



Installation Instructions:

(Part # SB77837)
JL XRC FLAT FLARE

NOTE: Carefully read entire instructions thoroughly before attempting to install this part.
Chock all 4 wheels if doing install without removing wheels.

| Parts Included | Qty | ID |
|------------------------------|-----|----|
| Driver Side Front Fender | 1 | |
| Passenger Side Front Fender | 1 | |
| Driver Side Rear Fender | 1 | |
| Passenger Side Rear Fender | 1 | |
| Smittybilt air outlet covers | 2 | |
| Rubber Trim | 4 | |
| Threaded Plated | 19 | |
| Nutsert Tool | 1 | |
| Nutserts | 12 | |
| M6 X 25mm BHCS | 34 | |

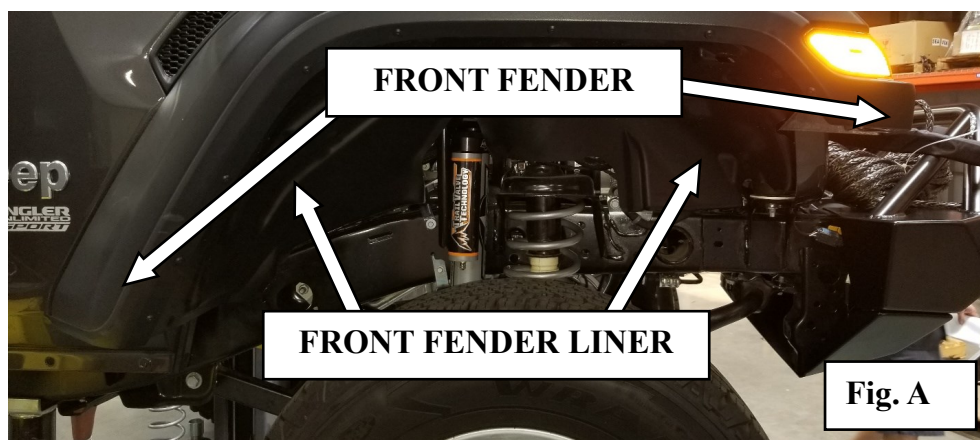
| Parts Included | Qty | ID |
|----------------------|-----|----|
| M6 X 15mm BHCS | 4 | |
| M6 Washer | 42 | |
| M6 Nuts | 8 | |
| M6 Split Washers | 34 | |
| M8 X 25mm Hex Bolts | 2 | |
| M8 Oversized Washers | 2 | |
| M8 Lock Washer | 2 | |
| M8 Washer | 2 | |
| M8 Nuts | 2 | |

INSTALLATION:

Step 1: Break your front wheel lugs loose, place your floor jack under the front axle and raise the vehicle. Place jack stands under the front axle and lower the vehicle onto the jack stands. Remove the jack and remove the front wheels.

Step 2: Starting on one side of the vehicle, remove your O.E fender liner, remove (7) plastic retaining clips using body clip pliers or a flat-head screw-driver and remove (3) 10mm bolts (Fig. A-D).

