

## XJ Off-Road Flare kit



PLEASE READ AND UNDERSTAND ALL INSTRUCTIONS BEFORE YOU BEGIN.

**Note:** Some procedures will be different depending on year and body trim. Please be sure to follow the steps carefully that applies to your model year.

**NOTICE:** Body modification is required for the installation of these flares. Cutting of the body panels is required.

Trimming of body moulding or modification of flares will be needed for a proper fit.

**CAUTION:** Body and eye protection must be worn during installation of the flares.

**Note:**

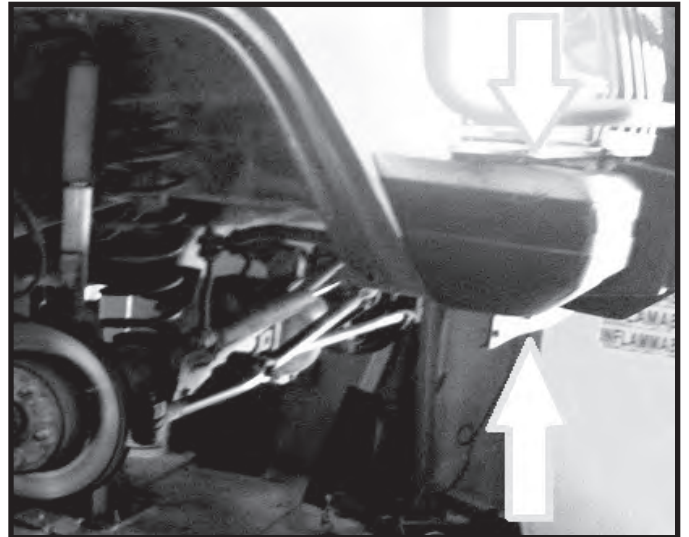
1. Verify fitment of flares to the vehicle. Some sanding or cutting may be necessary to ensure proper fitment.
2. Modifications to exhaust system may be necessary. A minimum of four inches of clearance between flares and exhaust system is required.
3. Bare metal will need to be treated and painted before installation of flares.

Step 1. Remove the factory flares and wheel well liners from the front wheel wells. The flares are held in by 10mm nuts inside and on the ends of the wheel opening.

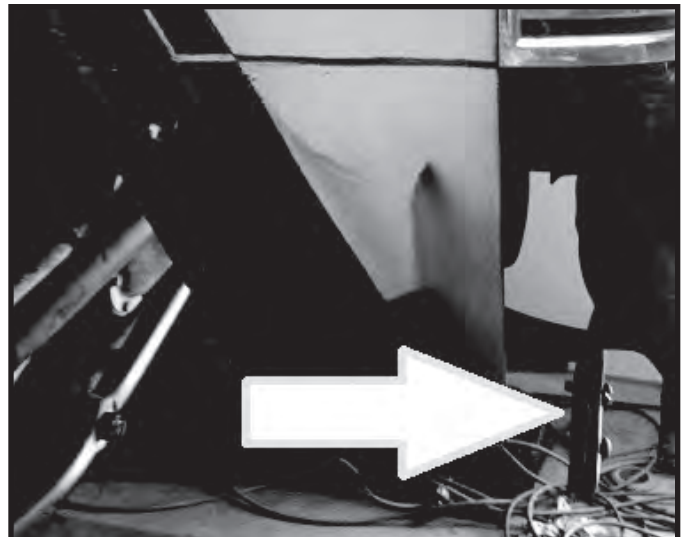


Note: 1984-96 only. 1997-2001 will not need the front section of the fender to be cut.

Step 2. Remove the front bumper end caps. The end caps are held on by one 10mm head bolt on top and bottom and push nut on the back side. Removal is needed for trimming of the front fenders.



Step 3. Unbolt the front airdam from the supports on each front lower section of the fender. The supports will be cut out in later steps.



Step 4. Carefully remove all emblems from the front fenders. Use of a putty knife may be needed. Use caution when removing to prevent damage to the paint. All adhesive will need to be removed before the flares are attached to the vehicle.

