



2012 Toyota Tacoma, Regular/Access/Double Cab, Longbed

Set Part #31927-02

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:

- Utility Knife
- Electric Drill
- 1/4" Drill Bit
- Vise Grips
- Trim Tool or Flat Head Screwdriver
- Socket Wrench
- 10mm Socket
- 8mm Socket
- 3/8" Wrench
- 7/16" Wrench
- #2 Phillips Bit
- Grease Pencil

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. |  |
| | CL1-0005,
Dacromet "U"
Spring Clip,
4 pcs | | SW1-0050,
10 x 5/16 Phillips
Truss Screw,
4 pcs | | MT1-0002,
1" x 1" x .017"
Black Tab,
4 pcs | | SP1-0005,
1/2" x .257" x 1"
Nylon Spacer,
2 pcs | | SP1-0008,
1/2" x .260" x 3/4"
Spacer,
2 pcs | | SP1-0003,
1/2" x .260" x 1/4"
Nylon Spacer,
2 pcs | | NU1-0011,
1/4-20 SS Serrated
Flange Nut,
4 pcs |
| 8. |  | 9. |  | 10. |  | 11. |  | 12. |  | 13. |  | 14. |  |
| | SW1-0005,
1/4-20 x 3/4"
HxHd Slot Screw,
4 pcs | | SW1-0034,
14 x 1-3/4" Phillips
Truss Tap Screw,
4 pcs | | SW1-0036,
M6-.3 x 20mm Hex
Magni Black Screw,
26 pcs | | SW1-0041,
5/16 x 18 x 1"
SS Torx Screw,
4 pcs | | WA1-0015,
5/16 x 1" SS
Fender Washer,
4 pcs | | WA1-0005,
5/16" SAE Zinc
Flat Washer,
4 pcs | | SW1-0052,
T-45 Torx Bit,
1 pc |

Hardware Kit Continued:

15.



SW1-0059,
5/16 x 18 x 3/8"
SS Torx Screw,
38 pcs

16.



WA1-0012,
.320 x .700 x .03
SS Washer,
42 pcs

17.



NU1-0019,
5/16-18 Jam Fin.
Nylock Nut,
42 pcs

18.



ET1-0002,
Edge Trim Tool,
1 pc

19.



GP1-0005,
Large Wiper Style
Edge Trim,
324 in

Front & Rear Flare Pocket Hardware Installation

NOTE: Pocket hardware for the Front Bumper Piece is covered later in this instruction set.



Put a Washer (WA1-0012) on each Bolt (SW1-0059).



FRONT MAIN & REAR FLARE ONLY: Put each Bolt/Washer combination through a pocket hole in the flare, Bolt head and Washer on the outside.



FRONT MAIN & REAR FLARE ONLY: Place a Nut (NU1-0019) over the end of each Bolt and tighten, using a 1/2" wrench for the Nut and the supplied Torx Bit (SW1-0052) for the Bolt. Repeat for remaining pockets.

Front Flare & Bumper Piece Installation Procedures (Driver's Side, No Aftermarket Bumper)



Remove three factory screws from the mud flap. Save screws for reinstallation.



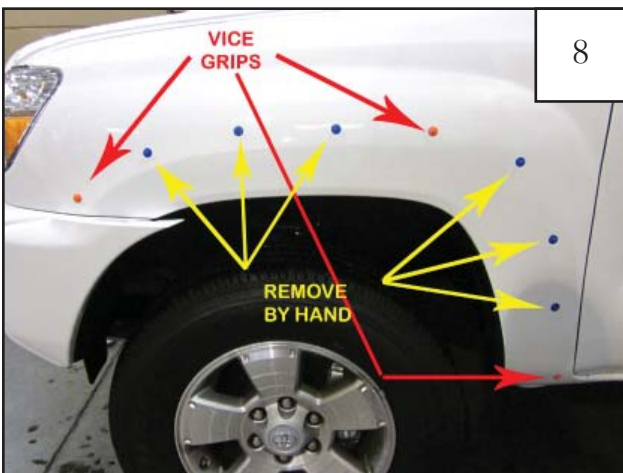
Remove four factory screws from the fender lip. Save screws for reinstallation. Remove flare by pulling part away from side of vehicle.



Using a clockwise twisting motion, remove eight factory plastic clips from fender. See step 8.



Remove one clip from front using vise grips, pulling with a rocking motion. See step 8.



Clip locations.



Remove two factory screws underneath the the front bumper cover.



10

Remove plastic screw located at front of wheel well by turning clockwise 1/2 turn with a flat head screwdriver and prying out



11

Pull down bumper cover and splash shield.
NOTE: Do not re-fasten splash shield until final step.



12

Using a flat head screwdriver, with a pressing motion, remove seven plastic clips located inside of bumper cover. Remove front bumper extension.



13

Slide a supplied Washer (WA1-0005) onto a supplied Hexhead Slot Screw (SW1-0005).



14

Insert the Screw/Washer assembly through the hole drilled in the end of the Front Main Flare and into the corresponding hole in the Front Bumper Piece. Two places.

