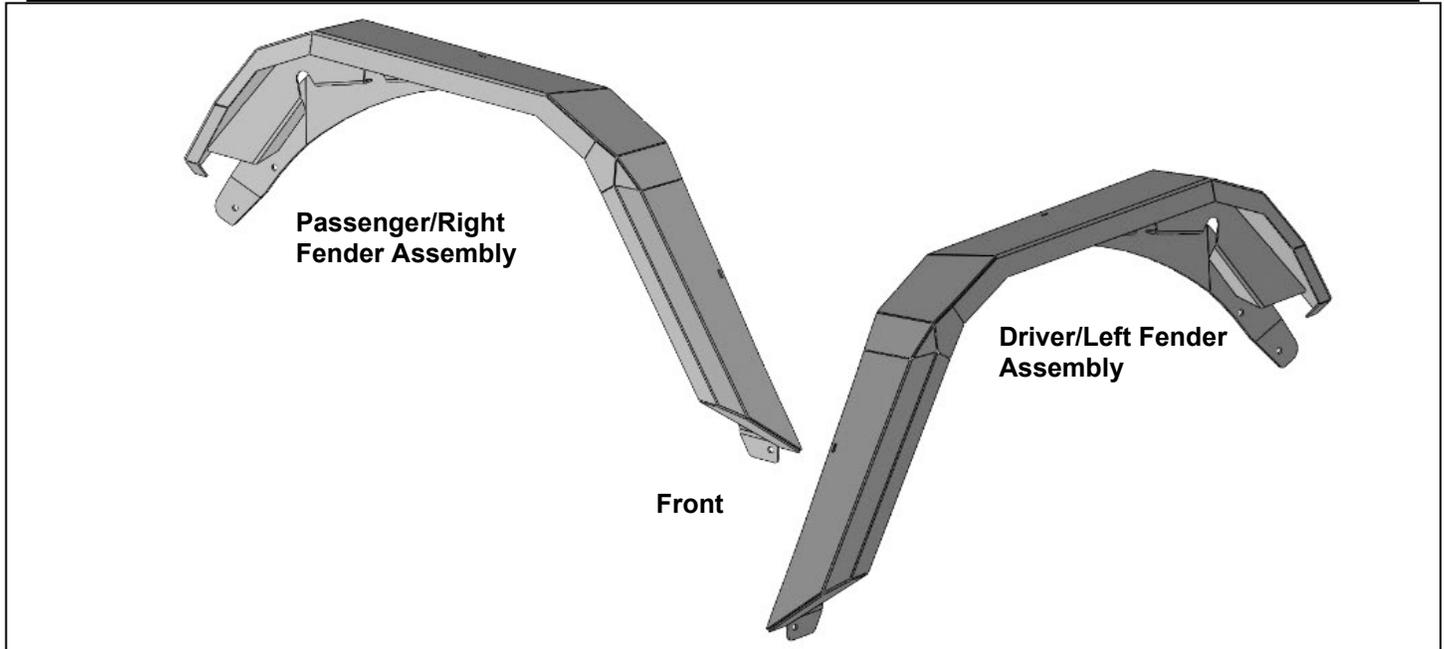


2019-2020 Jeep Wrangler JL Rear Fender Flares PART #JL-6103

PARTS LIST:

1	Driver/Left Rear Fender	22	6mm Lock Washers
1	Passenger/Right Rear Fender	28	6mm x 18mm OD x 1.6mm Flat Washers
2	Rubber Strips	6	6mm Hex Nuts
1	6mm Threaded Insert Tool	22	6mm Threaded Inserts
22	6-1.0mm x 25mm Button Head Bolts	1	4mm Hex Wrench



PROCEDURE:

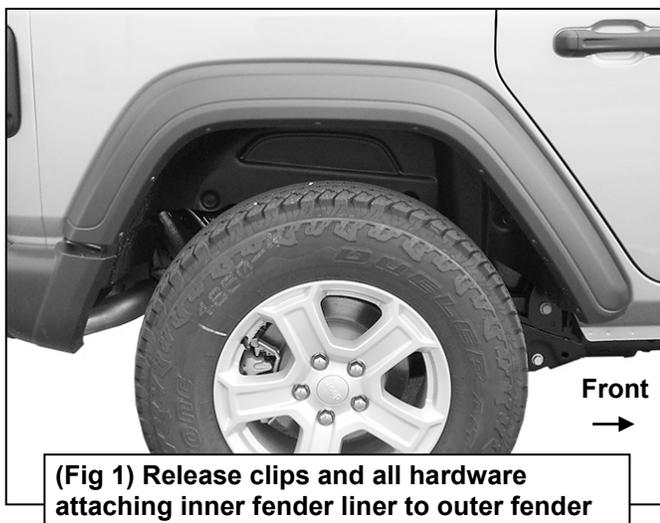
REMOVE CONTENTS FROM BOX. VERIFY ALL PARTS ARE PRESENT. READ INSTRUCTIONS CAREFULLY. CUTTING AND MODIFICATION IS REQUIRED TO REINSTALL THE PLASTIC FENDER LINER. DRILLING IS REQUIRED. ASSISTANCE IS RECOMMENDED.

1. Start installation on the Passenger/Right side of the vehicle. Release the plastic clips and remove any hardware attaching the liner to the outer edge and underside of the fender and the body, **(Figure 1)**. Remove the inner fender liner.
2. Next, firmly pull the fender straight outward from the body to pop the clips from the mounting holes, **(Figure 2)**. Remove any clips left attached to the body panel and move the fender to a clean surface.
3. Select the Passenger/Right Rear Fender. Carefully place the Fender up to the mounting location on the vehicle. Line up the holes in the Fender with the matching holes in the body to identify the correct mounting holes required for installation, **(Figures 3 & 4)**. Mark the (8) mounting holes requiring drilling **(Figure 4)**. **NOTE:** The last mounting hole in the Fender toward the rear of the vehicle does not line up with an existing hole in the vehicle and a hole will need to be drilled.
4. Use an electric drill and 25/64" drill bit, (not included) to drill out the (8) mounting holes along the body **(Figure 4)**. **VERY IMPORTANT:** Only drill through the outer sheet metal to enlarge the holes for a Threaded Insert, **do not drill completely through the body**.