NOTE: *The fender liner will come off with the fender as one assembly.*



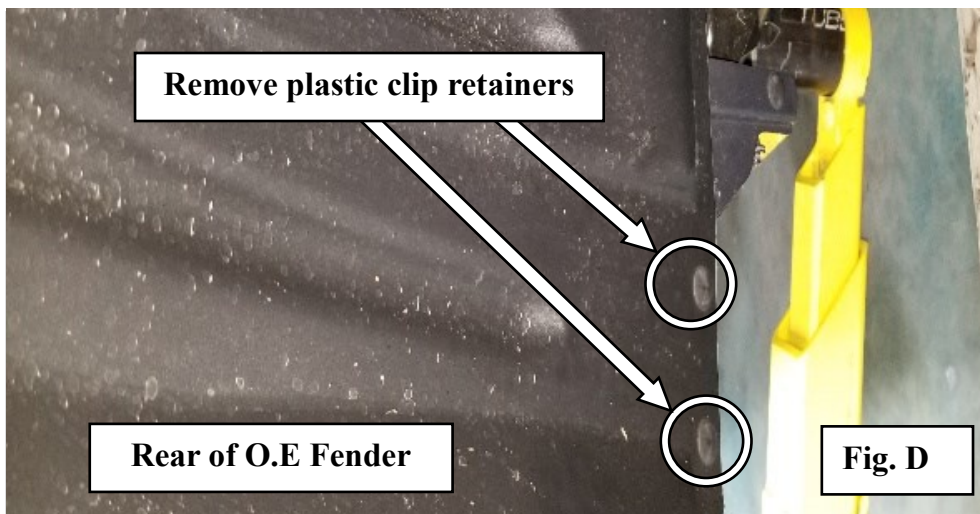
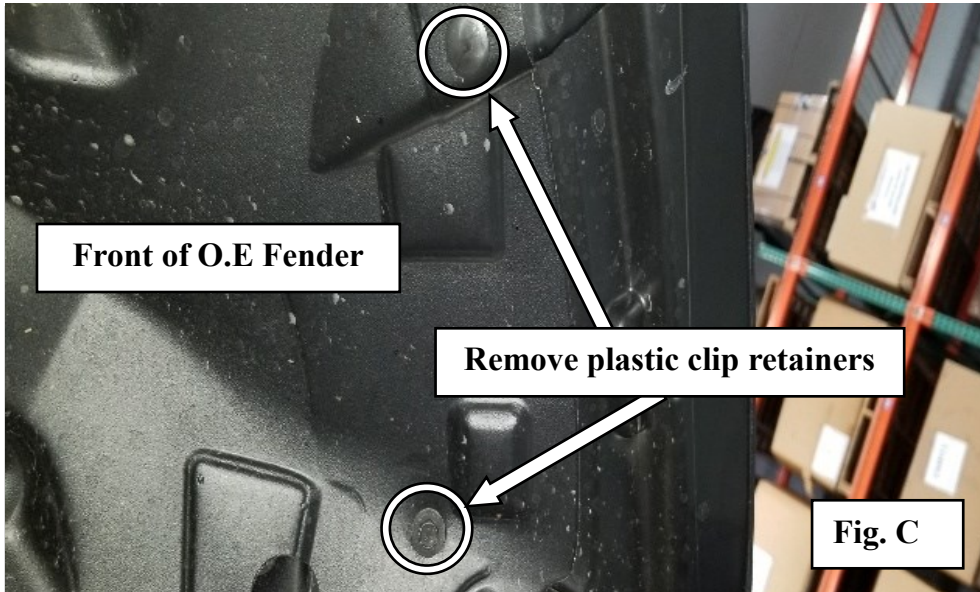
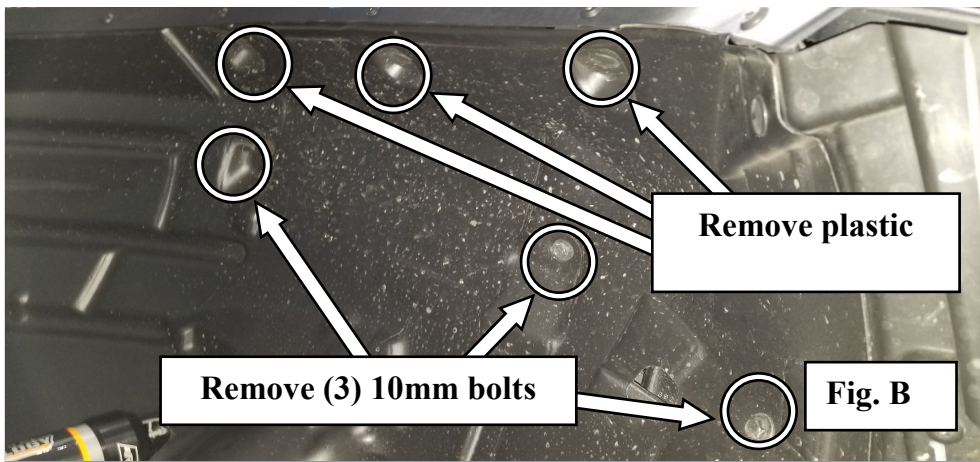
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JL XRC FLAT FLARE



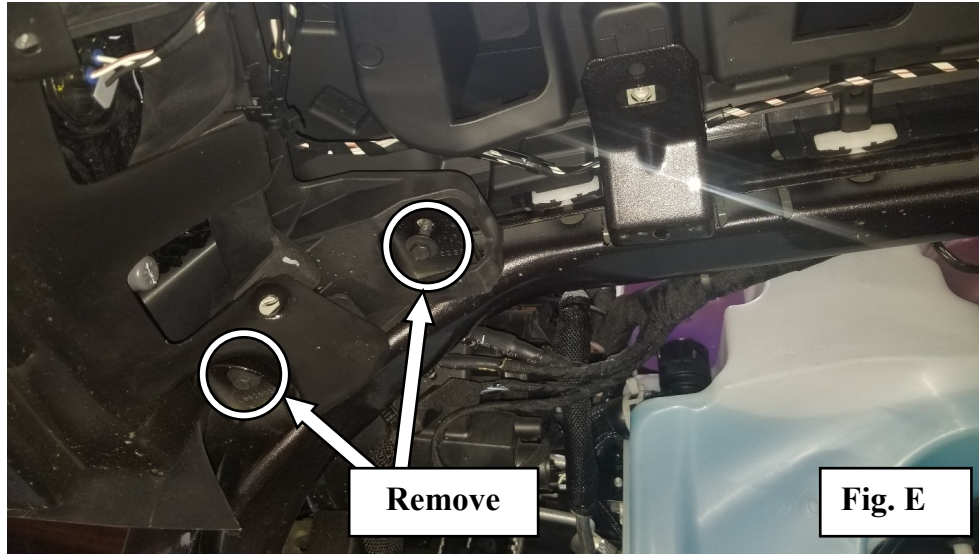
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(Part # SB77837)
 JL XRC FLAT FLARE

Step 3: Disconnect the front turn signal connector from the O.E fender. With the fender liner out of the way Remove the **(2) 10mm** O.E bolts located behind the turn signal bezel securing the O.E front fender in place (**Fig. E**).