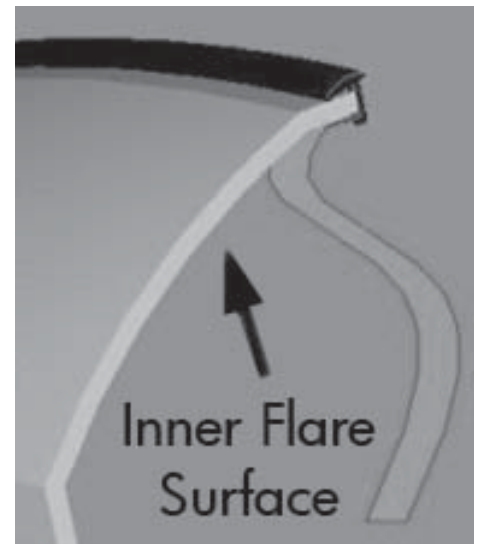


15

Install a supplied Nut (NU1-0011) on ends of screws and tighten

STEP 16 - EDGE TRIM INSTALLATION

- A) Peel two to three inches of red vinyl backing away from Edge Trim (GP1-0005) 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.
- C) Apply Edge Trim to Front Bumper Piece if installing.



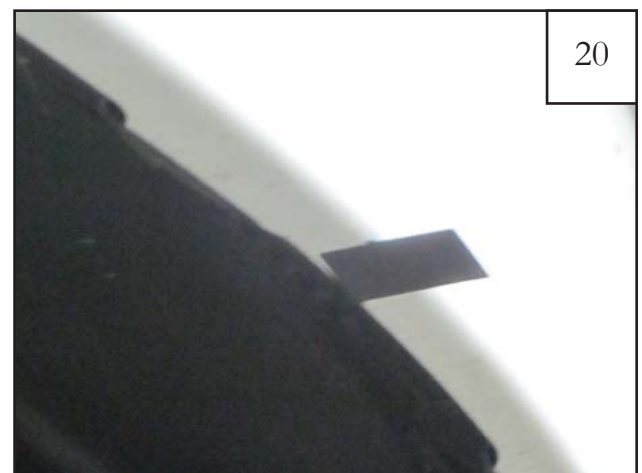
Hold the flare firmly on the fender. Make sure to line up the flare and bumper piece along the style line to ensure correct installation.



Hold the flare firmly on the fender. Using a grease pencil, mark two clip locations using existing holes in flare. See step 19



Clip locations



Remove flare from fender. Stick a supplied 1" Black Tab (MT1-0002) over marks made in step 17.



Place a supplied Spring Clip (CL1-0005) over each Tab.



Reposition flare on fender and install three 20mm hex screws (SW1-0036) through holes in flare and into factory holes



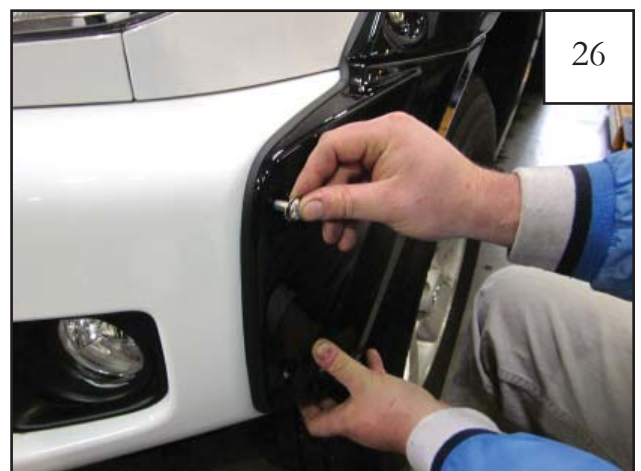
Install a supplied Phillips Truss Screw (SW1-0050) through holes in flare and into Clips installed in Step 21



Drill through holes in bumper piece and into sheet metal with a 5/16" drill bit



Make sure bumper piece is aligned with the style line. Install supplied 20mm hex screw (SW1-0036) into factory hole on front bumper and tighten



Slide a supplied .320 SS Washer (WA1-0012) onto a SS Torx Screw (SW1-0041). Situate flare on bumper, inserting screws through holes drilled in bumper in step 24.



27

Install a supplied SS Fender Washer (WA1-0015) and supplied 5/16" Nylock Nut (NU1-0019) on back of screws installed in step 27 and tighten. (Note: *Tighten from the back*)



28

Pull down bumper cover and slide splash shield back in place. Install supplied hex screw(SW1-00036) in front of bumper cover to fasten splash shield to bumper



