



# SS123HP FK3

FLARE - TEMPLATE KIT

Suits: TOYOTA HILUX GR SPORT MY24 Onwards



01/09/2024

## Parts List

ITEM	PART NO.	DESCRIPTION	QTY
1	322-017-650	TEMPLATE - FENDER FLARE SUPPORT BRACKET	1
2	322-017-660	TEMPLATE - FENDER FLARE - (Suits: HILUX GR SPORT)	1
3	322-332-600	BRACKET - FENDER FLARE SUPPORT - (Suits: HILUX GR SPORT)	1
4	000-039-300	BOLT - B/H - 6.0mm x 1.0 x 16mm - S/S	2
5	000-353	WASHER - BODY - 6mm x 18mm - S/S	4
6	000-204	NUT - NYLOC - 6mm x 1.0 - S/S	2
7	322-953-048	RUBBER EDGING - U CHANNEL - 8.5mm x 2.0mm x 480mm	1

## Installation Guide

**Fitment to:**

- Right Hand Side

**Fitting Time:**

- 60min

**Special Tools:**

- Body Saw (Reciprocating)
- Die Grinder
- Metric Drill Kit
- Files
- Sikaflex 227 Sealant
- Masking Tape
- Loctite 406 Instant Adhesive

1

Remove the right hand front mudflap, inner guard liner and right hand fender flare, then commence the installation of the SS123HP Snorkel kit as per the instructions to step 15.

Remove Fender Flare

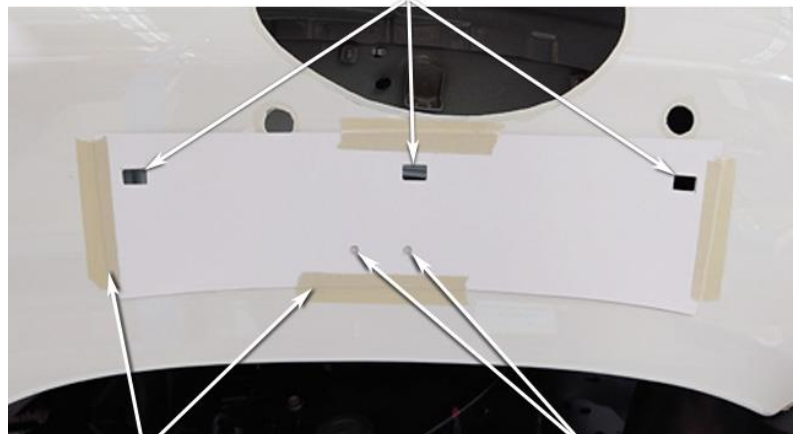


2

Align the flare support bracket template (item 1) to the three rectangular holes in the guard panel. Tape the template to the guard panel with masking tape, using a felt tip pen mark the two hole positions onto the guard panel.

Remove the template.

Align



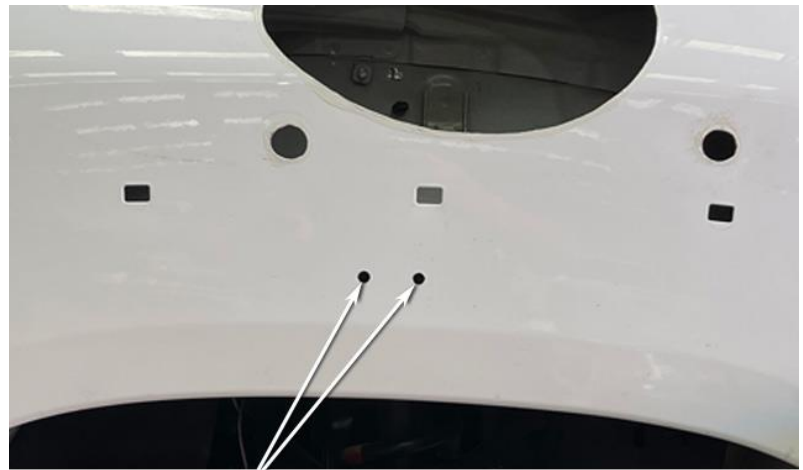
Secure Template

Mark

3

Drill a pilot hole at each of the marked hole positions, then drill the holes to 6.5mm with a 6.5mm drill bit.

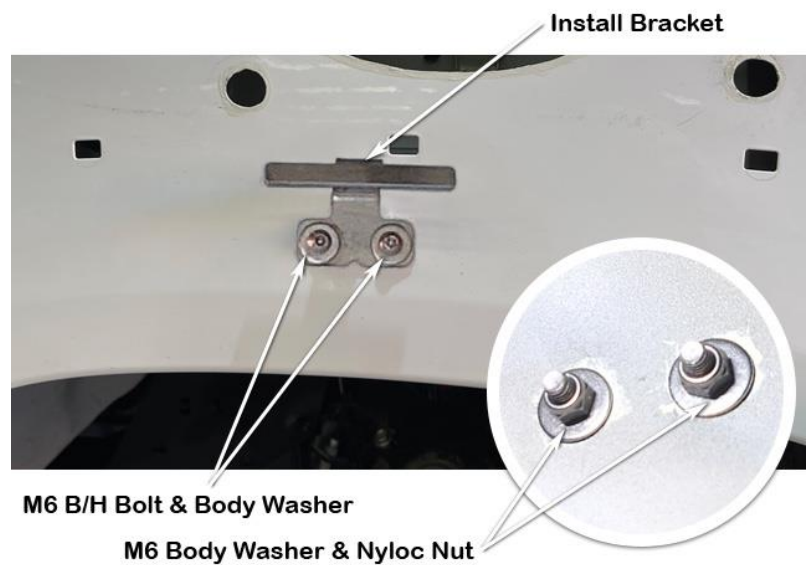
Deburr and paint holes.