Step 4: With the O.E hardware removed, remove your O.E fender and fender liner. Starting from the front working toward the rear, pull firmly outward to remove the fender from the body of the vehicle (**Fig. F**).



NOTE: *You will hear cracking/ popping noises, this is normal, it's from the clips snapping (they will not be reused).*

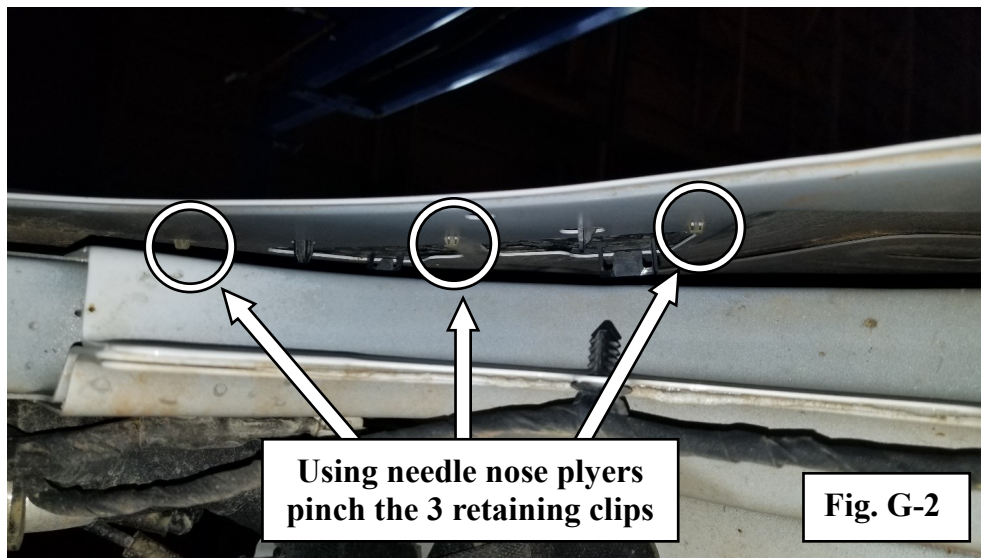
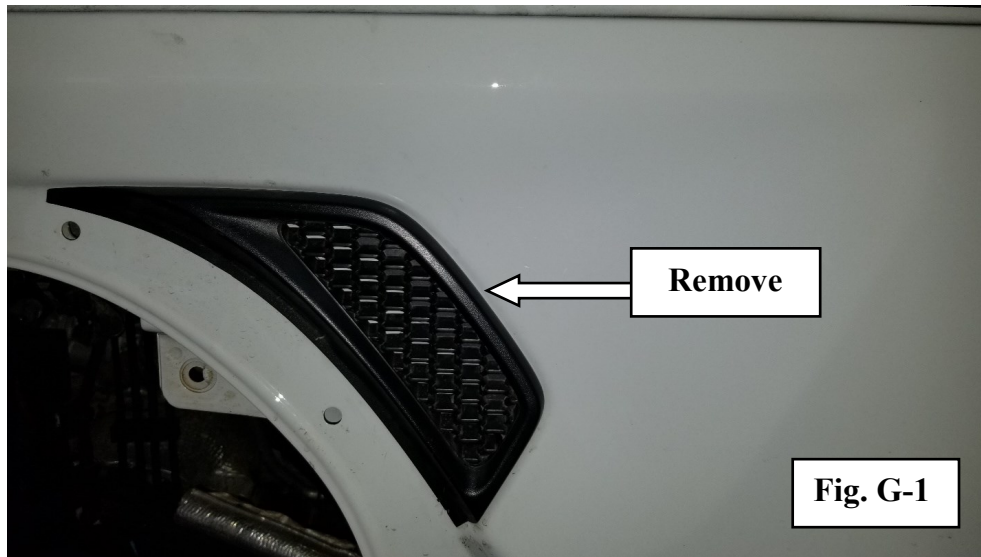
Step 5: Remove the O.E front fender air outlet plate, using needle nose pliers, pinch the three plastic clips behind the body panel (**Fig. G-1 & G-2**).

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JL XRC FLAT FLARE



Step 6: With the O.E fender and fender liner removed; you will now have to cut three of the four mounting brackets for the O.E fender using a grinder with a cut off wheel, Cut the mounts flush to the body panel, Deburr and round off any sharp corners to prevent injury (Fig. H).

