "U" Clip,
Magni 565
4 pcs | 4.

MT1-0014,
1" x1.5" x.01"
Black Tab,
8 pcs | 5.

SW1-0058,
#10 x 5/8" Phillips
SS Truss Screw,
16 pcs | 6.

SW1-0056,
#8 x 3/4"
PH Screw,
6 pcs | 7.

SW1-0057,
#14 x 3/4" Phillips
Truss Tap Screw,
4 pcs |
| 8.

RV1-P001,
1/4" Black Nylon
Retainer,
4 pcs | 9.

ET1-0002,
Edge Trim Tool,
1 pc | 10.

GP1-0001,
Small Wiper Style
Edge Trim,
316 in | | | | |

Component List



STEP 2 - EDGE TRIM INSTALLATION

- A) Peel two to three inches of red vinyl backing away from Edge Trim (GP1-0001) 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.



Inner Door Piece Installation Procedures (Driver's Side)



Install Clip (CL1-0023) over holes in Inner Door Piece. Three locations.



Start to peel red vinyl liner from tape at top of Inner Door Piece, folding tabs toward the outer curvature of the part and ensuring that inner liner is behind the outer liner.



Start to peel white vinyl liner from tape at bottom of Inner Door Piece, folding tabs toward the outer curvature of the part and ensuring that inner liner is behind the outer liner.



Open rear door and position Inner Door Piece on door. At top of part, align Inner Door Piece such that the breakaway tab hooks over the door lip.



Pull gasket up to expose edge of door. Align Inner Door Piece Indexing Bump with edge of door.



At bottom of part, align Inner Door Piece to nest snugly to lower curvature of the door.



Ensure that tape tabs are accessible, top and bottom.



Pull red tape liner on the left (tape closest to edge of door).



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Pull remaining red tape liner and press the Inner Door Piece firmly to ensure proper tape adhesion.



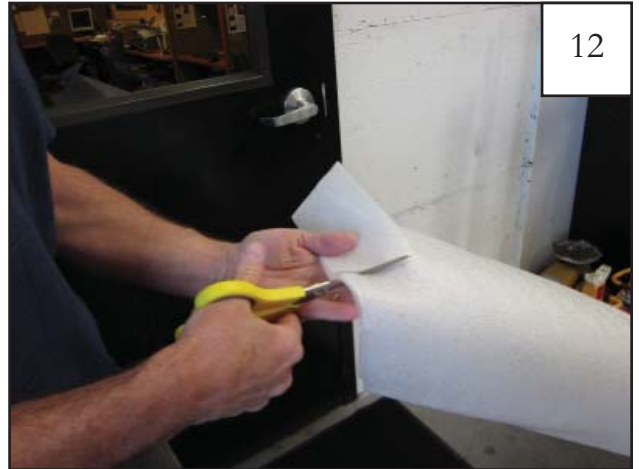
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Pull white tape liner at the top (tape closest to the edge of the door).



11

Pull remaining white tape liner and press the Inner Door Piece firmly to ensure proper tape adhesion.



12

Cut a piece of polyfoam packing material approximately 2" x 4".



13

Use the polyfoam as a pad between the inner sheet metal and the ratcheting spring clamp. Attach ratcheting spring clamp on upper part of Inner Door Piece in Position 1 and tighten. Leave clamp in place for at least 1 minute. Repeat clamping Inner Door Piece for positions 2 and 3. Leave clamp in place at least 1 minute in each position.



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Position of clamp on back of door.

Front Flare Installation Procedures (Driver's Side)



Using a 10mm socket wrench, remove factory bolt at front underside of wheel well. *Save for reinstallation.*



Factory bolt location.



Using a pry tool, remove two plastic factory fasteners.



Factory fastener locations.



Using a 3 mm Allen Wrench, remove two factory screws from rear of wheel well. *Save for reinstallation.*



Two factory screw locations.



Using a pry tool, remove plastic factory fastener at lower rear of wheel well.



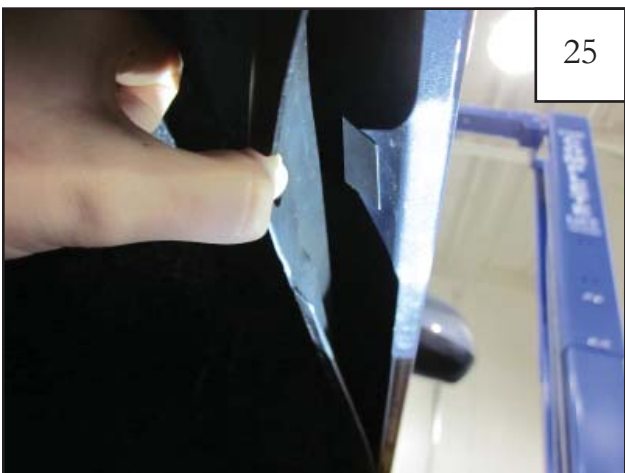
Use these two locations for the next five steps.



Using a pry tool, remove two plastic factory fasteners. *Reference Step 22 for locations.*



Pull wheel well liner out from behind fender lip.



Install Tab (MT1-0014) over factory hole locations behind wheel well liner. *Reference Step 22 for locations.*



Slide Clip (CL1-0022) over factory hole locations behind wheel well liner over tab installed in previous step. Two locations. *Reference Step 22 for locations.*



Using awl to poke hole through Tab using Clip installed in Step 26 as a guide. With Clip installed, tuck liner back in. Two locations



Identify left side and right side Front Inner Pieces. Parts are marked with an "L" for left side and an "R" for right side.



