



# FENDER FLARES

Assembly, Installation, Operation,  
and Maintenance Instructions

<b>PART NUMBER</b>	<b>TFF3008S</b>
<b>INSTALL TIME</b>	<b>2-3 HOURS</b>

## VEHICLE FITMENT

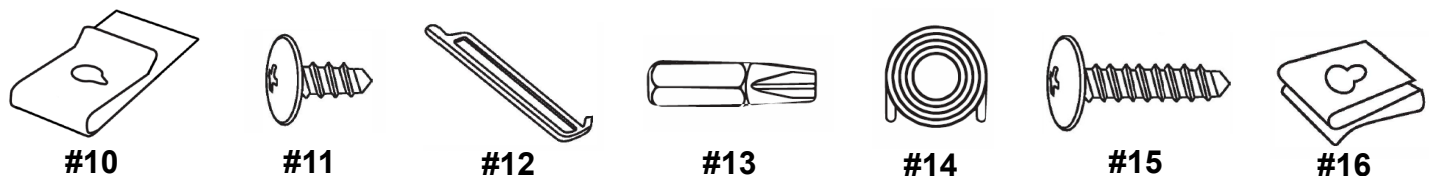
<b>VEHICLES</b>	<b>2023-2024 FORD F250/F350</b>
<b>DEALER / INSTALLER</b>	Provide a copy of these instructions to the end user of this product. These instructions provide important operating and safety information. Demonstrate the proper use of the product with the end user. Have the end user demonstrate that they understand the proper use of the product.
<b>END USER</b>	Read and follow all instructions included in this manual. Ask your Dealer / Installer for assistance if you do not understand the proper use of the product. Never remove any informational or warning labels from the product. Failure to follow these instructions can result in injury or death.

## TOOLS REQUIRED (NOT INCLUDED)

UTILITY KNIFE	#2 PHILLIPS DRIVE BIT
7/32" SOCKET	SOCKET WRENCH
GREASE PENCIL OR MARKER	10mm SOCKET
ELECTRIC DRILL	1/4" DRILL BIT
1/2" WRENCH	

## PACKAGE CONTENTS

ITEM	PART DESCRIPTION	QTY
1	LEFT & RIGHT FRONT FLARES	1
2	LEFT & RIGHT REAR FLARES	1
3	LEFT & RIGHT FRONT INNER PIECES	1
4A	5/16"-18 STAINLESS STEEL SCREWS	34
4B	5/16"-18 BLACK STEEL SCREWS	34
5	5/16" STAINLESS STEEL WASHERS	34
6	5/16"-18 STAINLESS STEEL LOCKNUTS	34
7	1/4" BLACK NYLON RETAINERS	2
8	SHORT U-CLIPS	6
9	1" X 1.5" BLACK TABS	10
10	LONG U-CLIPS	8
11	#10 X 5/16" TRUSS HEAD SCREWS	2
12	EDGE TRIM TOOL	1
13	TORX BIT	1
14	RUBBER EDGE TRIM	1
15	#10 X 5/8" TRUSS HEAD SCREWS	14
16	S-CLIPS	2



## WARNINGS/SAFETY PRECAUTIONS



Use safety glasses and gloves as necessary when operating power tools.

Dirt and debris may become lodged between the fender flares and the vehicle's fenders, causing scratching and paint wear from vibrations. Keystone Automotive Operations, Inc. is not responsible for any vehicle damage, and customer accepts all associated risks.

Do not over-tighten any screws. Over-tightening may result in stress fractures in the fender flares.

### PRIOR TO INSTALLATION:

Thoroughly clean installation area on the vehicle.

Verify contents of box.

Read instructions thoroughly.

Use caution to avoid scratching the fender flare and vehicle.

Verify proper fitment of fender flares to the vehicle. If the vehicle has oversized tires, ensure that the fender flares will not interfere with the tires. It may be necessary to lower bump stops or install steering stops.

Do not use alternative installation methods or materials, such as superglue or Loctite.

If applicable, remove existing fender flares and mud flaps.

Verify that installed fender flares will maintain at least 4 inches of clearance from exhaust pipes. Exhaust gases that discharge onto fender flare surfaces will cause heat distortion and may require modifications to remedy.

### PAINTING (OPTIONAL):

**NOTE:** Painting is optional and should only be attempted on fender flares with smooth outer surfaces. Fender flares with textured outer surfaces should not be painted. Painted fender flares cannot be returned.

1. Clean fender surface with a high-quality degreaser.

**NOTE:** Do not use any solvent-based product such as lacquer thinner.

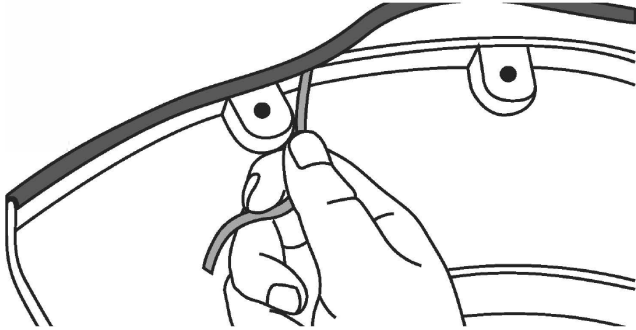
2. Wipe surface thoroughly with a tack rag.