NOTE: *It is strongly recommended to wear the proper protection equipment I.E; Safety glasses, face shield, Ear plugs and gloves.*

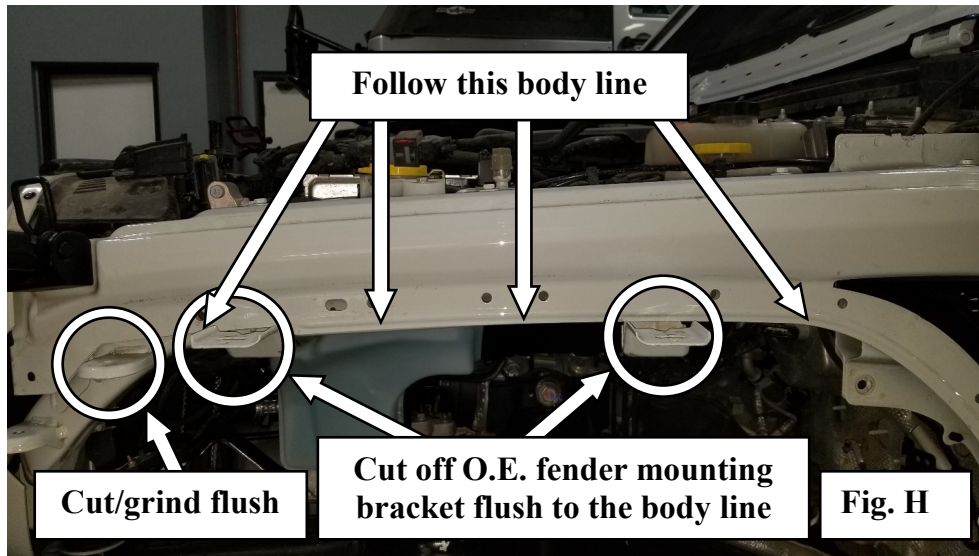
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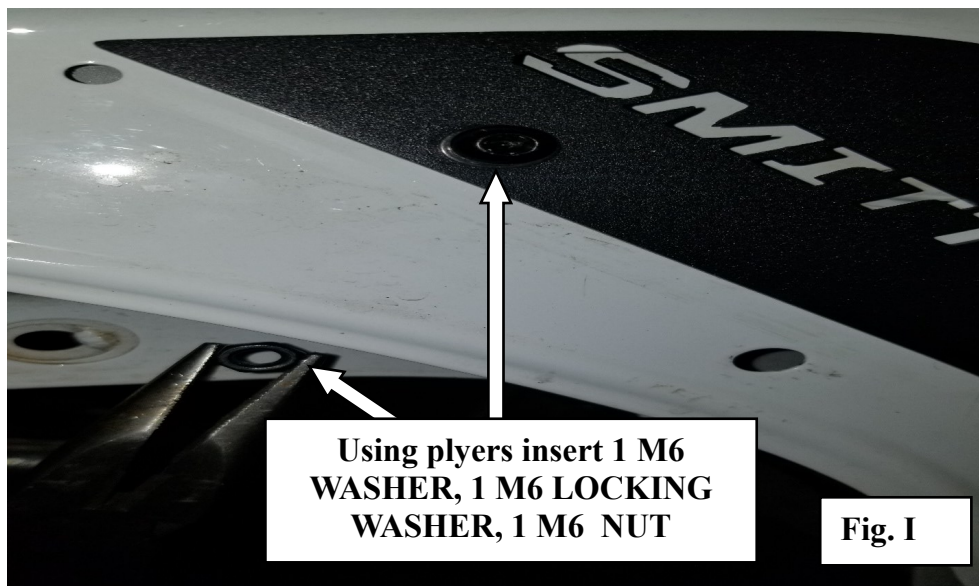
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JL XRC FLAT FLARE



Step 7: It is now time to install your new **XRC Flat Fender**, install the provided Smittybilt front fender air outlet plate in the O.E location using the provided M8 hardware (**Fig. I**).



Step 8: Moving to the fender install the provided rubber trim to the back edge of the fender. Trim off any excess rubber (**Fig. J & K**).

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Installation Instructions:

(Part # SB77837)

JL XRC FLAT FLARE



Step 9: With a helper install the **XRC Flat Fender**, start by lining up the fender with the O.E body panel holes, loosely install two of the provided M6 bolts with the nut plate on the back. Loosely install the remaining hardware to the fender (**Fig. L**).