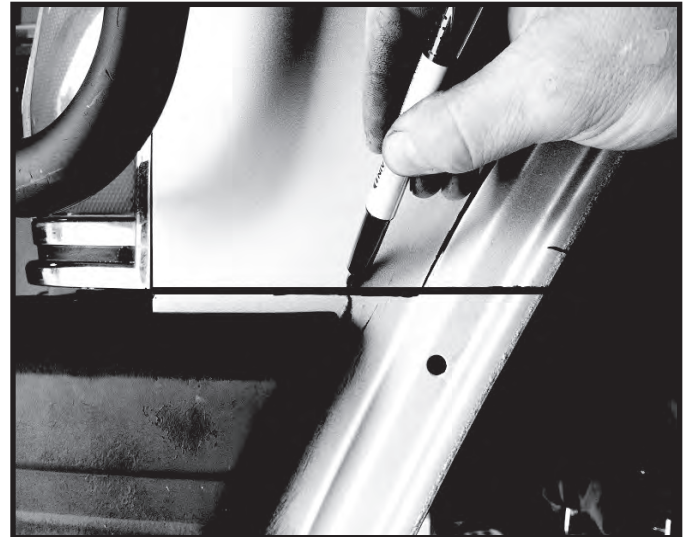


**Note:**

1984-1996: Require steps 5 thru 8 for cutting front fenders.

1997-2001: Do not require cutting.

Step 5. Draw a horizontal line on the front fender starting at the bottom of the front headlight bezel continuing to the edge of the fender well. Repeat for opposite side.



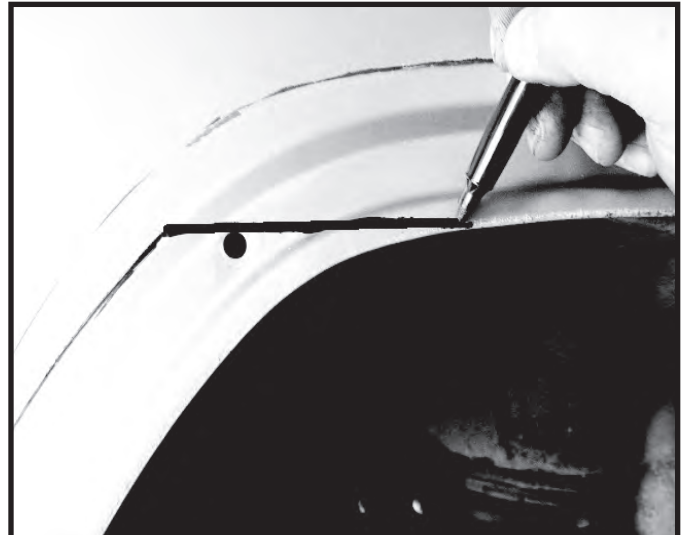
Step 6. Using the line previously drawn measure 5 Inches in towards the wheel well starting from the headlight bezel and place a mark. Repeat for opposite side.



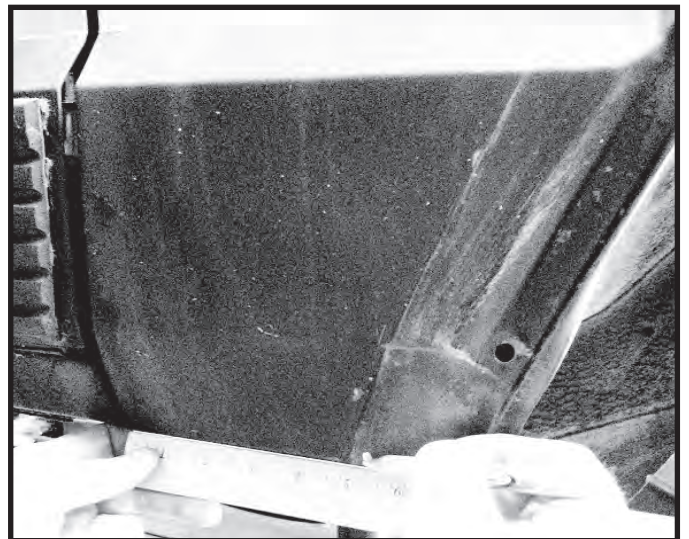
Step 7. Following the contour of the raised area on the fender, trace a line upwards to the top of the third factory mounting hole. Repeat for opposite side.



Step 8. Trace a horizontal line from the previous line in step 7 toward the inside of the fender well at the top of the third factory mounting hole. Repeat for opposite side.



Step 9. Mark a line 5 1/4" from the edge of the fender at the front door jam towards the fender well at the bottom of the vehicle. Repeat for opposite side.