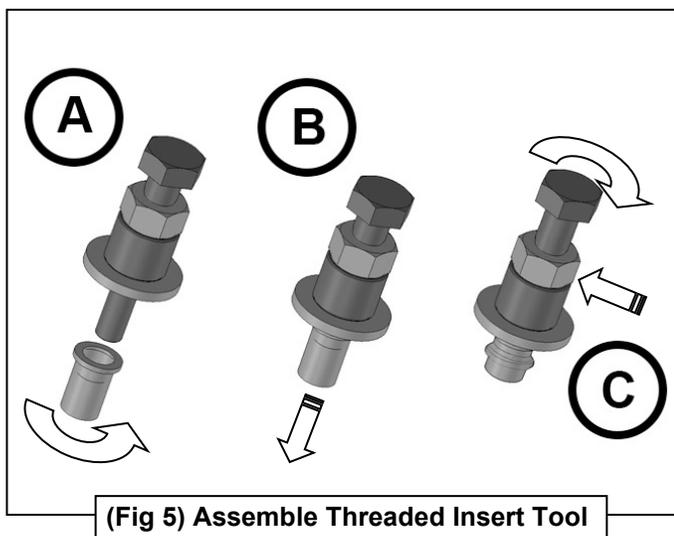
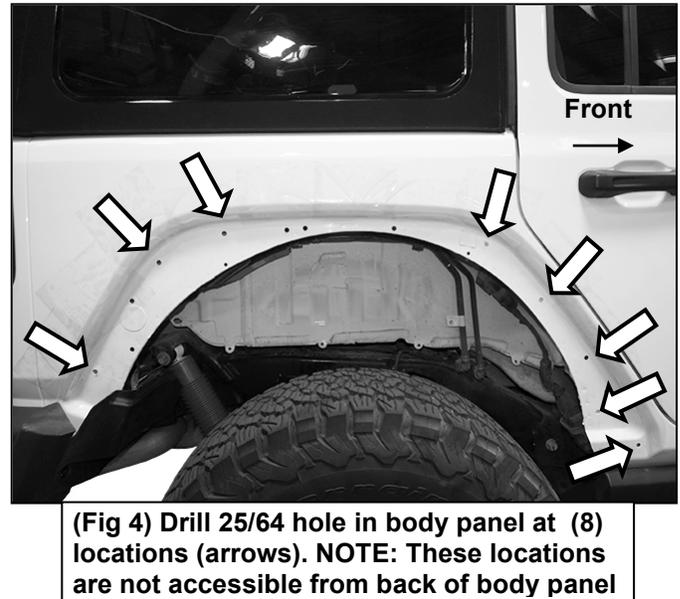
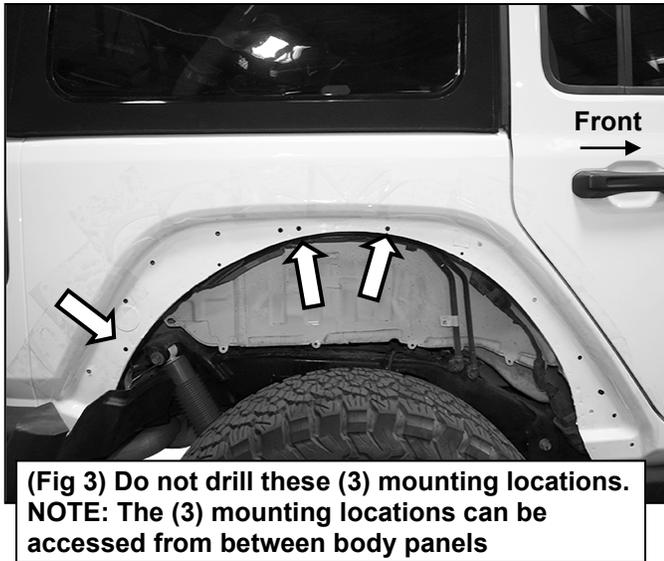
- a. Select the 6mm Threaded Insert Installation Tool and (1) 6mm Threaded Insert, **(Figure 5-A)**.
- b. Screw the Insert onto the threaded end of the Insert Tool, **(Figure 5-A)**.
- c. Firmly hold the Tool and push the Insert into one of the previously drilled holes, **(Figure 5-B)**.
- d. Insert should fit snug into the drilled hole. Lightly tap the Tool and Insert into the hole with a small hammer if necessary.
- e. Firmly hold the hex nut on the Insert Tool in place with a wrench and turn the hex bolt clockwise to tighten the bolt and expand the Insert in the hole **(Figure 5-C)**.
- f. Once Insert is fully compressed and expanded, remove the Tool from the Insert, **(Figure 6)**. **WARNING:** Do not overtighten Insert or damage to the Insert may result.
- g. Repeat the previous Steps to install the remaining (7) Threaded Inserts, **(Figures 6—8)**.
5. With assistance, hold the Fender up in position. Attach the Fender to the previously installed (8) Threaded Inserts with (8) 6mm Button Head Bolts, (8) 6mm Lock Washers and (8) 6mm Flat Washers, **(Figures 9—11)**. Do not tighten hardware at this time.
6. Next, attach the Fender to the (3) remaining mounting locations with access to the back of the outer body panel. Attach the Fender to the (3) locations, (2 at the top, 1 toward the rear), with (3) 6mm Button Head Bolts, (6) 6mm Flat Washers, (3) 6mm Lock Washers and (3) 6mm Hex Nuts, **(Figures 9—11)**. Do not tighten hardware at this time.
7. With the fender in place, determine if plastic fender liner will be reinstalled.
 - a. Slide fender liner into position.
 - b. Trim the outer section from the liner. **NOTE:** Actual amount to remove from liner to be determined by installer. Leave as many mounting points on the plastic liner as possible.
 - c. Reinstall modified plastic fender liner if desired.
8. Adjust the position of the Fender and fully tighten all hardware.
9. Repeat **Steps 1—8** for Driver/Left side Fender installation.
10. Do periodic inspections to the installation to make sure that all hardware is secure and tight.