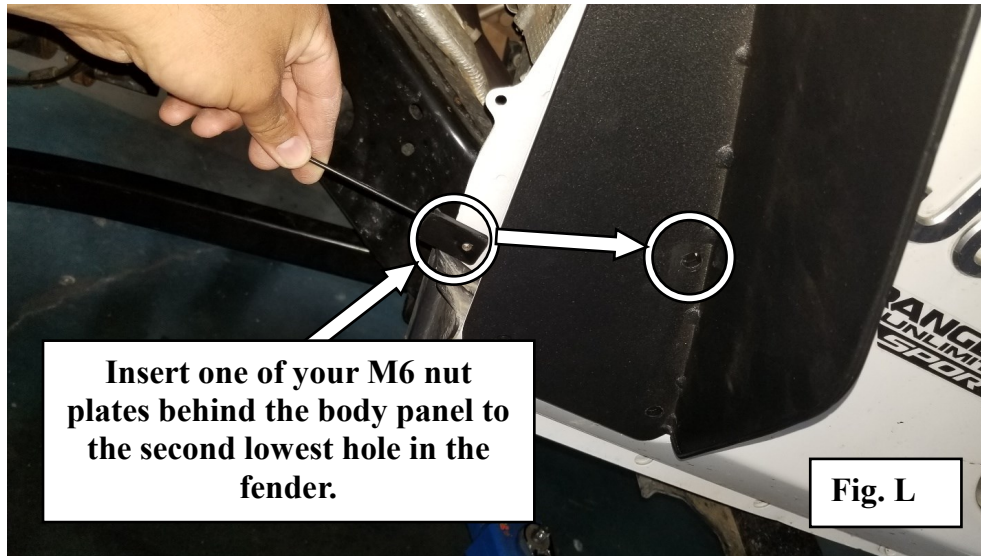
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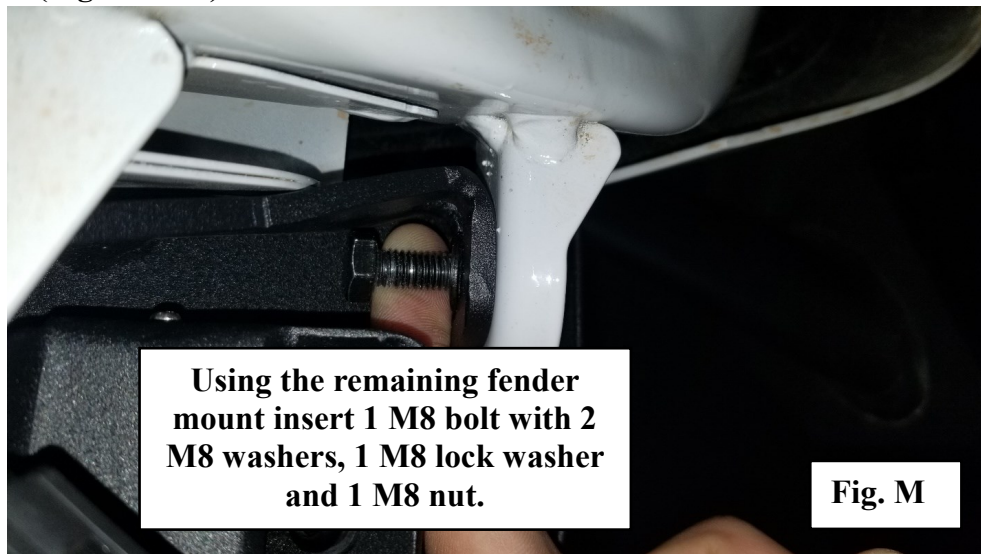


Installation Instructions:

(Part # SB77837)
JL XRC FLAT FLARE



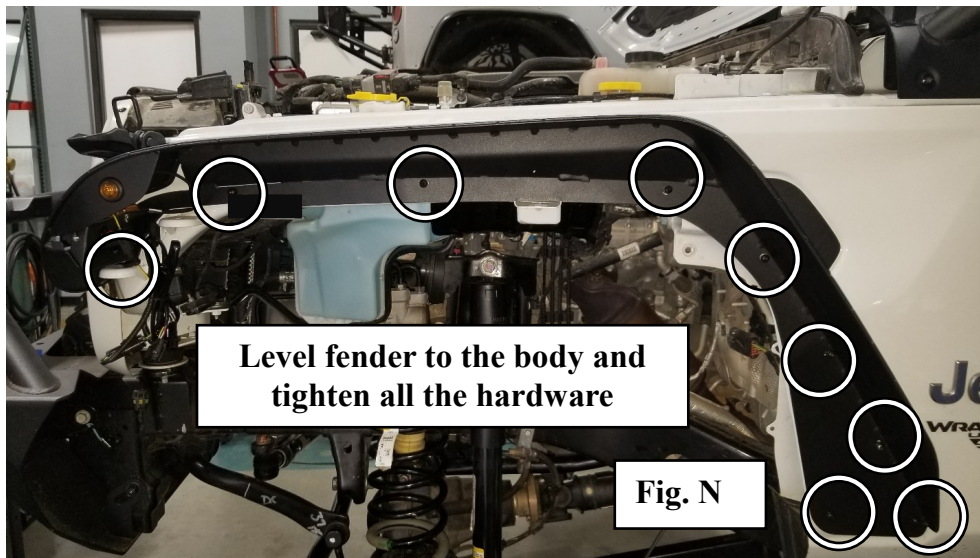
Step 10: With all the hardware loosely installed, level your **XRC Flat Fender** and secure all the hardware and connect the provided turn signal to the O.E turn signal wire harness on the vehicle zip tie wires away from any moving parts (**Fig. M & N**).



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Installation Instructions: (Part # SB77837) JL XRC FLAT FLARE



Step 11: Repeat **STEP 3-10** on the remaining side of the vehicle to complete the installation of your **XRC Flat Fenders**.