Install Clips (CL1-0022) at two locations on Front Inner Piece.



Two locations.



Hold front flare inner piece in wheel well with angled hole locations aligned with clips installed on wheel well lip in Step 26. Using a #2 Phillips Screwdriver, install Screws (SW1-0058) through front flare inner piece, through wheel well liner, and into Clip. Make sure that the corners of the Front Inner Piece are mounted flush with the sheet metal.



Hold flare to vehicle. Start Screws (SW1-0058) through two uppermost locations with #2 Phillips Screwdriver. *Do not tighten.*



Using a #2 Phillips Screwdriver, install Screws (SW1-0057) through two frontward locations inside wheel well. Do not tighten.



Start factory screws removed in Step 20 using a 3mm Allen Wrench. *Do not tighten.*



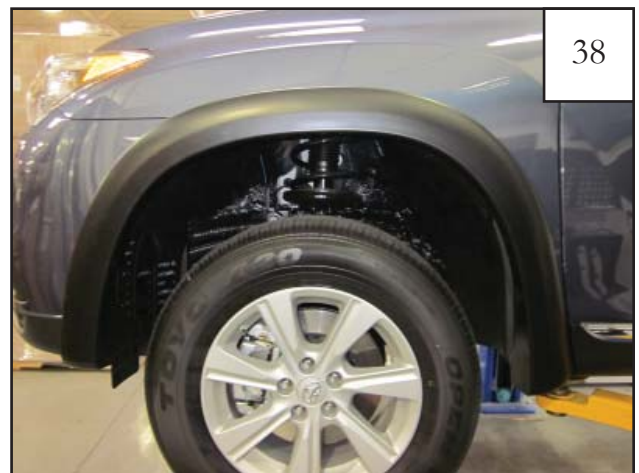
Using a 10 mm socket wrench, reinstall factory bolt removed in Step 15 by threading through flare.



Install a Tuflock (RV1-P001) through flare and into sheet metal of wheel well where rear and lowermost plastic factory fastener was removed in Step 21.



Once all hardware is started, check flare for proper positioning. Apply pressure at each fastening point and tighten all screws and bolts.



Completed Front Flare installation.

Rear Flare Installation Procedures (Driver's Side)



Hold flare to fender. Rotate the bottom of the flare 1/2" away from vehicle and mark two Clip locations with a grease pencil on the fender even with flare holes.



Remove flare from fender. Center a supplied Tab (MT1-0014) over each mark made in Step 39.



Install one Clip (CL1-0009) over each Tab installed in previous Step.



Using a 5/16" drill bit, drill two holes in wheel well lip at rear of wheel well. Use lowest dimple and third lowest dimple in wheel well lip as a guide. Install Clip (CL1-0022) at each of the drilled locations.



Hold flare to vehicle and start Screw (SW1-0058) through flare and into Clips installed in Step 41 & 42 using #2 Phillips Screwdriver. Four locations. Apply pressure at each fastening point, and tighten all screws.



Completed Rear Flare installation.

Outer Door Piece Installation Procedures (Driver's Side)



Use the polyfoam as a pad between the inner sheet metal and the ratcheting spring clamp. Attach ratcheting spring clamp on upper part of Inner Door Piece, aligning as close to uppermost Clip on part.



Break plastic tab off of Inner Door Piece. Remove ratcheting clamp.



Position Outer Door Piece over Inner Door Piece, checking for proper alignment of top of Outer Door Piece with the edge of the door.



Using a #2 Phillips Screwdriver, start supplied Screw (SW1-0056) through Outer Door Piece and into clips installed on Inner Door Piece. Three locations.



Close door and check for proper alignment between Door Piece and Rear Main Flare then apply pressure at each fastening point and tighten all Door Piece screws.



At bottom front of Door Piece, using the hole in part, use a drill with 1/4" drill bit to drill through sheet metal.

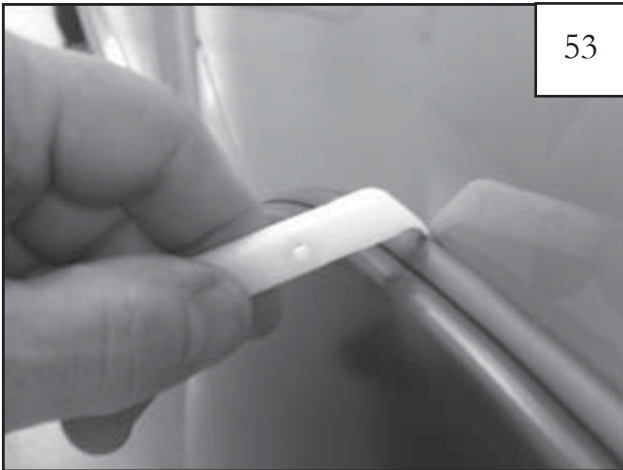


Install a Tuflock (RV1-P001) through hole drilled in previous Step.



Completed Door Piece Installation.

Front & Rear Edge Trim Tool Procedures



Using supplied Edge Trim Tool (ET1-0002), seat edge trim against vehicle by hooking curved end under edge trim at one end of flare. Next, slide around outer edge of flare to the other end.



Using flat end of supplied Edge Trim Tool (ET1-0002), seat edge trim against flare by inserting straight end between edge trim and flare at one end. Next, slide around entire edge to the other end.

Flare Height & Tire Coverage (Passenger's Side)

