



Installation Instructions

Rear Fender Flare

SKU: JL1001

2018 Jeep JL 4 Door

SAFETY

- Your safety and the safety of others is very important.
- In order to help you make informed decisions about safety, we have provided the following warnings, safety precautions, installation instructions, and other important information to alert you to potential hazards that could hurt you or others.
- Please do a job safety analysis before each task to identify potential hazards for your situation and remove/protect against them.
- Use own good judgment and take your time.
- Check packaged materials immediately upon arrival to ensure that all listed parts are included and undamaged.

Read and understand all warnings, safety precautions, and instructions before installing this product.

SENSORS' FIELD OF VIEW WILL BE ALTERED WITH USE OF THE REPLACEMENT BUMPER.

WARNINGS

- **FAILURE TO OBSERVE THE FOLLOWING WARNINGS AND INSTRUCTIONS PROVIDED IN THIS MANUAL COULD LEAD TO SEVERE INJURY AND/OR DEATH.**
- **FOR PROFESSIONAL INSTALLATION ONLY. CARELESS INSTALLATION AND/OR OPERATION CAN RESULT IN SERIOUS INJURY, DEATH, AND/OR EQUIPMENT DAMAGE. ALL LIABILITY FOR INSTALLATION AND USE RESTS WITH THE USER OR CONSUMER.**
- **FAB FOURS, INC. ONLY APPROVES INSTALLING THIS PRODUCT ACCORDING TO THESE WRITTEN INSTRUCTIONS WITH THE HARDWARE PROVIDED. 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.**
- **THIS PRODUCT IS FOR OFFROAD USE ONLY.**





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SAFETY PRECAUTIONS

- Always remove jewelry and wear eye protection.
- Always use extreme caution when jacking up a vehicle for work. Set emergency brake and use tire blocks. Locate and use the vehicle manufacturers designated lifting points. Use jack stands.
- Always use appropriate and adequate care in lifting components into place.
- Always ensure components will remain secure during installation and operation.
- Always wear safety glasses when installing this kit. A drilling operation will cause flying metal chips. Flying chips can cause serious eye injury.
- Always use extreme caution when drilling a vehicle. Always disconnect power before welding. Thoroughly inspect the area to be drilled (on both sides of material when possible) prior to drilling and relocate any objects that may be damaged.
- Always use extreme caution when welding a vehicle. Thoroughly inspect the area to be welded (on both sides of material when possible) prior to welding and relocate any objects that may be a fire hazard. When welding in a cab, make sure the interior surfaces are covered (*e.g.*, welding blanket) and a fire extinguisher is at hand.
- Always use extreme caution when cutting and trimming during fitting.
- Always tighten all nuts and bolts securely per installation instructions.
- Always route electrical cables carefully. Avoid moving parts, components that become hot, and rough or sharp edges.
- Always insulate and protect all exposed wiring and electrical terminals.
- Perform regular inspections and maintenance on mounts and hardware.
- Tire may rub at max turn or articulation.





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Overview

Congratulations on your new purchase of the rear fender flare assembly.

Your fenders were designed in 3-D from digitized data, CNC laser cut, fabricated, and powder coated... all in the U.S.A. Enjoy the fit and finish of a quality rear fender with flare from Fab Fours, Inc.





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I. Tools Required

- Allen wrenches
- Socket set and wrenches
- Drill
- ¼" & 17/32" drill bits
- Anti-seize (recommended)

NOTE: REAR BUMPER MUST BE REMOVED BEFORE YOU PROCEED.

II. Factory Fender Removal

(Perform these steps for both sides.)

1. Remove 6 Christmas tree clips located in the inner fender. Locations shown below.

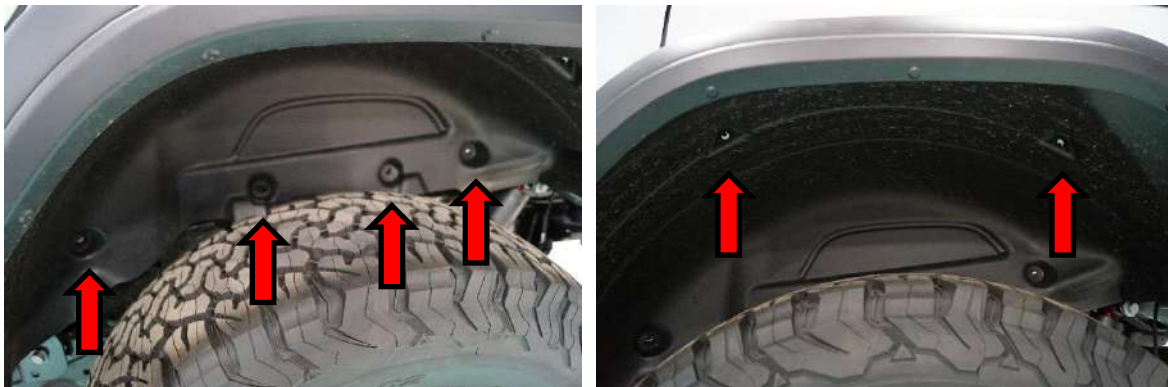


Figure 1a & 1b. Location of plastic clips to be removed.