Step 12: Reinstall the front wheels and lower the vehicle to the ground. Torque the wheels to factory specifications.

Step 13: Installation of front fender is now complete (**Fig. O**).



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(Part # SB77837)
 JL XRC FLAT FLARE

Step 14: Break your rear wheel lugs loose, place your floor jack under the rear axle and raise the vehicle. Place jack stands under the rear axle and lower the vehicle on to the jack stands. Remove the jack and remove the rear wheels.

Step 15: Starting on one side, remove (9) plastic clips to loosen your O.E fender liner (Fig. P & Q).



Fig. P



Fig. Q

NOTE: *The fender liner will come off with the fender as one assembly.*

Step 16: To remove the fender, start from the front working toward the rear, pull firmly outward to disconnect the fender from the body of the vehicle (Fig. R).

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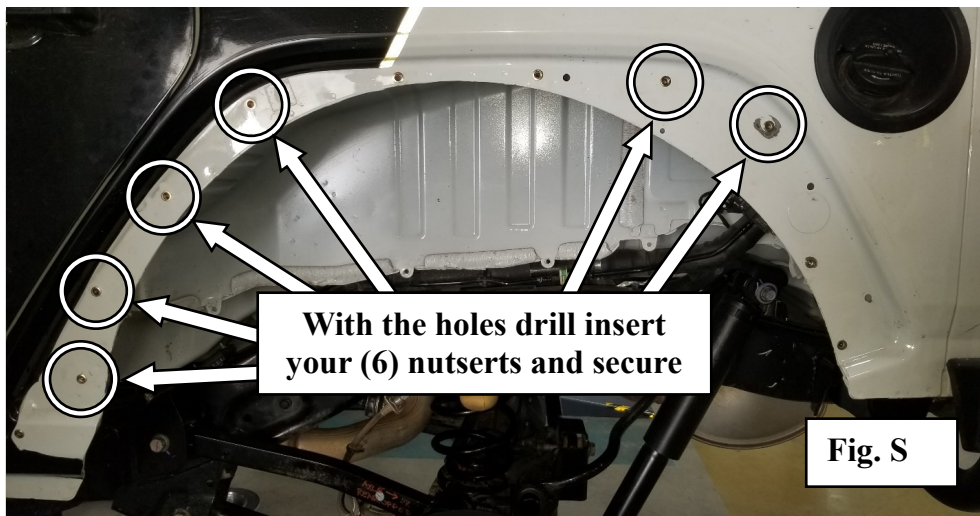
(Part # SB77837)
JL XRC FLAT FLARE



NOTE: *You will hear cracking/ popping noises, this is normal, it's from the clips snapping (they will not be reused).*

Step 17: With the O.E fender and fender liner removed; you will now have Drill out (6) of the O.E mounting holes using a size **W** drill bit to accept the provided nutserts. Installing the nutsert to the now drilled holes, it should be a tight fit (Fig S).

NOTE: *If the nutsert is loose in the hole it will not work properly. For easier, faster installation use SMITTYBILT NUTSERT TOOL (2834).*



NOTE: *When drilling, it is strongly recommended to use proper protection equipment I.E; safety glasses, face shield, and gloves. Deburr from drilling.*

Step 18: With the (6) holes drilled, insert your nutserts. Using the provided nutsert tool secure the nutserts to the body (Fig T).

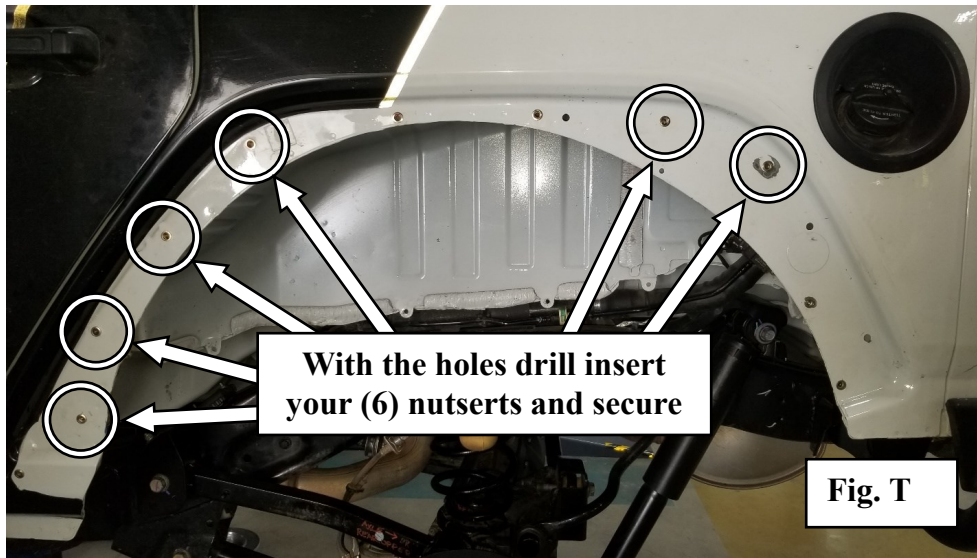
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Installation Instructions:

(Part # SB77837)

JL XRC FLAT FLARE



Step 19: On a flat covered surface, Install the provided rubber trim to the back edge of the fender. Trim off any excess rubber (**Fig. U**).