3. Paint fender flares with a high-quality paint lacquer, enamel, or polyurethane automotive paint.

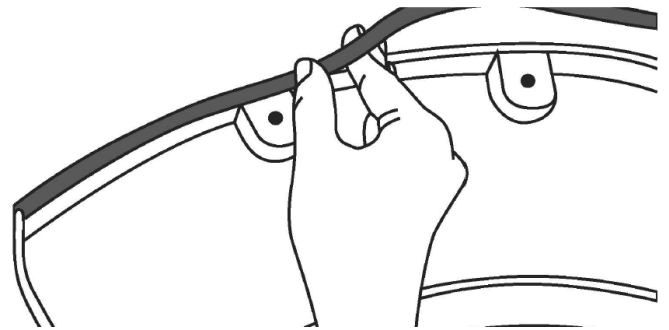
4. If painting edge trim (not recommended), use a flex additive.

## EDGE TRIM INSTALLATION

1. Peel 2-3 inches of red tape liner away from the edge trim tape (#14). Apply the adhesive surface of the edge trim to the inner surface of the flare. Install edge trim to the outside perimeter of the fender flare (the portion that physically contacts the vehicle). **(IMAGE 1)**
2. Press the edge trim into place along the top edge of the fender flare while simultaneously pulling away the red tape liner. Continue to work along the entire outside perimeter of the fender flare. **(IMAGE 2)**



**(IMAGE 1)**



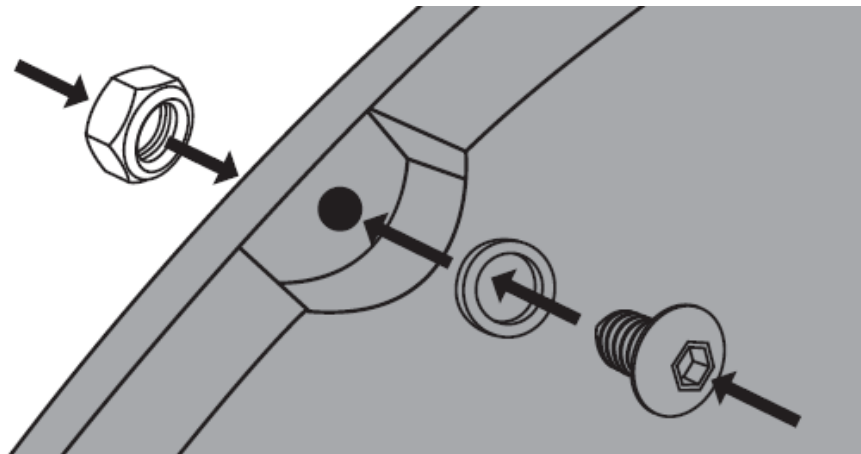
**(IMAGE 2)**

3. Cut the rubber edge trim to length when the installation is complete.
4. Repeat steps 1-3 for each fender flare.

## COSMETIC SCREW INSTALLATION

Install a 5/16"-18 screw (#4A or #4B) and washer (#5) into each pocket hole along the outer edge of the fender flare. Secure with a locknut (#6) using a wrench and Torx bit (#13). Repeat for each fender flare. **(IMAGE 3)**

**NOTE:** Cosmetic 5/16"-18 screws are provided in both stainless and black steel finishes. You may use whichever finish you prefer.

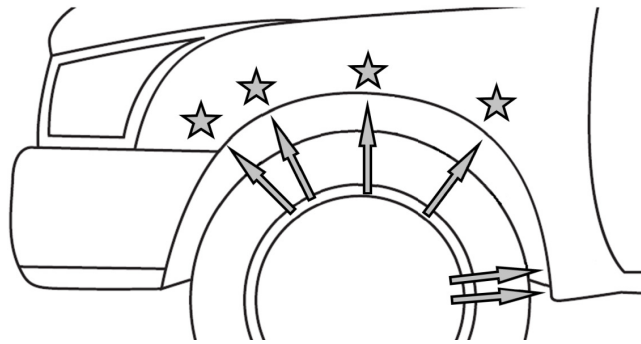


**(IMAGE 3)**

## FRONT FLARE INSTALLATION

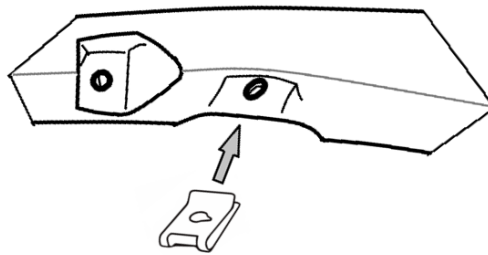
1. Remove and save six (6) original factory bolts using a 7/32" socket. These bolts are located where indicated. **(IMAGE 4)**

**NOTE:** On Platinum models, after the factory flare is removed, some additional screws must be removed and saved.



**(IMAGE 4)**

2. Attach three (3) short U-clips (#8) to the inner piece (#3) as shown. **(IMAGE 5)**



**(IMAGE 5)**

3. Line up the holes in the inner piece (#3) with the four uppermost factory holes (which are marked with a star in **IMAGE 4**).