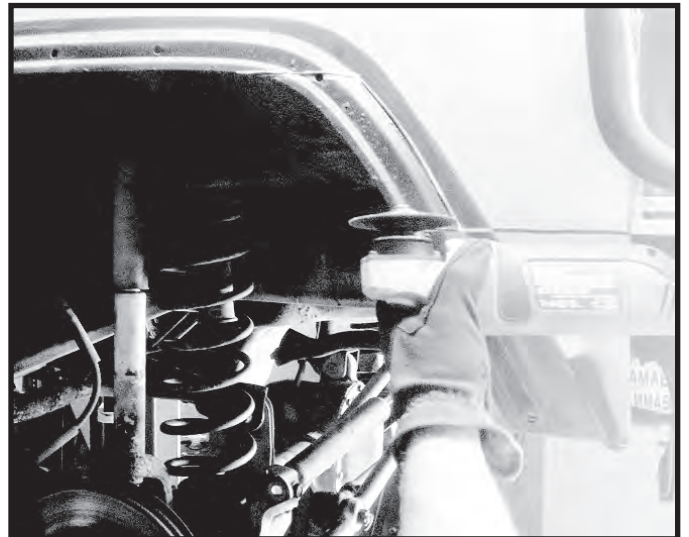
Step 10. Starting at the mark made in the previous step draw a line upward following the contour of the raised area on the fender to the top of the third factory bolt hole. Repeat for opposite side.



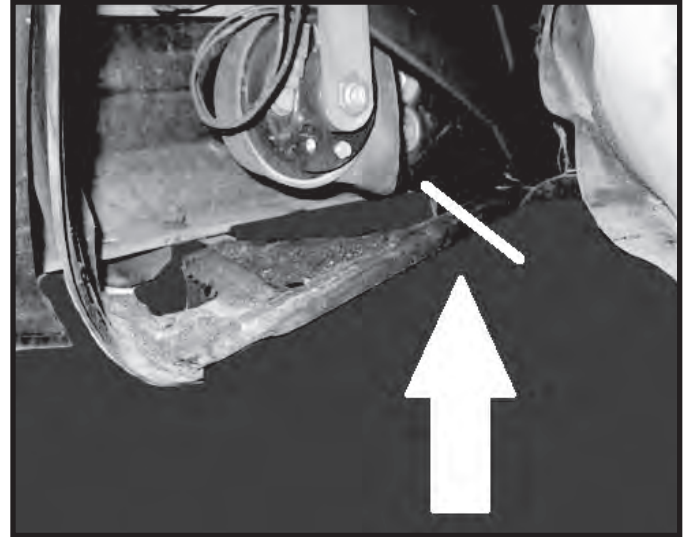
Step 11. Draw a horizontal line from the contour line inward towards the wheel well at the top of the third bolt hole. Repeat for opposite side.



Step 12. Begin trimming the marked areas. Use of an air saw or grinder will be needed. You must wear eye and ear protection when cutting metal. Gloves should be worn when handling sharp metal. Use caution when cutting metal. Do not over cut. Ensure there are no obstructions on the back side of the metal being cut.



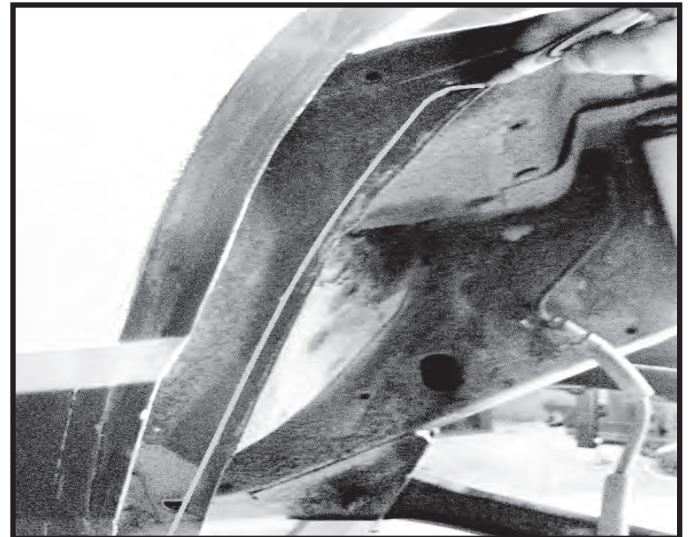
Step 13. Cut the lower fender brace close to the frame. Repeat for both sides.



Step 14. When cutting is finished the front fenders should look like the image. All edges should be smoothed and free of burrs. All exposed metal must be treated before flares are installed.