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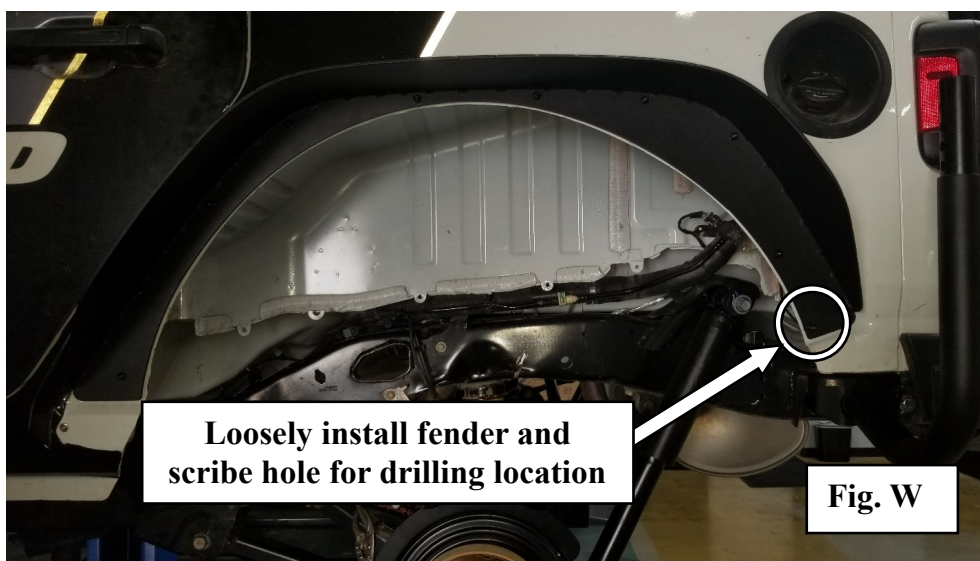
Installation Instructions:

(Part # SB77837)
 JL XRC FLAT FLARE

Step 20: With an another person install the **XRC Flat Fender**, start by lining up the fender with the O.E body panel holes, loosely install (2) of the provided M6 bolts into your previously installed nutsert. Loosely install the remaining hardware to the fender (**Fig. V**).



Step 21: With all the hardware installed, scribe the remaining hole. Remove your **XRC Flat Fender**, center punch and drill a pilot hole. After the pilot hole is drilled use your **W** drill bit and drill the hole (**Fig W & X**).

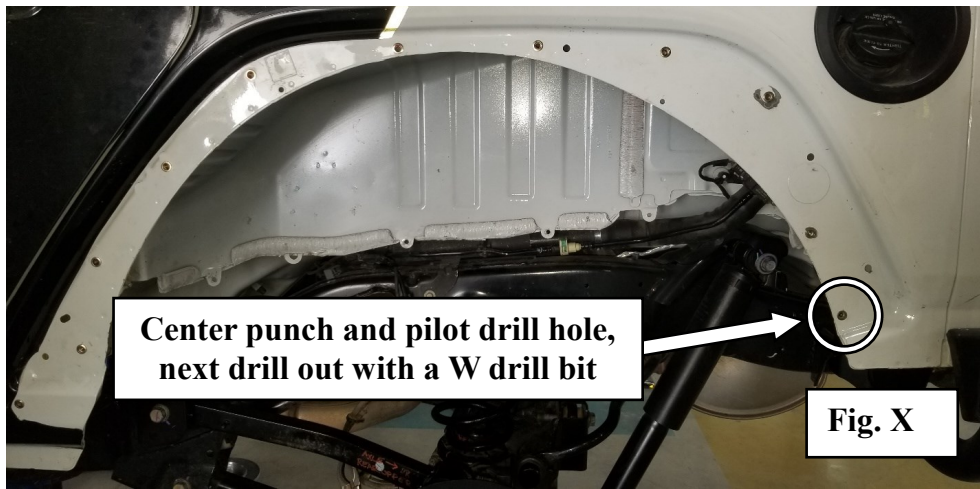


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Installation Instructions:

(Part # SB77837)
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Step 22: With an another person reinstall the **XRC Flat Fender**, start by lining up the fender with the O.E body panel holes, loosely install (2) of the provided M6 bolts with washers and the nut plate on the back. Loosely install the remaining hardware to the fender. level the fender with the body line and secure all your hardware (**Fig Y**).



Step 23: Repeat **STEPS 15-22** to complete the installation of your **XRC Flat Fenders**.

Step 24: Reinstall the rear wheels and lower the vehicle to the ground. Torque the wheels to factory specifications.

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Installation Instructions: (Part # SB77837) JL XRC FLAT FLARE

Step 25: Installation of the rear fender is now complete (**Fig. Z**).



