



Part No. 8873, 8874 or
Part No. 8893, 8894 or
Part No. 9103, 9104 or
Part No. 9113, 9114

Rear Fender Flares
Flat Panel Design
2007-12 Jeep JK, 2/4 Dr.



PLEASE READ INSTRUCTIONS THOROUGHLY BEFORE PROCEEDING

We have provided complete instructions and specific hardware, brackets, and fasteners. The list of these items is listed on the last page of the instructions.

--Before starting please verify that they are included with the shipment.

Also, verify that you received the correct part(s). All part numbers are embossed on the inside of the urethane component(s).

Tools & general materials required: drill, a 25/64" drill bit, 1/4" and 11mm socket, socket wrench, 15mm box wrench, Phillips screwdriver, and various hand tools.

THERE ARE THREE PHASES TO MOST INSTALLATIONS:

- 1) Removal of factory parts and then **TEST FIT** the parts
- 2) Preparation of the parts for paint--and painting (optional)

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- 3) Installation of the parts

PHASE 1) REMOVAL & TEST FIT

-REMOVAL: Remove the black plastic wheel liner and save. Remove the factory fender flares.

TEST FIT the parts to verify excellent fit

DO NOT PREP, DRILL OR PAINT THE PARTS UNTIL THIS IS DONE.

NOTE: Occasionally, our urethane parts might seem to be slightly distorted upon test fit. If so, place them in the sun drilled side down (if a warm day) or in a warm area for an hour or more and they should return to their original shape.

Set the wheel liner back onto the Jeep. Using a light colored grease pencil and using the edge of the steel wheel opening as a guide mark the wheel liner from front to back (See Figure #1). Remove the liner.



Figure #1- This photo shows the driver's rear fender liner marked for trimming. The view is of the front part of the liner.

Trim the wheel liner where marked with a razor blade knife and clean up the trimmed edges with 150 grit sandpaper.

The picture below illustrates the driver's side rear liner trimmed. The photo is taken from the inside of the liner.



PHASE 2) PREPARATION OF URETHANE PART(S) FOR PAINTING (July, 05): This process is following an approved Sherwin Williams process and materials. Consult your paint supplier for equivalent materials and / or processes.

****NOTE:** If the flares are not going to be painted protect them with a good anti UV dressing such as:
303 Protectant www.303products.com

- WASH the paintable surfaces and the tape ledge w/ heavy duty detergent degreaser i.e...Castrol purple stuff, Palmolive liquid dish soap or red hot and USP90 scuff gel, using a gray scuff pad until the part is dull and then rinse thoroughly.
- SAND across item with 400 grit or finer and check for imperfections and repair as needed.
- RE-WASH with heavy detergent degreaser and USP90 scuff gel using gray scuff pad to remove any residue. Rinse thoroughly and wipe dry with a lint free towel.
- APPLY mashing tape on top of the parts that have a tape ledge (consult Xenon instructions-they will indicate if the part is going to be installed utilizing adhesive tape as part of the installation process).
- WIPE item down using SC159 plastic and anti-static cleaner with lint free towel.
- SPRAY item with UPO7227 plastic adhesion promoter.
- SPRAY item with P30 sealer base coat then clear coat.
- DO NOT oven bake our parts above 100 degrees F. They should be well supported during any heat cycle to avoid the flexible part from warping.

PHASE 3) INSTALLATION OF THE PART(s) (perform in a warm area above 70 degrees)

NOTE: Some people will prefer to black paint the part of the steel body below the mounting holes so that no body color shows where our fender flares mount. IF that is your choice be sure to mask off above the center line of the mounting holes and prepare the surface of the steel body per the paint manufacture's recommendations and then paint.

There are 11 points of attachment of each rear flare to the body. Except for the top 2 holes (located at approximately 12 o'clock high) carefully drill out the other existing nine body holes with a 25/64" size drill where the stock fender flare clips where attached. LOCATE the expendable tool, #AA184-20, the ¼

x 20 x 3/4" stainless steel bolts, 3/4" stainless steel fender washers and the #ALS420165 1/4-20 rivet nuts. Review the instructions supplied with the expendable tool. The expendable tool nut has a smooth end and the other end of the nut has a ring groove on it. The bolt goes through the smooth end. Thread onto the bolt the rivet nut and finger tighten. -INSTALL the rivet nut into the 9 enlarged holes using a box wrench holding the tool nut. With an 11mm socket wrench turn the bolt clockwise until you cannot turn it anymore using moderate torque. This causes the rivet nut to compress against the inside of the body hole and provides a secure point to attach the 1/4 x 20 x 3/4" bolts when you install the flares (again, see the instructions that come with the expendable tool). Now remove the 1/4-20 bolt from the rivet nut. Install all 9 rivet nuts (per each side). See Figures #4 & #5.



Fig. #4- Showing the rivet and the Expendable Tool



Fig. #5- Shows the tools needed to install the 1/4-20 rivet nut

-INSTALL fender flare (where rivet nut is installed) using the 1/4 x 20 x 3/4" bolts and the fender washers at all locations where 7 rivet nuts are installed except the top two next to the mounting holes that do not have the rivet nuts installed. Do not tighten yet. Install the 1/4 x 20 x 1 1/2" bolt and washer into mounting hole #5 and #7 at the top of the wheel well. Now install the 1/4 x 20 x 1 1/2" bolts, washers and nylon lock nuts at the top two holes on each rear flare and tighten. Now tighten all bolts. -INSTALL the trimmed rear fender liners with the supplied (8) Christmas tree fasteners. They secure the liner at the same points as the factory does.

PART NUMBER(S): 8873 and 8874, 8893 and 8894, 9103 and 9104, or 9113 and 9114

Rear fender flares, Flat Panel Design, 1.5" wider than stock

-or- 1.5" less width than stock

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HARDWARE PROVIDED: (14) - Christmas tree fasteners, (14)- 1/4-20x 3/4 Stainless Hex Head bolts

(8) 1/4 x 20 x 1 1/2" stainless bolts, (26)- 3/4" fender washers, stainless

(4)- 1/4" x 20 nylon lock nuts,

(1)- #AA184-420 expendable tool, (18)- #ALS420-165 1/4"-20 rivet nut

(2) left and right support panels, #88933 and #88944 (Kit #88930) for parts 8873, 8874 or 8893 and 8894

-OR- (2) left and right support panels, #91033 and #91034 (Kit #91030) for parts 9103 and 9104 or 9113 and 9114

(4)- Pages of Instructions

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