Step 15. Trim the inner seam at the rear of each front fender well. The inner seam should match the outer cut fender. The cut piece from the outer fender can be used as a template. A sanding wheel should be used to even out the cut areas.



Step 16. Bare metal must be treated. A primer surfacer is recommend before painting.



Step 17. Re-install the front wheel well liners. Mark the front of the liner with a horizontal line starting from the headlight bezel going towards the wheel well. Next trace a line following the cut portion of the fender onto the wheel liner. Trim this area out. Do not trim below the front of the fenders near the bumper, this will be done in the next step.



Step 18. Fold the wheel well liner flap forward near the front bumper. Draw a line on the inside of the liner from the corner of the fender by the marker light diagonally down to the outside of the first mounting hole. Trim on the line that was created. It may be necessary to secure the front area of the liner to the inside of the wheel well.



Note: Depending on the model and year of the vehicle the body trim will vary. On newer models it may be necessary to trim the flare to fit over the body moulding.

Step 19. Hold the flare against the body using slight pressure to check fitment. Some trimming and sanding may be necessary.



1984-1996 models with low profile trim.

Step 20. Mark the area of trim to be cut by pressing the flare against the body in the desired position for mounting.



Step 21. Using a putty knife lift the body trim off of the body enough to cut with a razor knife.

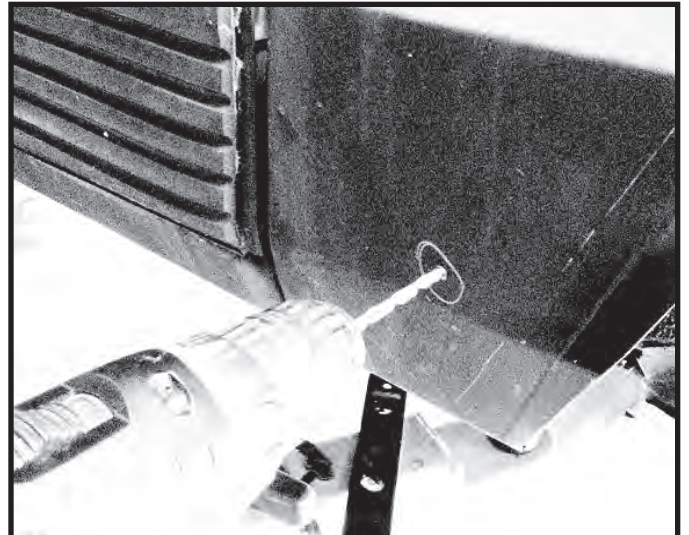




Step 22. Once fitment is complete hold the flares in place and mark the mounting holes on the body using the pre-drilled holes in the flare as a guide.



Step 23. Drill the mounting holes using a 3/16" drill bit.



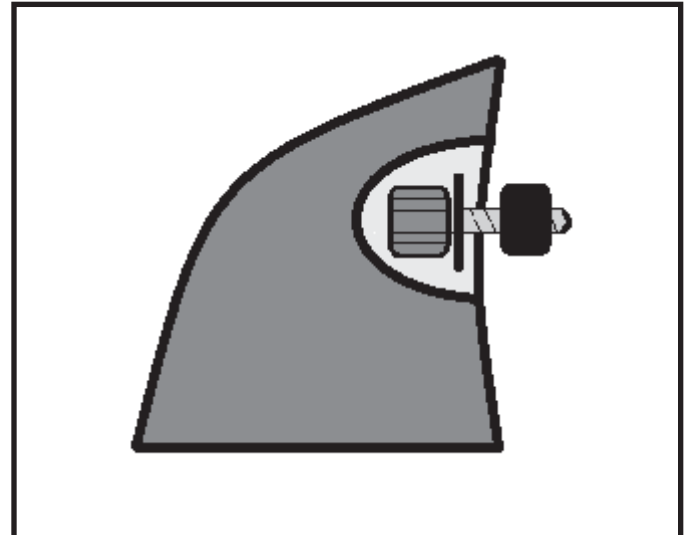
Step 24. Clean inside mounting lip edge with rubbing alcohol. Install edge trim as shown by removing red vinyl tape covering only a few inches at a time. Do not stretch the trim while being applied, this may cause shrinkage after installation.



Step 25. Clean inside mounting lip edge with rubbing alcohol. Install edge trim as shown by removing red vinyl tape covering only a few inches at a time. Do not stretch the trim while being applied, this may cause shrinkage after installation.