Drill to 6.5mm Dia.

4

Install the fender flare support bracket (item 3), fasten to guard panel with M6 B/H bolts, M6 body washers (item's 4 & 5) and M6 body washers, M6 nyloc nuts (item's 5 & 6).



5

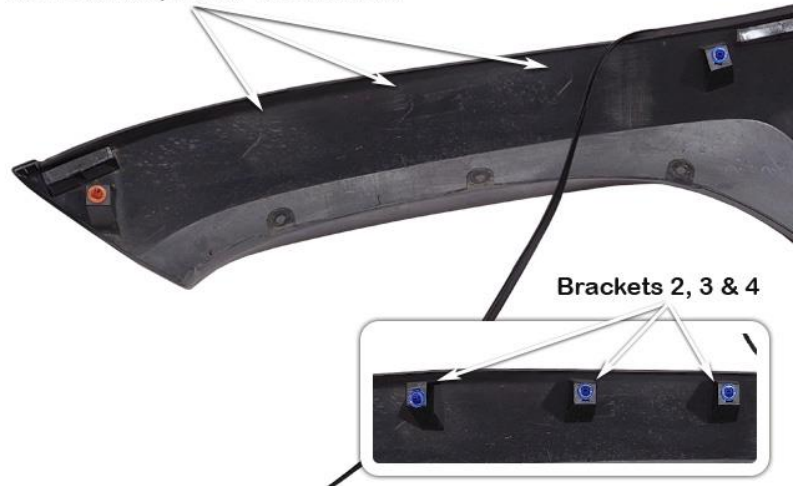
Apply masking tape to external face of the fender flare to prevent the fender flare from being scratched whilst marking and cutting the fender flare.

Carefully peel the standard fender flare seal back past the fourth flare mounting bracket.



Using a die grinder with a cut-off disc or sharp pair of side cutters, remove the 2<sup>nd</sup>, 3<sup>rd</sup> & 4<sup>th</sup> flare mounting brackets flush with the rear side of the flare as shown.

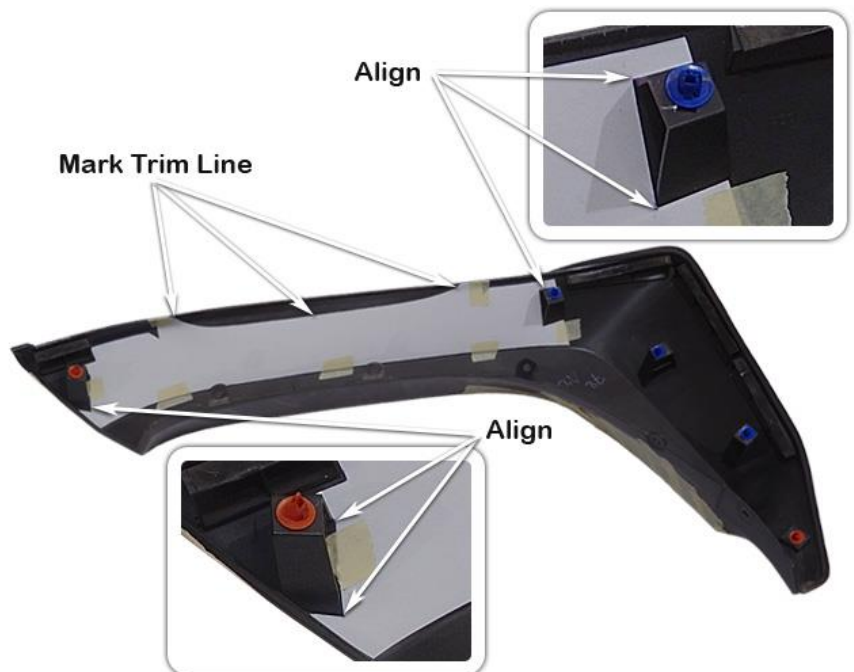
Remove 2nd, 3rd & 4th Brackets



Align the flare cut template (item 2) to the inside surface of the flare, align the template to the 1<sup>st</sup> and 5<sup>th</sup> mounting bracket of the inside surface of the flare as shown.

Using a paint pen or permanent marker, mark the required cut-out.