**NOTE:** Left inner piece is marked with "LR" and right inner piece is marked with an "RR".

4. Using a 7/32" socket, install four original factory bolts that were saved during step 1 through the holes of the inner piece (#3) and through the original vehicle holes as applicable.

5. Position the front fender flare (#1) in place to line up the holes on the flare and the short U-clips (#8) on the inner piece (#3). Loosely install three (3) #10 x 5/8" truss head screws (#15) through the flare and the U-clips on the inner piece. Do not tighten.

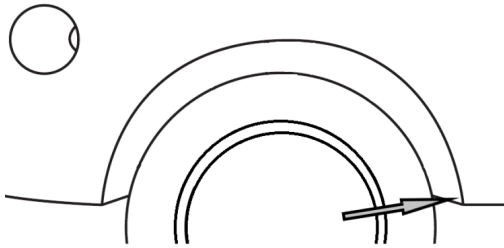
6. While continuing to hold the fender flare in place, reinstall remaining original factory bolts that were removed during step. The remaining holes are those shown in **(IMAGE 4)** which are not marked with a star.

7. Tighten all screws.

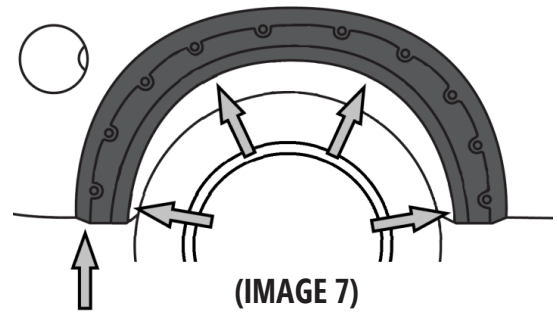
8. Repeat steps 1-7 for the remaining front fender flare.

## REAR FLARE INSTALLATION

1. Remove one (1) original factory bolt using a 10mm socket. This bolt is located where indicated nearest to the rear of the vehicle. **(IMAGE 6)**
2. Hold the flare in position against the vehicle with moderate pressure. Using a marker or grease pencil, mark the five positions where each fender flare hole is located along the lip of the wheel well. **(IMAGE 7)**



**(IMAGE 6)**



**(IMAGE 7)**

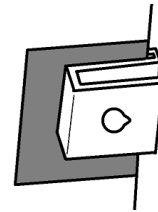
3. Remove the flare and install a 1" x 1.5" black tab (#9) centered over each of the five (5) marked locations. **(IMAGE 8)**
4. Slide a long U-clip (#10) onto each of the four uppermost black tabs. **(IMAGE 9)**
5. For the location marked at the lower front portion of the rear wheel well, slide an S-clip (#16) over the black tab. **(IMAGE 10)**



**(IMAGE 8)**



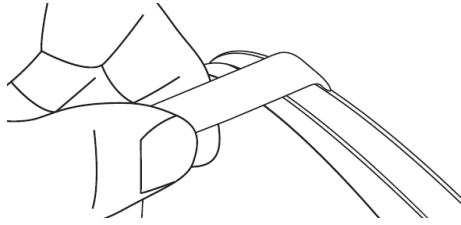
**(IMAGE 9)**



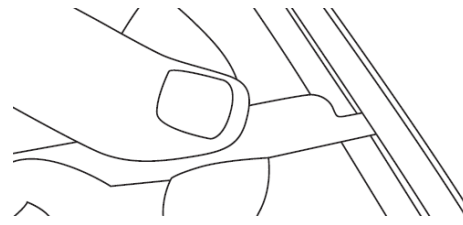
**(IMAGE 10)**

6. Hold the fender flare in position and loosely install #10 x 5/8" truss head screws (#15) through the four topmost holes in the rear fender flare (#2) and through the aligned long U-clips (#10). Then loosely install a #10 x 5/16" truss head screw (#11) through the remaining flare hole and through the S-clip. Tighten all five truss head screws evenly.
7. Install a black nylon retainer (#7) through the flare and the factory hole nearest to the rear of the vehicle as indicated in **(IMAGE 6)**.
8. Repeat steps 1-7 for the remaining rear fender flare.

**NOTE:** The edge trim tool (#12) may be used after fender flare installation is complete to improve fitment as illustrated. **(IMAGES 11, 12)**



**(IMAGE 11)**



**(IMAGE 12)**

## **WARRANTY INFORMATION**

### **Limited Lifetime Warranty:**

Keystone Automotive Operations (KAO) warrants this product to be free of defects in material and workmanship at the time of purchase by the original retail consumer. KAO disclaims any other warranties, express or implied, including the warranty of fitness for a particular purpose or an intended use. If the product is found to be defective, KAO may replace or repair the product at our option, when the product is returned prepaid, with proof of purchase. Alteration to, improper installation, or misuse of this product voids the warranty. KAO's liability is limited to repair or replacement of products found to be defective, and specifically excludes liability for any incidental or consequential loss or damage.

## **CONTACT US**

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