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Smittybilt, 400 W Artesia, Compton, CA 90220



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(Part # SB77837)
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Use this only as a guide for hardware without a called out torque specification in the instruction manual.

| Bolt Torque and ID | | | | | | |
|----------------------------------|---------|---------|----------------------|-----------|------------|------------|
| Decimal System | | | Metric System | | | |
| All Torques in Ft. Lbs. Maximums | | | | | | |
| Bolt Size | Grade 5 | Grade 8 | Bolt Size | Class 9.8 | Class 10.9 | Class 12.9 |
| 5/16 | 15 | 20 | M6 | 5 | 9 | 12 |
| 3/8 | 30 | 45 | M8 | 18 | 23 | 27 |
| 7/16 | 45 | 60 | M10 | 32 | 45 | 50 |
| 1/2 | 65 | 90 | M12 | 55 | 75 | 90 |
| 9/16 | 95 | 130 | M14 | 85 | 120 | 145 |
| 5/8 | 135 | 175 | M16 | 130 | 165 | 210 |
| 3/4 | 185 | 280 | M18 | 170 | 240 | 290 |

1/2-13x1.75 HHCS

Grade 5 Grade 8
(No. of Marks + 2)

D T L X

M12-1.25x50 HHCS

P

D T L X

G = Grade (Bolt Strength)
 D = Nominal Diameter (Inches)
 T = Thread Count (Threads per Inch)
 L = Length (Inches)
 X = Description (Hex Head Cap Screw)

P = Property Class (Bolt Strength)
 D = Nominal Diameter (Millimeters)
 T = Thread Pitch (Thread Width, mm)
 L = Length (Millimeters)
 X = Description (Hex Head Cap Screw)

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Product cleaning and maintenance instructions

Stainless Steel Finish – Aluminum polish may be used to polish small scratches and scuffs on the finish. Mild soap, window or glass cleaner may be used to clean the finish. Dual state powder coat finish – Mild soap, window or glass cleaner may be used to clean the finish. In order to protect the finish, you may wax your product on a regular basis with pure carnauba automotive wax. Do not use any types of soap, polish or was that contains abrasive that could damage the finish. Textured coated finishes should be cleaned with a mild soap on a damp sponge. Do not apply polish or was that requires to be removed by means of buffing. This type of wax is commonly used at car wash facilities. Chrome Finish – Mild soap, window or glass cleaner may be used to clean the finish. In order to protect the finish, you should wax your product on a regular basis with pure carnauba automotive wax. Do not use any types of soap, polish or was that contains abrasive that could damage the finish.

Limited Warranties

Smittybilt's products are covered under the following limited warranties only. Note that the duration of the limited warranty differs according to the material and finish of the product purchased. Subject to the duration and conditions of the limited warranty stated below, Smittybilt warrants to the original retail purchaser that its products are free from defects in material and workmanship. All other warranties and representations express or implied, are hereby disclaimed, including fitness for merchantability and buyer's intended use or purpose. All parts are sold "AS IS" except for the limited warranties granted herein. Buyer assumes all risks as to the selection, suitability and performance of all goods and products selected. This limited warranty does not cover damage or impairment in any part due to misuse, improper installation, accident or contact with on-road or off-road hazards, product modification, improper or inadequate cleaning and/or maintenance. Smittybilt is not responsible for items damaged during shipping. This warranty is not transferable from the original buyer. For the original Buyer to be eligible for the limited warranty coverage, the Buyer must provide proof of purchase. Smittybilt strongly recommends returning the warranty registration card.

Customer's remedy hereunder shall be limited only to repair or replacement (at Smittybilt's option) of any defective part(s) returned to Smittybilt at customer's expense. The determination of whether or not a returned part is defective or subject to coverage under the limited warranties stated herein shall be made at Smittybilt's sole discretion.

To assure product quality, Smittybilt reserves the right to change product design, material, specification and finishes without prior notice to customers. This limited warranty gives you specific legal rights and you may also have other rights, which may vary from state to state. Some states do not allow limitations on how long an implied warranty lasts, so the above limitations may not apply as to you. Also, some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitations or exclusions may not apply to you. Smittybilt reserves the right to discontinue product lines and substitute products or provide other remedies than those listed in this limited warranty for those discontinued products.

Warning

Rollover and other types of vehicle accidents may result in serious injury or death to you, your passengers and others sharing the road. Smittybilt accessories are decorative and are not intended to reduce or avoid injury or damage in the event of an accident. The weight and location of Smittybilt accessories may affect your vehicles' handling, stability and performance, creating an increased risk of accident or rollover. Before installing any accessory, check state laws and assure that the accessory will not obscure any lights or interfere with proper operation on your vehicle's safety equipment. Consult your owner's manual and the Smittybilt instructions, or additional safety information. Smittybilt products, nor the warnings contained herein, are not a substitute for your safe driving. Don't drink and drive, always use seat belts and don't drive faster than conditions permit.

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