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2. Once clips are removed. Start by firmly grasping the rear of fender flare and pulling flare outward towards you. This may take a decent amount of pressure and some clips may break during removal.
3. Once stock flare is off the vehicle, use a “push pin” tool to remove the remaining clips that did not come out with the stock flare.



Figure 2. Remove white plastic clips that were left behind by OEM flare removal.

Repeat steps 1 through 3 for passenger side.





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III. Cut Template Installation and Cutting

1. Begin by cleaning the template installation surface with a cloth.
2. Place template **DS 1** on the forward portion of the bodyside surface starting at the bottom and following the edge of the wheel well (see figure 3).
3. Place template **DS 2** on the rear portion of the bodyside surface starting at the bottom and following the edge of the wheel well (see figure 3).



Figure 3. Template placement for DS 1 and DS 2

4. Using a cutoff wheel (or other appropriate cutting tool), cut each template by following the dashed red line indicating the cut profile. There are multiple layers of material in some places that will need to be cut all the way through; once the outer layer of the surface has been cut, keep chipping away at the inner layers following the same profile.
5. Follow cutting with a grinding wheel to clean up all cut edges. Apply rust trap to all cut edges after cleaning up.

Repeat steps 1 through 5 for passenger side.





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IV. Fab Fours Fender Installation

1. Start by drilling out the existing OEM holes (shown below) using the 17/32" drill bit included in the hardware kit. Step up to this size with smaller drill bits and/or use a step bit.



Figure 4. Drilling OEM holes wider to accommodate rivet nuts.

2. Place a rivet nut in each hole and install with the tool included in the hardware; instructions are with tool.
3. Install the body bracket with the 3/8" yellow zinc-plated hardware included.



Figure 5. Body bracket installed with YZ hardware.





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4. With a partner, position the fender by bolting the middle mounting hole to the body bracket with the 3/8" SS hardware; do not tighten fully. Use the 5/16" SS hardware to bolt the lower, forward mounting hole to the existing OEM slot on the pinch seam of the Jeep.

5. Orient the rear of the fender to cradle the contours on the lower portion of the Jeep (see figures 6a & 6b) to correctly position the fender. Clamp at the lower back end when satisfied with the fender position.



Figure 6a & 6b. Initial placement of fender for marking mounting points correctly.

6. With fender base held in place, using a transfer punch, mark the center of the mounting holes. Once holes are marked, remove fender base.



Figure 7. Marking hole locations with transfer punch.





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7. Once fender is removed, you can begin drilling. Start out by drilling all punch marks with a $\frac{1}{4}$ " drill bit. Step up incrementally to the $\frac{17}{32}$ " drill bit for the holes marked in figure 8 (red arrows). Drill the two lower holes out to $\frac{3}{8}$ " (yellow arrows).

8. With all the holes drilled out to $\frac{17}{32}$ " you can now begin installing rivet nuts with the provided rivet nut tool.



Figure 8. All rivet nuts installed and holes drilled. Red arrows indicate holes to drill out to $\frac{17}{32}$ "; yellow arrows indicate holes to drill out to $\frac{3}{8}$ ".

9. Once all rivet nuts are installed you can install the fender base. Start by re-installing the middle bolt and the lower, forward bolt. This will hold the fender on vehicle while you install the rest of the hardware.

10. Install the $\frac{3}{8}$ " SS hardware in the upper rivet nut mount holes first (indicated by red arrows in Fig. 9), then install the $\frac{5}{16}$ " SS hardware in the lower open mount holes (indicated by yellow arrows in Fig. 9). Once all bolts have been mounted, tighten all fasteners.





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Figure 9. Locations for 3/8" SS hardware (red arrows) and 5/16" SS hardware (yellow arrows).

Repeat steps 1 through 10 to install other side.



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V. Maintenance/Care

- Periodically check and tighten all nuts.
- Stripped, fractured, or bent bolts or nuts need to be replaced.



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