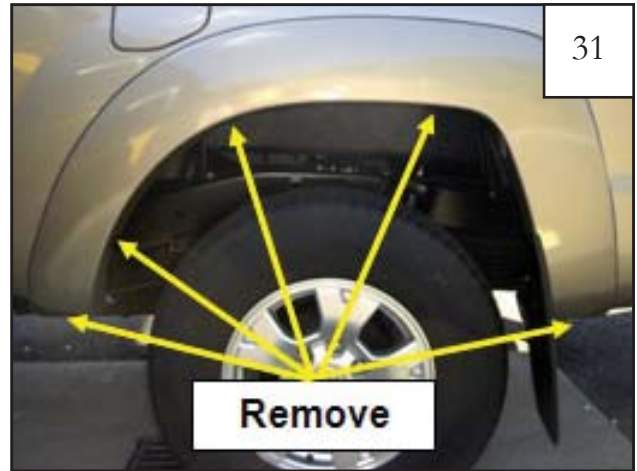
29

Tighten all screws. Completed Front Flare installation

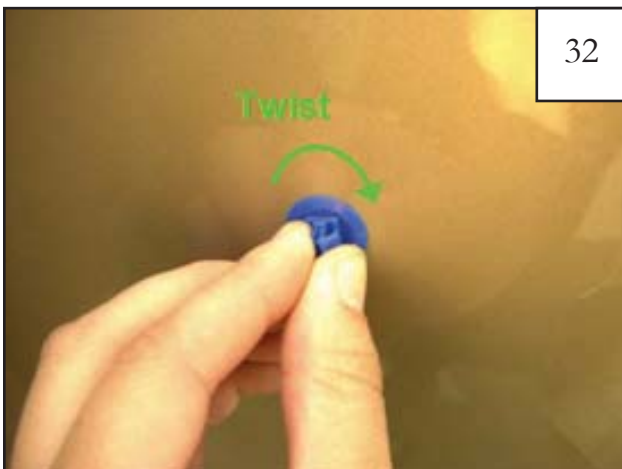
Rear Flare Installation Procedures (Driver's Side)



Remove three factory screws from mud flap. Discard mud flap.



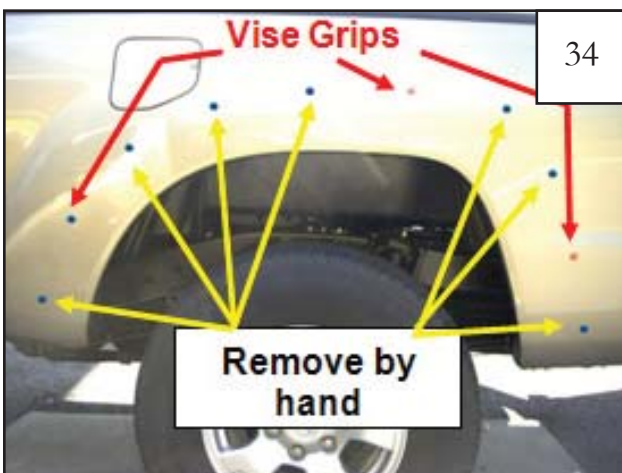
Remove five factory screws. Remove flare by pulling part away from side of vehicle.



Using a clockwise twisting motion, remove eight factory plastic clips from fender. See step 34.



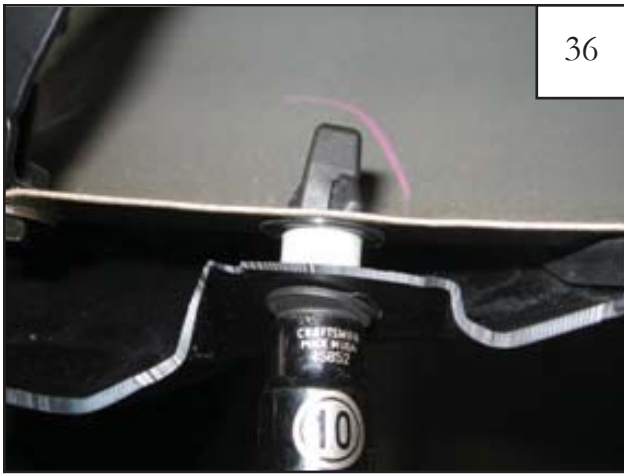
Remove three clips from fender using vise grips, pulling with a rocking motion. See step 34.



Clip locations.



Position flare on fender and install eight supplied hex head screws (SW1-0036) through holes in flare and into factory holes.



36

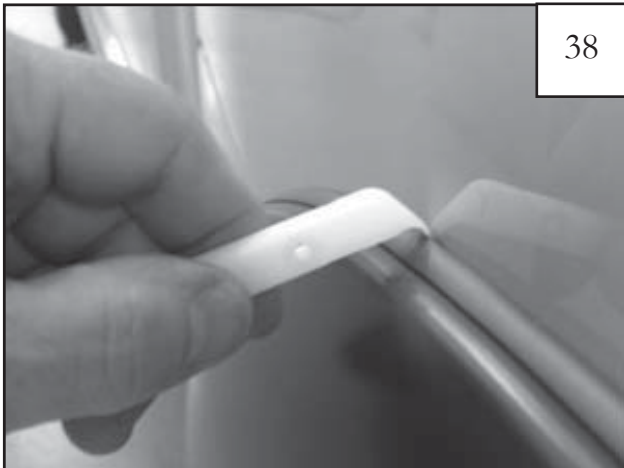
At bottom front of flare, install a supplied Screw (SW1-0036) and a Spacer (SP1-0003).



37

At bottom rear of flare, install a supplied Screw (SW1-0034) and a Spacer (SP1-0008).

Edge Trim Tool Procedures



38

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.



39

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.