Step 26. Place a washer on each bolt and insert them into the pre-drilled holes in the flare. Place a rubber spacer on each bolt on the inside of the flare.

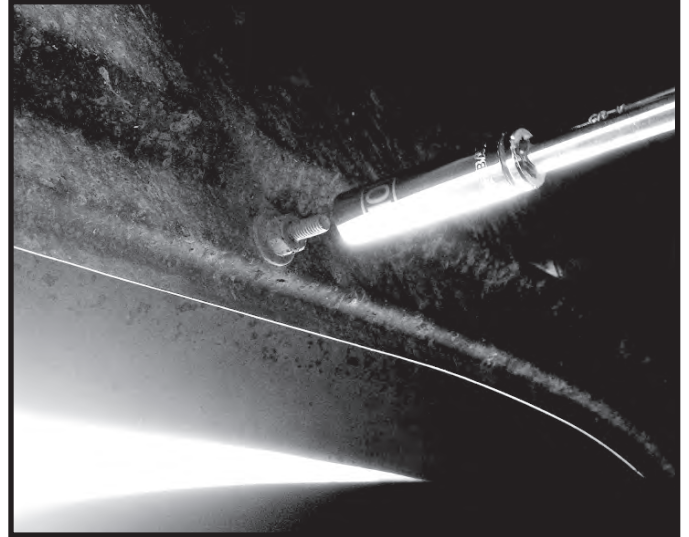


Step 27. Place the flare against the body and align the screws into the drilled holes in the body. Tighten the screws. Do not torque over 24 inch pounds.



## REAR FLARE INSTALLTION PROCEDURES

Step 28. Remove the rear factory flares. The flares are held in by 10mm nuts inside and on the ends of the wheel opening.



Step 29. At the bottom front of the rear wheel well opening measure forward 2 inches and place a mark. Repeat for opposite side.



Step 30. Starting at the mark made in the previous step continue following the contour up maintaing a 2 inch distance from the wheel well. The line shall continue to 1 inch past the door opening. Repeat for opposite side.



Step 31. Mark a vertical line 1 inch from the door edge toward the rear of the vehicle. The line should intersect the line in the previous step and continue down to the wheel opening. Repeat for opposite side.



Step 32. At the bottom of the rear portion of the wheel well housing measure a distance of 1 5/8 inch from the the wheel well towards the rear of the vehicle. Maintaining the same distance trace a line around the wheel well up to the third mounting hole. Draw the line straight down intersecting the mounting hole. Repeat for opposite side.



Step 33. Measure 3/8 inch up from the edge of the fender well and draw a horizontal line along the fender connecting the two lines made in the previous steps. Repeat for opposite side.



Step 34. Cut out the rear fender in the order shown. Starting with #1 area trim the 3/8 inch lip from the fender. Area's # 2, 3 only trim down to the body moulding area. Area # 5 only cut the outer skin in this area. See next steps for areas # 4, 5. Repeat for opposite side.



Step 35. Cut area # 4 carefully. Start by cutting 3/8 inch from the line and grind the rest of the way. A filler putty or silicone is needed to fill the gap between the sheet metal. Repeat for opposite side.



Step 36. Cut area # 5 in steps. Trace a line following the contour of the raised flare out of the body. Trim only the outer skin in the area outlined. The remaining area should be cut through both layers and removed. Repeat for opposite side.



Step 37. Fold the metal flap created to close the gap between the inner and outer sheet metal. All edges should be smoothed and free of burrs. All exposed metal must be treated before flares are installed. A filler putty may be used to seal the area. Repeat for opposite side.



Step 38. Install the dog leg shaped trim piece on the door edge. At the rear door opening fit the trim against the body. Secure the trim in place with the supplied self tapping screws. Use the dimples in the plastic as guides for the screws. Do not overtighten. Repeat for opposite side.



Note: Depending on the model and year of the vehicle the body trim will vary. On newer models it may be necessary to trim the flare to fit over the body moulding.

Step 39. Refer to steps 19 thru 27 for flare mounting procedures.



Step 40. The kit comes with additional self tapping screws that if desired may be used in the area indicated for additional securement.



Step 41. Use of the trim tool may need to be used on any parts of the trim that have been misaligned during installation. To seat the trim against the body, the curved side will be used. To seat the trim side against the flare the flat side will be used. It may be necessary to start at one end and run the tool the full length of the flare.