To protect your investment, Do not use any type of polish or wax that may contain abrasives that could damage the finish. Mild soap may be used to clean the Fenders.

Passenger/Right Side Installation Pictured



Passenger/Right Side Installation Pictured

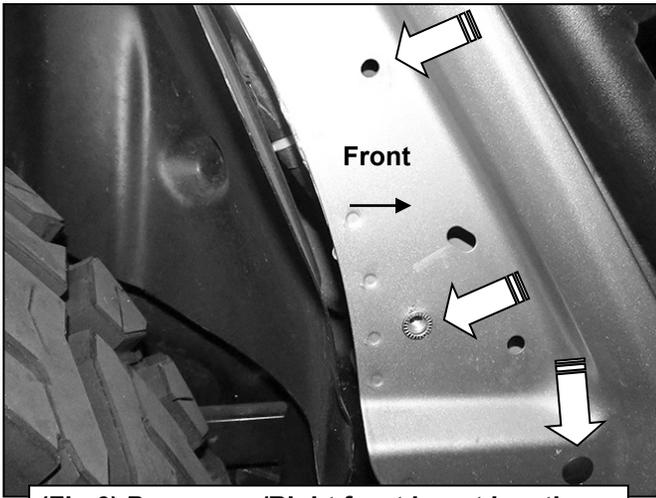


(5-A) Select Insert Tool and (1) Insert. Thread Insert onto end of Insert Tool. Hand tighten only, do not tighten hex bolt

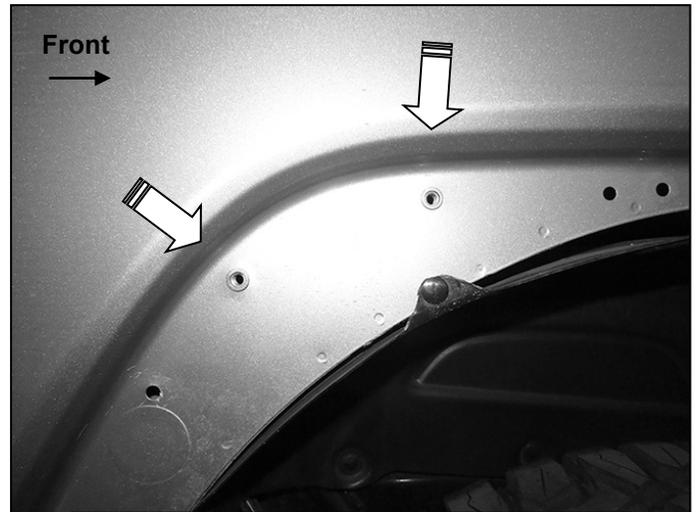
(5-B) Firmly hold assembly and push Insert into drilled hole.

(5-C) Use a wrench (open or box end) to hold nut (arrow) to prevent nut and tool from turning. Hold Tool Assembly up tight in body panel. Turn hex bolt in Tool clockwise to expand insert in body panel. Remove Tool once Insert is fully tightened. Do not overtighten or Insert may be damaged. Repeat steps for all Insert installations