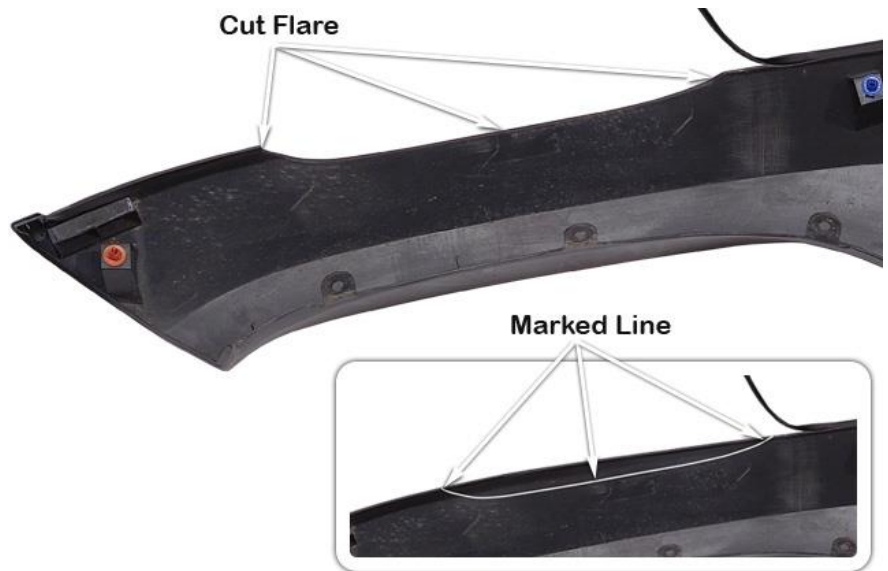
Remove the template.



8

Using the body saw, cut the marked section of the flare.

Clean-up the cut edges of the flare using a die grinder or files.



9

Refit the standard fender flare seal and neatly cut the seal level with the removed section of flare, it may be necessary to apply a small drop of Loctite 406 instant adhesive to each end of the standard seal.

*Hint: Only apply the Loctite 406 instant adhesive to the self-adhesive tape part of the seal.*



10

Continue with the installation of the SS123HP snorkel kit from step 16 through to step 23.

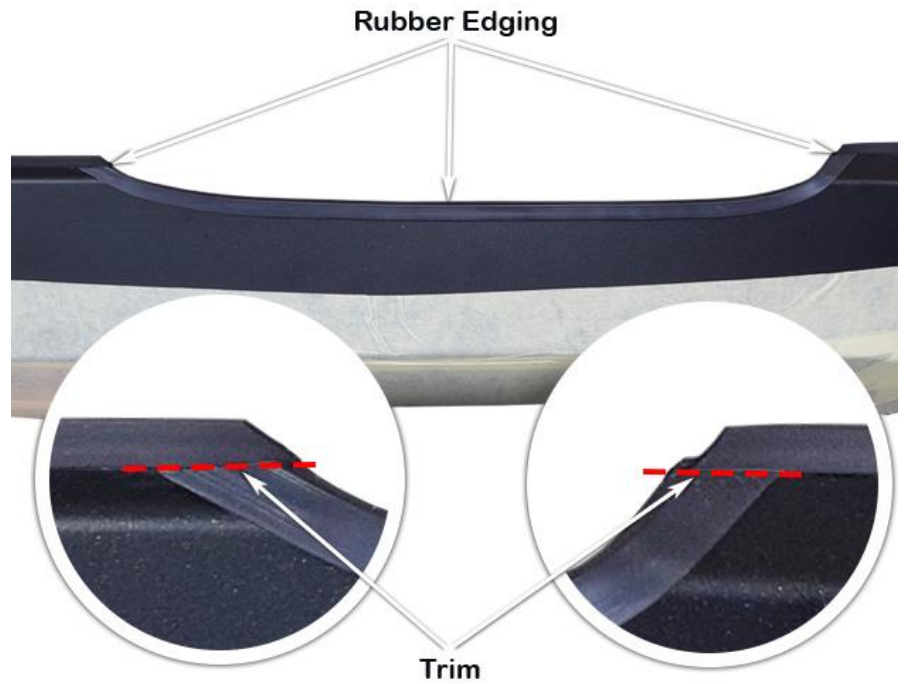
With the snorkel body installed, trial fit the fender flare to the vehicle and check for adequate clearance between the fender flare and snorkel body (*approximately 2-3mm clearance is required*), it may be necessary to either adjust the position of the snorkel body or mark up the flare where any extra clearance is required.

Remove the flare from the vehicle.

Using the die grinder or files, remove any sections of the flare requiring extra clearance, trial fit the flare re-checking the clearance between the snorkel body and flare.



Install the supplied rubber edging (item 7) to the cut section of the flare, neatly cut the end of the rubber edging to match up to the factory flare rubber seal as shown.



Trial fit the fender flare back onto the guard and adjust the clearance between the rubber edging and the snorkel body by tapping the rubber edging upwards, so it sits neatly against the snorkel body. Remove the fender flare.



Apply several small drops of Loctite 406 instant adhesive between the backside of the flare and rubber edging as shown and secure the rubber edging to the flare.



Apply Sikaflex 227 sealant to the fender flare support bracket and install the fender flare to the vehicle ensuring all the fender flare clips are correctly engaged.

Complete the final steps of the SS123HP installation instructions (steps 24 & 25).