Passenger/Right Side Installation Pictured



(Fig 6) Passenger/Right front insert locations

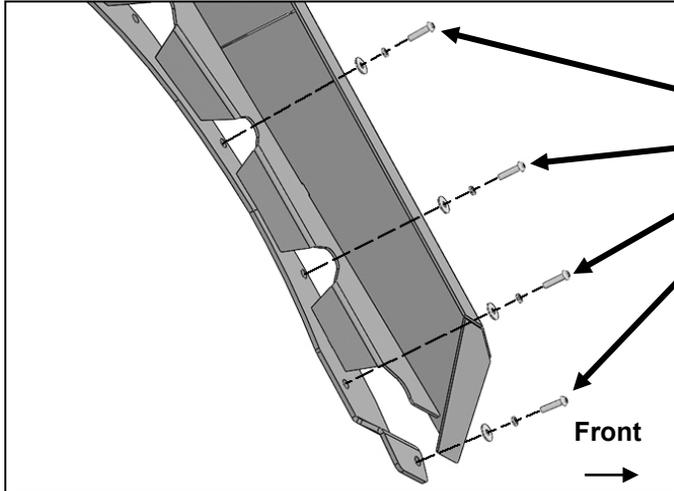


(Fig 7) Passenger/Right rear-top mounting locations with inserts fully installed



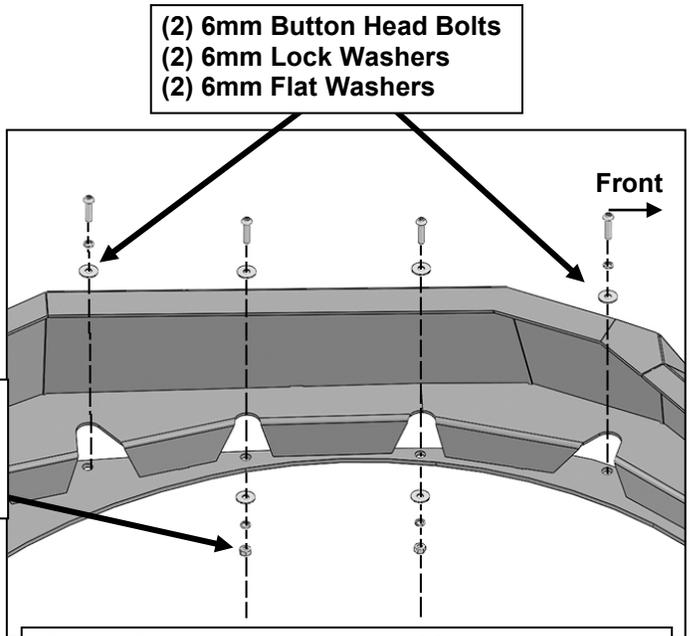
(Fig 8) Passenger/Right rear mounting locations with inserts fully installed

Passenger/Right Side Installation Pictured



- (4) 6mm Button Head Bolts
- (4) 6mm Lock Washers
- (4) 6mm Flat Washers

(Fig 9) Passenger/Right front of fender illustrated

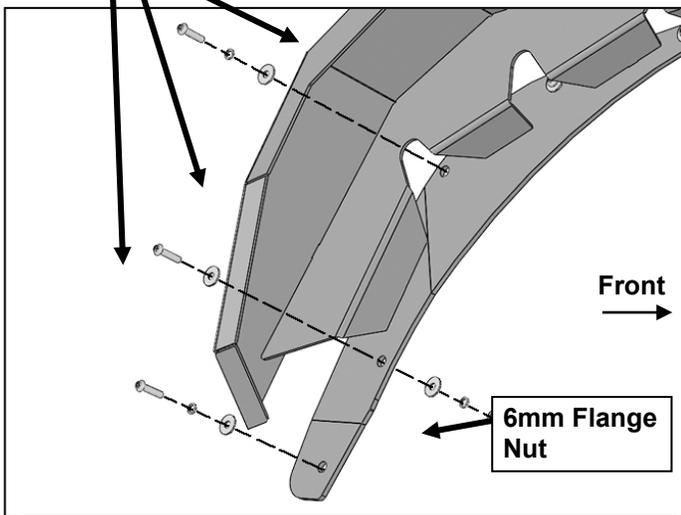


- (2) 6mm Button Head Bolts
- (2) 6mm Lock Washers
- (2) 6mm Flat Washers

(Fig 10) Passenger/Right top of fender illustrated

- (2) 6mm Button Head Bolts
- (4) 6mm Flat Washers
- (2) 6mm Lock Washers
- (2) 6mm Hex Nuts

- 6mm x 25mm Button Head Bolt
- 6mm Lock Washer
- 6mm Flat Washer



- 6mm Flange Nut

(Fig 11) Passenger/Right rear of fender illustrated